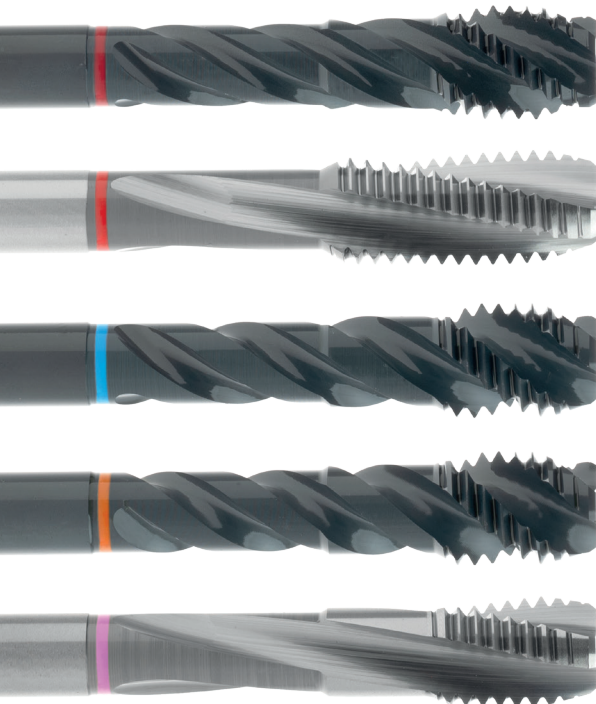


ISO P M S



MATERIAL SPECIFIC ACTION

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(*) Net price reported in the leaflet



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				PH-SP		PM-SP		SP-VA		ZEN-B		ZET-B	
				HSS-E OX		HSS-P		HSS-E OX		HSS-P OX		HSS-P NI	
													
TCTR (tolerance)				ISO2(6H)		ISO2X(6HX)		ISO2(6H)		ISO2X(6HX)		ISO2X(6HX)	
THCHT (chamfer)				2.5P		2.75P		2.5P		3P		3P	
Size (TD)	Pitch (TP)	Drill Ø (mm)	Hole Ø (mm)	edp	€	edp	€	edp	€	edp	€	edp	€
M3	0.5	2.50	2.56	SD3.0GAEEEX	12,22	SD3.0GBDPB	13,00	SD3.0GAGEX	9,54	SD3.0GBJPX	18,77	SD3.0GBIPN	19,68
M4	0.7	3.30	3.38	SD4.0IAEEEX	12,22	SD4.0IBDPB	13,00	SD4.0IAGEX	9,54	SD4.0IBJPX	18,77	SD4.0IBIPN	18,77
M5	0.8	4.20	4.28	SD5.0KAEEEX	12,58	SD5.0KBDPB	13,21	SD5.0KAGEX	9,83	SD5.0KBJPX	19,40	SD5.0KBIPN	19,40
M6	1	5.00	5.09	SD6.0MAEEEX	12,58	SD6.0MBDPB	13,31	SD6.0MAGEX	9,93	SD6.0MBJPX	19,40	SD6.0MBIPN	19,40
M8	1.25	6.80	6.85	SD8.0NAEEEX	15,31	SD8.0NBDPB	15,85	SD8.0NAGEX	12,00	SD8.0NBJPX	24,24	SD8.0NBIPN	24,24
M10	1.5	8.50	8.60	SD010OAEEX	18,39	SD010OBDPB	18,92	SD010OAGEX	14,36	SD010OBJPX	29,14	SD010OBIPN	29,14
M12	1.75	10.30	10.36	SG012PAEEX	23,95	SG012PBDPB	22,29	SG012PAGEX	18,48	SG012PBJPX	37,83	SG012PBIPN	37,83
M14	2	12	12.12	SG014QAEEX	28,75	SG014QBDPB	26,79	SG014QAGEX	22,21	SG014QBJPX	47,77	SG014QBIPN	45,61
M16	2	14	14.12	SG016QAEEX	36,33	SG016QBDPB	33,83	SG016QAGEX	28,07	SG016QBJPX	57,72	SG016QBIPN	57,72
M18	2.5	15.5	15.63	SG018RAEEX	49,27	SG018RBDPB	42,35	SG018RAGEX	35,11				
M20	2.5	17.5	17.63	SG020RAEEX	55,71	SG020RBDPB	49,92	SG020RAGEX	41,42				
M22	2.5	19.5	19.63	SG022RAEEX	70,97	SG022RBDPB	60,72	SG022RAGEX	50,37				
M24	3	21	21.13	SG024SAEEX	76,33	SG024SBDPB	68,80	SG024SAGEX	57,07				
				Vc (m/min)		Vc (m/min)		Vc (m/min)		Vc (m/min)		Vc (m/min)	
ISO P <900 N/mm ²								★	<10				
ISO P 900 ÷ 1150 N/mm ²				★	<8	★	<8						
ISO P 900 ÷ 1400 N/mm ²						★	<6						
ISO M 1.4301-AISI 304, 1.4305-AISI 303								★	<10	★	5 ÷ 15		
ISO M 1.4401-AISI 316, Duplex										★	5 ÷ 10		
ISO S Ni <35 HRC										★	3 ÷ 10		
ISO S Ni >35 HRC												★	3 ÷ 6
ISO S Ti												★	3 ÷ 8

★ 1st choice ☆ suitable

For difficult to cut workpiece materials such as stainless steel, Nickel base alloy or Titanium alloy we strongly recommend to prepare the hole size as large as possible

				PM-PO		PO-VA		ZEN-P		ZET-P	
				HSS-P		HSS-E OX		HSS-P NX		HSS-P NI	
											
TCTR (tolerance)				ISO2X(6HX)		ISO2X(6HX)		ISO2X(6HX)		ISO2X(6HX)	
THCHT (chamfer)				5.5P		4.5P		4.5P		5P	
Size (TD)	Pitch (TP)	Drill Ø (mm)	Hole Ø (mm)	edp	€	edp	€	edp	€	edp	€
M3	0.5	2.50	2.56	PD3.0GBDPB	11,34	PD3.0GBGEX	9,29	PD3.0GBJPW	18,86	LD3.0GBIPN	19,68
M4	0.7	3.30	3.38	PD4.0IBDPB	11,34	PD4.0IBGEX	9,29	PD4.0IBJPW	18,86	LD4.0IBIPN	19,68
M5	0.8	4.20	4.28	PD5.0KBDPB	11,80	PD5.0KBGEX	9,67	PD5.0KBJPW	19,40	LD5.0KBIPN	20,32
M6	1	5.00	5.09	PD6.0MBDPB	11,80	PD6.0MBGEX	9,76	PD6.0MBJPW	19,40	LD6.0MBIPN	19,40
M8	1.25	6.80	6.85	PD8.0NBDPB	13,96	PD8.0NBGEX	11,69	PD8.0NBJPW	24,24	LD8.0NBIPN	24,24
M10	1.5	8.50	8.60	PD10.0BDPB	19,07	PD10.0BGEX	13,99	PD10.0BJPW	28,75	LD10.0BIPN	30,59
M12	1.75	10.30	10.36	PG012PBDPB	21,77	PG012PBGEX	18,06	PG012PBJPW	37,83	LG012PBIPN	38,19
M14	2	12	12.12	PG014QBDPB	26,20	PG014QBGEX	21,74	PG014QBJPW	47,77		
M16	2	14	14.12	PG016QBDPB	33,01	PG016QBGEX	27,37	PG016QBJPW	60,44	LG016QBIPN	61,01
M18	2.5	15.5	15.63	PG018RBDPB	41,28	PG018RBGEX	34,24				
M20	2.5	17.5	17.63	PG020RBDPB	48,74	PG020RBGEX	40,44				
M22	2.5	19.5	19.63	PG022RBDPB	59,24	PG022RBGEX	49,14				
M24	3	21	21.13	PG024SBDPB	67,08	PG024SBGEX	55,67				
				Vc (m/min)		Vc (m/min)		Vc (m/min)		Vc (m/min)	
ISO P <900 N/mm ²						★	<10				
ISO P 900 ÷ 1150 N/mm ²				★	<10						
ISO P 900 ÷ 1400 N/mm ²				★	<6						
ISO M 1.4301-AISI 304, 1.4305-AISI 303						★	<10	★	5 ÷ 15		
ISO M 1.4401-AISI 316, Duplex								★	5 ÷ 10		
ISO S Ni <35 HRC								★	3 ÷ 10		
ISO S Ni >35 HRC								★	3 ÷ 6	★	3 ÷ 6
ISO S Ti										★	3 ÷ 8

★ 1st choice ☆ suitable

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