

**DIAMETAL®**

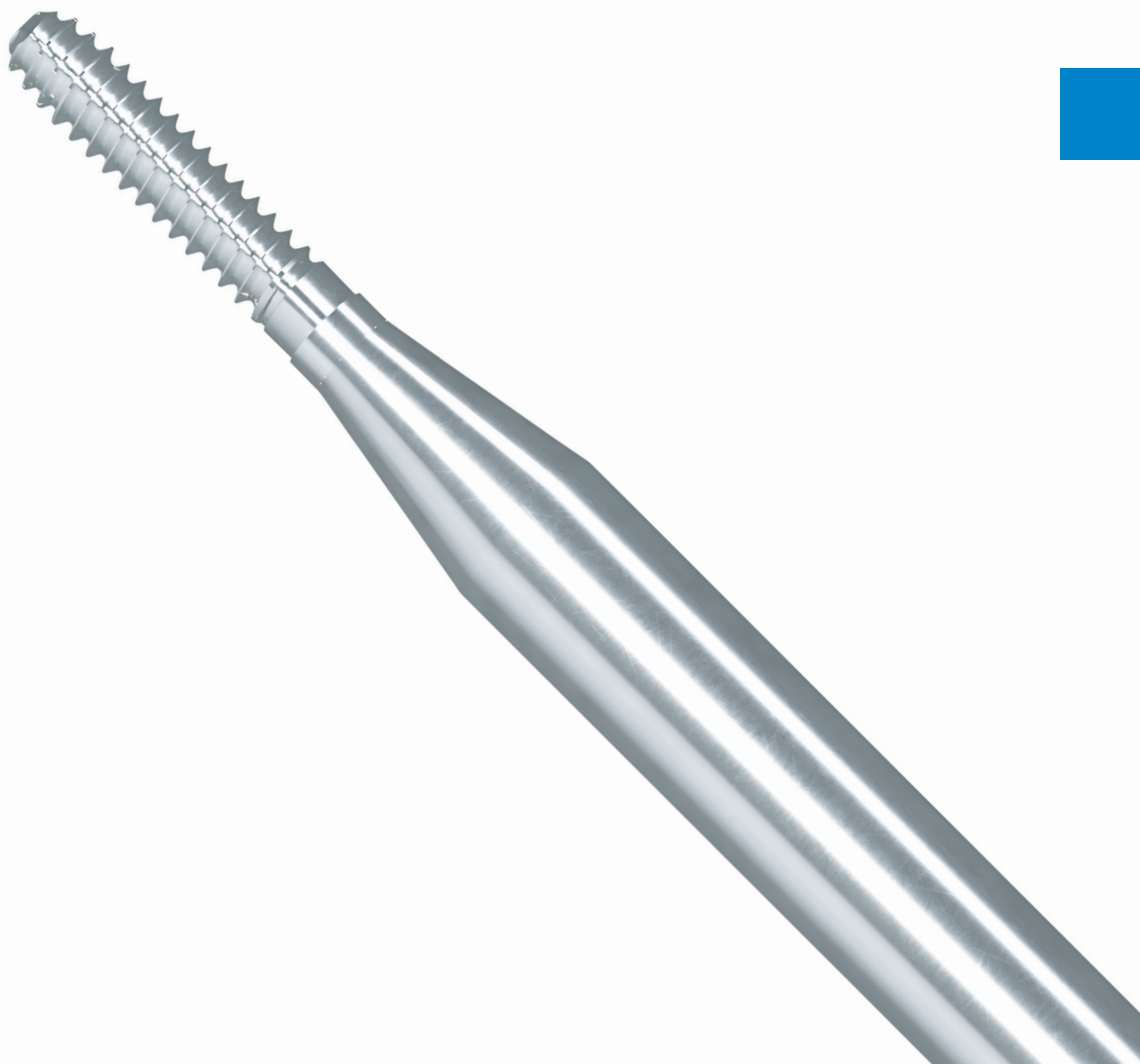
**DIATHREAD**

FR-IT

# DIAtread

Solutions complètes  
pour l'usinage de filets

*Soluzioni complete  
per la lavorazione dei filetti*



# DIAtread

Table des matières  
*Indice dei contenuti*

# DIAtread

Applications  
*Applicazioni*

## TH0342-NR01101 (2.5xD)

Fraise à tourbillonner profil double  
*Fresa per tourbillonage a profilo doppio*

## TH0342-NR01101 (3xD)

Fraise à tourbillonner profil double  
*Fresa per tourbillonage a profilo doppio*

## TH0343-NR01101

Fraise à tourbillonner profil unique  
*Fresa per tourbillonage a profilo unico*

## TH0344-NR01102

Fraise à tourbillonner dent unique  
*Fresa per tourbillonage a dente singolo*

## TH0343-SR04103

Fraise à tourbillonner en céramique  
*Fresa per tourbillonage in ceramica*

## TH0141-SR01101

Taraud helice a droite  
*Maschio elica destra*

## TH0205-SR01101

Taraud refouleur  
*Maschio a rullare*

## DR0101-NR01101

Foret pour DIAtread  
*Punta per DIAtread*

103

104

106

107

110

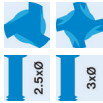
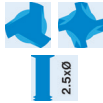
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114

116

118

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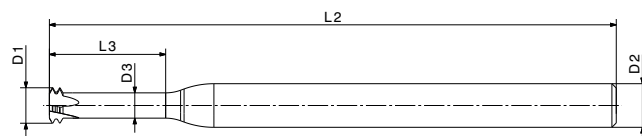
|     |                                                                                         | Outil<br>Utensile                        | Fraise à tourbillonner profil double<br>Fresa per tourbillonage a profilo doppio  | Fraise à tourbillonner profil unique<br>Fresa per tourbillonage a profilo unico     | Fraise à tourbillonner dent unique<br>Fresa per tourbillonage a dente singolo       |
|-----|-----------------------------------------------------------------------------------------|------------------------------------------|-----------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------|
|     |                                                                                         | Géométrie frontale<br>Geometria frontale |                                                                                   |                                                                                     |                                                                                     |
|     |                                                                                         | Nombre de dents<br>Numero di denti       |  |  |  |
|     |                                                                                         | Profondeur<br>Profondità                 |                                                                                   |                                                                                     |                                                                                     |
|     |                                                                                         | Angle d'hélice<br>Angolo dell'elica      |                                                                                   |                                                                                     |                                                                                     |
|     |                                                                                         | Revêtement<br>Rivestimento               | DWS                                                                               | DWS                                                                                 | DWS                                                                                 |
|     |                                                                                         | Codification<br>Codifica                 | TH0342-NR01101                                                                    | TH0343-NR01101                                                                      | TH0344-NR01102                                                                      |
|     |                                                                                         |                                          |  |  |  |
|     |                                                                                         | Pages<br>Pagine                          | 106                                                                               | 110                                                                                 | 112                                                                                 |
| ISO | Matières à usiner<br>Materiali da lavorare                                              |                                          | M 0.80 - 6.00                                                                     | M 0.80 - 6.00<br>S 0.50 - 1.40                                                      | S 0.30 - 0.60                                                                       |
| P1  | Aciers de décolletage<br>Acciai automatici                                              | ▶ ▶ ▶                                    | ▶ ▶ ▶                                                                             | ▶ ▶ ▶                                                                               | ▶ ▶ ▶                                                                               |
| P2  | Aciers de décolletage sans plomb<br>Acciai automatici senza piombo                      | ▶ ▶ ▶                                    | ▶ ▶ ▶                                                                             | ▶ ▶ ▶                                                                               | ▶ ▶ ▶                                                                               |
| P3  | Aciers non alliés (Rm < 800 N/mm²)<br>Acciai non legati (Rm < 800 N/mm²)                | ▶ ▶ ▶                                    | ▶ ▶ ▶                                                                             | ▶ ▶ ▶                                                                               | ▶ ▶ ▶                                                                               |
| P4  | Aciers faiblement alliés (Rm < 900 N/mm²)<br>Acciai debolmente legati (Rm < 900 N/mm²)  | ▶ ▶ ▶                                    | ▶ ▶ ▶                                                                             | ▶ ▶ ▶                                                                               | ▶ ▶                                                                                 |
| P5  | Aciers fortement alliés (Rm < 1200 N/mm²)<br>Acciai fortemente legati (Rm < 1200 N/mm²) | ▶ ▶ ▶                                    | ▶ ▶ ▶                                                                             | ▶ ▶ ▶                                                                               | ▶ ▶                                                                                 |
| M1  | Aciers inoxydables ferritiques<br>Acciai inossidabili ferritici                         | ▶ ▶ ▶                                    | ▶ ▶ ▶                                                                             | ▶ ▶ ▶                                                                               | ▶ ▶                                                                                 |
| M2  | Aciers inoxydables martensitiques<br>Acciai inossidabili martensitici                   | ▶ ▶ ▶                                    | ▶ ▶ ▶                                                                             | ▶ ▶ ▶                                                                               | ▶ ▶                                                                                 |
| M3  | Aciers inoxydables austénitiques<br>Acciai inossidabili austenitici                     | ▶ ▶ ▶                                    | ▶ ▶ ▶                                                                             | ▶ ▶ ▶                                                                               | ▶ ▶                                                                                 |
| K1  | Fontes<br>Ghise                                                                         | ▶ ▶ ▶                                    | ▶ ▶ ▶                                                                             | ▶ ▶ ▶                                                                               | ▶ ▶ ▶                                                                               |
| N1  | Fontes d'aluminium<br>Fusioni d'alluminio                                               | ▶ ▶ ▶                                    | ▶ ▶ ▶                                                                             | ▶ ▶ ▶                                                                               | ▶ ▶ ▶                                                                               |
| N2  | Alliages d'aluminium<br>Leghe d'alluminio                                               | ▶ ▶ ▶                                    | ▶ ▶ ▶                                                                             | ▶ ▶ ▶                                                                               | ▶ ▶ ▶                                                                               |
| N3  | Laiton. Bronze<br>Ottone. Bronzo                                                        | ▶ ▶ ▶                                    | ▶ ▶ ▶                                                                             | ▶ ▶ ▶                                                                               | ▶ ▶ ▶                                                                               |
| N4  | Laiton sans plomb<br>Ottone senza piombo                                                | ▶ ▶ ▶                                    | ▶ ▶ ▶                                                                             | ▶ ▶ ▶                                                                               | ▶ ▶ ▶                                                                               |
| N5  | Cuivre<br>Rame                                                                          | ▶ ▶ ▶                                    | ▶ ▶ ▶                                                                             | ▶ ▶ ▶                                                                               | ▶ ▶ ▶                                                                               |
| N6  | Métaux précieux<br>Metalli preziosi                                                     | ▶ ▶ ▶                                    | ▶ ▶ ▶                                                                             | ▶ ▶ ▶                                                                               | ▶ ▶ ▶                                                                               |
| N7  | Platine. Palladium<br>Platino. Palladio                                                 | ▶ ▶ ▶                                    | ▶ ▶ ▶                                                                             | ▶ ▶ ▶                                                                               | ▶ ▶ ▶                                                                               |
| N8  | Matières plastiques<br>Materiali plastici                                               | ▶ ▶ ▶                                    | ▶ ▶ ▶                                                                             | ▶ ▶ ▶                                                                               | ▶ ▶ ▶                                                                               |
| S1  | Titane pur<br>Titanio puro                                                              | ▶ ▶ ▶                                    | ▶ ▶ ▶                                                                             | ▶ ▶ ▶                                                                               | ▶ ▶                                                                                 |
| S2  | Alliages de titane<br>Leghe di titanio                                                  | ▶ ▶ ▶                                    | ▶ ▶ ▶                                                                             | ▶ ▶ ▶                                                                               | ▶ ▶                                                                                 |
| S3  | Superalliages (Cr. Co. Ni)<br>Superleghe (Cr. Co. Ni)                                   | ▶ ▶ ▶                                    | ▶ ▶ ▶                                                                             | ▶ ▶ ▶                                                                               | ▶                                                                                   |
| H1  | Aciers trempés (< 55 HRC)<br>Acciai temprati (< 55 HRC)                                 | ▶ ▶                                      | ▶ ▶                                                                               | ▶                                                                                   |                                                                                     |
| H2  | Aciers trempés (> 55 HRC)<br>Acciai temprati (> 55 HRC)                                 |                                          |                                                                                   |                                                                                     |                                                                                     |

▶ ▶ ▶ Optimal / Scelta eccellente ▶ ▶ Bon / Buona scelta ▶ Fonctionnel / Scelta funzionale

100

# TH0342-NR01101 (2.5xD)

Fraise à tourbillonner profil double  
Fresa per tourbillonage a profilo doppio



| M    | P     | D1<br>±0.01 | L3    | D2 | L2 | D3   | Z |  | Art. N°       | DWS<br>Art. N° |
|------|-------|-------------|-------|----|----|------|---|-------------------------------------------------------------------------------------|---------------|----------------|
| 0.80 | 0.200 | 0.58        | 2.20  | 3  | 39 | 0.30 | 3 | 0.66                                                                                | <b>439792</b> | <b>439662</b>  |
| 0.90 | 0.225 | 0.65        | 2.50  | 3  | 39 | 0.33 | 3 | 0.74                                                                                | <b>439793</b> | <b>439728</b>  |
| 1.00 | 0.250 | 0.72        | 2.80  | 3  | 39 | 0.37 | 3 | 0.75                                                                                | <b>439794</b> | <b>439729</b>  |
| 1.20 | 0.250 | 0.92        | 3.30  | 3  | 39 | 0.57 | 3 | 0.95                                                                                | <b>439796</b> | <b>439730</b>  |
| 1.40 | 0.300 | 1.06        | 3.80  | 3  | 39 | 0.64 | 3 | 1.10                                                                                | <b>439798</b> | <b>439731</b>  |
| 1.60 | 0.350 | 1.21        | 4.40  | 3  | 39 | 0.72 | 3 | 1.30                                                                                | <b>439800</b> | <b>439732</b>  |
| 1.80 | 0.350 | 1.41        | 4.90  | 3  | 39 | 0.92 | 3 | 1.50                                                                                | <b>439801</b> | <b>439733</b>  |
| 2.00 | 0.200 | 1.78        | 5.20  | 3  | 39 | 1.50 | 3 | 1.80                                                                                | <b>443383</b> | <b>443327</b>  |
| 2.00 | 0.250 | 1.72        | 5.30  | 3  | 39 | 1.37 | 3 | 1.75                                                                                | <b>443382</b> | <b>443328</b>  |
| 2.00 | 0.400 | 1.55        | 5.40  | 3  | 39 | 0.99 | 3 | 1.65                                                                                | <b>439802</b> | <b>439734</b>  |
| 2.30 | 0.400 | 1.85        | 6.20  | 3  | 39 | 1.29 | 3 | 1.90                                                                                | <b>439803</b> | <b>439735</b>  |
| 2.50 | 0.200 | 2.28        | 6.50  | 3  | 39 | 2.00 | 3 | 2.30                                                                                | <b>443385</b> | <b>443329</b>  |
| 2.50 | 0.250 | 2.22        | 6.50  | 3  | 39 | 1.87 | 3 | 2.25                                                                                | <b>443384</b> | <b>443330</b>  |
| 2.50 | 0.450 | 2.00        | 6.70  | 3  | 39 | 1.37 | 3 | 2.10                                                                                | <b>439804</b> | <b>439736</b>  |
| 2.60 | 0.450 | 2.10        | 7.00  | 3  | 39 | 1.47 | 3 | 2.15                                                                                | <b>439805</b> | <b>439738</b>  |
| 3.00 | 0.350 | 2.61        | 7.90  | 3  | 39 | 2.12 | 4 | 2.65                                                                                | <b>443386</b> | <b>443331</b>  |
| 3.00 | 0.500 | 2.44        | 8.00  | 3  | 39 | 1.74 | 4 | 2.55                                                                                | <b>439806</b> | <b>439739</b>  |
| 3.50 | 0.600 | 2.82        | 9.40  | 5  | 51 | 1.98 | 4 | 2.90                                                                                | <b>443387</b> | <b>443342</b>  |
| 4.00 | 0.500 | 3.43        | 10.50 | 5  | 51 | 2.73 | 4 | 3.50                                                                                | <b>443389</b> | <b>443343</b>  |
| 4.00 | 0.700 | 3.20        | 10.70 | 5  | 51 | 2.22 | 4 | 3.30                                                                                | <b>443388</b> | <b>443344</b>  |
| 5.00 | 0.500 | 4.43        | 13.00 | 5  | 51 | 3.73 | 4 | 4.50                                                                                | <b>443391</b> | <b>443345</b>  |
| 5.00 | 0.800 | 4.09        | 13.30 | 5  | 51 | 2.97 | 4 | 4.20                                                                                | <b>443390</b> | <b>443346</b>  |
| 6.00 | 0.750 | 4.95        | 15.80 | 5  | 51 | 3.90 | 4 | 5.30                                                                                | <b>443393</b> | <b>443347</b>  |
| 6.00 | 1.000 | 4.86        | 16.00 | 5  | 51 | 3.46 | 4 | 5.00                                                                                | <b>443392</b> | <b>443348</b>  |

Autres dimensions et revêtements sur demande  
Altre dimensioni e rivestimenti su richiesta

# TH0342-NR01101 (3xD)

Fraise à tourbillonner profil double  
Fresa per tourbillonage a profilo doppio



|    |    |    |    |    |    |    |    |    |    |    |
|----|----|----|----|----|----|----|----|----|----|----|
| P1 | P2 | P3 | P4 | P5 | M1 | M2 | M3 | K1 | N1 | N2 |
| N3 | N4 | N5 | N6 | N7 | N8 | S1 | S2 | S3 | H1 |    |



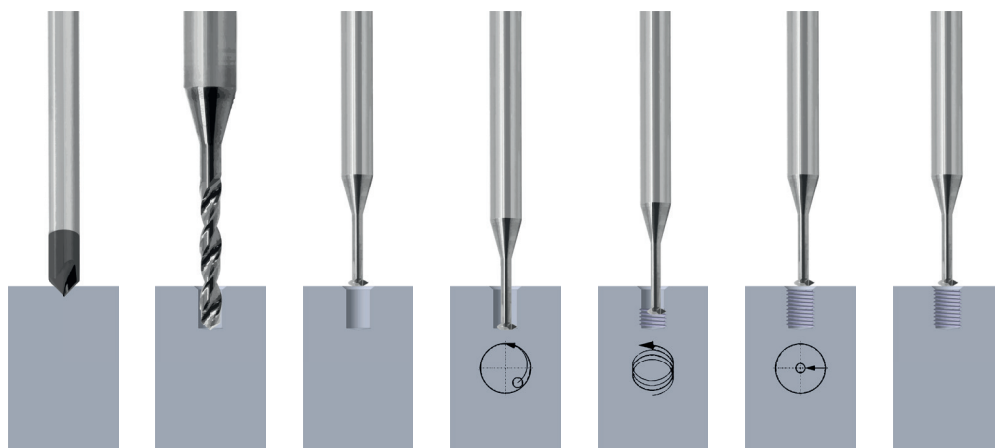
| M    | P     | D1<br>±0.01 | L3    | D2 | L2 | D3   | Z |  | Art. N°       | DWS<br>Art. N° |
|------|-------|-------------|-------|----|----|------|---|-------------------------------------------------------------------------------------|---------------|----------------|
| 0.80 | 0.200 | 0.58        | 2.60  | 3  | 39 | 0.30 | 3 | 0.66                                                                                | <b>439792</b> | <b>439745</b>  |
| 0.90 | 0.225 | 0.65        | 3.00  | 3  | 39 | 0.33 | 3 | 0.74                                                                                | <b>439793</b> | <b>439746</b>  |
| 1.00 | 0.250 | 0.72        | 3.30  | 3  | 39 | 0.37 | 3 | 0.75                                                                                | <b>439794</b> | <b>439747</b>  |
| 1.20 | 0.250 | 0.92        | 3.90  | 3  | 39 | 0.57 | 3 | 0.95                                                                                | <b>439796</b> | <b>439748</b>  |
| 1.40 | 0.300 | 1.06        | 4.50  | 3  | 39 | 0.64 | 3 | 1.10                                                                                | <b>439798</b> | <b>439749</b>  |
| 1.60 | 0.350 | 1.21        | 5.20  | 3  | 39 | 0.72 | 3 | 1.30                                                                                | <b>439800</b> | <b>439750</b>  |
| 1.80 | 0.350 | 1.41        | 5.80  | 3  | 39 | 0.92 | 3 | 1.50                                                                                | <b>439801</b> | <b>439751</b>  |
| 2.00 | 0.200 | 1.78        | 5.20  | 3  | 39 | 1.50 | 3 | 1.80                                                                                | <b>443383</b> | <b>443332</b>  |
| 2.00 | 0.250 | 1.72        | 5.30  | 3  | 39 | 1.37 | 3 | 1.75                                                                                | <b>443382</b> | <b>443333</b>  |
| 2.00 | 0.400 | 1.55        | 6.40  | 3  | 39 | 0.99 | 3 | 1.65                                                                                | <b>439802</b> | <b>439752</b>  |
| 2.30 | 0.400 | 1.85        | 7.30  | 3  | 39 | 1.29 | 3 | 1.90                                                                                | <b>439803</b> | <b>439753</b>  |
| 2.50 | 0.200 | 2.28        | 7.70  | 3  | 39 | 2.00 | 3 | 2.30                                                                                | <b>443385</b> | <b>443334</b>  |
| 2.50 | 0.250 | 2.22        | 7.80  | 3  | 39 | 1.87 | 3 | 2.25                                                                                | <b>443384</b> | <b>443335</b>  |
| 2.50 | 0.450 | 2.00        | 8.00  | 3  | 39 | 1.37 | 3 | 2.10                                                                                | <b>439804</b> | <b>439754</b>  |
| 2.60 | 0.450 | 2.10        | 8.30  | 3  | 39 | 1.47 | 3 | 2.15                                                                                | <b>439805</b> | <b>439755</b>  |
| 3.00 | 0.350 | 2.61        | 9.40  | 3  | 39 | 2.12 | 4 | 2.65                                                                                | <b>443386</b> | <b>443336</b>  |
| 3.00 | 0.500 | 2.44        | 9.50  | 3  | 39 | 1.74 | 4 | 2.55                                                                                | <b>439806</b> | <b>439756</b>  |
| 3.50 | 0.600 | 2.82        | 11.10 | 5  | 51 | 1.98 | 4 | 2.90                                                                                | <b>443387</b> | <b>443349</b>  |
| 4.00 | 0.500 | 3.43        | 12.50 | 5  | 51 | 2.73 | 4 | 3.50                                                                                | <b>443389</b> | <b>443350</b>  |
| 4.00 | 0.700 | 3.20        | 12.70 | 5  | 51 | 2.22 | 4 | 3.30                                                                                | <b>443388</b> | <b>443351</b>  |
| 5.00 | 0.500 | 4.43        | 15.50 | 5  | 51 | 3.73 | 4 | 4.50                                                                                | <b>443391</b> | <b>443352</b>  |
| 5.00 | 0.800 | 4.09        | 15.80 | 5  | 51 | 2.97 | 4 | 4.20                                                                                | <b>443390</b> | <b>443353</b>  |
| 6.00 | 0.750 | 4.95        | 18.80 | 5  | 51 | 3.90 | 4 | 5.30                                                                                | <b>443393</b> | <b>443354</b>  |
| 6.00 | 1.000 | 4.86        | 19.00 | 5  | 51 | 3.46 | 4 | 5.00                                                                                | <b>443392</b> | <b>443355</b>  |

Autres dimensions et revêtements sur demande  
Altre dimensioni e rivestimenti su richiesta

# TH0342-NR01101

Paramètres de coupe  
Parametri di taglio

Processus d'usinage  
Processo di lavorazione



|     |                        | f <sub>z</sub> [mm] |               |               |               |
|-----|------------------------|---------------------|---------------|---------------|---------------|
| ISO | V <sub>c</sub> [m/min] | Ø 0.30 - 0.80       | Ø 0.81 - 1.20 | Ø 1.21 - 3.00 | Ø 3.01 - 6.00 |
| P1  | 80 - 110               | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| P2  | 80 - 110               | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| P3  | 60 - 90                | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| P4  | 60 - 80                | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.040 - 0.080 |
| P5  | 40 - 60                | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.040 - 0.080 |
| M1  | 40 - 60                | 0.003 - 0.008       | 0.008 - 0.020 | 0.020 - 0.045 | 0.030 - 0.050 |
| M2  | 40 - 60                | 0.003 - 0.008       | 0.008 - 0.020 | 0.020 - 0.045 | 0.030 - 0.050 |
| M3  | 40 - 60                | 0.003 - 0.008       | 0.008 - 0.020 | 0.020 - 0.045 | 0.030 - 0.050 |
| K1  | 90 - 120               | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N1  | 220 - 280              | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N2  | 220 - 280              | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N3  | 200 - 250              | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N4  | 200 - 250              | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N5  | 200 - 250              | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N6  | 70 - 110               | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N7  | 70 - 110               | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N8  | 150 - 220              | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| S1  | 30 - 50                | 0.003 - 0.008       | 0.008 - 0.015 | 0.015 - 0.030 | 0.020 - 0.040 |
| S2  | 15 - 35                | 0.003 - 0.008       | 0.008 - 0.015 | 0.015 - 0.030 | 0.020 - 0.040 |
| S3  | 30 - 50                | 0.003 - 0.008       | 0.008 - 0.015 | 0.015 - 0.030 | 0.020 - 0.040 |
| H1  | 20 - 40                | 0.003 - 0.008       | 0.008 - 0.015 | 0.015 - 0.030 | 0.015 - 0.030 |
| H2  |                        |                     |               |               |               |

Valeurs indicatives  
Valori indicativi

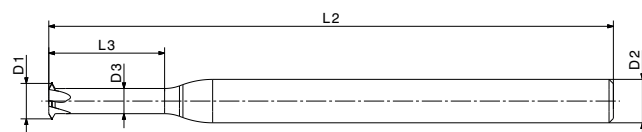
# TH0343-NR01101

Fraise à tourbillonner profil unique  
Fresa per tourbillonage a profilo unico



|    |    |    |    |    |    |    |    |    |    |    |
|----|----|----|----|----|----|----|----|----|----|----|
| P1 | P2 | P3 | P4 | P5 | M1 | M2 | M3 | K1 | N1 | N2 |
| N3 | N4 | N5 | N6 | N7 | N8 | S1 | S2 | S3 | H1 |    |

|     |    |  |  |  |        |        |       |  |
|-----|----|--|--|--|--------|--------|-------|--|
| VHM | h5 |  |  |  | DIN 13 | DIN 14 | 2.5xØ |  |
|-----|----|--|--|--|--------|--------|-------|--|



| M    | P     | D1<br>±0.01 | L3    | D2 | L2 | D3   | Z |      | Art. N° | DWS<br>Art. N° |
|------|-------|-------------|-------|----|----|------|---|------|---------|----------------|
| 0.80 | 0.200 | 0.58        | 2.20  | 3  | 39 | 0.30 | 3 | 0.66 | 439792  | 439681         |
| 0.90 | 0.225 | 0.65        | 2.50  | 3  | 39 | 0.33 | 3 | 0.74 | 439793  | 439762         |
| 1.00 | 0.250 | 0.72        | 2.80  | 3  | 39 | 0.37 | 3 | 0.75 | 439794  | 439763         |
| 1.20 | 0.250 | 0.92        | 3.30  | 3  | 39 | 0.57 | 3 | 0.95 | 439796  | 439764         |
| 1.40 | 0.300 | 1.06        | 3.80  | 3  | 39 | 0.64 | 3 | 1.10 | 439798  | 439765         |
| 1.60 | 0.350 | 1.21        | 4.40  | 3  | 39 | 0.72 | 3 | 1.30 | 439800  | 439766         |
| 1.80 | 0.350 | 1.41        | 4.90  | 3  | 39 | 0.92 | 3 | 1.50 | 439801  | 439767         |
| 2.00 | 0.400 | 1.55        | 5.40  | 3  | 39 | 0.99 | 3 | 1.65 | 439802  | 439768         |
| 2.30 | 0.400 | 1.85        | 6.20  | 3  | 39 | 1.29 | 3 | 1.90 | 439803  | 439769         |
| 2.50 | 0.450 | 2.00        | 6.70  | 3  | 39 | 1.37 | 3 | 2.10 | 439804  | 439770         |
| 2.60 | 0.450 | 2.10        | 7.00  | 3  | 39 | 1.47 | 3 | 2.15 | 439805  | 439771         |
| 3.00 | 0.500 | 2.44        | 8.00  | 3  | 39 | 1.74 | 4 | 2.55 | 439806  | 443369         |
| 3.50 | 0.600 | 2.82        | 9.40  | 5  | 51 | 1.98 | 4 | 2.90 | 443387  | 443371         |
| 4.00 | 0.700 | 3.20        | 10.70 | 5  | 51 | 2.22 | 4 | 3.30 | 443388  | 443372         |
| 5.00 | 0.800 | 4.09        | 13.30 | 5  | 51 | 2.97 | 4 | 4.20 | 443390  | 443373         |
| 6.00 | 1.000 | 4.86        | 16.00 | 5  | 51 | 3.46 | 4 | 5.00 | 443392  | 443374         |

|     |    |  |  |  |      |       |  |
|-----|----|--|--|--|------|-------|--|
| VHM | h5 |  |  |  | NIHS | 2.5xØ |  |
|-----|----|--|--|--|------|-------|--|

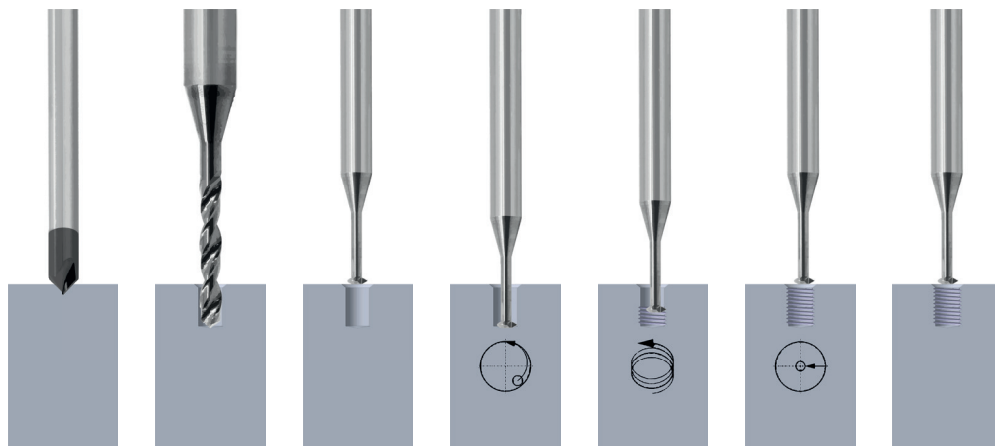
| S    | P     | D1<br>±0.01 | L3   | D2 | L2 | D3   | Z |      | Art. N° | DWS<br>Art. N° |
|------|-------|-------------|------|----|----|------|---|------|---------|----------------|
| 0.50 | 0.125 | 0.36        | 1.40 | 3  | 39 | 0.19 | 3 | 0.41 | 439789  | 439772         |
| 0.60 | 0.150 | 0.43        | 1.70 | 3  | 39 | 0.22 | 3 | 0.50 | 439790  | 439773         |
| 0.70 | 0.175 | 0.50        | 2.00 | 3  | 39 | 0.26 | 3 | 0.58 | 439791  | 439774         |
| 0.80 | 0.200 | 0.58        | 2.20 | 3  | 39 | 0.30 | 3 | 0.66 | 439792  | 439775         |
| 0.90 | 0.225 | 0.65        | 2.50 | 3  | 39 | 0.33 | 3 | 0.74 | 439793  | 439776         |
| 1.00 | 0.250 | 0.72        | 2.80 | 3  | 39 | 0.37 | 3 | 0.82 | 439795  | 439777         |
| 1.20 | 0.250 | 0.92        | 3.30 | 3  | 39 | 0.57 | 3 | 1.02 | 439797  | 439778         |
| 1.40 | 0.300 | 1.06        | 3.80 | 3  | 39 | 0.64 | 3 | 1.18 | 439799  | 439779         |

Autres dimensions et revêtements sur demande  
Altre dimensioni e rivestimenti su richiesta

# TH0343-NR01101

Paramètres de coupe  
Parametri di taglio

Processus d'usinage  
Processo di lavorazione



|     |                        | f <sub>z</sub> [mm] |               |               |               |
|-----|------------------------|---------------------|---------------|---------------|---------------|
| ISO | V <sub>c</sub> [m/min] | Ø 0.30 - 0.80       | Ø 0.81 - 1.20 | Ø 1.21 - 3.00 | Ø 3.01 - 6.00 |
| P1  | 80 - 110               | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| P2  | 80 - 110               | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| P3  | 60 - 90                | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| P4  | 60 - 80                | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.040 - 0.080 |
| P5  | 40 - 60                | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.040 - 0.080 |
| M1  | 40 - 60                | 0.003 - 0.008       | 0.008 - 0.020 | 0.020 - 0.045 | 0.030 - 0.050 |
| M2  | 40 - 60                | 0.003 - 0.008       | 0.008 - 0.020 | 0.020 - 0.045 | 0.030 - 0.050 |
| M3  | 40 - 60                | 0.003 - 0.008       | 0.008 - 0.020 | 0.020 - 0.045 | 0.030 - 0.050 |
| K1  | 90 - 120               | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N1  | 220 - 280              | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N2  | 220 - 280              | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N3  | 200 - 250              | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N4  | 200 - 250              | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N5  | 200 - 250              | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N6  | 70 - 110               | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N7  | 70 - 110               | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N8  | 150 - 220              | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| S1  | 30 - 50                | 0.003 - 0.008       | 0.008 - 0.015 | 0.015 - 0.030 | 0.020 - 0.040 |
| S2  | 15 - 35                | 0.003 - 0.008       | 0.008 - 0.015 | 0.015 - 0.030 | 0.020 - 0.040 |
| S3  | 30 - 50                | 0.003 - 0.008       | 0.008 - 0.015 | 0.015 - 0.030 | 0.020 - 0.040 |
| H1  | 20 - 40                | 0.003 - 0.008       | 0.008 - 0.015 | 0.015 - 0.030 | 0.015 - 0.030 |
| H2  |                        |                     |               |               |               |

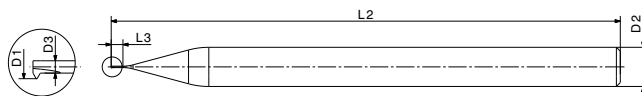
Valeurs indicatives  
Valori indicativi

# TH0344-NR01102

Fraise à tourbillonner dent unique  
Fresa per tourbillonage a dente singolo



|    |    |    |    |    |    |    |    |    |    |    |
|----|----|----|----|----|----|----|----|----|----|----|
| P1 | P2 | P3 | P4 | P5 | M1 | M2 | M3 | K1 | N1 | N2 |
| N3 | N4 | N5 | N6 | N7 | N8 | S1 | S2 | S3 |    |    |



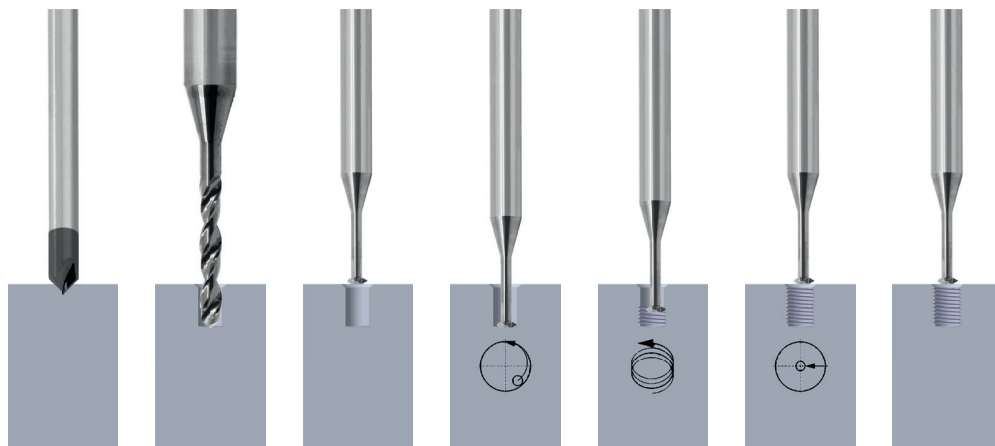
| S    | P     | D1<br>±0.005 | L3   | D2 | L2 | D3   | Z |      | Art. N°       | DWS<br>Art. N° |
|------|-------|--------------|------|----|----|------|---|------|---------------|----------------|
| 0.30 | 0.080 | 0.21         | 0.90 | 3  | 39 | 0.11 | 1 | 0.23 | <b>439665</b> | <b>439682</b>  |
| 0.35 | 0.090 | 0.25         | 1.00 | 3  | 39 | 0.13 | 1 | 0.28 | <b>439787</b> | <b>439780</b>  |
| 0.40 | 0.100 | 0.29         | 1.10 | 3  | 39 | 0.16 | 1 | 0.32 | <b>439788</b> | <b>439781</b>  |
| 0.50 | 0.125 | 0.36         | 1.40 | 3  | 39 | 0.20 | 1 | 0.41 | <b>439789</b> | <b>439782</b>  |
| 0.60 | 0.150 | 0.43         | 1.70 | 3  | 39 | 0.24 | 1 | 0.50 | <b>439790</b> | <b>439783</b>  |

Autres dimensions et revêtements sur demande  
Altre dimensioni e rivestimenti su richiesta

# TH0344-NR01101

Paramètres de coupe  
Parametri di taglio

Processus d'usinage  
Processo di lavorazione



| ISO | V <sub>c</sub> [m/min] | f <sub>z</sub> [mm] |               |               |               |
|-----|------------------------|---------------------|---------------|---------------|---------------|
|     |                        | Ø 0.30 - 0.80       | Ø 0.81 - 1.20 | Ø 1.21 - 3.00 | Ø 3.01 - 6.00 |
| P1  | 80 - 110               | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| P2  | 80 - 110               | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| P3  | 60 - 90                | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| P4  | 60 - 80                | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.040 - 0.080 |
| P5  | 40 - 60                | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.040 - 0.080 |
| M1  | 40 - 60                | 0.003 - 0.008       | 0.008 - 0.020 | 0.020 - 0.045 | 0.030 - 0.050 |
| M2  | 40 - 60                | 0.003 - 0.008       | 0.008 - 0.020 | 0.020 - 0.045 | 0.030 - 0.050 |
| M3  | 40 - 60                | 0.003 - 0.008       | 0.008 - 0.020 | 0.020 - 0.045 | 0.030 - 0.050 |
| K1  | 90 - 120               | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N1  | 220 - 280              | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N2  | 220 - 280              | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N3  | 200 - 250              | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N4  | 200 - 250              | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N5  | 200 - 250              | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N6  | 70 - 110               | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N7  | 70 - 110               | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| N8  | 150 - 220              | 0.004 - 0.009       | 0.009 - 0.025 | 0.025 - 0.050 | 0.050 - 0.100 |
| S1  | 30 - 50                | 0.003 - 0.008       | 0.008 - 0.015 | 0.015 - 0.030 | 0.020 - 0.040 |
| S2  | 15 - 35                | 0.003 - 0.008       | 0.008 - 0.015 | 0.015 - 0.030 | 0.020 - 0.040 |
| S3  | 30 - 50                | 0.003 - 0.008       | 0.008 - 0.015 | 0.015 - 0.030 | 0.020 - 0.040 |
| H1  | 20 - 40                | 0.003 - 0.008       | 0.008 - 0.015 | 0.015 - 0.030 | 0.015 - 0.030 |
| H2  |                        |                     |               |               |               |

Valeurs indicatives  
Valori indicativi

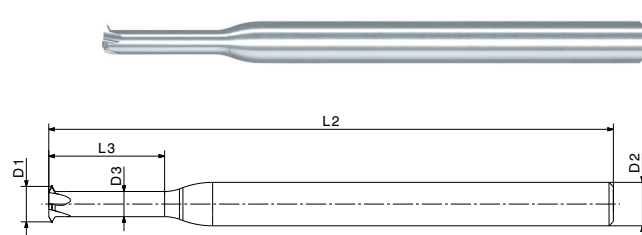
# TH0343-SR04103

Fraise à tourbillonner en céramique  
Fresa per tourbillonage in ceramica



K1 N1 N2

N3 N4 N5 N6 N7 N8



| M    | P     | D1<br>±0.005 | L3    | D2 | L2 | D3   | Z |  | Art. N° | Cer<br>Art. N° |
|------|-------|--------------|-------|----|----|------|---|-------------------------------------------------------------------------------------|---------|----------------|
| 1.60 | 0.350 | 1.21         | 4.40  | 3  | 39 | 0.72 | 3 | 1.30                                                                                | 439800  | 443762         |
| 1.80 | 0.350 | 1.41         | 4.90  | 3  | 39 | 0.92 | 3 | 1.50                                                                                | 439801  | 443763         |
| 2.00 | 0.400 | 1.55         | 5.40  | 3  | 39 | 0.99 | 3 | 1.65                                                                                | 439802  | 443764         |
| 2.30 | 0.400 | 1.85         | 6.20  | 3  | 39 | 1.29 | 3 | 1.90                                                                                | 439803  | 443765         |
| 2.50 | 0.450 | 2.00         | 6.70  | 3  | 39 | 1.37 | 3 | 2.10                                                                                | 439804  | 443766         |
| 2.60 | 0.450 | 2.10         | 7.00  | 3  | 39 | 1.47 | 3 | 2.15                                                                                | 439805  | 443767         |
| 3.00 | 0.500 | 2.44         | 8.00  | 3  | 39 | 1.74 | 4 | 2.55                                                                                | 439806  | 443768         |
| 3.50 | 0.600 | 2.82         | 9.40  | 5  | 51 | 1.98 | 4 | 2.90                                                                                | 443387  | 443769         |
| 4.00 | 0.700 | 3.20         | 10.70 | 5  | 51 | 2.22 | 4 | 3.30                                                                                | 443388  | 443770         |
| 5.00 | 0.800 | 4.09         | 13.30 | 5  | 51 | 2.97 | 4 | 4.20                                                                                | 443390  | 443771         |
| 6.00 | 1.000 | 4.86         | 16.00 | 5  | 51 | 3.46 | 4 | 5.00                                                                                | 443392  | 443772         |



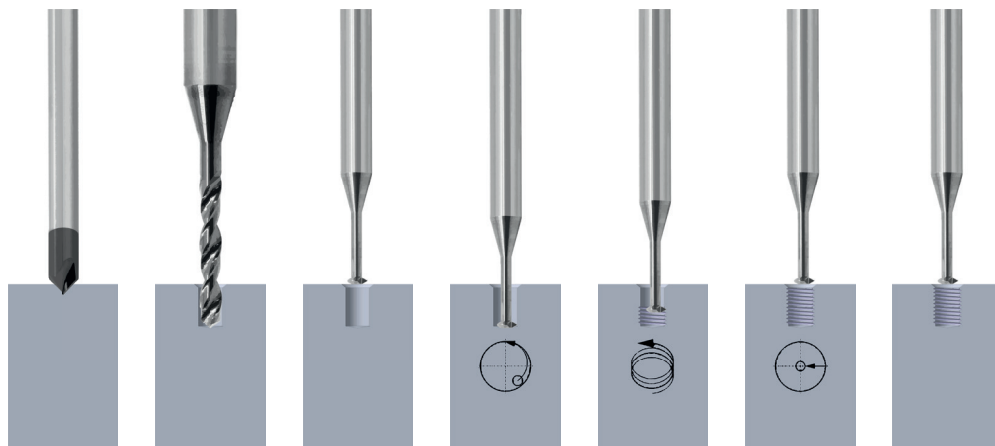
| S    | P     | D1<br>±0.005 | L3   | D2 | L2 | D3   | Z |  | Art. N° | Cer<br>Art. N° |
|------|-------|--------------|------|----|----|------|---|---------------------------------------------------------------------------------------|---------|----------------|
| 0.50 | 0.125 | 0.36         | 1.40 | 3  | 39 | 0.19 | 3 | 0.41                                                                                  | 439789  | 440551         |
| 0.60 | 0.150 | 0.43         | 1.70 | 3  | 39 | 0.22 | 3 | 0.50                                                                                  | 439790  | 440552         |
| 0.70 | 0.175 | 0.50         | 2.00 | 3  | 39 | 0.26 | 3 | 0.58                                                                                  | 439791  | 440553         |
| 0.80 | 0.200 | 0.58         | 2.20 | 3  | 39 | 0.30 | 3 | 0.66                                                                                  | 439792  | 440554         |
| 0.90 | 0.225 | 0.65         | 2.50 | 3  | 39 | 0.33 | 3 | 0.74                                                                                  | 439793  | 440555         |
| 1.00 | 0.250 | 0.72         | 2.80 | 3  | 39 | 0.37 | 3 | 0.82                                                                                  | 439795  | 440556         |
| 1.20 | 0.250 | 0.92         | 3.30 | 3  | 39 | 0.57 | 3 | 1.02                                                                                  | 439797  | 440557         |
| 1.40 | 0.300 | 1.06         | 3.80 | 3  | 39 | 0.64 | 3 | 1.18                                                                                  | 439799  | 440558         |

Autres dimensions et revêtements sur demande  
Altre dimensioni e rivestimenti su richiesta

# TH0343-SR04102

Paramètres de coupe  
Parametri di taglio

Processus d'usinage  
Processo di lavorazione



|     |                        | f <sub>z</sub> [mm] |               |               |
|-----|------------------------|---------------------|---------------|---------------|
| ISO | V <sub>c</sub> [m/min] | Ø 0.50 - 1.40       | Ø 1.41 - 3.50 | Ø 3.51 - 6.00 |
| P1  |                        |                     |               |               |
| P2  |                        |                     |               |               |
| P3  |                        |                     |               |               |
| P4  |                        |                     |               |               |
| P5  |                        |                     |               |               |
| M1  |                        |                     |               |               |
| M2  |                        |                     |               |               |
| M3  |                        |                     |               |               |
| K1  | 150 - 200              | 0.009 - 0.025       | 0.025 - 0.050 | 0.050 - 0.100 |
| N1  | 220 - 300              | 0.009 - 0.025       | 0.025 - 0.050 | 0.050 - 0.100 |
| N2  | 220 - 300              | 0.009 - 0.025       | 0.025 - 0.050 | 0.050 - 0.100 |
| N3  | 250 - 300              | 0.009 - 0.025       | 0.025 - 0.050 | 0.050 - 0.100 |
| N4  | 220 - 300              | 0.009 - 0.025       | 0.025 - 0.050 | 0.050 - 0.100 |
| N5  | 200 - 250              | 0.009 - 0.025       | 0.025 - 0.050 | 0.050 - 0.100 |
| N6  | 100 - 150              | 0.009 - 0.025       | 0.025 - 0.050 | 0.050 - 0.100 |
| N7  | 100 - 150              | 0.009 - 0.025       | 0.025 - 0.050 | 0.050 - 0.100 |
| N8  | 150 - 220              | 0.009 - 0.025       | 0.025 - 0.050 | 0.050 - 0.100 |
| S1  |                        |                     |               |               |
| S2  |                        |                     |               |               |
| S3  |                        |                     |               |               |
| H1  |                        |                     |               |               |
| H2  |                        |                     |               |               |

Valeurs indicatives  
Valori indicativi

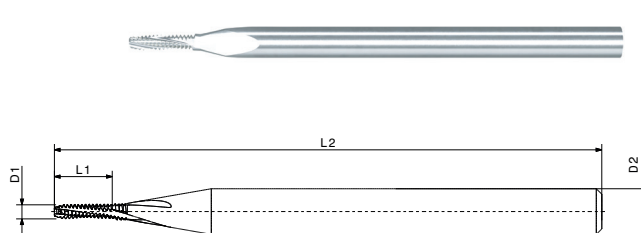
# TH0141-SR01101

Taraud helice a droite  
Maschio elica destra



K1 N1 N2

N3 N4 N5 N6 N7 N8



| M    | P     | D1   | L1    | D2  | L2 | Z | Tolérance<br>Tolleranza |      | Art. N° | DWS<br>Art. N° |
|------|-------|------|-------|-----|----|---|-------------------------|------|---------|----------------|
| 0.30 | 0.080 | 0.30 | 1.10  | 1.5 | 32 | 3 | 4H                      | 0.23 | 439665  | 455824         |
| 0.35 | 0.090 | 0.35 | 1.30  | 1.5 | 32 | 3 | 4H                      | 0.28 | 439787  | 455825         |
| 0.40 | 0.100 | 0.40 | 1.50  | 1.5 | 32 | 3 | 4H                      | 0.32 | 439788  | 455826         |
| 0.50 | 0.125 | 0.50 | 1.90  | 1.5 | 32 | 3 | 4H                      | 0.41 | 439789  | 455827         |
| 0.60 | 0.150 | 0.60 | 2.30  | 1.5 | 32 | 3 | 4H                      | 0.50 | 439790  | 455828         |
| 0.70 | 0.175 | 0.70 | 2.60  | 1.5 | 32 | 3 | 4H                      | 0.58 | 439791  | 455829         |
| 0.80 | 0.200 | 0.80 | 3.00  | 1.5 | 32 | 3 | 4H                      | 0.66 | 439792  | 455830         |
| 0.90 | 0.225 | 0.90 | 3.40  | 1.5 | 32 | 3 | 4H                      | 0.74 | 439793  | 455831         |
| 1.00 | 0.250 | 1.00 | 3.80  | 2.0 | 32 | 3 | 4H                      | 0.75 | 439794  | 455832         |
| 1.20 | 0.250 | 1.20 | 4.50  | 2.0 | 32 | 3 | 4H                      | 0.95 | 439796  | 455833         |
| 1.40 | 0.300 | 1.40 | 5.30  | 2.0 | 32 | 3 | 4H                      | 1.10 | 439798  | 455834         |
| 1.60 | 0.350 | 1.60 | 6.00  | 2.0 | 32 | 3 | 6H                      | 1.25 | 456100  | 455835         |
| 1.80 | 0.350 | 1.80 | 6.80  | 2.0 | 32 | 3 | 6H                      | 1.25 | 456101  | 455836         |
| 2.00 | 0.400 | 2.00 | 7.50  | 3.0 | 39 | 3 | 6H                      | 1.60 | 439802  | 455837         |
| 2.30 | 0.400 | 2.30 | 8.60  | 3.0 | 39 | 3 | 6H                      | 1.90 | 439803  | 455838         |
| 2.50 | 0.450 | 2.50 | 9.40  | 3.0 | 39 | 3 | 6H                      | 2.10 | 439804  | 455839         |
| 2.60 | 0.450 | 2.60 | 9.80  | 3.0 | 39 | 3 | 6H                      | 2.15 | 439805  | 455840         |
| 3.00 | 0.500 | 3.00 | 11.30 | 4.0 | 51 | 3 | 6H                      | 2.55 | 439806  | 455841         |



| S    | P     | D1   | L1   | D2  | L2 | Z |      | Art. N° | DWS<br>Art. N° |
|------|-------|------|------|-----|----|---|------|---------|----------------|
| 0.30 | 0.080 | 0.30 | 1.10 | 1.5 | 32 | 3 | 0.23 | 439665  | 455842         |
| 0.35 | 0.090 | 0.35 | 1.30 | 1.5 | 32 | 3 | 0.28 | 439787  | 455843         |
| 0.40 | 0.100 | 0.40 | 1.50 | 1.5 | 32 | 3 | 0.32 | 439788  | 455844         |
| 0.50 | 0.125 | 0.50 | 1.90 | 1.5 | 32 | 3 | 0.41 | 439789  | 455845         |
| 0.60 | 0.150 | 0.60 | 2.30 | 1.5 | 32 | 3 | 0.50 | 439790  | 455846         |
| 0.70 | 0.175 | 0.70 | 2.60 | 1.5 | 32 | 3 | 0.58 | 439791  | 455847         |
| 0.80 | 0.200 | 0.80 | 3.00 | 1.5 | 32 | 3 | 0.66 | 439792  | 455848         |
| 0.90 | 0.225 | 0.90 | 3.40 | 1.5 | 32 | 3 | 0.74 | 439793  | 455849         |
| 1.00 | 0.250 | 1.00 | 3.80 | 2.0 | 32 | 3 | 0.82 | 439795  | 455850         |
| 1.20 | 0.250 | 1.20 | 4.50 | 2.0 | 32 | 3 | 1.02 | 439797  | 455851         |
| 1.40 | 0.300 | 1.40 | 5.30 | 2.0 | 32 | 3 | 1.18 | 439799  | 455852         |

Autres dimensions et revêtements sur demande  
Altre dimensioni e rivestimenti su richiesta

# TH0141-SR01101

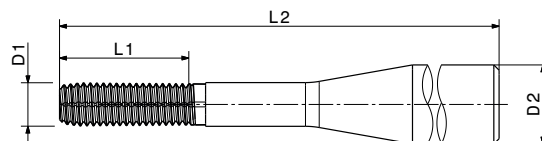
Paramètres de coupe  
Parametri di taglio

| ISO | V <sub>c</sub> [m/min] |               |
|-----|------------------------|---------------|
|     | Ø 0.30 - 1.40          | Ø 1.60 - 3.00 |
| P1  |                        |               |
| P2  |                        |               |
| P3  |                        |               |
| P4  |                        |               |
| P5  |                        |               |
| M1  |                        |               |
| M2  |                        |               |
| M3  |                        |               |
| K1  | 6 - 12                 | 14 - 20       |
| N1  | 6 - 12                 | 14 - 20       |
| N2  | 6 - 12                 | 14 - 20       |
| N3  | 6 - 12                 | 14 - 20       |
| N4  | 6 - 12                 | 14 - 20       |
| N5  | 6 - 12                 | 14 - 20       |
| N6  | 6 - 12                 | 14 - 20       |
| N7  | 6 - 12                 | 14 - 20       |
| N8  | 6 - 12                 | 14 - 20       |
| S1  |                        |               |
| S2  |                        |               |
| S3  |                        |               |
| H1  |                        |               |
| H2  |                        |               |

Valeurs indicatives  
Valori indicativi

# TH0205-SR01101

Taraud refouleur  
Maschio a rullare



N3 N4 N5 N6 N7 N8



| M    | P     | D1   | L1   | D2  | L2 | Tolérance<br>Tolleranza |      | Art. N° | DWS<br>Art. N° |
|------|-------|------|------|-----|----|-------------------------|------|---------|----------------|
| 0.50 | 0.125 | 0.50 | 1.50 | 1.5 | 32 | 4HX                     | 0.44 | 455743  | 455801         |
| 0.60 | 0.150 | 0.60 | 1.80 | 1.5 | 32 | 4HX                     | 0.53 | 455744  | 455802         |
| 0.70 | 0.175 | 0.70 | 2.10 | 1.5 | 32 | 4HX                     | 0.62 | 455745  | 455803         |
| 0.80 | 0.200 | 0.80 | 2.40 | 1.5 | 32 | 4HX                     | 0.71 | 455746  | 455804         |
| 0.90 | 0.225 | 0.90 | 2.70 | 1.5 | 32 | 4HX                     | 0.80 | 455747  | 455805         |
| 1.00 | 0.250 | 1.00 | 3.00 | 2.0 | 32 | 4HX                     | 0.88 | 455748  | 455806         |
| 1.20 | 0.250 | 1.20 | 3.60 | 2.0 | 32 | 4HX                     | 1.08 | 455749  | 455807         |
| 1.40 | 0.300 | 1.40 | 4.20 | 2.0 | 32 | 4HX                     | 1.25 | 456100  | 455808         |
| 1.60 | 0.350 | 1.60 | 4.80 | 2.0 | 32 | 6HX                     | 1.45 | 456101  | 455809         |
| 1.80 | 0.350 | 1.80 | 5.40 | 2.0 | 32 | 6HX                     | 1.65 | 439802  | 455810         |
| 2.00 | 0.400 | 2.00 | 6.00 | 3.0 | 39 | 6HX                     | 1.80 | 443383  | 455811         |
| 2.30 | 0.400 | 2.30 | 6.90 | 3.0 | 39 | 6HX                     | 2.10 | 439804  | 455812         |
| 2.50 | 0.450 | 2.50 | 7.50 | 3.0 | 39 | 6HX                     | 2.30 | 443385  | 455813         |
| 2.60 | 0.450 | 2.60 | 7.80 | 3.0 | 39 | 6HX                     | 2.40 | 455750  | 455814         |
| 3.00 | 0.500 | 3.00 | 9.00 | 4.0 | 51 | 6HX                     | 2.80 | 455751  | 455815         |



| S    | P     | D1   | L1   | D2  | L2 |      | Art. N° | DWS<br>Art. N° |
|------|-------|------|------|-----|----|------|---------|----------------|
| 0.50 | 0.125 | 0.50 | 1.50 | 1.5 | 32 | 0.44 | 455743  | 455816         |
| 0.60 | 0.150 | 0.60 | 1.80 | 1.5 | 32 | 0.53 | 455744  | 455817         |
| 0.70 | 0.175 | 0.70 | 2.10 | 1.5 | 32 | 0.62 | 455745  | 455818         |
| 0.80 | 0.200 | 0.80 | 2.40 | 1.5 | 32 | 0.71 | 455746  | 455819         |
| 0.90 | 0.225 | 0.90 | 2.70 | 1.5 | 32 | 0.80 | 455747  | 455820         |
| 1.00 | 0.250 | 1.00 | 3.00 | 2.0 | 32 | 0.88 | 455748  | 455821         |
| 1.20 | 0.250 | 1.20 | 3.60 | 2.0 | 32 | 1.08 | 455749  | 455822         |
| 1.40 | 0.300 | 1.40 | 4.20 | 2.0 | 32 | 1.25 | 456100  | 455823         |

Autres dimensions et revêtements sur demande  
Altre dimensioni e rivestimenti su richiesta

# TH0205-SR01101

Paramètres de coupe  
Parametri di taglio

| ISO | V <sub>c</sub> [m/min] |               |
|-----|------------------------|---------------|
|     | Ø 0.30 - 1.40          | Ø 1.60 - 3.00 |
| P1  |                        |               |
| P2  |                        |               |
| P3  |                        |               |
| P4  |                        |               |
| P5  |                        |               |
| M1  |                        |               |
| M2  |                        |               |
| M3  |                        |               |
| K1  |                        |               |
| N1  | 6 - 12                 | 14 - 20       |
| N2  | 6 - 12                 | 14 - 20       |
| N3  | 6 - 12                 | 14 - 20       |
| N4  | 6 - 12                 | 14 - 20       |
| N5  | 6 - 12                 | 14 - 20       |
| N6  | 6 - 12                 | 14 - 20       |
| N7  | 6 - 12                 | 14 - 20       |
| N8  | 6 - 12                 | 14 - 20       |
| S1  |                        |               |
| S2  |                        |               |
| S3  |                        |               |
| H1  |                        |               |
| H2  |                        |               |

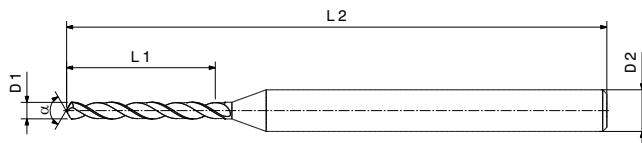
Valeurs indicatives  
Valori indicativi

# DR0101-NR01101

Foret pour DIAtread  
Punta per DIAtread



|    |    |    |    |    |    |    |    |    |    |    |
|----|----|----|----|----|----|----|----|----|----|----|
| P1 | P2 | P3 | P4 | P5 | M1 | M2 | M3 | K1 | N1 | N2 |
| N3 | N4 | N5 | N6 | N7 | N8 | S1 | S2 | S3 | H1 |    |



| D1   | L1    | D2 | L2 | α    | DWS<br>Art. N° |
|------|-------|----|----|------|----------------|
| 0.23 | 1.50  | 3  | 39 | 130° | 439665         |
| 0.28 | 1.80  | 3  | 39 | 130° | 439787         |
| 0.32 | 1.80  | 3  | 39 | 130° | 439788         |
| 0.41 | 2.70  | 3  | 39 | 130° | 439789         |
| 0.44 | 2.70  | 3  | 39 | 130° | 455743         |
| 0.50 | 3.20  | 3  | 39 | 130° | 439790         |
| 0.53 | 3.20  | 3  | 39 | 130° | 455744         |
| 0.58 | 3.60  | 3  | 39 | 130° | 439791         |
| 0.62 | 3.90  | 3  | 39 | 130° | 455745         |
| 0.66 | 3.90  | 3  | 39 | 130° | 439792         |
| 0.71 | 4.50  | 3  | 39 | 130° | 455746         |
| 0.74 | 4.50  | 3  | 39 | 130° | 439793         |
| 0.75 | 4.50  | 3  | 39 | 130° | 439794         |
| 0.80 | 5.00  | 3  | 39 | 130° | 455747         |
| 0.82 | 5.00  | 3  | 39 | 130° | 439795         |
| 0.88 | 5.70  | 3  | 39 | 130° | 455748         |
| 0.95 | 5.70  | 3  | 39 | 130° | 439796         |
| 1.02 | 6.50  | 3  | 39 | 130° | 439797         |
| 1.08 | 7.30  | 3  | 39 | 130° | 455749         |
| 1.10 | 7.30  | 3  | 39 | 130° | 439798         |
| 1.18 | 8.20  | 3  | 39 | 130° | 439799         |
| 1.25 | 8.20  | 3  | 39 | 130° | 456100         |
| 1.30 | 8.20  | 3  | 39 | 130° | 439800         |
| 1.45 | 9.20  | 3  | 39 | 130° | 456101         |
| 1.50 | 9.20  | 3  | 39 | 130° | 439801         |
| 1.65 | 11.20 | 3  | 39 | 130° | 439802         |
| 1.75 | 11.20 | 3  | 39 | 130° | 443382         |
| 1.80 | 11.20 | 3  | 39 | 130° | 443383         |
| 1.90 | 11.20 | 3  | 39 | 130° | 439803         |
| 2.10 | 12.50 | 3  | 39 | 130° | 439804         |
| 2.15 | 12.50 | 3  | 39 | 130° | 439805         |
| 2.25 | 12.50 | 3  | 39 | 130° | 443384         |
| 2.30 | 12.50 | 3  | 39 | 130° | 443385         |
| 2.40 | 12.00 | 3  | 39 | 130° | 455750         |
| 2.55 | 14.00 | 3  | 39 | 130° | 439806         |
| 2.65 | 14.00 | 3  | 39 | 130° | 443386         |
| 2.80 | 14.00 | 3  | 39 | 130° | 455751         |
| 2.90 | 15.00 | 6  | 66 | 140° | 443387         |
| 3.30 | 17.00 | 6  | 66 | 140° | 443388         |
| 3.50 | 18.00 | 6  | 66 | 140° | 443389         |
| 4.20 | 21.00 | 6  | 74 | 140° | 443390         |
| 4.50 | 23.00 | 6  | 74 | 140° | 443391         |
| 5.00 | 25.00 | 6  | 82 | 140° | 443392         |
| 5.30 | 27.00 | 6  | 82 | 140° | 443393         |

Autres dimensions et revêtements sur demande  
Altre dimensioni e rivestimenti su richiesta

# DR0101-NR01101

Paramètres de coupe  
Parametri di taglio

| ISO | V <sub>C</sub> [m/min] |               |               |               | f <sub>U</sub> [mm] |               |               |               |
|-----|------------------------|---------------|---------------|---------------|---------------------|---------------|---------------|---------------|
|     | Ø 0.23 - 0.50          | Ø 0.51 - 1.00 | Ø 1.01 - 2.55 | Ø 2.90 - 5.30 | Ø 0.23 - 0.50       | Ø 0.51 - 1.00 | Ø 1.01 - 2.55 | Ø 2.90 - 5.30 |
| P1  | 6 - 12                 | 12 - 35       | 35 - 60       | 60 - 110      | 0.004 - 0.008       | 0.008 - 0.015 | 0.015 - 0.030 | 0.070 - 0.130 |
| P2  | 6 - 12                 | 12 - 35       | 35 - 60       | 60 - 110      | 0.004 - 0.008       | 0.008 - 0.015 | 0.015 - 0.030 | 0.070 - 0.130 |
| P3  | 6 - 12                 | 12 - 35       | 35 - 60       | 60 - 110      | 0.004 - 0.008       | 0.008 - 0.015 | 0.015 - 0.030 | 0.070 - 0.130 |
| P4  | 4 - 9                  | 9 - 25        | 25 - 50       | 50 - 90       | 0.003 - 0.006       | 0.006 - 0.014 | 0.014 - 0.028 | 0.060 - 0.120 |
| P5  | 3 - 6                  | 6 - 20        | 20 - 40       | 40 - 60       | 0.002 - 0.005       | 0.005 - 0.011 | 0.011 - 0.023 | 0.050 - 0.100 |
| M1  | 4 - 9                  | 9 - 25        | 25 - 50       | 40 - 60       | 0.002 - 0.005       | 0.005 - 0.012 | 0.012 - 0.024 | 0.050 - 0.080 |
| M2  | 4 - 9                  | 9 - 25        | 25 - 50       | 40 - 60       | 0.002 - 0.005       | 0.005 - 0.012 | 0.012 - 0.024 | 0.050 - 0.080 |
| M3  | 3 - 6                  | 6 - 20        | 20 - 35       | 40 - 60       | 0.002 - 0.004       | 0.004 - 0.009 | 0.009 - 0.022 | 0.050 - 0.080 |
| K1  | 6 - 12                 | 12 - 35       | 35 - 60       | 60 - 90       | 0.004 - 0.008       | 0.008 - 0.015 | 0.015 - 0.030 | 0.100 - 0.150 |
| N1  | 7 - 19                 | 19 - 45       | 45 - 80       | 90 - 170      | 0.003 - 0.006       | 0.006 - 0.012 | 0.012 - 0.024 | 0.090 - 0.150 |
| N2  | 6 - 15                 | 15 - 35       | 35 - 65       | 90 - 170      | 0.003 - 0.006       | 0.006 - 0.012 | 0.012 - 0.024 | 0.090 - 0.150 |
| N3  | 7 - 18                 | 18 - 40       | 40 - 70       | 90 - 170      | 0.003 - 0.006       | 0.006 - 0.012 | 0.012 - 0.024 | 0.090 - 0.150 |
| N4  | 6 - 15                 | 15 - 35       | 35 - 65       | 90 - 170      | 0.003 - 0.006       | 0.006 - 0.012 | 0.012 - 0.024 | 0.090 - 0.150 |
| N5  | 6 - 15                 | 15 - 35       | 35 - 65       | 90 - 170      | 0.003 - 0.006       | 0.006 - 0.012 | 0.012 - 0.024 | 0.090 - 0.150 |
| N6  | 5 - 10                 | 10 - 25       | 25 - 50       | 90 - 170      | 0.003 - 0.006       | 0.006 - 0.012 | 0.012 - 0.024 | 0.090 - 0.150 |
| N7  | 5 - 10                 | 10 - 25       | 25 - 50       | 90 - 170      | 0.003 - 0.006       | 0.006 - 0.012 | 0.012 - 0.024 | 0.090 - 0.150 |
| N8  | 6 - 12                 | 12 - 35       | 35 - 60       | 90 - 170      | 0.004 - 0.008       | 0.008 - 0.016 | 0.016 - 0.032 | 0.090 - 0.150 |
| S1  | 5 - 9                  | 9 - 18        | 18 - 35       | 35 - 55       | 0.003 - 0.006       | 0.006 - 0.012 | 0.012 - 0.024 | 0.030 - 0.060 |
| S2  | 5 - 9                  | 9 - 18        | 18 - 35       | 35 - 55       | 0.003 - 0.006       | 0.006 - 0.012 | 0.012 - 0.024 | 0.030 - 0.060 |
| S3  | 3 - 6                  | 6 - 12        | 12 - 20       | 35 - 55       | 0.002 - 0.005       | 0.005 - 0.009 | 0.009 - 0.015 | 0.030 - 0.060 |
| H1  | 3 - 6                  | 6 - 12        | 12 - 20       | 25 - 40       | 0.002 - 0.005       | 0.005 - 0.009 | 0.009 - 0.015 | 0.030 - 0.060 |
| H2  |                        |               |               |               |                     |               |               |               |

Valeurs indicatives  
Valori indicativi

| TH                                                                      |                                | 03 | 42 | - | N | R | 0 | 1 | 1 | 01 |
|-------------------------------------------------------------------------|--------------------------------|----|----|---|---|---|---|---|---|----|
| Taraud<br><i>Maschio</i>                                                | Taraud                         | 01 |    |   |   |   |   |   |   |    |
|                                                                         | Taraud refouleur               | 02 |    |   |   |   |   |   |   |    |
|                                                                         | Maschio a rullare              | 03 |    |   |   |   |   |   |   |    |
|                                                                         | Fraise à tourbillonner         | 04 |    |   |   |   |   |   |   |    |
|                                                                         | Fresa per tourbillonage        |    |    |   |   |   |   |   |   |    |
|                                                                         | Fraise à fileter               |    |    |   |   |   |   |   |   |    |
| Tourbillonneur perceur<br><i>Fora filetta per tourbillonage</i>         | Fresa a filetare               | 06 |    |   |   |   |   |   |   |    |
|                                                                         | Tourbillonneur perceur         |    |    |   |   |   |   |   |   |    |
|                                                                         | Fora filetta per tourbillonage |    |    |   |   |   |   |   |   |    |
|                                                                         | ...                            |    |    |   |   |   |   |   |   |    |
|                                                                         | ...                            |    |    |   |   |   |   |   |   |    |
|                                                                         | ...                            |    |    |   |   |   |   |   |   |    |
| ...                                                                     | ... helice a droite            | 41 |    |   |   |   |   |   |   |    |
|                                                                         | ... elica destra               | 40 |    |   |   |   |   |   |   |    |
|                                                                         | ... helice a gauche            | 03 |    |   |   |   |   |   |   |    |
|                                                                         | ... elica sinistra             | 05 |    |   |   |   |   |   |   |    |
|                                                                         | ... rainure droite             | 42 |    |   |   |   |   |   |   |    |
|                                                                         | ... dentatura dritta           | 43 |    |   |   |   |   |   |   |    |
| ...                                                                     | ... Standard                   | 44 |    |   |   |   |   |   |   |    |
|                                                                         | ... profil double              | 45 |    |   |   |   |   |   |   |    |
|                                                                         | ... a profilo doppio           | 99 |    |   |   |   |   |   |   |    |
|                                                                         | ... profil unique              |    |    |   |   |   |   |   |   |    |
|                                                                         | ... a profilo unico            |    |    |   |   |   |   |   |   |    |
|                                                                         | ... dent unique                |    |    |   |   |   |   |   |   |    |
| ...                                                                     | ... a denté singolo            |    |    |   |   |   |   |   |   |    |
|                                                                         | Capacité de chantreinage       |    |    |   |   |   |   |   |   |    |
|                                                                         | Capacità di sinussatura        |    |    |   |   |   |   |   |   |    |
|                                                                         | ... Spécial                    |    |    |   |   |   |   |   |   |    |
|                                                                         | ... speciale                   |    |    |   |   |   |   |   |   |    |
|                                                                         | ...                            |    |    |   |   |   |   |   |   |    |
| Normal                                                                  | Normale                        |    |    |   | N |   |   |   |   |    |
|                                                                         | Ténace                         |    |    |   | T |   |   |   |   |    |
|                                                                         | Tenaci                         |    |    |   | S |   |   |   |   |    |
|                                                                         | Soft                           |    |    |   | A |   |   |   |   |    |
|                                                                         | Teneri                         |    |    |   | H |   |   |   |   |    |
|                                                                         | Superallages et titane         |    |    |   |   |   |   |   |   |    |
| Superleghe e titanio                                                    | Superleghe e titanio           |    |    |   |   |   |   |   |   |    |
|                                                                         | Dur                            |    |    |   |   |   |   |   |   |    |
|                                                                         | Duri                           |    |    |   |   |   |   |   |   |    |
|                                                                         | Coupe à droite                 |    |    |   |   |   |   |   |   |    |
|                                                                         | Taglio a destra                |    |    |   | R |   |   |   |   |    |
|                                                                         | Coupe à gauche                 |    |    |   | L |   |   |   |   |    |
| Neutre                                                                  | Taglio a sinistra              |    |    |   | N |   |   |   |   |    |
|                                                                         | Neutre                         |    |    |   |   |   |   |   |   |    |
|                                                                         | Neutrale                       |    |    |   |   |   |   |   |   |    |
|                                                                         | ...                            |    |    |   |   |   |   |   |   |    |
|                                                                         | ...                            |    |    |   |   |   |   |   |   |    |
|                                                                         | ...                            |    |    |   |   |   |   |   |   |    |
| Sans canaux de refroidissement<br><i>Senza canali di raffreddamento</i> | Sans canaux de refroidissement | 0  |    |   |   |   |   |   |   |    |
|                                                                         | Senza canali di raffreddamento | 1  |    |   |   |   |   |   |   |    |
|                                                                         | Avec canaux de refroidissement |    |    |   |   |   |   |   |   |    |
|                                                                         | Con canali di raffreddamento   |    |    |   |   |   |   |   |   |    |
|                                                                         | ...                            |    |    |   |   |   |   |   |   |    |
|                                                                         | ...                            |    |    |   |   |   |   |   |   |    |
| Carbure de Tungstène (WC)<br><i>Carburo di tungsteno (WC)</i>           | Carbure de Tungstène (WC)      |    |    |   |   |   |   | 1 |   |    |
|                                                                         | Carburo di tungsteno (WC)      |    |    |   |   |   |   | 2 |   |    |
|                                                                         | Diamant monocristallin (MCD)   |    |    |   |   |   |   | 3 |   |    |
|                                                                         | Diamante monocristallino (MCD) |    |    |   |   |   |   | 4 |   |    |
|                                                                         | Diamant polycristallin (PCD)   |    |    |   |   |   |   | 5 |   |    |
|                                                                         | Diamante policristallino (PCD) |    |    |   |   |   |   | 6 |   |    |
| Céramique<br><i>Ceramica</i>                                            | Céramique                      |    |    |   |   |   |   |   |   |    |
|                                                                         | Ceramica                       |    |    |   |   |   |   |   |   |    |
|                                                                         | Acier rapide (HSS)             |    |    |   |   |   |   |   |   |    |
|                                                                         | Acciaio super rapido (HSS)     |    |    |   |   |   |   |   |   |    |
|                                                                         | Cermet                         |    |    |   |   |   |   |   |   |    |
|                                                                         | Cermet                         |    |    |   |   |   |   |   |   |    |
| Cylindrique<br><i>Cilindrico</i>                                        | Cylindrique                    |    |    |   |   |   |   |   | 1 |    |
|                                                                         | Cilindrico                     |    |    |   |   |   |   |   | 2 |    |
|                                                                         | WM701S                         |    |    |   |   |   |   |   |   |    |
|                                                                         | ...                            |    |    |   |   |   |   |   |   |    |
|                                                                         | ...                            |    |    |   |   |   |   |   |   |    |
|                                                                         | ...                            |    |    |   |   |   |   |   |   |    |



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