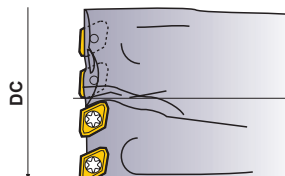
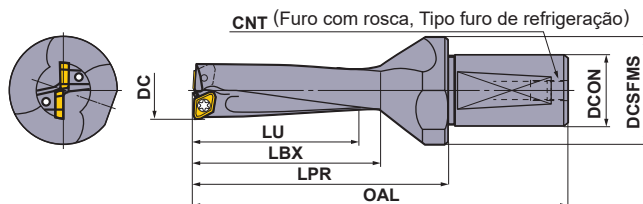


TAFS/TAFM/TAFL

- Suporte de alta rigidez.
- Insertos de 4 arestas.
- Várias classes e quebra-cavacos.



METAL DURO



Nota 1) O furo rosqueado na lateral da flange não é para refrigeração.

Número de Dentes = 4 ($\phi DC \geq 49$)

DC (mm)	Prof. do Furo (L/D)	Referência para Pedido	Estoque	Número de Dentes	Dimensões (mm)							Referência do Inserto	Parafuso de Fixação	F Chave
					LU	LBX	LPR	OAL	DCON	DCSFMS	CNT			
12.0	2	TAFS1200F20	●	2	24	29	39	82	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
12.0	3	TAFM1200F20	●	2	36	41	51	94	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
12.5	2	TAFS1250F20	●	2	25	29	39	82	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
12.5	3	TAFM1250F20	●	2	37.5	41	51	94	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
13.0	2	TAFS1300F20	●	2	26	31	41	84	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
13.0	3	TAFM1300F20	●	2	39	44	54	97	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
13.5	2	TAFS1350F20	●	2	27	31	41	84	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
13.5	3	TAFM1350F20	●	2	40.5	44	54	97	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
14.0	2	TAFS1400F20	●	2	28	33	43	86	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
14.0	3	TAFM1400F20	●	2	42	47	57	100	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
14.5	2	TAFS1450F20	●	2	29	33	43	86	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
14.5	3	TAFM1450F20	●	2	43.5	47	57	100	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
15.0	2	TAFS1500F20	●	2	30	35	45	88	20	25	PT1/8	GPMT060204-U	TS2	TKY06F
15.0	3	TAFM1500F20	●	2	45	50	60	103	20	25	PT1/8	GPMT060204-U	TS2	TKY06F
15.5	2	TAFS1550F20	●	2	31	35	45	88	20	25	PT1/8	GPMT060204-U	TS2	TKY06F
15.5	3	TAFM1550F20	●	2	46.5	50	60	103	20	25	PT1/8	GPMT060204-U	TS2	TKY06F
16.0	2	TAFS1600F25	●	2	32	38	57	107	25	35	PT1/8	GPMT060204-U	TS2	TKY06F
16.0	3	TAFM1600F25	●	2	48	54	73	123	25	35	PT1/8	GPMT060204-U	TS2	TKY06F
16.0	4	TAFL1600F25	●	2	64	70	89	139	25	35	PT1/8	GPMT060204-U	TS2	TKY06F
16.5	2	TAFS1650F25	●	2	33	38	57	107	25	35	PT1/8	GPMT060204-U	TS2	TKY06F
16.5	3	TAFM1650F25	●	2	49.5	54	73	123	25	35	PT1/8	GPMT060204-U	TS2	TKY06F
17.0	2	TAFS1700F25	●	2	34	41	59	109	25	35	PT1/8	GPMT060204-U	TS2	TKY06F
17.0	3	TAFM1700F25	●	2	51	58	76	126	25	35	PT1/8	GPMT060204-U	TS2	TKY06F
17.0	4	TAFL1700F25	●	2	68	75	93	143	25	35	PT1/8	GPMT060204-U	TS2	TKY06F
17.5	2	TAFS1750F25	▲	2	35	41	59	109	25	35	PT1/8	GPMT060204-U	TS2	TKY06F
17.5	3	TAFM1750F25	▲	2	52.5	58	76	126	25	35	PT1/8	GPMT060204-U	TS2	TKY06F
18.0	2	TAFS1800F25	▲	2	36	43	61	111	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
18.0	3	TAFM1800F25	▲	2	54	61	79	129	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
18.0	4	TAFL1800F25	▲	2	72	79	97	147	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
18.5	2	TAFS1850F25	▲	2	37	43	61	111	25	35	PT1/8	GPMT070204-U	TS25	TKY08F

* Torque de Fixação (N • m) : TS2=0.5, TS25=1.0

- : Estoque mantido.
- ▲ : Estoque mantido. Será substituído por novos produtos.

DESCRIÇÃO DO INSERTO > N175
ACESSÓRIOS > P001


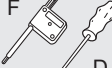
N171

FURAÇÃO N

FURAÇÃO(TIPO INTERCAMBIÁVEL)

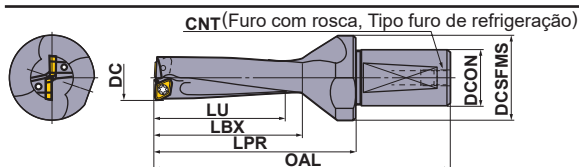
TAFS/TAFM/TAFL



METAL DURO

DC (mm)	Prof. do Furo (L/D)	Referência para Pedido	Estoque	Número de Dentes	Dimensões (mm)							Referência do Inserto		
					LU	LBX	LPR	OAL	DCON	DCSfMS	CNT			
18.5	3	TAFM1850F25	▲	2	55.5	61	79	129	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
19.0	2	TAFS1900F25	▲	2	38	46	63	113	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
19.0	3	TAFM1900F25	▲	2	57	65	82	132	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
19.0	4	TAFL1900F25	▲	2	76	84	101	151	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
19.5	2	TAFS1950F25	▲	2	39	46	63	113	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
19.5	3	TAFM1950F25	▲	2	58.5	65	82	132	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
20.0	2	TAFS2000F25	▲	2	40	48	65	115	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
20.0	3	TAFM2000F25	▲	2	60	68	85	135	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
20.0	4	TAFL2000F25	▲	2	80	88	105	155	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
20.5	2	TAFS2050F25	▲	2	41	48	65	115	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
20.5	3	TAFM2050F25	▲	2	61.5	68	85	135	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
21.0	2	TAFS2100F25	▲	2	42	50	67	117	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
21.0	3	TAFM2100F25	▲	2	63	71	88	138	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
21.0	4	TAFL2100F25	▲	2	84	92	109	159	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
21.5	2	TAFS2150F25	▲	2	43	50	67	117	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
21.5	3	TAFM2150F25	▲	2	64.5	71	88	138	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
22.0	2	TAFS2200F25	▲	2	44	53	69	119	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
22.0	3	TAFM2200F25	▲	2	66	75	91	141	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
22.0	4	TAFL2200F25	▲	2	88	97	113	163	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
22.5	2	TAFS2250F25	▲	2	45	53	69	119	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
22.5	3	TAFM2250F25	▲	2	67.5	75	91	141	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
23.0	2	TAFS2300F25	▲	2	46	55	71	121	25	35	PT1/8	GPMT090304-U	TS3	TKY08F
23.0	3	TAFM2300F25	▲	2	69	78	94	144	25	35	PT1/8	GPMT090304-U	TS3	TKY08F
23.0	4	TAFL2300F25	▲	2	92	101	117	167	25	35	PT1/8	GPMT090304-U	TS3	TKY08F
23.5	2	TAFS2350F25	▲	2	47	55	71	121	25	35	PT1/8	GPMT090304-U	TS3	TKY08F
23.5	3	TAFM2350F25	▲	2	70.5	78	94	144	25	35	PT1/8	GPMT090304-U	TS3	TKY08F
24.0	2	TAFS2400F25	▲	2	48	58	73	123	25	35	PT1/8	GPMT090304-U	TS3	TKY08F
24.0	3	TAFM2400F25	▲	2	72	82	97	147	25	35	PT1/8	GPMT090304-U	TS3	TKY08F
24.0	4	TAFL2400F25	▲	2	96	106	121	171	25	35	PT1/8	GPMT090304-U	TS3	TKY08F
24.5	2	TAFS2450F25	▲	2	49	58	73	123	25	35	PT1/8	GPMT090304-U	TS3	TKY08F
24.5	3	TAFM2450F25	▲	2	73.5	82	97	147	25	35	PT1/8	GPMT090304-U	TS3	TKY08F
25.0	2	TAFS2500F32	▲	2	50	60	75	130	32	42	PT1/8	GPMT090304-U	TS3	TKY08F
25.0	3	TAFM2500F32	▲	2	75	85	100	155	32	42	PT1/8	GPMT090304-U	TS3	TKY08F
25.0	4	TAFL2500F32	▲	2	100	110	125	180	32	42	PT1/8	GPMT090304-U	TS3	TKY08F
25.5	2	TAFS2550F32	▲	2	51	60	75	130	32	42	PT1/8	GPMT090304-U	TS3	TKY08F
25.5	3	TAFM2550F32	▲	2	76.5	85	100	155	32	42	PT1/8	GPMT090304-U	TS3	TKY08F
26.0	2	TAFS2600F32	▲	2	52	62	77	132	32	42	PT1/8	GPMT090304-U	TS3	TKY08F
26.0	3	TAFM2600F32	▲	2	78	88	103	158	32	42	PT1/8	GPMT090304-U	TS3	TKY08F
26.0	4	TAFL2600F32	▲	2	104	114	129	184	32	42	PT1/8	GPMT090304-U	TS3	TKY08F
26.5	2	TAFS2650F32	▲	2	53	62	77	132	32	42	PT1/8	GPMT090304-U	TS3	TKY08F
26.5	3	TAFM2650F32	▲	2	79.5	88	103	158	32	42	PT1/8	GPMT090304-U	TS3	TKY08F
27.0	2	TAFS2700F32	▲	2	54	65	79	134	32	42	PT1/8	GPMT090304-U	TS3	TKY08F
27.0	3	TAFM2700F32	▲	2	81	92	106	161	32	42	PT1/8	GPMT090304-U	TS3	TKY08F
27.0	4	TAFL2700F32	▲	2	108	119	133	188	32	42	PT1/8	GPMT090304-U	TS3	TKY08F
27.5	2	TAFS2750F32	▲	2	55	65	79	134	32	42	PT1/8	GPMT090304-U	TS3	TKY08F
27.5	3	TAFM2750F32	▲	2	82.5	92	106	161	32	42	PT1/8	GPMT090304-U	TS3	TKY08F
28.0	2	TAFS2800F32	▲	2	56	67	81	136	32	42	PT1/8	GPMT11T308-U	TS4	TKY15D
28.0	3	TAFM2800F32	▲	2	84	95	109	164	32	42	PT1/8	GPMT11T308-U	TS4	TKY15D

* Torque de Fixação (N • m) : TS25=1.0, TS3=1.0

▲ : Estoque mantido. Será substituído por novos produtos.




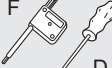
DC (mm)	Prof. do Furo (L/D)	Referência para Pedido	Estoque	Número de Dentes	Dimensões (mm)							Referência do Inserto		D 
					LU	LBX	LPR	OAL	DCON	DCSFMS	CNT			
28.0	4	T AFL2800F32	▲	2	112	123	137	192	32	42	PT1/8	GPMT11T308-U	TS4	TKY15D
28.5	2	T AFS2850F32	▲	2	57	67	81	136	32	42	PT1/8	GPMT11T308-U	TS4	TKY15D
28.5	3	T AFM2850F32	▲	2	85.5	95	109	164	32	42	PT1/8	GPMT11T308-U	TS4	TKY15D
29.0	2	T AFS2900F32	▲	2	58	70	83	138	32	42	PT1/8	GPMT11T308-U	TS4	TKY15D
29.0	3	T AFM2900F32	▲	2	87	99	112	167	32	42	PT1/8	GPMT11T308-U	TS4	TKY15D
29.0	4	T AFL2900F32	▲	2	116	128	141	196	32	42	PT1/8	GPMT11T308-U	TS4	TKY15D
29.5	2	T AFS2950F32	▲	2	59	70	83	138	32	42	PT1/8	GPMT11T308-U	TS4	TKY15D
29.5	3	T AFM2950F32	▲	2	88.5	99	112	167	32	42	PT1/8	GPMT11T308-U	TS4	TKY15D
30.0	2	T AFS3000F40	▲	2	60	72	90	155	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
30.0	3	T AFM3000F40	▲	2	90	102	120	185	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
30.0	4	T AFL3000F40	▲	2	120	132	150	215	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
31.0	2	T AFS3100F40	▲	2	62	74	92	157	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
31.0	3	T AFM3100F40	▲	2	93	105	123	188	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
31.0	4	T AFL3100F40	▲	2	124	136	154	219	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
32.0	2	T AFS3200F40	▲	2	64	77	94	159	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
32.0	3	T AFM3200F40	▲	2	96	109	126	191	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
32.0	4	T AFL3200F40	▲	2	128	141	158	223	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
33.0	2	T AFS3300F40	▲	2	66	79	96	161	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
33.0	3	T AFM3300F40	▲	2	99	112	129	194	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
33.0	4	T AFL3300F40	▲	2	132	145	162	227	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
34.0	2	T AFS3400F40	▲	2	68	82	98	163	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
34.0	3	T AFM3400F40	▲	2	102	116	132	197	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
34.0	4	T AFL3400F40	▲	2	136	150	166	231	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
35.0	2	T AFS3500F40	▲	2	70	84	100	165	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
35.0	3	T AFM3500F40	▲	2	105	119	135	200	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
36.0	2	T AFS3600F40	▲	2	72	86	102	167	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
36.0	3	T AFM3600F40	▲	2	108	122	138	203	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
37.0	2	T AFS3700F40	▲	2	74	89	104	169	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
37.0	3	T AFM3700F40	▲	2	111	126	141	206	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
38.0	2	T AFS3800F40	▲	2	76	91	106	171	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
38.0	3	T AFM3800F40	▲	2	114	129	144	209	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
39.0	2	T AFS3900F40	▲	2	78	94	108	173	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
39.0	3	T AFM3900F40	▲	2	117	133	147	212	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
40.0	2	T AFS4000F40	▲	2	80	96	110	175	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
40.0	3	T AFM4000F40	▲	2	120	136	150	215	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
41.0	2	T AFS4100F40	▲	2	82	98	112	177	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
41.0	3	T AFM4100F40	▲	2	123	139	153	218	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
42.0	2	T AFS4200F40	▲	2	84	101	114	179	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
42.0	3	T AFM4200F40	▲	2	126	143	156	221	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
43.0	2	T AFS4300F40	▲	2	86	103	116	181	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
43.0	3	T AFM4300F40	▲	2	129	146	159	224	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
44.0	2	T AFS4400F40	▲	2	88	106	118	183	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
44.0	3	T AFM4400F40	▲	2	132	150	162	227	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
45.0	2	T AFS4500F40	▲	2	90	108	120	185	40	54	PT1/4	GPMT140408-U	TS55	TKY25D
45.0	3	T AFM4500F40	▲	2	135	153	165	230	40	54	PT1/4	GPMT140408-U	TS55	TKY25D
46.0	2	T AFS4600F40	▲	2	92	110	122	187	40	54	PT1/4	GPMT140408-U	TS55	TKY25D
46.0	3	T AFM4600F40	▲	2	138	156	168	233	40	54	PT1/4	GPMT140408-U	TS55	TKY25D
47.0	2	T AFS4700F40	▲	2	94	113	124	189	40	54	PT1/4	GPMT140408-U	TS55	TKY25D

* Torque de Fixação (N • m) : TS4=3.5, TS55=7.5

FURAÇÃO(TIPO INTERCAMBIÁVEL)

TAFS/TAFM/TAFL

METAL DURO

DC (mm)	Prof. do Furo (L/D)	Referência para Pedido	Estoque	Número de Dentes	Dimensões (mm)							Referência do Inserto		
					LU	LBX	LPR	OAL	DCON	DCSFMS	CNT			
47.0	3	TAFM4700F40	▲	2	141	160	171	236	40	54	PT1/4	GPMT140408-U	TS55	TKY25D
48.0	2	TAFS4800F40	▲	2	96	115	126	191	40	54	PT1/4	GPMT140408-U	TS55	TKY25D
48.0	3	TAFM4800F40	▲	2	144	163	174	239	40	54	PT1/4	GPMT140408-U	TS55	TKY25D
49.0	2	TAFS4900F40	▲	4	98	118	133	198	40	58	PT1/4	GPMT090304-U	TS3	TKY08F
49.0	3	TAFM4900F40	▲	4	147	167	182	247	40	58	PT1/4	GPMT090304-U	TS3	TKY08F
50.0	2	TAFS5000F40	▲	4	100	120	135	200	40	58	PT1/4	GPMT090304-U	TS3	TKY08F
50.0	3	TAFM5000F40	▲	4	150	170	185	250	40	58	PT1/4	GPMT090304-U	TS3	TKY08F
51.0	2	TAFS5100F40	▲	4	102	122	137	202	40	58	PT1/4	GPMT090304-U	TS3	TKY08F
51.0	3	TAFM5100F40	▲	4	153	173	188	253	40	58	PT1/4	GPMT090304-U	TS3	TKY08F
52.0	2	TAFS5200F40	▲	4	104	125	139	204	40	58	PT1/4	GPMT090304-U	TS3	TKY08F
52.0	3	TAFM5200F40	▲	4	156	177	191	256	40	58	PT1/4	GPMT090304-U	TS3	TKY08F
53.0	2	TAFS5300F40	▲	4	106	127	141	206	40	63	PT1/4	GPMT090304-U	TS3	TKY08F
53.0	3	TAFM5300F40	▲	4	159	180	194	259	40	63	PT1/4	GPMT090304-U	TS3	TKY08F
54.0	2	TAFS5400F40	▲	4	108	128	143	208	40	63	PT1/4	GPMT090304-U	TS3	TKY08F
54.0	3	TAFM5400F40	▲	4	162	182	197	262	40	63	PT1/4	GPMT090304-U	TS3	TKY08F
55.0	2	TAFS5500F40	▲	4	110	130	145	210	40	63	PT1/4	GPMT090304-U	TS3	TKY08F
55.0	3	TAFM5500F40	▲	4	165	185	200	265	40	63	PT1/4	GPMT090304-U	TS3	TKY08F
56.0	2	TAFS5600F40	▲	4	112	132	147	212	40	63	PT1/4	GPMT090304-U	TS3	TKY08F
56.0	3	TAFM5600F40	▲	4	168	188	203	268	40	63	PT1/4	GPMT090304-U	TS3	TKY08F

* Torque de Fixação (N • m) : TS3=1.0, TS55=7.5

N

FURAÇÃO

● : Estoque mantido. ▲ : Estoque mantido. Será substituído por novos produtos.

(Nota: 10 insertos por embalagem)

N174

INSERTOS

Geometria	Diâm. da Broca	Referência do Inserto	Dimensões (mm)				Com Cobertura				
			IC	L	S	RE	VP15TF	UP20M	GP20M	UE6020	US735
Quebra-cavaco U1 	ø12.0–ø14.5	GCMT040204-U1	–	5.0	2.38	0.4		●			
	ø15.0–ø17.5	GPMT060204-U1	5.56	–	2.38	0.4		▲		▲	
	ø18.0–ø22.5	GPMT070204-U1	6.35	–	2.38	0.4		▲		▲	
	ø23.0–ø27.5 ø49.0–ø56.0	GPMT090304-U1	7.94	–	3.18	0.4		▲		▲	
	ø28.0–ø34.0	GPMT11T308-U1	9.525	–	3.97	0.8		▲		▲	
	ø35.0–ø48.0	GPMT140408-U1	12.70	–	4.76	0.8		▲		▲	
Quebra-cavaco U2 	ø12.0–ø14.5	GCMT040204-U2	–	5.0	2.38	0.4	●		●		
	ø15.0–ø17.5	GPMT060204-U2	5.56	–	2.38	0.4	▲	▲		▲	▲
	ø18.0–ø22.5	GPMT070204-U2	6.35	–	2.38	0.4	▲	▲		▲	▲
	ø23.0–ø27.5 ø49.0–ø56.0	GPMT090304-U2	7.94	–	3.18	0.4	▲	▲		▲	▲
	ø28.0–ø34.0	GPMT11T308-U2	9.525	–	3.97	0.8	▲	▲		▲	▲
	ø35.0–ø48.0	GPMT140408-U2	12.70	–	4.76	0.8	▲	▲		▲	▲
Quebra-cavaco U3 	ø15.0–ø17.5	GPMT060204-U3	5.56	–	2.38	0.4		▲		▲	▲
	ø18.0–ø22.5	GPMT070204-U3	6.35	–	2.38	0.4		▲		▲	▲
	ø23.0–ø27.5 ø49.0–ø56.0	GPMT090304-U3	7.94	–	3.18	0.4		▲		▲	▲
	ø28.0–ø34.0	GPMT11T308-U3	9.525	–	3.97	0.8		▲		▲	▲
	ø35.0–ø48.0	GPMT140408-U3	12.70	–	4.76	0.8		▲		▲	▲

RECOMENDAÇÃO DE INSERTO

RECOMENDAÇÃO DE QUEBRA-CAVACO

◎ : 1ª Recomendação ○ : 2ª Recomendação

Material	P						M		K			
	Aço Baixo Carbono		Aço Carbono		Aço Liga		Aço Inoxidável		Ferro Fundido Cinzento		Ferro Fundido Nodular	
	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT
U1	◎	◎	○	○	○	○	○	○	○	○	○	○
U2	○	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
U3		○		○		○		○		○		○

RECOMENDAÇÃO DE CLASSE

◎ : 1ª Recomendação ○ : 2ª Recomendação

Material	P						M		K			
	Aço Baixo Carbono		Aço Carbono		Aço Liga		Aço Inoxidável		Ferro Fundido Cinzento		Ferro Fundido Nodular	
	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT
VP15TF		○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
UP20M	◎	◎	○	○	○	○	○	○	○	○	○	○
GP20M	○		○		○		○		○		○	
UE6020		○		○		○		○		○		○
US735		○		○		○		○		○		○

CONDIÇÕES DE CORTE RECOMENDADAS

Material	Dureza	Vel. de Corte (m/min)			Quebra-cavacos	Avanço (mm/rot)					
		Para L/D=2,3		Para L/D=4		Diâm. da Broca (mm)					
		($\phi 12-\phi 14.5$)	($\phi 15-$)	($\phi 16-$)		$\phi 12-\phi 14.5$	$\phi 15-\phi 22.5$	$\phi 23-\phi 34$	$\phi 35-\phi 48$	$\phi 49-\phi 56$	
P	Aço Baixo Carbono	$\leq 180\text{HB}$	150 (100-200)	200 (150-300)	140 (100-200)	U1	0.06 (0.04-0.10)	0.07 (0.04-0.10)	0.08 (0.04-0.10)	0.10 (0.04-0.12)	0.08 (0.04-0.10)
						U2	0.06 (0.04-0.10)	0.08 (0.04-0.12)	0.10 (0.04-0.12)	0.12 (0.04-0.14)	0.10 (0.04-0.12)
						U3	-	0.08 (0.04-0.12)	0.10 (0.04-0.12)	0.12 (0.04-0.14)	0.10 (0.04-0.12)
	Aço Carbono	180-280HB	120 (80-160)	150 (120-180)	100 (80-120)	U1	0.06 (0.04-0.10)	0.09 (0.06-0.12)	0.12 (0.08-0.14)	0.15 (0.08-0.18)	0.12 (0.08-0.14)
						U2	0.06 (0.04-0.10)	0.12 (0.06-0.14)	0.14 (0.08-0.18)	0.17 (0.08-0.20)	0.14 (0.08-0.18)
						U3	-	0.12 (0.06-0.14)	0.14 (0.08-0.18)	0.17 (0.08-0.20)	0.14 (0.08-0.18)
	Aço Liga	180-280HB	120 (80-160)	150 (120-180)	100 (80-120)	U1	0.06 (0.04-0.10)	0.08 (0.06-0.10)	0.09 (0.06-0.12)	0.11 (0.06-0.14)	0.09 (0.06-0.12)
						U2	0.06 (0.04-0.10)	0.10 (0.06-0.12)	0.12 (0.08-0.16)	0.14 (0.08-0.18)	0.12 (0.08-0.16)
						U3	-	0.10 (0.06-0.12)	0.12 (0.08-0.16)	0.14 (0.08-0.18)	0.12 (0.08-0.16)
M	Aço Inoxidável	$\leq 200\text{HB}$	100 (80-120)	150 (120-200)	110 (80-140)	U1	0.07 (0.04-0.10)	0.07 (0.04-0.10)	0.08 (0.04-0.10)	0.10 (0.04-0.12)	0.08 (0.04-0.10)
						U2	0.07 (0.04-0.10)	0.08 (0.04-0.12)	0.10 (0.04-0.14)	0.12 (0.04-0.16)	0.10 (0.04-0.14)
						U3	-	0.08 (0.04-0.12)	0.10 (0.04-0.14)	0.12 (0.04-0.16)	0.10 (0.04-0.14)
K	Ferro Fundido Cinzento	Resistência à Tração $\leq 350\text{MPa}$	120 (80-160)	150 (120-180)	140 (110-160)	U1	0.07 (0.06-0.10)	0.07 (0.06-0.10)	0.10 (0.04-0.14)	0.10 (0.06-0.14)	0.10 (0.06-0.14)
						U2	0.07 (0.06-0.10)	0.15 (0.10-0.18)	0.20 (0.10-0.25)	0.20 (0.10-0.25)	0.20 (0.10-0.25)
						U3	-	0.15 (0.10-0.18)	0.20 (0.10-0.25)	0.20 (0.10-0.25)	0.20 (0.10-0.25)
	Ferro Fundido Nodular	Resistência à Tração $\leq 450\text{MPa}$	120 (80-150)	150 (120-180)	100 (80-120)	U1	0.06 (0.04-0.10)	0.07 (0.06-0.10)	0.10 (0.06-0.14)	0.10 (0.06-0.14)	0.10 (0.06-0.14)
						U2	0.06 (0.04-0.10)	0.12 (0.08-0.14)	0.15 (0.08-0.20)	0.18 (0.08-0.20)	0.15 (0.08-0.20)
						U3	-	0.12 (0.08-0.14)	0.15 (0.08-0.20)	0.18 (0.08-0.20)	0.15 (0.08-0.20)

Nota 1) Quando utilizar brocas para L/D= 4, o avanço deve ser reduzido para 80% das recomendações acima.

RESISTÊNCIA DE CORTE

Material : AISI 4140 (220HB) Velocidade de Corte : 150m/min Inserto : Quebra-cavaco U2

