

# O1

## ALESATORI REAMERS

### D.01.01

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Guida alla selezione dell'utensile  
Tool selection guide

798-803

### D.01.02

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Gamma prodotti  
Products range

805-838

### D.01.03

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Parametri di taglio  
Cutting data

839-845



**ALESATORI**  
REAMERS

# D.01.01

**Guida alla selezione dell'utensile**  
Tool selection guide

| Codice Utensile<br>Tool code | Materiale utensile<br>Tool material | DIN | Forma<br>Form | Tolleranza foro<br>Hole tolerance | Angolo elica<br>Helix angle | Codolo<br>Shank | Rivestimento<br>Coating | Direzione taglio<br>Cutting Direction | Gamma diametri<br>Diameters range | P M K N S H | Pagina utensile<br>Tool page |
|------------------------------|-------------------------------------|-----|---------------|-----------------------------------|-----------------------------|-----------------|-------------------------|---------------------------------------|-----------------------------------|-------------|------------------------------|
|------------------------------|-------------------------------------|-----|---------------|-----------------------------------|-----------------------------|-----------------|-------------------------|---------------------------------------|-----------------------------------|-------------|------------------------------|

## ▶ ALESATORI A MANO | HAND REAMERS

|      |  |     |            |   |    |    |        |   |   |          |             |     |
|------|--|-----|------------|---|----|----|--------|---|---|----------|-------------|-----|
| 6301 |  | HSS | 206<br>DIN | A | H7 | 0° | DIN 10 | - | ↻ | 1 ÷ 50   | P M K N S H | 806 |
| 6302 |  | HSS | 206<br>DIN | B | H7 | 6° | DIN 10 | - | ↻ | 0,8 ÷ 50 | P M K N S H | 806 |

## ▶ ALESATORI A MANO | HAND REAMERS

Registrabili espansione max 1% oltre il Ø nominale | Adjustable range of expansion max 1 % over nominal size

|      |  |     |            |   |   |    |        |   |   |        |             |     |
|------|--|-----|------------|---|---|----|--------|---|---|--------|-------------|-----|
| 6306 |  | HSS | 859<br>DIN | A | - | 0° | DIN 10 | - | ↻ | 4 ÷ 30 | P M K N S H | 808 |
| 6309 |  | HSS | 859<br>DIN | B | - | 6° | DIN 10 | - | ↻ | 8 ÷ 30 | P M K N S H | 808 |

## ▶ ALESATORI A MANO | HAND REAMERS

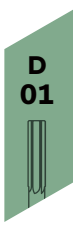
Per spine coniche - conicità 1:50 | Hand taper pin reamers, taper 1 : 50

|      |  |     |          |   |   |    |        |   |   |          |             |     |
|------|--|-----|----------|---|---|----|--------|---|---|----------|-------------|-----|
| 6315 |  | HSS | 9<br>DIN | A | - | 0° | DIN 10 | - | ↻ | 1 ÷ 30   | P M K N S H | 831 |
| 6304 |  | HSS | 9<br>DIN | B | - | 6° | DIN 10 | - | ↻ | 1,5 ÷ 50 | P M K N S H | 831 |

## ▶ ALESATORI A MANO | HAND REAMERS

Per cono morse secondo DIN 228 | Taper socket reamer – finishing for taper sleeves according to DIN 228

|      |  |     |            |   |   |    |        |   |   |                      |             |     |
|------|--|-----|------------|---|---|----|--------|---|---|----------------------|-------------|-----|
| 6317 |  | HSS | 204<br>DIN | C | - | 0° | DIN 10 | - | ↻ | C.M.   M.T.<br>0 ÷ 6 | P M K N S H | 837 |
| 6312 |  | HSS | 204<br>DIN | D | - | 6° | DIN 10 | - | ↻ | C.M.   M.T.<br>0 ÷ 6 | P M K N S H | 837 |



| Codice Utensile<br>Tool code | Materiale utensile<br>Tool material | DIN | Forma<br>Form | Tolleranza foro<br>Hole tolerance | Angolo elica<br>Helix angle | Codolo<br>Shank | Rivestimento<br>Coating | Direzione taglio<br>Cutting Direction | Gamma diametri<br>Diameter range | P | M         | K | N | S | H | Pagina utensile<br>Tool page |
|------------------------------|-------------------------------------|-----|---------------|-----------------------------------|-----------------------------|-----------------|-------------------------|---------------------------------------|----------------------------------|---|-----------|---|---|---|---|------------------------------|
|                              |                                     |     |               |                                   |                             |                 |                         |                                       |                                  |   | Color bar |   |   |   |   |                              |

**▶ ALESATORI A MACCHINA | MACHINE CHUCKING REAMERS**

Tipo corto per macchine automatiche | Short for automatic machines

|      |  |        |             |   |    |    |  |   |  |          |  |  |  |  |  |  |     |
|------|--|--------|-------------|---|----|----|--|---|--|----------|--|--|--|--|--|--|-----|
| 6324 |  | HSS-Co | 8089<br>DIN | B | H7 | 9° |  | - |  | 1,5 ÷ 20 |  |  |  |  |  |  | 809 |
|------|--|--------|-------------|---|----|----|--|---|--|----------|--|--|--|--|--|--|-----|

**▶ ALESATORI A MACCHINA | MACHINE CHUCKING REAMERS**

|      |  |        |            |     |    |    |   |   |  |          |  |  |  |  |  |  |     |
|------|--|--------|------------|-----|----|----|---|---|--|----------|--|--|--|--|--|--|-----|
| 6321 |  | HSS-Co | 212<br>DIN | A-C | H7 | 0° |   | - |  | 1 ÷ 20   |  |  |  |  |  |  | 810 |
| 6333 |  | HSS-Co | 208<br>DIN | A   | H7 | 0° |   | - |  | 5 ÷ 32   |  |  |  |  |  |  | 822 |
| 6361 |  | HSS    | 219<br>DIN | A   | H7 | 0° | - | - |  | 25 ÷ 100 |  |  |  |  |  |  | 827 |

**▶ ALESATORI A MACCHINA | MACHINE CHUCKING REAMERS**

Progressione centesimale di 0,01 mm | Progression of 0,01 mm

|        |  |        |            |     |    |    |   |     |  |              |  |  |  |  |  |  |     |
|--------|--|--------|------------|-----|----|----|---|-----|--|--------------|--|--|--|--|--|--|-----|
| 6326   |  | HSS-Co | 212<br>DIN | B/D | H7 | 9° |   | -   |  | 1 ÷ 20       |  |  |  |  |  |  | 810 |
| 6326TN |  | HSS-Co | 212<br>DIN | B/D | H7 | 9° |   | TiN |  | 1 ÷ 20       |  |  |  |  |  |  | 810 |
| 6326C  |  | HSS-Co | 212<br>DIN | D   | -  | 9° |   | -   |  | 0,95 ÷ 16,10 |  |  |  |  |  |  | 817 |
| 6337   |  | HSS-Co | 208<br>DIN | B   | H7 | 9° |   | -   |  | 5 ÷ 40       |  |  |  |  |  |  | 822 |
| 6360   |  | HSS    | 219<br>DIN | B   | H7 | 9° | - | -   |  | 25 ÷ 100     |  |  |  |  |  |  | 827 |

**▶ ALESATORI A MACCHINA | MACHINE CHUCKING REAMERS**

Elicoidali 45° | 45° Helix

|      |  |        |            |   |    |     |  |   |  |        |  |  |  |  |  |  |     |
|------|--|--------|------------|---|----|-----|--|---|--|--------|--|--|--|--|--|--|-----|
| 6325 |  | HSS-Co | 212<br>DIN | E | H7 | 45° |  | - |  | 1 ÷ 20 |  |  |  |  |  |  | 810 |
|------|--|--------|------------|---|----|-----|--|---|--|--------|--|--|--|--|--|--|-----|

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01

| Codice Utensile<br>Tool code | Materiale utensile<br>Tool material | DIN | Forma<br>Form | Tolleranza foro<br>Hole tolerance | Angolo elica<br>Helix angle | Codolo<br>Shank | Rivestimento<br>Coating | Direzione taglio<br>Cutting Direction | Gamma diametri<br>Diameters range | P M K N S H | Pagina utensile<br>Tool page |
|------------------------------|-------------------------------------|-----|---------------|-----------------------------------|-----------------------------|-----------------|-------------------------|---------------------------------------|-----------------------------------|-------------|------------------------------|
|------------------------------|-------------------------------------|-----|---------------|-----------------------------------|-----------------------------|-----------------|-------------------------|---------------------------------------|-----------------------------------|-------------|------------------------------|

## ▶ ALESATORI A MACCHINA | MACHINE CHUCKING REAMERS

Elicoidali 45° | 45° Helix

|      |  |        |            |   |    |     |   |   |  |          |  |     |
|------|--|--------|------------|---|----|-----|---|---|--|----------|--|-----|
| 6335 |  | HSS-Co | 208<br>DIN | C | H7 | 45° |   | - |  | 5 ÷ 32   |  | 822 |
| 6362 |  | HSS    | 219<br>DIN | C | H7 | 45° | - | - |  | 25 ÷ 100 |  | 827 |

## ▶ ALESATORI A MACCHINA | MACHINE CHUCKING REAMERS

Registrabili espansione max 0,01 mm del Ø | Expansion reamers up to max 0,01 mm Ø

|      |  |        |                     |   |    |    |  |   |  |        |  |     |
|------|--|--------|---------------------|---|----|----|--|---|--|--------|--|-----|
| 6307 |  | HSS-Co | ILIX<br>NORM<br>DIN | - | H7 | 0° |  | - |  | 8 ÷ 18 |  | 826 |
|------|--|--------|---------------------|---|----|----|--|---|--|--------|--|-----|

## ▶ ALESATORI A MACCHINA | MACHINE CHUCKING REAMERS

Per spine coniche - conicità 1:50 | Taper pin reamers - taper 1:50

|      |  |        |             |   |   |     |  |   |  |        |  |     |
|------|--|--------|-------------|---|---|-----|--|---|--|--------|--|-----|
| 6313 |  | HSS-Co | 2179<br>DIN | - | - | 45° |  | - |  | 1 ÷ 12 |  | 833 |
| 6314 |  | HSS    | 2180<br>DIN | - | - | 45° |  | - |  | 4 ÷ 20 |  | 834 |

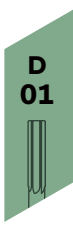
## ▶ ALESATORI A MACCHINA CONICI | MACHINE TAPER REAMERS

|      |  |     |                     |   |   |    |  |        |   |  |        |  |     |
|------|--|-----|---------------------|---|---|----|--|--------|---|--|--------|--|-----|
| 6308 |  | HSS | ILIX<br>NORM<br>DIN | - | - | 0° |  | DIN 10 | - |  | 3 ÷ 45 |  | 836 |
|------|--|-----|---------------------|---|---|----|--|--------|---|--|--------|--|-----|

## ▶ ALESATORI A MACCHINA CONICI | MACHINE TAPER REAMERS

Per preforo NPT/NPTF | Taper pin reamer for NPT/NPTF thread

|      |  |     |                     |   |   |    |  |        |   |  |            |  |     |
|------|--|-----|---------------------|---|---|----|--|--------|---|--|------------|--|-----|
| 6310 |  | HSS | ILIX<br>NORM<br>DIN | A | - | 0° |  | DIN 10 | - |  | 1/16" ÷ 2" |  | 835 |
| 6311 |  | HSS | ILIX<br>NORM<br>DIN | B | - | 6° |  | DIN 10 | - |  | 1/16" ÷ 2" |  | 835 |



| Codice Utensile<br>Tool code | Materiale utensile<br>Tool material | DIN | Forma<br>Form | Tolleranza foro<br>Hole tolerance | Angolo elica<br>Helix angle | Codolo<br>Shank | Rivestimento<br>Coating | Direzione taglio<br>Cutting Direction | Gamma diametri<br>Diameter range | P M K N S H | Pagina utensile<br>Tool page |
|------------------------------|-------------------------------------|-----|---------------|-----------------------------------|-----------------------------|-----------------|-------------------------|---------------------------------------|----------------------------------|-------------|------------------------------|
|------------------------------|-------------------------------------|-----|---------------|-----------------------------------|-----------------------------|-----------------|-------------------------|---------------------------------------|----------------------------------|-------------|------------------------------|

**▶ ALESATORI A MACCHINA CONICI | MACHINE TAPER REAMERS**

per spine coniche (NF: Norme Francesi) - conicità 1:50 | Taper pin reamers (nf: French standard) – taper 1 : 50

|      |  |     |                   |    |   |     |  |   |  |         |             |     |
|------|--|-----|-------------------|----|---|-----|--|---|--|---------|-------------|-----|
| 6319 |  | HSS | E<br>66-011<br>NF | NF | - | 45° |  | - |  | 1 ÷ 4,5 | P M K N S H | 832 |
|------|--|-----|-------------------|----|---|-----|--|---|--|---------|-------------|-----|

**▶ ALESATORI A MACCHINA CONICI | MACHINE TAPER REAMERS**

con attacco conico per fori da chiodi | Bridge reamers with morse taper

|      |  |     |            |   |   |     |  |   |  |          |             |     |
|------|--|-----|------------|---|---|-----|--|---|--|----------|-------------|-----|
| 6355 |  | HSS | 311<br>DIN | - | - | 25° |  | - |  | 6,4 ÷ 32 | P M K N S H | 838 |
|------|--|-----|------------|---|---|-----|--|---|--|----------|-------------|-----|

**▶ ALESATORI A MACCHINA CONICI | MACHINE TAPER REAMERS**

per fori di coppiglie | Taper pin reamers

|      |  |     |                     |   |   |    |  |   |  |          |             |     |
|------|--|-----|---------------------|---|---|----|--|---|--|----------|-------------|-----|
| 6303 |  | HSS | ILIX<br>NORM<br>DIN | - | - | 0° |  | - |  | 1,5 ÷ 20 | P M K N S H | 829 |
|------|--|-----|---------------------|---|---|----|--|---|--|----------|-------------|-----|

**▶ MICRO ALESATORI A MACCHINA CONICI | MACHINE TAPER MICRO REAMERS**

per lavorazioni in fori poco profondi | For fast smooth reaming of shallow holes

|      |  |     |                     |   |   |     |  |   |  |           |             |     |
|------|--|-----|---------------------|---|---|-----|--|---|--|-----------|-------------|-----|
| 6318 |  | HSS | ILIX<br>NORM<br>DIN | - | - | 12° |  | - |  | 1,2 ÷ 1,9 | P M K N S H | 830 |
|------|--|-----|---------------------|---|---|-----|--|---|--|-----------|-------------|-----|

**▶ ALESATORI A MACCHINA CONICI | MACHINE TAPER REAMERS**

|      |  |              |             |   |    |    |  |   |  |        |             |     |
|------|--|--------------|-------------|---|----|----|--|---|--|--------|-------------|-----|
| 6369 |  | M.D.I.<br>HM | 8094<br>DIN | A | H7 | 0° |  | - |  | 5 ÷ 20 | P M K N S H | 824 |
|------|--|--------------|-------------|---|----|----|--|---|--|--------|-------------|-----|

**▶ ALESATORI A MACCHINA | MACHINE REAMERS**

|      |  |              |             |   |    |    |  |   |  |        |             |     |
|------|--|--------------|-------------|---|----|----|--|---|--|--------|-------------|-----|
| 6372 |  | M.D.I.<br>HM | 8093<br>DIN | B | H7 | 9° |  | - |  | 1 ÷ 20 | P M K N S H | 813 |
|------|--|--------------|-------------|---|----|----|--|---|--|--------|-------------|-----|





















|        |  |              |             |   |    |    |  |     |  |        |             |     |
|--------|--|--------------|-------------|---|----|----|--|-----|--|--------|-------------|-----|
| 6372TN |  | M.D.I.<br>HM | 8093<br>DIN | B | H7 | 9° |  | TiN |  | 1 ÷ 20 | P M K N S H | 813 |
|--------|--|--------------|-------------|---|----|----|--|-----|--|--------|-------------|-----|

|        |  |              |             |   |   |    |  |   |  |              |             |     |
|--------|--|--------------|-------------|---|---|----|--|---|--|--------------|-------------|-----|
| 6372C* |  | M.D.I.<br>HM | 8093<br>DIN | B | - | 9° |  | - |  | 0,98 ÷ 12,05 | P M K N S H | 818 |
|--------|--|--------------|-------------|---|---|----|--|---|--|--------------|-------------|-----|

 \* Progressione centesimale. Tolleranza del ø nominale dell'alesatore +0,003/0  
 Centesimal progression. Tolerance of the nominal ø of the reamer +0,003/0


| Codice Utensile<br>Tool code | Materiale utensile<br>Tool material | DIN | Forma<br>Form | Tolleranza foro<br>Hole tolerance | Angolo elica<br>Helix angle | Codolo<br>Shank | Rivestimento<br>Coating | Direzione taglio<br>Cutting Direction | Gamma diametri<br>Diameters range | P | M | K | N | S | H | Pagina utensile<br>Tool page |
|------------------------------|-------------------------------------|-----|---------------|-----------------------------------|-----------------------------|-----------------|-------------------------|---------------------------------------|-----------------------------------|---|---|---|---|---|---|------------------------------|
|                              |                                     |     |               |                                   |                             |                 |                         |                                       |                                   |   |   |   |   |   |   |                              |

## ► ALESATORI A MACCHINA | MACHINE REAMERS

|             |   |              |                     |   |    |     |   |   |   |          |  |   |   |   |   |   |            |
|-------------|---|--------------|---------------------|---|----|-----|---|---|---|----------|--|---|---|---|---|---|------------|
| <b>6370</b> |    | M.D.I.<br>HM | -8093<br>DIN        | B | H7 | 9°  |    | - |    | 4 ÷ 20   |   | - | - | - | - | - | <b>815</b> |
| <b>6371</b> |    | M.D.I.<br>HM | -8093<br>DIN        | B | H7 | 9°  |    | - |    | 4 ÷ 20   |   | - | - | - | - | - | <b>816</b> |
| <b>6376</b> |    | M.D.I.<br>HM | -8094<br>DIN        | B | H7 | 9°  |    | - |    | 5 ÷ 20   |   | - | - | - | - | - | <b>825</b> |
| <b>6323</b> |    | CERMET       | -212<br>DIN         | - | H7 | 12° |    | - |    | 3,5 ÷ 16 |   | - | - | - | - | - | <b>820</b> |
| <b>6373</b> |  | PKD          | ILIX<br>NORM<br>DIN | - | H7 | 0°  |  | - |  | 12 ÷ 16  |  | - | - | - | - | - | <b>821</b> |







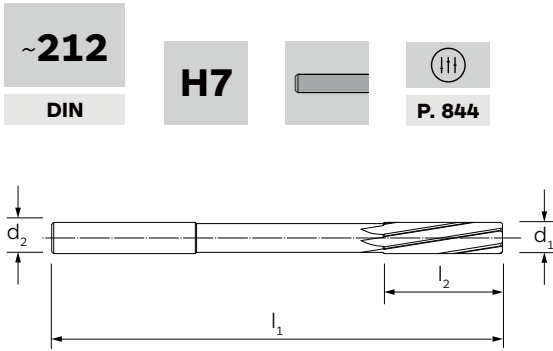
**ALESATORI**  
REAMERS

# D.01.02

**Gamma prodotti**  
Products range

D  
01

Alesatori a macchina in Cermet per ottenere fori in tolleranza H7  
 Machine chucking reamers made of Cermet, to produce holes with H7 tolerance



|                                      |   |
|--------------------------------------|---|
| MATERIALE   MATERIAL                 | CERMET  |
| ANGOLO ELICA   HELIX ANGLE           | 12°   |
| FORMA   FORM                         | B   |
| RIVESTIMENTO   COATING               | -   |
| DIREZIONE TAGLIO   CUTTING DIRECTION | ↻   |
| GRUPPO MATERIALI<br>MATERIAL GROUPS  | <b>P</b>   Acciai   Steels  |
|                                      | <b>M</b>   Acciai Inossidabili   Stainless Steels                   |
|                                      | <b>K</b>   Ghise   Cast Irons                                       |
|                                      | <b>N</b>   Metalli non ferrosi   Non-ferrous metals                 |
|                                      | <b>S</b>   Leghe resistenti al calore e Titanio   HRSA and Titanium |
|                                      | <b>H</b>   Acciai Temprati   Hardened Steels                        |

|        |
|--------|
| CERMET |
| 12°    |
| B      |
| -      |
| ↻      |
| P      |
| M      |
| K      |
| N      |
| -      |
| -      |

| $d_1$<br>(H7) | $l_1$ | $l_2$ | $d_2$<br>(h9) | Z |  | 6323 |
|---------------|-------|-------|---------------|---|--|------|
|---------------|-------|-------|---------------|---|--|------|

|      |     |    |    |   |  |   |
|------|-----|----|----|---|--|---|
| 3,5  | 60  | 18 | 4  | 6 |  | ■ |
| 4,0  | 75  | 19 | 4  | 6 |  | ■ |
| 4,5  | 75  | 21 | 5  | 6 |  | ■ |
| 6,5  | 101 | 28 | 6  | 6 |  | ■ |
| 7,0  | 109 | 31 | 8  | 6 |  | ■ |
| 7,5  | 109 | 33 | 8  | 6 |  | ■ |
| 9,5  | 125 | 38 | 10 | 6 |  | ■ |
| 11,0 | 142 | 41 | 10 | 6 |  | ■ |
| 12,0 | 151 | 44 | 10 | 6 |  | ■ |
| 13,0 | 151 | 44 | 10 | 8 |  | ■ |
| 15,0 | 162 | 50 | 14 | 8 |  | ■ |
| 16,0 | 170 | 53 | 14 | 8 |  | ■ |
|      |     |    |    |   |  |   |
|      |     |    |    |   |  |   |
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|      |     |    |    |   |  |   |

| $d_1$<br>(H7) | $l_1$ | $l_2$ | $d_2$<br>(h9) | Z |  | 6323 |
|---------------|-------|-------|---------------|---|--|------|
|---------------|-------|-------|---------------|---|--|------|

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|  |  |  |  |  |  |  |

■ Fino ad esaurimento scorte | Till stocks last



**ALESATORI**  
**REAMERS**

# D.01.03

**Parametri di taglio**  
Cutting data

| Pagina catalogo<br>Catalogue page  | Codice utensile<br>Tool Code |  | Acciaio debolmente legato<br>Low-Alloyed Steel<br><800 N/mm <sup>2</sup> | Acciaio mediamente legato<br>Medium-Alloyed Steel<br>700/1000 N/mm <sup>2</sup> | Acciaio fortemente legato<br>High-Alloyed Steel<br>1000/1300 N/mm <sup>2</sup> | Acciaio inossidabile<br>Martensitico/Ferritico<br>Stainless steel<br>Martensitic/Ferritic | Acciaio inossidabile<br>Austenitico<br>Stainless steel<br>Austenitic | Ghisa grigia<br>Grey cast iron | Ghisa sferoidale<br>Nodular cast iron |
|------------------------------------|------------------------------|--|--|---|--|---|--|--------------------------------|---------------------------------------|
| Gruppo Materiali   Materials Group |                              |  | <b>P1</b>  | <b>P2</b>   | <b>P3</b>  | <b>M1</b>   | <b>M2</b>  | <b>K1</b>                      | <b>K2</b>                             |

|     |               |  | V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f   |
|-----|---------------|--|----------------|-----|----------------|-----|----------------|-----|----------------|-----|----------------|-----|----------------|-----|----------------|-----|
| 809 | <b>6324</b>   |  | 12             | 1.0 | 8              | 0.8 | 6              | 0.6 | 5              | 0.8 | 3              | 0.6 | 12             | 1.0 | 8              | 1.2 |
| 810 | <b>6321</b>   |  | 12             | 1.0 | 8              | 0.8 | 6              | 0.6 | 5              | 0.8 | 3              | 0.6 | 12             | 1.0 | 8              | 1.2 |
| 822 | <b>6333</b>   |  | 12             | 1.0 | 8              | 0.8 | 6              | 0.6 | 5              | 0.8 | 3              | 0.6 | 12             | 1.0 | 8              | 1.2 |
| 827 | <b>6361</b>   |  | 10             | 1.0 | 6              | 0.8 | 4              | 0.6 | 3              | 0.8 | 2              | 0.6 | 10             | 1.0 | 6              | 1.2 |
| 810 | <b>6326</b>   |  | 12             | 1.0 | 8              | 0.8 | 6              | 0.6 | 5              | 0.8 | 3              | 0.6 | 12             | 1.0 | 8              | 1.2 |
| 810 | <b>6326TN</b> |  | 12             | 1.0 | 8              | 0.8 | 6              | 0.6 | 5              | 0.8 | 3              | 0.6 | 12             | 1.0 | 8              | 1.2 |
| 817 | <b>6326C</b>  |  | 12             | 1.0 | 8              | 0.8 | 6              | 0.6 | 5              | 0.8 | 3              | 0.6 | 12             | 1.0 | 8              | 1.2 |
| 822 | <b>6337</b>   |  | 12             | 1.0 | 8              | 0.8 | 6              | 0.6 | 5              | 0.8 | 3              | 0.6 | 12             | 1.0 | 8              | 1.2 |
| 827 | <b>6360</b>   |  | 10             | 1.0 | 6              | 0.8 | 4              | 0.6 | 3              | 0.8 | 2              | 0.6 | 10             | 1.0 | 6              | 1.2 |
| 810 | <b>6325</b>   |  | 12             | 1.0 | 8              | 0.8 | 6              | 0.6 | 5              | 0.8 | 3              | 0.6 | 12             | 1.0 | 8              | 1.2 |
| 822 | <b>6335</b>   |  | 12             | 1.0 | 8              | 0.8 | 6              | 0.6 | 5              | 0.8 | 3              | 0.6 | 12             | 1.0 | 8              | 1.2 |

V<sub>c</sub>: velocità di taglio (m/min) | cutting speed (m/min)    f: Tabella avanzamenti (mm/giro) | Feed table (mm/rev)

### Avanzamento f<sub>n</sub> (mm/g) | Feed f<sub>n</sub> (mm/rev)

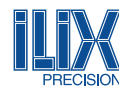
|   |       | Ø 1   | Ø 1,5 | Ø 2   | Ø 3   | Ø 4   | Ø 5   | Ø 6   | Ø 8   |
|---|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Coefficiente di avanzamento<br>Coefficient Number | 0.6   | 0,030 | 0,040 | 0,050 | 0,060 | 0,080 | 0,090 | 0,100 | 0,120 |
|   | 0.8   | 0,045 | 0,060 | 0,075 | 0,090 | 0,110 | 0,120 | 0,140 | 0,160 |
|   | 1.0   | 0,060 | 0,075 | 0,090 | 0,120 | 0,140 | 0,160 | 0,180 | 0,210 |
|   | 1.2   | 0,075 | 0,090 | 0,110 | 0,140 | 0,170 | 0,190 | 0,210 | 0,250 |
|   | 1.4   | 0,085 | 0,110 | 0,130 | 0,160 | 0,190 | 0,220 | 0,240 | 0,290 |
|   | 1.6   | 0,098 | 0,120 | 0,140 | 0,190 | 0,220 | 0,250 | 0,270 | 0,320 |
|   | 1.8   | 0,110 | 0,130 | 0,160 | 0,210 | 0,250 | 0,280 | 0,310 | 0,360 |
|   | 2.0   | 0,120 | 0,150 | 0,180 | 0,230 | 0,280 | 0,310 | 0,340 | 0,410 |
| 2.5   | 0,150 | 0,180 | 0,210 | 0,280 | 0,330 | 0,380 | 0,420 | 0,500 |       |

Esempio della scelta dei dati di lavoro: 6324 Ø 5 | Gruppo di materiale da lavorare **P1** | V<sub>c</sub> = 12 m/min | f<sub>n</sub> = **0,160 mm/giro** (coefficiente f=1)  
 Cutting data example: 6324 Ø 5 | Working material group **P1** | V<sub>c</sub> = 12 m/min | f<sub>n</sub> = **0,160 mm/rev** (coefficient f=1)














# PARAMETRI DI TAGLIO | CUTTING DATA

Alesatori in HSS e HSS-Co | HSS and HSS-Co reamers

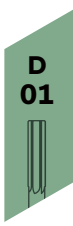


|   |   |   |  |   |   |   |   |                                     |  |
|---|---|---|--|---|---|---|---|-------------------------------------|--|
| <b>Alluminio e leghe di Alluminio</b><br>Aluminum and Aluminum alloys | <b>Materiali non ferrosi</b><br>Non ferrous materials | <b>Titanio e leghe di Titanio</b><br>Titanium and Titanium alloys | <b>HRSA</b><br>Leghe resistenti al calore<br>Heat resistant alloys | <b>Acciai temprati</b><br>Hardened steels<br><b>38/48 HRC</b> | <b>Acciai temprati</b><br>Hardened steels<br><b>48/58 HRC</b> | <b>Acciai temprati</b><br>Hardened steels<br><b>58/68 HRC</b> |   | <b>Codice utensile</b><br>Tool Code | <b>Pagina catalogo</b><br>Catalogue page |
| <b>N1</b>   | <b>N2</b>   | <b>S1</b>   | <b>S2</b>  | <b>H1</b>   | <b>H2</b>   | <b>H3</b>   | <b>Gruppo Materiali   Materials Group</b> |                                     |  |

| V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f | V <sub>c</sub> | f | V <sub>c</sub> | f |   |               |     |
|----------------|-----|----------------|-----|----------------|-----|----------------|-----|----------------|---|----------------|---|----------------|---|---|---------------|-----|
| 15             | 1.6 | 10             | 1.4 | 2              | 0.6 | 2              | 0.6 | -              | - | -              | - | -              | - |    | <b>6324</b>   | 809 |
| 15             | 1.6 | 10             | 1.4 | 2              | 0.6 | 2              | 0.6 | -              | - | -              | - | -              | - |    | <b>6321</b>   | 810 |
| 15             | 1.6 | 10             | 1.4 | 2              | 0.6 | 2              | 0.6 | -              | - | -              | - | -              | - |    | <b>6333</b>   | 822 |
| 13             | 1.6 | 8              | 1.4 | -              | -   | -              | -   | -              | - | -              | - | -              | - |    | <b>6361</b>   | 827 |
| 15             | 1.6 | 10             | 1.4 | 2              | 0.6 | 2              | 0.6 | -              | - | -              | - | -              | - |   | <b>6326</b>   | 810 |
| 15             | 1.6 | 10             | 1.4 | 2              | 0.6 | 2              | 0.6 | -              | - | -              | - | -              | - |  | <b>6326TN</b> | 810 |
| 15             | 1.6 | 10             | 1.4 | 2              | 0.6 | 2              | 0.6 | -              | - | -              | - | -              | - |  | <b>6326C</b>  | 817 |
| 15             | 1.6 | 10             | 1.4 | 2              | 0.6 | 2              | 0.6 | -              | - | -              | - | -              | - |  | <b>6337</b>   | 822 |
| 13             | 1.6 | 8              | 1.4 | -              | -   | -              | -   | -              | - | -              | - | -              | - |  | <b>6360</b>   | 827 |
| 15             | 1.6 | 10             | 1.4 | 2              | 0.6 | 2              | 0.6 | -              | - | -              | - | -              | - |  | <b>6325</b>   | 810 |
| 15             | 1.6 | 10             | 1.4 | 2              | 0.6 | 2              | 0.6 | -              | - | -              | - | -              | - |  | <b>6335</b>   | 822 |

| Ø 10  | Ø 12  | Ø 15  | Ø 20  | Ø 25  | Ø 30  | Ø 40  | Ø 50  |            | <b>Numero avanzamento</b><br>Feed Number |
|-------|-------|-------|-------|-------|-------|-------|-------|------------|--|
| 0,140 | 0,150 | 0,160 | 0,200 | 0,230 | 0,260 | 0,300 | 0,350 | <b>0.6</b> |  |
| 0,180 | 0,220 | 0,240 | 0,270 | 0,320 | 0,350 | 0,420 | 0,480 | <b>0.8</b> |  |
| 0,240 | 0,270 | 0,300 | 0,350 | 0,400 | 0,450 | 0,520 | 0,600 | <b>1.0</b> |  |
| 0,280 | 0,330 | 0,360 | 0,430 | 0,480 | 0,550 | 0,650 | 0,720 | <b>1.2</b> |  |
| 0,340 | 0,380 | 0,410 | 0,500 | 0,550 | 0,640 | 0,750 | 0,820 | <b>1.4</b> |  |
| 0,380 | 0,420 | 0,480 | 0,560 | 0,650 | 0,710 | 0,850 | 0,950 | <b>1.6</b> |  |
| 0,420 | 0,480 | 0,530 | 0,620 | 0,720 | 0,800 | 0,950 | 1,100 | <b>1.8</b> |  |
| 0,480 | 0,530 | 0,600 | 0,700 | 0,800 | 0,900 | 1,200 | 1,400 | <b>2.0</b> |  |
| 0,580 | 0,650 | 0,730 | 0,880 | 1,000 | 1,200 | 1,400 | 1,600 | <b>2.5</b> |  |

► I parametri di taglio indicati in tabella sono da considerarsi validi in condizioni macchina/pezzo ottimali  
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions



| Pagina catalogo<br>Catalogue page  | Codice utensile<br>Tool Code |  | Acciaio debolmente legato<br>Low-Alloyed Steel<br><800 N/mm <sup>2</sup> | Acciaio mediamente legato<br>Medium-Alloyed Steel<br>700/1000 N/mm <sup>2</sup> | Acciaio fortemente legato<br>High-Alloyed Steel<br>1000/1300 N/mm <sup>2</sup> | Acciaio inossidabile<br>Martensitico/Ferritico<br>Stainless steel<br>Martensitic/Ferritic | Acciaio inossidabile<br>Austenitico<br>Stainless steel<br>Austenitic | Ghisa grigia<br>Grey cast iron | Ghisa sferoidale<br>Nodular cast iron |
|------------------------------------|------------------------------|--|--|---|--|---|--|--------------------------------|---------------------------------------|
| Gruppo Materiali   Materials Group |                              |  | <b>P1</b>  | <b>P2</b>   | <b>P3</b>  | <b>M1</b>   | <b>M2</b>  | <b>K1</b>                      | <b>K2</b>                             |

|     |             |  | V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f   |
|-----|-------------|--|----------------|-----|----------------|-----|----------------|-----|----------------|-----|----------------|-----|----------------|-----|----------------|-----|
| 827 | <b>6362</b> |  | 10             | 1.0 | 6              | 0.8 | 4              | 0.6 | 3              | 0.8 | 2              | 0.6 | 10             | 1.0 | 6              | 1.2 |
| 826 | <b>6307</b> |  | 10             | 1.0 | 6              | 0.8 | 4              | 0.6 | 3              | 0.8 | 2              | 0.6 | 10             | 1.0 | 6              | 1.2 |
| 833 | <b>6313</b> |  | 10             | 1.0 | 6              | 0.8 | 4              | 0.6 | 3              | 0.8 | 2              | 0.6 | 10             | 1.0 | 6              | 1.2 |
| 834 | <b>6314</b> |  | 10             | 1.0 | 6              | 0.8 | 4              | 0.6 | 3              | 0.8 | 2              | 0.6 | 10             | 1.0 | 6              | 1.2 |
| 836 | <b>6308</b> |  | 10             | 1.0 | 6              | 0.8 | 4              | 0.6 | 3              | 0.8 | 2              | 0.6 | 10             | 1.0 | 6              | 1.2 |
| 835 | <b>6310</b> |  | 10             | 1.0 | 6              | 0.8 | 4              | 0.6 | 3              | 0.8 | 2              | 0.6 | 10             | 1.0 | 6              | 1.2 |
| 835 | <b>6311</b> |  | 10             | 1.0 | 6              | 0.8 | 4              | 0.6 | 3              | 0.8 | 2              | 0.6 | 10             | 1.0 | 6              | 1.2 |
| 832 | <b>6319</b> |  | 10             | 1.0 | 6              | 0.8 | 4              | 0.6 | 3              | 0.8 | 2              | 0.6 | 10             | 1.0 | 6              | 1.2 |
| 838 | <b>6355</b> |  | 10             | 1.0 | 6              | 0.8 | 4              | 0.6 | 3              | 0.8 | 2              | 0.6 | 10             | 1.0 | 6              | 1.2 |
| 829 | <b>6303</b> |  | 10             | 1.0 | 6              | 0.8 | 4              | 0.6 | 3              | 0.8 | 2              | 0.6 | 10             | 1.0 | 6              | 1.2 |
| 830 | <b>6318</b> |  | 10             | 1.0 | 6              | 0.8 | 4              | 0.6 | 3              | 0.8 | 2              | 0.6 | 10             | 1.0 | 6              | 1.2 |

V<sub>c</sub>: velocità di taglio (m/min) | cutting speed (m/min)    f: Tabella avanzamenti (mm/giro) | Feed table (mm/rev)

### Avanzamento f<sub>n</sub> (mm/g) | Feed f<sub>n</sub> (mm/rev)

|   |       | Ø 1   | Ø 1,5 | Ø 2   | Ø 3   | Ø 4   | Ø 5   | Ø 6   | Ø 8   |
|---|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Coefficiente di avanzamento<br>Coefficient Number | 0.6   | 0,030 | 0,040 | 0,050 | 0,060 | 0,080 | 0,090 | 0,100 | 0,120 |
|   | 0.8   | 0,045 | 0,060 | 0,075 | 0,090 | 0,110 | 0,120 | 0,140 | 0,160 |
|   | 1.0   | 0,060 | 0,075 | 0,090 | 0,120 | 0,140 | 0,160 | 0,180 | 0,210 |
|   | 1.2   | 0,075 | 0,090 | 0,110 | 0,140 | 0,170 | 0,190 | 0,210 | 0,250 |
|   | 1.4   | 0,085 | 0,110 | 0,130 | 0,160 | 0,190 | 0,220 | 0,240 | 0,290 |
|   | 1.6   | 0,098 | 0,120 | 0,140 | 0,190 | 0,220 | 0,250 | 0,270 | 0,320 |
|   | 1.8   | 0,110 | 0,130 | 0,160 | 0,210 | 0,250 | 0,280 | 0,310 | 0,360 |
|   | 2.0   | 0,120 | 0,150 | 0,180 | 0,230 | 0,280 | 0,310 | 0,340 | 0,410 |
| 2.5   | 0,150 | 0,180 | 0,210 | 0,280 | 0,330 | 0,380 | 0,420 | 0,500 |       |

Esempio della scelta dei dati di lavoro: 6362 Ø 5 | Gruppo di materiale da lavorare P1 | V<sub>c</sub> = 10 m/min | f<sub>n</sub> = 0,160 mm/giro (coefficiente f=1.0)  
Cutting data example: 6362 Ø 5 | Working material group P1 | V<sub>c</sub> = 10 m/min | f<sub>n</sub> = 0,160 mm/rev (coefficient f=1.0)
















# PARAMETRI DI TAGLIO | CUTTING DATA

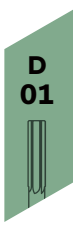
Alesatori in HSS e HSS-Co | HSS and HSS-Co reamers

|   |   |   |   |   |   |   |   |                                     |  |
|---|---|---|---|---|---|---|---|-------------------------------------|--|
| <b>Alluminio e leghe di Alluminio</b><br>Aluminum and Aluminum alloys | <b>Materiali non ferrosi</b><br>Non ferrous materials | <b>Titanio e leghe di Titanio</b><br>Titanium and Titanium alloys | <b>HRSA</b><br><b>Leghe resistenti al calore</b><br>Heat resistant alloys | <b>Acciai temprati</b><br>Hardened steels<br><b>38/48 HRC</b> | <b>Acciai temprati</b><br>Hardened steels<br><b>48/58 HRC</b> | <b>Acciai temprati</b><br>Hardened steels<br><b>58/68 HRC</b> |   | <b>Codice utensile</b><br>Tool Code | <b>Pagina catalogo</b><br>Catalogue page |
| <b>N1</b>   | <b>N2</b>   | <b>S1</b>   | <b>S2</b>   | <b>H1</b>   | <b>H2</b>   | <b>H3</b>   | <b>Gruppo Materiali   Materials Group</b> |                                     |  |

| V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f | V <sub>c</sub> | f | V <sub>c</sub> | f | V <sub>c</sub> | f | V <sub>c</sub> | f |   |             |     |
|----------------|-----|----------------|-----|----------------|---|----------------|---|----------------|---|----------------|---|----------------|---|---|-------------|-----|
| 13             | 1.6 | 8              | 1.4 | -              | - | -              | - | -              | - | -              | - | -              | - |    | <b>6362</b> | 827 |
| 13             | 1.6 | 8              | 1.4 | -              | - | -              | - | -              | - | -              | - | -              | - |    | <b>6307</b> | 826 |
| 13             | 1.6 | 8              | 1.4 | -              | - | -              | - | -              | - | -              | - | -              | - |    | <b>6313</b> | 833 |
| 13             | 1.6 | 8              | 1.4 | -              | - | -              | - | -              | - | -              | - | -              | - |    | <b>6314</b> | 834 |
| 13             | 1.6 | 8              | 1.4 | -              | - | -              | - | -              | - | -              | - | -              | - |    | <b>6308</b> | 836 |
| 13             | 1.6 | 8              | 1.4 | -              | - | -              | - | -              | - | -              | - | -              | - |  | <b>6310</b> | 835 |
| 13             | 1.6 | 8              | 1.4 | -              | - | -              | - | -              | - | -              | - | -              | - |  | <b>6311</b> | 835 |
| 13             | 1.6 | 8              | 1.4 | -              | - | -              | - | -              | - | -              | - | -              | - |  | <b>6319</b> | 832 |
| 13             | 1.6 | 8              | 1.4 | -              | - | -              | - | -              | - | -              | - | -              | - |  | <b>6355</b> | 838 |
| 13             | 1.6 | 8              | 1.4 | -              | - | -              | - | -              | - | -              | - | -              | - |  | <b>6303</b> | 829 |
| 13             | 1.6 | 8              | 1.4 | -              | - | -              | - | -              | - | -              | - | -              | - |  | <b>6318</b> | 830 |

| Ø 10  | Ø 12  | Ø 15  | Ø 20  | Ø 25  | Ø 30  | Ø 40  | Ø 50  |            | <b>Numero avanzamento</b><br>Feed Number |
|-------|-------|-------|-------|-------|-------|-------|-------|------------|--|
| 0,140 | 0,150 | 0,160 | 0,200 | 0,230 | 0,260 | 0,300 | 0,350 | <b>0.6</b> |  |
| 0,180 | 0,220 | 0,240 | 0,270 | 0,320 | 0,350 | 0,420 | 0,480 | <b>0.8</b> |  |
| 0,240 | 0,270 | 0,300 | 0,350 | 0,400 | 0,450 | 0,520 | 0,600 | <b>1.0</b> |  |
| 0,280 | 0,330 | 0,360 | 0,430 | 0,480 | 0,550 | 0,650 | 0,720 | <b>1.2</b> |  |
| 0,340 | 0,380 | 0,410 | 0,500 | 0,550 | 0,640 | 0,750 | 0,820 | <b>1.4</b> |  |
| 0,380 | 0,420 | 0,480 | 0,560 | 0,650 | 0,710 | 0,850 | 0,950 | <b>1.6</b> |  |
| 0,420 | 0,480 | 0,530 | 0,620 | 0,720 | 0,800 | 0,950 | 1,100 | <b>1.8</b> |  |
| 0,480 | 0,530 | 0,600 | 0,700 | 0,800 | 0,900 | 1,200 | 1,400 | <b>2.0</b> |  |
| 0,580 | 0,650 | 0,730 | 0,880 | 1,000 | 1,200 | 1,400 | 1,600 | <b>2.5</b> |  |

► I parametri di taglio indicati in tabella sono da considerarsi validi in condizioni macchina/pezzo ottimali  
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions



| Pagina catalogo<br>Catalogue page  | Codice utensile<br>Tool Code |  | Acciaio debolmente legato<br>Low-Alloyed Steel<br><800 N/mm <sup>2</sup> | Acciaio mediamente legato<br>Medium-Alloyed Steel<br>700/1000 N/mm <sup>2</sup> | Acciaio fortemente legato<br>High-Alloyed Steel<br>1000/1300 N/mm <sup>2</sup> | Acciaio inossidabile<br>Martensitico/Ferritico<br>Stainless steel<br>Martensitic/Ferritic | Acciaio inossidabile<br>Austenitico<br>Stainless steel<br>Austenitic | Ghisa grigia<br>Grey cast iron | Ghisa sferoidale<br>Nodular cast iron |
|------------------------------------|------------------------------|--|--|---|--|---|--|--------------------------------|---------------------------------------|
| Gruppo Materiali   Materials Group |                              |  | <b>P1</b>  | <b>P2</b>   | <b>P3</b>  | <b>M1</b>   | <b>M2</b>  | <b>K1</b>                      | <b>K2</b>                             |

|     |               |  | V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f   |
|-----|---------------|--|----------------|-----|----------------|-----|----------------|-----|----------------|-----|----------------|-----|----------------|-----|----------------|-----|
| 824 | <b>6369</b>   |  | 20             | 1.2 | 15             | 1.0 | 10             | 0.8 | 10             | 1.0 | 7              | 0.8 | 20             | 1.4 | 15             | 1.2 |
| 813 | <b>6372</b>   |  | 20             | 1.2 | 15             | 1.0 | 10             | 0.8 | 10             | 1.0 | 7              | 0.8 | 20             | 1.4 | 15             | 1.2 |
| 813 | <b>6372TN</b> |  | 20             | 1.2 | 15             | 1.0 | 10             | 0.8 | 10             | 1.0 | 7              | 0.8 | 20             | 1.4 | 15             | 1.2 |
| 818 | <b>6372C</b>  |  | 20             | 1.2 | 15             | 1.0 | 10             | 0.8 | 10             | 1.0 | 7              | 0.8 | 20             | 1.4 | 15             | 1.2 |
| 815 | <b>6370</b>   |  | 20             | 1.2 | 15             | 1.0 | 10             | 0.8 | 10             | 1.0 | 7              | 0.8 | 20             | 1.4 | 15             | 1.2 |
| 816 | <b>6371</b>   |  | 20             | 1.2 | 15             | 1.0 | 10             | 0.8 | 10             | 1.0 | 7              | 0.8 | 20             | 1.4 | 15             | 1.2 |
| 825 | <b>6376</b>   |  | 20             | 1.2 | 15             | 1.0 | 10             | 0.8 | 10             | 1.0 | 7              | 0.8 | 20             | 1.4 | 15             | 1.2 |
| 820 | <b>6323</b>   |  | 50             | 1.2 | 40             | 1.0 | 30             | 0.8 | 20             | 1.0 | 15             | 0.8 | 80             | 1.4 | 40             | 1.2 |
| 821 | <b>6373</b>   |  | -              | -   | -              | -   | -              | -   | -              | -   | -              | -   | -              | -   | -              | -   |

V<sub>c</sub>: velocità di taglio (m/min) | cutting speed (m/min)    f: Tabella avanzamenti (mm/giro) | Feed table (mm/rev)

### Avanzamento f<sub>n</sub> (mm/g) | Feed f<sub>n</sub> (mm/rev)

|   |            | Ø 1   | Ø 1,5 | Ø 2   | Ø 3   | Ø 4   | Ø 5   | Ø 6   | Ø 8   |
|---|------------|-------|-------|-------|-------|-------|-------|-------|-------|
| Coefficiente di avanzamento<br>Coefficient Number | <b>0.6</b> | 0,030 | 0,040 | 0,050 | 0,060 | 0,080 | 0,090 | 0,100 | 0,120 |
|   | <b>0.8</b> | 0,045 | 0,060 | 0,075 | 0,090 | 0,110 | 0,120 | 0,140 | 0,160 |
|   | <b>1.0</b> | 0,060 | 0,075 | 0,090 | 0,120 | 0,140 | 0,160 | 0,180 | 0,210 |
|   | <b>1.2</b> | 0,075 | 0,090 | 0,110 | 0,140 | 0,170 | 0,190 | 0,210 | 0,250 |
|   | <b>1.4</b> | 0,085 | 0,110 | 0,130 | 0,160 | 0,190 | 0,220 | 0,240 | 0,290 |
|   | <b>1.6</b> | 0,098 | 0,120 | 0,140 | 0,190 | 0,220 | 0,250 | 0,270 | 0,320 |
|   | <b>1.8</b> | 0,110 | 0,130 | 0,160 | 0,210 | 0,250 | 0,280 | 0,310 | 0,360 |
|   | <b>2.0</b> | 0,120 | 0,150 | 0,180 | 0,230 | 0,280 | 0,310 | 0,340 | 0,410 |
|   | <b>2.5</b> | 0,150 | 0,180 | 0,210 | 0,280 | 0,330 | 0,380 | 0,420 | 0,500 |

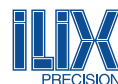
Esempio della scelta dei dati di lavoro: 6369 Ø 5 | Gruppo di materiale da lavorare **P1** | V<sub>c</sub> = 20 m/min | f<sub>n</sub> = **0,190 mm/giro** (coefficiente f=1.2)  
 Cutting data example: 6369 Ø 5 | Working material group **P1** | V<sub>c</sub> = 20 m/min | f<sub>n</sub> = **0,190 mm/rev** (coefficient f=1.2)





# PARAMETRI DI TAGLIO | CUTTING DATA

Alesatori in Metallo Duro Integrale, Cermet e PKD | Solid Carbide, Cermet and PKD reamers



|   |   |   |  |   |   |   |   |                                     |  |
|---|---|---|--|---|---|---|---|-------------------------------------|--|
| <b>Alluminio e leghe di Alluminio</b><br>Aluminum and Aluminum alloys | <b>Materiali non ferrosi</b><br>Non ferrous materials | <b>Titanio e leghe di Titanio</b><br>Titanium and Titanium alloys | <b>HRSA</b><br>Leghe resistenti al calore<br>Heat resistant alloys | <b>Acciai temprati</b><br>Hardened steels<br><b>38/48 HRC</b> | <b>Acciai temprati</b><br>Hardened steels<br><b>48/58 HRC</b> | <b>Acciai temprati</b><br>Hardened steels<br><b>58/68 HRC</b> |   | <b>Codice utensile</b><br>Tool Code | <b>Pagina catalogo</b><br>Catalogue page |
| <b>N1</b>   | <b>N2</b>   | <b>S1</b>   | <b>S2</b>  | <b>H1</b>   | <b>H2</b>   | <b>H3</b>   | <b>Gruppo Materiali   Materials Group</b> |                                     |  |

| V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f   | V <sub>c</sub> | f | V <sub>c</sub> | f | V <sub>c</sub> | f |  |               |     |
|----------------|-----|----------------|-----|----------------|-----|----------------|-----|----------------|---|----------------|---|----------------|---|--|---------------|-----|
| 30             | 1.8 | 25             | 1.6 | 5              | 0.8 | 5              | 0.8 | -              | - | -              | - | -              | - |  | <b>6369</b>   | 824 |
| 30             | 1.8 | 25             | 1.6 | 5              | 0.8 | 5              | 0.8 | -              | - | -              | - | -              | - |  | <b>6372</b>   | 813 |
| 30             | 1.8 | 25             | 1.6 | 5              | 0.8 | 5              | 0.8 | -              | - | -              | - | -              | - |  | <b>6372TN</b> | 813 |
| 30             | 1.8 | 25             | 1.6 | 5              | 0.8 | 5              | 0.8 | -              | - | -              | - | -              | - |  | <b>6372C</b>  | 818 |
| 30             | 1.8 | 25             | 1.6 | 5              | 0.8 | 5              | 0.8 | -              | - | -              | - | -              | - |  | <b>6370</b>   | 815 |
| 30             | 1.8 | 25             | 1.6 | 5              | 0.8 | 5              | 0.8 | -              | - | -              | - | -              | - |  | <b>6371</b>   | 816 |
| 30             | 1.8 | 25             | 1.6 | 5              | 0.8 | 5              | 0.8 | -              | - | -              | - | -              | - |  | <b>6376</b>   | 825 |
| 150            | 1.8 | 100            | 1.6 | -              | -   | -              | -   | -              | - | -              | - | -              | - |  | <b>6323</b>   | 820 |
| 200            | 2.0 | 150            | 1.8 | -              | -   | -              | -   | -              | - | -              | - | -              | - |  | <b>6373</b>   | 821 |

| Ø 10  | Ø 12  | Ø 15  | Ø 20  | Ø 25  | Ø 30  | Ø 40  | Ø 50  |            | Numero avanzamento<br>Feed Number |
|-------|-------|-------|-------|-------|-------|-------|-------|------------|-----------------------------------|
| 0,140 | 0,150 | 0,160 | 0,200 | 0,230 | 0,260 | 0,300 | 0,350 | <b>0.6</b> |                                   |
| 0,180 | 0,220 | 0,240 | 0,270 | 0,320 | 0,350 | 0,420 | 0,480 | <b>0.8</b> |                                   |
| 0,240 | 0,270 | 0,300 | 0,350 | 0,400 | 0,450 | 0,520 | 0,600 | <b>1.0</b> |                                   |
| 0,280 | 0,330 | 0,360 | 0,430 | 0,480 | 0,550 | 0,650 | 0,720 | <b>1.2</b> |                                   |
| 0,340 | 0,380 | 0,410 | 0,500 | 0,550 | 0,640 | 0,750 | 0,820 | <b>1.4</b> |                                   |
| 0,380 | 0,420 | 0,480 | 0,560 | 0,650 | 0,710 | 0,850 | 0,950 | <b>1.6</b> |                                   |
| 0,420 | 0,480 | 0,530 | 0,620 | 0,720 | 0,800 | 0,950 | 1,100 | <b>1.8</b> |                                   |
| 0,480 | 0,530 | 0,600 | 0,700 | 0,800 | 0,900 | 1,200 | 1,400 | <b>2.0</b> |                                   |
| 0,580 | 0,650 | 0,730 | 0,880 | 1,000 | 1,200 | 1,400 | 1,600 | <b>2.5</b> |                                   |

► I parametri di taglio indicati in tabella sono da considerarsi validi in condizioni macchina/pezzo ottimali  
The cutting parameters shown in the table have to be considered valid in optimal machine/workpiece conditions

