Nuovi prodotti 2017.1
In questa brochure sono presenti solo i nuovi prodotti. Questa icona indica se è presente l’intera gamma nel Catalogo Pramet 2017, con il corrispondente numero di pagina.
La nostra linea di frese per spianatura con inserti OEHT è stata ampliata con una nuova gamma di frese versatili che possono essere utilizzate con inserti ottagonali (OD), rotondi (RD) e quadrati (SD).

**CARATTERISTICHE & VANTAGGI**

- **Versatilità dell’utensile** – Un’unica fresa per moltissime operazioni
- **Semplicità di impiego per gli operatori** – Stessa fresa per una produzione mista
- **Economicità** – 8 taglienti dell’inserto ODxT
- **Produttività** – maggiori profondità di taglio con inserti SDxT

**TIPI DI INSERTO**

**OTTAGONALE**
Splanatura e spallamento con inserto ottagonale
- 8 taglienti

**ROTONDO**
Sgrossatura ad elevata velocità di avanzamento, profilatura cava, fresatura a rampa

**QUADRATO**
Spallamento retto economico con 4 taglienti

**GEOMETRIE DEGLI INSERTI**

**GEOMETRIA F**
Prima scelta per acciai a basso tenore di carbonio e materiali non ferrosi
- Geometria positiva
- Finitura

**GEOMETRIA FM**
Acciaio, acciaio inox
- Geometria positiva con smusso protettivo
- Universale – da semfinitura a lavorazione media

**GEOMETRIA R**
Acciaio, ghisa
- Adatta a condizioni di taglio instabili
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<th>30</th>
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<td>2.510</td>
<td>2.828</td>
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### Diagrams

- ODGT 05
- ODMT 05

- Aperture: 1, 2, 3, 4, 5
- Aperture: 1, 2, 3, 4

- ODGT 05: 3, 4, 5, 7
- ODMT 05: 3, 7, 8, 8.5

- ODGT 05: 2, 7, 8
- ODMT 05: 2, 8, 4
La nostra gamma di utensili per fresatura economica è stata ampliata con frese di piccolo diametro per basse profondità di taglio. Nuovi inserti economici SOMT 05 con 4 taglianti per lavorazione generica.

CARATTERISTICHE & VANTAGGI

- Frese con diametro ridotto – ampio range da 12-40 mm
- Monolaterale con 4 taglianti
- Raggi dell’inserto di 0,4 e 0,8 mm
- Profondità di taglio fino a 4,5 mm
- Elevate prestazioni per la fresatura di acciaio e acciaio inox
- Per spallamento, spianatura e scanalatura e fresatura a tuffo

- Costi ridotti – prezzo del tagliente
- Produttività – elevato numero di denti
- Adattati per la fresatura di parti piccole su macchine per lavorazioni leggere
- Gamma di frese adatte ai torni motorizzati

GEOMETRIA DEGLI INSERTI

GEOMETRIA M
Particolarmente adatta per lavorazioni medie e leggere

- Adatta principalmente per acciaio, acciaio inox e ghisa
- Geometria affilata con rinforzo del tagliente ridotto positivo
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## INSERTI PER FRESATURA

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**INSERTI PER FRESATURA**
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- TNGX 100404SR-F M6330
- TNGX 100408SR-F M6330
- TNGX 100408SR-M M6330

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### RDMDT 16

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Diagram showing feed (f) values for different ISO grades and tool types.
I nuovi inserti negativi sono stati sviluppati per la sgrossatura e la semisgrossatura dell’acciaio inox e dell’acciaio debolmente legato. Disponibilità del rompitruciolo sia per inserti bilaterali che monolaterali di grandi dimensioni.

CARATTERISTICHE & VANTAGGI

- Vasta gamma di profondità di taglio
- Ampio rompitruciolo
- Gli inserti bilaterali possono essere impiegati per le operazioni di sgrossatura e semisgrossatura
- Gli inserti monolaterali possono inoltre essere usati per velocità di avanzamento e profondità di taglio superiori
- Sgrossatura dell’acciaio inox senza rischio di incrudimento
- Progettati per la produzione in serie - elevate prestazioni e maggiori velocità di avanzamento
- Eccellente controllo del truciolo nell’acciaio inox, anche a velocità di avanzamento inferiori
- Buona evacuazione del truciolo in molte aree applicative
- Vasta gamma di profondità di taglio
- Ampio rompitruciolo
- Gli inserti bilaterali possono essere impiegati per le operazioni di sgrossatura e semisgrossatura
- Gli inserti monolaterali possono inoltre essere usati per velocità di avanzamento e profondità di taglio superiori

ESEMPIO DI LAVORAZIONE

Materiale: DIN 1.4301
Gruppo materiali: M
Inserto: CNMG 120408-NRM: T7335

Velocità di taglio $v$: 150 m/min
Avanzamento $f$: 0,27 mm/giro
Profondità di taglio $a_p$: 4 mm

AREA APPLICATIVA
CNMG

- **ISO**
- **P M K N S H**
- **r c f m f m d m a m**

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CNMM

- **ISO**
- **P M K N S H**
- **r c f m f m d m a m**

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SNMG

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<td>25.400</td>
<td>9.12</td>
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</table>

As a professional you can judge the quality for being simply reliable. It signals and that's why we use it as a symbol itself tells a story. It is a clear and consistent clean and uncomplicated shape that in
SNMM 250924-NRM

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SNMM 250716-NRM

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<tr>
<td>2509</td>
<td>25,400</td>
<td>9,12</td>
<td>25,400</td>
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</tbody>
</table>
INSERTI PER PELATURA DI BARRE IN ACCIAIO INOX

È stato sviluppato un nuovo rompitruciolo per la lavorazione dell’acciaio inox. Adatto anche ad acciaio e superleghe.

**CARATTERISTICHE & VANTAGGI**

- Nuovo rompitruciolo progettato per l’acciaio inox
- Geometria robusta
- Maggiore stabilità del tagliente
- Marcature di identificazione del tagliente

**Opzioni del tagliente:**
- S01 per materiale duro
- S02 per materiale medio
- S03 per materiali pastosi o a bassa rigidità

**ROMPITRUCIOLO MM**

Dalla sgrossatura alla finitura
- Rinforzo del tagliente robusto
- Per acciaio inox e acciaio.
- Adatto alle superleghe

**Inserti LNGF**

Dalla sgrossatura alla finitura

**Inserti RNGH**

Sgrossatura

**Inserti WNGF**

Dalla sgrossatura alla finitura

**ESEMPIO DI LAVORAZIONE**

**Materiali:** 1.4028
**Gruppo materiali:** M
**Inserto:** RNGH 381200-MM: T9315

**Velocità di taglio** $v_c$ 70 m/min
**Avanzamento** $f$ 5,5 mm/giro
**Profondità di taglio assiale** $a_p$ 4 mm
**Lunghezza di taglio** 5 000 mm

**Durata di tagliente (%)**

- **MM** 19
- **Concorrenti** 13
### WNXJ

<table>
<thead>
<tr>
<th>k*</th>
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<th>d1</th>
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<tbody>
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### WNXJ 150935-PM

- ISO: 6630
- **r**: 0.40
- **f**: 0.50
- **a**: 15°
- **f**: 0.50
- **a**: 10°
- **F**: 0.40

### WNXJ 201380-PM-501

- ISO: 6630
- **r**: 0.40
- **f**: 0.50
- **a**: 15°
- **f**: 0.50
- **a**: 10°
- **F**: 0.40

### WNXX

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<td>7,94</td>
<td>15</td>
<td>12</td>
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### WNXX 150935-PM

- ISO: 6630
- **r**: 0.40
- **f**: 0.50
- **a**: 15°
- **f**: 0.50
- **a**: 10°
- **F**: 0.40

### WNXX 201380-PM-501

- ISO: 6630
- **r**: 0.40
- **f**: 0.50
- **a**: 15°
- **f**: 0.50
- **a**: 10°
- **F**: 0.40

---

**Note:** The text includes a table with specifications for different insert types and geometries, along with diagrams showing the application of these inserts. The table provides data such as material properties, dimensions, and recommended settings for use in various cutting applications.
GEOMETRIA DELL’INSERTO

PR

LNXR, RNGH, WNNJ, WNXJ

f 1,6 – 16,0

f 0,5 – 8,0
Un professionista può giudicare la qualità del lavoro grazie ad un semplice esame del truciolo. Il nostro truciolo è pulito e di forma semplice e da solo racchiude in sé’ una storia. Il truciolo è il simbolo perfetto del nostro essere simply reliable.