

1158/9

HSS DIN 338 NSP



|             | P     |           |        |        | M    |        | K         |           |        | N         |           |       |           | S  |    | H      |        |        |
|-------------|-------|-----------|--------|--------|------|--------|-----------|-----------|--------|-----------|-----------|-------|-----------|----|----|--------|--------|--------|
|             | <800  | <1.000    | <1.200 | <1.400 | <950 | <1.200 | <500      | <800      | <1.400 | Al        | Cu        | Mg/Zn | Plastic   | Ni | Ti | 50 HRC | 55 HRC | 60 HRC |
|             | ●     |           |        |        |      |        | ●         | ●         |        | ○         | ●         |       | ○         |    |    |        |        |        |
|             | 15-35 |           |        |        |      |        | 25-30     | 12-16     |        | 50-60     | 30-60     |       | 20-25     |    |    |        |        |        |
| Avance/feed | Ø2    | 0,02-0,06 |        |        |      |        | 0,04-0,06 | 0,04-0,06 |        | 0,02-0,05 | 0,02-0,05 |       | 0,03-0,04 |    |    |        |        |        |
|             | Ø5    | 0,08-0,12 |        |        |      |        | 0,08-0,12 | 0,05-0,12 |        | 0,05-0,12 | 0,05-0,1  |       | 0,06-0,07 |    |    |        |        |        |
|             | Ø10   | 0,12-0,30 |        |        |      |        | 0,20-0,30 | 0,18-0,30 |        | 0,18-0,24 | 0,18-0,24 |       | 0,12-0,13 |    |    |        |        |        |
|             | Ø15   | 0,18-0,40 |        |        |      |        | 0,30-0,40 | 0,20-0,40 |        | 0,20-0,32 | 0,2-0,32  |       | 0,16-0,17 |    |    |        |        |        |
|             | Ø20   | 0,22-0,46 |        |        |      |        | 0,35-0,46 | 0,25-0,46 |        | 0,25-0,37 | 0,25-0,37 |       | 0,25-0,26 |    |    |        |        |        |

Vc (m/min). ● Optima / Optimun ○ Alternativo / Alternative



| Ø<br>mm | L<br>mm | I<br>mm |    |
|---------|---------|---------|----|
| 1/16"   | 43      | 20      | 10 |
| 5/64"   | 49      | 24      | 10 |
| 3/32"   | 57      | 30      | 10 |
| 7/64"   | 61      | 33      | 10 |
| 1/8"    | 65      | 36      | 10 |
| 9/64"   | 70      | 39      | 10 |
| 5/32"   | 75      | 43      | 10 |
| 11/64"  | 80      | 47      | 10 |
| 3/16"   | 86      | 52      | 10 |
| 13/64"  | 86      | 52      | 10 |
| 7/32"   | 93      | 57      | 10 |
| 15/64"  | 93      | 57      | 10 |
| 1/4"    | 101     | 63      | 10 |
| 17/64"  | 109     | 69      | 10 |
| 9/32"   | 109     | 69      | 10 |

| Ø<br>mm | L<br>mm | I<br>mm |    |
|---------|---------|---------|----|
| 19/64"  | 117     | 75      | 10 |
| 5/16"   | 117     | 75      | 10 |
| 21/64"  | 117     | 75      | 10 |
| 11/32"  | 125     | 81      | 10 |
| 23/64"  | 125     | 81      | 10 |
| 3/8"    | 133     | 87      | 10 |
| 25/64"  | 133     | 87      | 10 |
| 13/32"  | 133     | 87      | 5  |
| 27/64"  | 142     | 94      | 5  |
| 7/16"   | 142     | 94      | 5  |
| 29/64"  | 142     | 94      | 5  |
| 15/32"  | 151     | 101     | 5  |
| 31/64"  | 151     | 101     | 5  |
| 1/2"    | 151     | 101     | 5  |