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# CVD TECHNOLOGY

Chemical Vapor Deposition



**MEGACOAT**  
NANO EX | Milling



WE PROVIDE  
THE BEST SERVICE



**Pfeifer-tti**

Tehnika - Tehnologija - Informacija

2023.



# LJETNA PROMOCIJA

**Napredna produktivnost s najnovijom tehnologijom**



# NOVITETI



**Kupnjom 10 pločica po ležištu glodala  
cijena glodače glave 1€**

**Pri kupnji 30 pločica dobivate  
10 dodatnih pločica + majica GRATIS!!!**

### 90° tangencialno glodalo

MA90



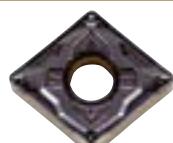
45° glodalo

# MB45



Nova CVD presvlaka za čelik

## **CA125P/CA115P**



## **HYBRID CERMET**



# **PR115S/PR120S**





90° tangencijalno glodalo

## MA90

jedinstven dizajn 90° tangencijalnog čeonog glodala pruža veliki izbor operacija strojne obrade



Kontinuirani i isprekidani rez

## CA125P/CA115P

Nova CVD presvlaka za čelik



**PMG  
lomač**

Za srednju i grubu obradu



Za tokarenje čelika i legura otpornih na toplinu  
- završna i gruba obrada

## PR115S/PR120S



Nova PVD presvlaka pruža  
stabilnu i odličnu obradu



Predstavljamo novu PVD presvlaku serije PR18

Duži vijek alata, novi dizajn pločica s presvlakom PR18, visoka kvaliteta obrade površine s garancijom presvlake za glodanje i tokarenje

45° glodalo

## MB45

iznimno svestrano glodalo, visoke performanse, visoke kvalitete i vijeka trajanja alata



Za obradu čelika - finiširanje

## HYBRID CERMET

Odlična završna obrada s cermetom sa i bez presvlake



THE NEW VALUE FRONTIER



# MFH Serija

**Glodalo visoke učinkovitosti i posmaka****Stabilna strojna obrada s većom otpornošću**

Promjeri glodala veći od Ø8.

Kraće vrijeme ciklusa pri grubim obradama.

MFH Mini/Micro glodala visokog posmaka za male obradne centre.

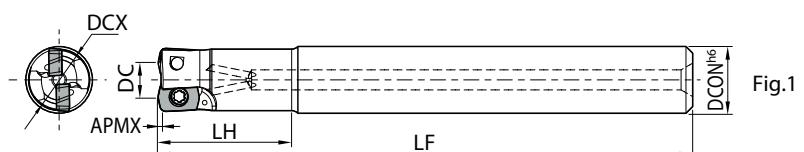
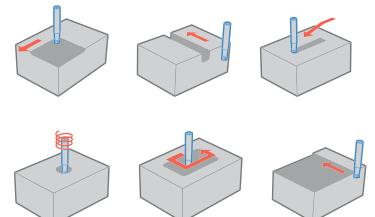
Novi GH lomač i PR15S presvlaka.

**NOVO**MFH Micro  
Ø8 - Ø16MFH Mini  
Ø16 - Ø52MFH Harrier  
Ø25 - Ø160MFH Boost  
Ø25 - Ø80



# **MFH MICRO**

**BRZE GLAVE OD Ø8 DO Ø16**

**Dimenziije glodače glave****ODGOVARAJUĆE PLOČICE LPGT010210**

Shank	Description	Avail-ability	No. of inserts	Dimensions (mm)						Max. ramping angle	Rake angle A.R.	Coolant hole	Drawing	Weight (kg)	Max. revolution (min <sup>-1</sup> )
				DCX	DC	DCON	LF	LH	APMX						
Standard (Straight)	MFH08-S10-01-1T	●	1	8	4.2	10	75	16	0.5	4°	+5°	Yes	Fig.1	0.04	20,000
	MFH10-S10-01-2T	●	2	10	6.2	10	80	20		3°				0.04	16,200
	MFH12-S12-01-3T	●	3	12	8.2	12	80	20		2°				0.06	14,000
	MFH16-S16-01-4T	●	4	16	12.2	16	90	25		1.2°				0.12	11,400

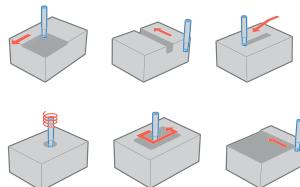
**KUPNJOM 10 PLOČICA po ležištu glodala  
cijena glodače glave 1€**

**MFH Micro**

Insert	Description	Dimensions (mm)					MEGACOAT NANO		CVD coated carbide
		W1	S	D1	INSL	RE	PR1835	PR1825	CA6535
 General purpose	 LPGT 010210ER-GM	4.19	2.19	2.1	6.26	1.0			

# MFH MINI

BRZE GLAVE OD Ø16 DO Ø52



1€

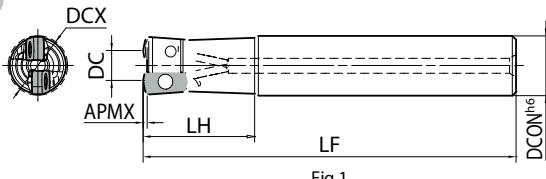


Fig.1

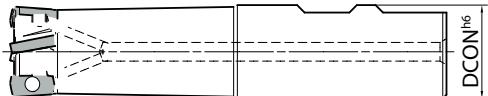


Fig.3

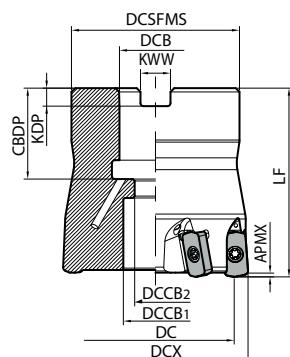
Dimenzije glodače glave

ODGOVARAJUĆE PLOČICE LOGU 030310

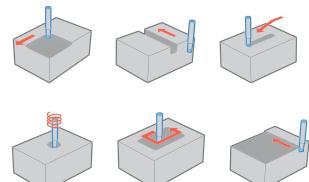
Shank	Description	Avail-ability	No. of inserts	Dimensions (mm)						Rake angle	Coolant hole	Drawing	Weight (kg)	Max. revolution (min-1)
				DCX	DC	DCON	LF	LH	APMX					
Standard (Straight)	MFH 16-S16-03-2T	●	2	16	8	16	100	30		1	-10°	Yes	0.1	18,800
	MFH 20-S20-03-3T	●	3	20	12	20	130	50					0.3	15,700
	20-S20-03-4T	●	4	20	12	20	130	50					0.3	15,700
	MFH 25-S25-03-4T	●	4	25	17	25	140	60					0.5	13,400
	25-S25-03-5T	●	5	25	17	25	140	60					0.5	13,400
	MFH 32-S32-03-5T	●	5	32	24	32	150	70					0.8	11,400
	32-S32-03-6T	●	6	32	24	32	150	70					0.8	11,400
Standard (Weldon)	MFH 16-W16-03-2T	●	2	16	8	16	79	30		1	-10°	Yes	0.1	18,800
	MFH 20-W20-03-3T	●	3	20	12	20	101	50					0.2	15,700
	20-W20-03-4T	●	4	20	12	20	101	50					0.2	15,700
	MFH 25-W25-03-4T	●	4	25	17	25	117	60					0.4	13,400
	25-W25-03-5T	●	5	25	17	25	117	60					0.4	13,400
	MFH 32-W32-03-5T	●	5	32	24	32	131	70					0.7	11,400
	32-W32-03-6T	●	6	32	24	32	131	70					0.7	11,400
Long shank (Straight)	MFH 16-S16-03-2T-150	●	2	16	8	16	150	50		1	-10°	Yes	0.2	18,800
	MFH 20-S20-03-3T-160	●	3	20	12	20	160	80					0.3	15,700
	MFH 25-S25-03-4T-180	●	4	25	17	25	180	100					0.6	13,400
	MFH 32-S32-03-5T-200	●	5	32	24	32	200	120					1.1	11,400



1€



KYOCERA



Dimenzije glodače glave

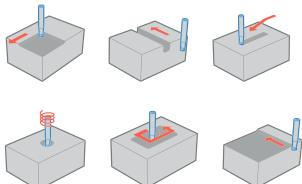
ODGOVARAJUĆE PLOČICE LOGU 030310

Description	Avail-ability	No. of inserts	Dimensions (mm)									Rake angle	Coolant hole	Weight (kg)	Max. revolution (min-1)		
			DCX	DC	DCSFMS	DCB	DCCB <sup>1</sup>	DCCB <sup>2</sup>	LF	CBDP	KDP						
MFH 040R-03-5T-M	●	5	40	32	38	16	15	9	40	19	5.6	8.4	1	-10°	Yes	0.2	9,900
	●	6	40	32	38	16	15	9	40	19	5.6	8.4					
	●	7	40	32	34	16	14	9	40	19	5.6	8.4					
	●	7	42	34	34	16	15	9	40	19	5.6	8.4					
	●	8	50	42	47	22	19	11	50	21	6.3	10.4					
	●	8	52	44	47	22	19	11	40	21	6.3	10.4					
	●	8	52	44	47	22	19	11	40	21	6.3	10.4					

## MFH Mini

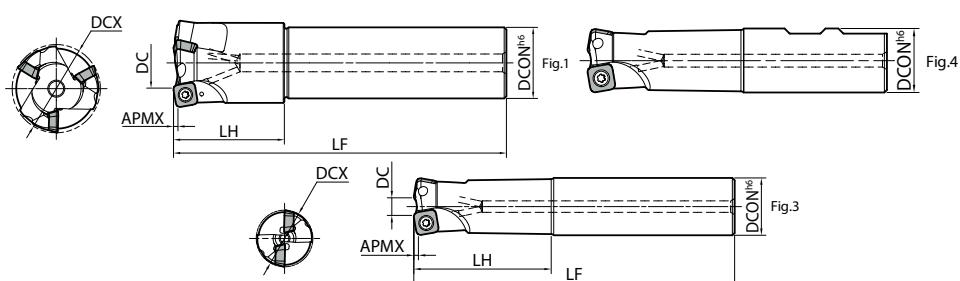
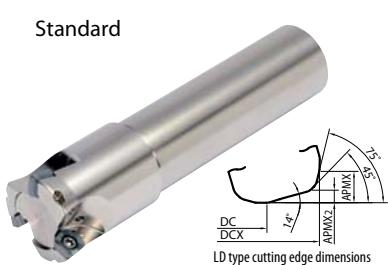
Insert	Description	Dimensions (mm)					MEGACOAT NANO			MEGACOAT HARD	CVD coated carbide
		W1	S	D1	INSL	RE	PR1835	PR1825	PR1810	PR0155	CA6535
General purpose	LOGU030310ER-GM	6.2	3.96	3.45	11.9	1.0	●	●	●	-	●
Tough edge	LOGU030310ER-GH	6.2	3.96	3.45	11.9	1.0	●	●	●	●	-

**KUPNJOM 10 PLOČICA po ležištu glodala cijena glodače glave 1€**



## MFH HARRIER

BRZE GLAVE



### Dimenziije glodače glave

### ODGOVARAJUĆE PLOČICE SOMT 100420

Shank	Description	Avail-ability	No. of inserts	Dimensions (mm)							Rake angle	Coolant hole	Drawing	Weight (kg)	Max. revolution (min <sup>-1</sup> )
				DCX	DC			DCON	LF	LH	APMX	APMX <sup>2</sup>	A.R.		
Standard (Straight)	MFH 25-S25-10-2T	●	2	25	8	12.5	11.5	25	140	60	1.5 (3.5) *	1.2	+10°	Yes	Fig.3
	MFH 28-S25-10-2T	●	2	28	11	15.5	14.5	25	140	40					
	MFH 32-S32-10-2T	●	2	32	15	19.5	18.5	32	150	70					
	32-S32-10-3T	●	3	32	15	19.5	18.5	32	150	70					
	MFH 35-S32-10-2T	●	2	35	18	22.5	21.5	32	150	50					Fig.1
	35-S32-10-3T	●	3	35	18	22.5	21.5	32	150	50					
	MFH 40-S32-10-3T	●	3	40	23	27.5	26.5	32	150	50					Fig.1
	40-S32-10-4T	●	4	40	23	27.5	26.5	32	150	50					
Standard (Weldon)	MFH 25-W25-10-2T	●	2	25	8	12.5	11.5	25	117	60	1.5 (3.5)	1.2	+10°	Yes	Fig.4
	MFH 32-W32-10-3T	●	3	32	15	19.5	18.5	32	131	70					

# MFH HARRIER

## BRZE GLAVE



1€

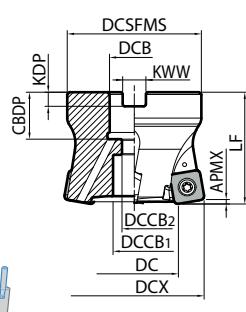
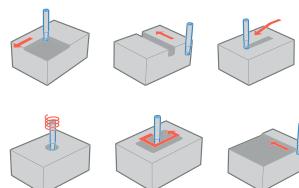


Fig.1

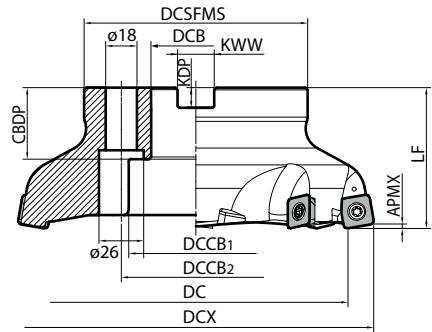


Fig.3

### Dimenziije glodaće glave

Description	Avail-ability	No. of inserts	Dimensions (mm)												Rake angle	Coolant hole	Drawing	Weight (kg)	Max. revolution (min-1)	
			DCX			DC		DCSFMS	DCB	DCCB <sup>1</sup>	DCCB <sup>2</sup>	LF	CBDP	KDP	KWW	APMX				
			GM-GH	LD	FL															
MFH 050R-10-4T-M	●	4	50	33	37.5	36.5	47	22	19	11	50	21	6.3	10.4	1.5 (3.5) *2	+10°	Yes	Fig.1	0.4	10,000
050R-10-5T-M	●	5	50	33	37.5	36.5	47	22	19	11	50	21	6.3	10.4					0.4	10,000
MFH 052R-10-4T-M	●	4	52	35	39.5	38.5	47	22	19	11	50	21	6.3	10.4	1.5 (3.5) *2	+10°	Yes	Fig.1	0.4	10,000
052R-10-5T-M	●	5	52	35	39.5	38.5	47	22	19	11	50	21	6.3	10.4					0.4	10,000
MFH 063R-10-5T-22M	●	5	63	46	50.5	49.5	60	22	19	11	50	21	6.3	10.4	1.2	+10°	Yes	Fig.1	0.7	8,800
063R-10-6T-22M	●	6	63	46	50.5	49.5	60	22	19	11	50	21	6.3	10.4					0.7	8,800
063R-10-5T-27M	●	5	63	46	50.5	49.5	60	27	20	13	50	24	7	12.4	1.2	+10°	Yes	Fig.1	0.7	8,800
063R-10-6T-27M	●	6	63	46	50.5	49.5	60	27	20	13	50	24	7	12.4					0.7	8,800
MFH 080R-10-7T-M	●	7	80	63	67.5	66.5	76	27	20	13	63	24	7	12.4	1.2	+10°	Yes	Fig.1	1.6	7,600

### MFH Harrier

Classification of usage		P	Carbon steel / alloy steel							★	★					Applicable toolholders			
			Die steel																
★ : Roughing / 1st choice		M	Austenitic stainless steel							★	★								
			Martensitic stainless steel							★									
			Precipitation hardened stainless steel							★									
			Gray cast iron																
■ : Roughing / 2nd choice		K	Nodular cast iron																
			Ni-base heat-resistant alloy							★									
			Titanium alloy (ti-6al-4v)							★									
□ : Finishing / 1st choice		S	High hardness steel																
										★									
Insert			Description		Dimensions (mm)					Angle (°)	MEGACOAT NANO			MEGACOAT HARD	CVD coated carbide				
			IC	S	D1	BS	RE	AN	PR1835	PR1825	PR1810	PR0155	CA6535						
				SOMT100420ER-GM	10.30	4.58	4.6	–	2.0	16	●	●	●	–	●				
				SOMT100420ER-LD	10.45	4.58	4.6	0.9	2.0	16	●	●	●	–	●				
				SOMT100420ER-FL	10.44	4.58	4.6	1.4	2.0	16	●	●	●	–	●				
				SOMT100420ER-GH	10.43	4.57	4.55	–	2.0	16	●	●	●	–	–				



1€

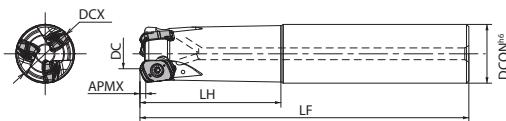


Fig.1

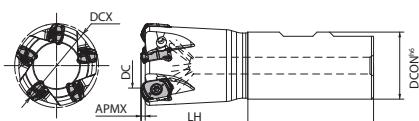


Fig.4

- Glodače glave za velike posmake
- Dubina glodanja do 2,5 mm
- Izvrsne performanse u širokim rasponu primjena, uključujući dijelove za auto-industriju, teško obradive materijale i kalupe

**KYOCERA**

# MFH BOOST

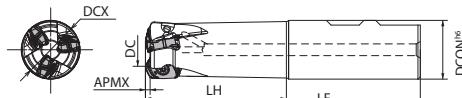
**BRZE GLAVE**

Fig.3

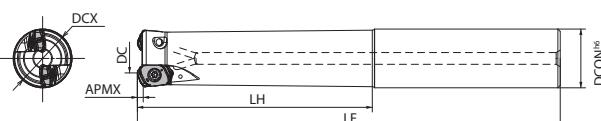


Fig.5



Fig.6

**KUPNJOM 10 PLOČICA  
po ležištu glodala cijena  
glodače glave 1€**

**Dimenzije glodače glave****ODGOVARAJUĆE PLOČICE LOMU 040410**

Shank	Description	Availability	No. of inserts	Dimensions (mm)						Rake angle	Coolant hole	Shape	Weight (kg)	Max. revolution (min⁻¹)
				DCX	DC	DCON	LH	LF	APMX					
Standard (Straight)	MFH 25-S25-04-2T	●	2	25	14	25	60	140	2.5	-10°	Yes	Fig.1	0.5	12,700
	25-S25-04-3T	●	3										0.5	11,200
	32-S32-04-4T	●	4	32	21	32	70	150					0.8	11,200
	32-S32-04-5T	●	5										0.8	
Standard (Weldon)	MFH 25-W25-04-2T	●	2	25	14	25	60	117	2.5	-10°	Yes	Fig.3	0.4	12,700
	25-W25-04-3T	●	3										0.4	
	32-W32-04-4T	●	4	32	21	32	70	131				Fig.3	0.7	11,200
	32-W32-04-5T	●	5				50	111					0.7	
	40-W32-04-5T	●	6	40	29							Fig.4	0.7	10,000
	40-W32-04-6T	●											0.7	
Long Shank (Straight)	MFH 25-S25-04-2T-180	●	2	25	14	25	100	180	2.5	-10°	Yes	Fig.5	0.6	12,700
	25-S25-04-3T-180	●	3				40						0.6	
	28-S25-04-3T-200	●	4	28	17		120	200				Fig.6	0.7	12,000
	32-S32-04-4T-200	●	4	32	21	32	50	250					1.1	11,200
	35-S32-04-4T-200	●	5	35	24							Fig.6	1.1	10,700
	40-S32-04-5T-250	●	5	40	29		50						1.5	

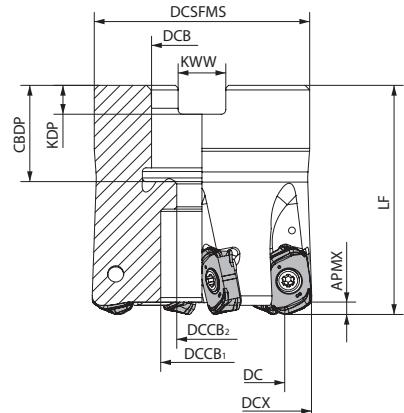
Caution with max. revolution

● : Available

# KYOCERA

## MFH BOOST

### BRZE GLAVE



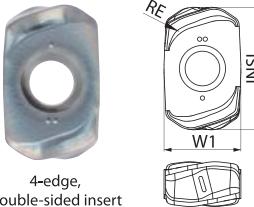
Dimenziije glodače glave

Description	Availability	No. of inserts	Dimensions (mm)										Rake angle	Coolant hole	Weight (kg)	Max. revolution (min <sup>-1</sup> )
			DCX	DC	DCSFMS	DCB	DCCB <sub>1</sub>	DCCB <sub>2</sub>	LF	CBDP	KDP	KWW	APMX			
MFH 040R-04-5T-M	●	5	40	29	38	16	1594		01	95	.6	8.4			0.2	10,000
040R-04-6T-M	●	6	50	39											0.2	
050R-04-6T-M	●														0.4	9,000
050R-04-7T-M	●	7	52	41	47	22	18	11	50	21	6.3	10.4			0.4	
052R-04-6T-M	●	6													0.5	8,800
052R-04-7T-M	●														0.4	
063R-04-7T-M	●	7	63	52	60										0.8	8,000
063R-04-9T-M	●	9													0.8	
063R-04-7T-27M	●	7													0.8	8,000
063R-04-9T-27M	●	9													0.7	
080R-04-8T-M	●	8	80	69	76	27	20	13	63	24	7.0	12.4			1.8	7,100
080R-04-10T-M	●	10													1.7	

Caution with max. revolution

**KUPNJOM 10 PLOČICA po ležištu glodala cijena glodače glave 1€**

#### Odgovarajuće pločice

Shape	Description	Dimensions (mm)					MEGACOAT NANO			CVD Coating
		W1	S	D1	INSL	RE	PR1835	PR1825	PR1810	
 4-edge, Double-sided insert	LOMU 040410ER-GM	9.1	4.4	4.1	14.5	1.0	●	●	●	CA6535

#### Oznaka kvalitete pločica:

PR1835 za obradu čelika, titana, poboljšanog čelika itd.

PR1825 Za obradu čelika - opća upotreba.

PR1810 Za obradu sivog lijeva.

PR6535 Za obradu INOX-a i legura otpornih na visoke temperature.

## MFH Micro | Preporučeni režimi rada

★ 1. izbor

☆ 2. izbor

Insert	Workpiece	Holder description and feed rate (fz: mm/t) Recommended feed ap = 0.3 mm (reference value)					Recommended insert grade (Vc: m/min)		
		MFH08-...-1T		MFH10-...-2T		MFH12-...-3T	MFH14-...-3T	MFH16-...-4T	MEGACOAT NANO
		PR1825				PR1835	CA6535		CVD coated carbide
GM	Carbon steel	0.2 – 0.4 – 0.6		0.2 – 0.5 – 0.8		★ 120 – 180 – 250	☆ 120 – 180 – 250	–	–
	Alloy steel								
	Die steel ~40 HRC	0.2 – 0.3 – 0.5		0.2 – 0.4 – 0.6		★ 80 – 140 – 180	☆ 80 – 140 – 180	–	–
	Die steel 40~50 HRC	0.2 – 0.25 – 0.3		0.2 – 0.25 – 0.4		★ 60 – 100 – 130	☆ 60 – 100 – 130	–	–
	Austenitic stainless steel	0.2 – 0.3 – 0.5		0.2 – 0.4 – 0.6		☆ 100 – 160 – 200	★ 100 – 160 – 200	–	–
	Martensitic stainless steel					–	☆ 150 – 200 – 250	★ 180 – 240 – 300	–
	Precipitation hardened stainless steel					–	★ 90 – 120 – 150	–	–
	Gray cast iron	0.2 – 0.4 – 0.6		0.2 – 0.5 – 0.8		★ 120 – 180 – 250	–	–	–
	Nodular cast iron	0.2 – 0.3 – 0.5		0.2 – 0.4 – 0.6		★ 100 – 150 – 200	–	–	–
	Ni-base heat-resistant alloy	0.2 – 0.25 – 0.3		0.2 – 0.25 – 0.4		–	☆ 20 – 30 – 50	★ 20 – 30 – 50	–
	Titanium alloy					–	★ 40 – 60 – 80	–	–

Machining with coolant is recommended for Ni-base heat resistant alloy and titanium alloy. The number in bold font is recommended starting conditions. Adjust the cutting speed and the feed rate within the above conditions according to the actual machining situation. Internal coolant is recommended for slotting applications.

## MFH Mini | Preporučeni režimi rada

★ 1. izbor

☆ 2. izbor

Insert	Workpiece	Holder description and feed rate (fz: mm/t) Recommended feed ap = 0.5 mm (reference value)								Recommended insert grade (vc: m/min)						
		MFH16-...-2T		MFH20-...-3T		MFH20-...-4T		MFH25-...-5T		MFH32-...-6T		MFH-...-R-03	MEGACOAT NANO	MEGACOAT HARD	CVD coated carbide	
		PR1835	PR1825	PR1810	PR0155	CA6535										
GM GH	Carbon steel	0.2 – 0.7 – 1.2	0.2 – 0.5 – 0.8	0.2 – 0.8 – 1.5	0.2 – 0.5 – 0.8	0.2 – 0.8 – 1.5	0.2 – 0.5 – 0.8	0.2 – 0.5 – 0.8	0.2 – 0.5 – 0.8	0.2 – 0.5 – 0.8	0.2 – 0.5 – 0.8	0.2 – 0.5 – 0.8	☆ 120 – 180 – 250	★ 120 – 180 – 250	–	–
	Alloy steel												☆ 100 – 160 – 220	★ 100 – 160 – 220	–	–
	~40HRC	0.2 – 0.5 – 0.9	0.2 – 0.4 – 0.6	0.2 – 0.6 – 1.2	0.2 – 0.4 – 0.6	0.2 – 0.6 – 1.2	0.2 – 0.4 – 0.6	0.2 – 0.4 – 0.6	0.2 – 0.4 – 0.6	0.2 – 0.4 – 0.6	0.2 – 0.4 – 0.6	0.2 – 0.4 – 0.6	☆ 80 – 140 – 180	☆ 80 – 140 – 180	–	GH ★ 80 – 140 – 180
	40~50HRC	0.2 – 0.3 – 0.5	0.2 – 0.25 – 0.3	0.2 – 0.3 – 0.6	0.2 – 0.25 – 0.3	0.2 – 0.3 – 0.6	0.2 – 0.25 – 0.3	0.2 – 0.25 – 0.3	0.2 – 0.25 – 0.3	0.2 – 0.25 – 0.3	0.2 – 0.25 – 0.3	0.2 – 0.25 – 0.3	–	☆ 60 – 100 – 130	GH ★ 60 – 100 – 130	–
	Die steel	50~55HRC	0.1 – 0.3 – 0.5	0.1 – 0.2 – 0.3	0.1 – 0.3 – 0.5	0.1 – 0.2 – 0.3	0.1 – 0.3 – 0.5	0.1 – 0.2 – 0.3	0.1 – 0.2 – 0.3	0.1 – 0.2 – 0.3	0.1 – 0.2 – 0.3	0.1 – 0.2 – 0.3	–	☆ 50 – 70 – 100	GH ★ 50 – 70 – 100	–
	55~60HRC	0.03 – 0.06 – 0.1 (*Recommended only for GH chipbreaker)								–	–	–	–	GH ☆ 50 – 60 – 70	–	–
	Austenitic stainless steel	0.2 – 0.5 – 0.9	0.2 – 0.4 – 0.6	0.2 – 0.6 – 1.2	0.2 – 0.4 – 0.6	0.2 – 0.6 – 1.2	0.2 – 0.4 – 0.6	0.2 – 0.4 – 0.6	0.2 – 0.4 – 0.6	0.2 – 0.4 – 0.6	0.2 – 0.4 – 0.6	0.2 – 0.4 – 0.6	GM ★ 100 – 160 – 200	GM ☆ 100 – 160 – 200	–	–
	Martensitic stainless steel												☆ 150 – 200 – 250	–	–	★ 180 – 240 – 300
	Precipitation hardened stainless steel												★ 90 – 120 – 150	–	–	–
	Gray cast iron	0.2 – 0.7 – 1.2	0.2 – 0.5 – 0.8	0.2 – 0.8 – 1.5	0.2 – 0.5 – 0.8	0.2 – 0.8 – 1.5	0.2 – 0.5 – 0.8	0.2 – 0.5 – 0.8	0.2 – 0.5 – 0.8	0.2 – 0.5 – 0.8	0.2 – 0.5 – 0.8	0.2 – 0.5 – 0.8	–	★ 120 – 180 – 250	–	–
	Nodular cast iron	0.2 – 0.5 – 0.9	0.2 – 0.4 – 0.6	0.2 – 0.6 – 1.2	0.2 – 0.4 – 0.6	0.2 – 0.6 – 1.2	0.2 – 0.4 – 0.6	0.2 – 0.4 – 0.6	0.2 – 0.4 – 0.6	0.2 – 0.4 – 0.6	0.2 – 0.4 – 0.6	0.2 – 0.4 – 0.6	–	★ 100 – 150 – 200	–	–
	Ni-base heat-resistant alloy	0.2 – 0.3 – 0.6	0.2 – 0.25 – 0.4	0.2 – 0.4 – 0.8	0.2 – 0.25 – 0.4	0.2 – 0.4 – 0.8	0.2 – 0.25 – 0.4	0.2 – 0.25 – 0.4	0.2 – 0.25 – 0.4	0.2 – 0.25 – 0.4	0.2 – 0.25 – 0.4	0.2 – 0.25 – 0.4	☆ 20 – 30 – 50	–	–	★ 20 – 30 – 50
	Titanium alloy												GM ★ 40 – 60 – 80	GM ☆ 30 – 50 – 70	–	–

The number in bold font is recommended starting conditions. Adjust the cutting speed and the feed rate within the above conditions according to the actual machining situation

• Machining with coolant is recommended for Ni-base heat resistant alloy and titanium alloy • Machining with BT30 or equivalent, feed rate should be reduced to 25% of recommended cutting conditions • Internal coolant is recommended for slotting applications • Slotting and pocketing are not recommended for face mill type.

Fine pitch

Standard pitch

**MFH Boost | Preporučeni režimi rada**

★ 1. izbor

☆ 2. izbor

Chipbreaker	Workpiece	Toolholder description and feed (fz: mm/t)		Recommended insert grade (Vc: m/min)			
		ap(mm)	MFH...04...	MEGACOAT NANO			CVD Coating
				PR1835	PR1825	PR18-10	CA6535
GM	Carbon steel (~ 280HB)	≤ 0.5	0.20 – 0.80 – 1.30	120 – 160 – 220 ☆	120 – 160 – 220 ★	–	–
		≤ 1.0	0.20 – 0.70 – 1.10				
		≤ 1.5	0.20 – 0.60 – 0.80				
		≤ 2.0	0.20 – 0.40 – 0.70				
		≤ 2.5	0.20 – 0.30 – 0.50				
	Alloy steel (~ 350HB)	≤ 0.5	0.20 – 0.75 – 1.20	100 – 150 – 200 (Dry machining recommended) ☆	100 – 150 – 200 (Dry machining recommended) ★	–	–
		≤ 1.0	0.20 – 0.65 – 1.00				
		≤ 1.5	0.20 – 0.55 – 0.70				
		≤ 2.0	0.20 – 0.40 – 0.55				
		≤ 2.5	0.20 – 0.25 – 0.35				
	Mold steel (40 ~ 50HRC)	≤ 0.5	0.20 – 0.60 – 1.10	80 – 120 – 160 (Dry machining recommended) ☆	80 – 120 – 160 (Dry machining recommended) ★	–	–
		≤ 1.0	0.20 – 0.50 – 0.90				
		≤ 1.5	0.20 – 0.40 – 0.65				
		≤ 2.0	0.20 – 0.30 – 0.55				
		≤ 2.5	0.20 – 0.25 – 0.35				
	(50 ~ 55HRC)	≤ 0.5	0.10 – 0.30 – 0.50	–	60 – 100 – 130 (Dry machining recommended) ★	–	–
		≤ 1.0	0.10 – 0.25 – 0.40				
		≤ 1.5	0.10 – 0.20 – 0.30				
		≤ 2.0	–				
		≤ 2.5	–				
	Austenitic stainless steel	≤ 0.5	0.20 – 0.60 – 1.00	100 – 140 – 180 ★	100 – 140 – 180 ☆	–	–
		≤ 1.0	0.20 – 0.50 – 0.90				
		≤ 1.5	0.20 – 0.45 – 0.60				
		≤ 2.0	0.20 – 0.30 – 0.50				
		≤ 2.5	0.20 – 0.25 – 0.40				
	Martensitic stainless steel	≤ 0.5	0.20 – 0.60 – 1.00	100 – 150 – 200 ☆	–	–	150 – 200 – 300 ★
		≤ 1.0	0.20 – 0.50 – 0.90				
		≤ 1.5	0.20 – 0.45 – 0.60				
		≤ 2.0	0.20 – 0.30 – 0.50				
		≤ 2.5	0.20 – 0.25 – 0.40				
	Precipitation hardened stainless steel	≤ 0.5	0.10 – 0.30 – 0.50	90 – 120 – 150 ★	–	–	–
		≤ 1.0	0.10 – 0.25 – 0.45				
		≤ 1.5	0.10 – 0.15 – 0.25				
		≤ 2.0	–				
		≤ 2.5	–				
	Gray cast iron	≤ 0.5	0.20 – 0.80 – 1.30	–	–	120 – 160 – 220 ★	–
		≤ 1.0	0.20 – 0.70 – 1.10				
		≤ 1.5	0.20 – 0.60 – 0.80				
		≤ 2.0	0.20 – 0.40 – 0.70				
		≤ 2.5	0.20 – 0.30 – 0.50				
	Nodular cast iron	≤ 0.5	0.20 – 0.60 – 1.00	–	–	100 – 150 – 200 ★	–
		≤ 1.0	0.20 – 0.50 – 0.90				
		≤ 1.5	0.20 – 0.40 – 0.70				
		≤ 2.0	0.20 – 0.30 – 0.60				
		≤ 2.5	0.20 – 0.25 – 0.40				
	Ni-base heat-resistant alloy	≤ 0.5	0.10 – 0.30 – 0.45	20 – 30 – 50 ☆	–	–	20 – 30 – 50 ★
		≤ 1.0	0.10 – 0.25 – 0.40				
		≤ 1.5	0.10 – 0.15 – 0.20				
		≤ 2.0	–				
		≤ 2.5	–				
	Titanium alloy	≤ 0.5	0.10 – 0.30 – 0.50	40 – 60 – 80 ★	–	–	–
		≤ 1.0	0.10 – 0.25 – 0.45				
		≤ 1.5	0.10 – 0.15 – 0.25				
		≤ 2.0	–				
		≤ 2.5	–				

THE NEW VALUE FRONTIER



# MA90

**NOVO****Tangencijalno glodalo 90° s 4 rezne oštrice****Pouzdana, stabilna visokokvalitetna obrada s produženim vijekom trajanja alata**

Jedinstven dizajn 90° tangencijalnog čeonog glodala pruža veliki izbor operacije strojne obrade.

Novi dizajn pločica s presvlakom PR18.

Visokokvalitetna obrada površine i izvrsna točnost.

Podržava višenamjensku obradu kao što je 3D - glodanje.





# MA90



1€

KUPNJOM 10 PLOČICA po ležištu  
glodala cijena glodače glave 1€

Dimenziije glodače glave

NOVO

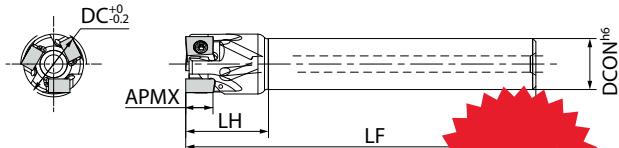


Fig.1

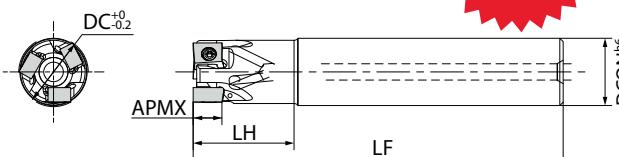
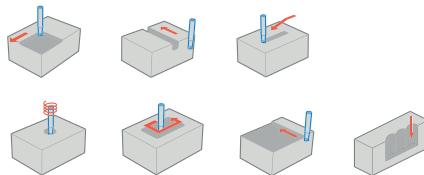


Fig.2



## ODGOVARAJUĆE PLOČICE LOGU 09

Description		Avail-ability	Number of inserts	Dimensions (mm)					Coolant hole	Shape	Weight (kg)	Maximum number of revolutions (min <sup>-1</sup> )					
				DC	DCON	LF	LH	APMX									
Standard shank	MA90 - 16S12-09T2C	●	2	16	12	100	23	16	Fig.1	Yes	0.1	29,500					
	18S16-09T2C	●		18	20		26					27,900					
	20S16-09T2C	●		20	110	0.2						26,600					
	20S16-09T3C	●		22	25	120	29					25,400					
	22S20-09T3C	●	3	25								0.3	23,900				
	25S20-09T3C	●		25								22,600					
	25S20-09T4C	●		30	25	130	32					0.5	21,900				
	28S25-09T3C	●	3	28								0.9	21,200				
	30S25-09T4C	●	4	35	32	150	50					1.0	20,300				
	32S25-09T4C	●		35								0.7	19,000				
	32S25-09T5C	●	5	40	32	120	40					0.9	17,000				
	35S32-09T4C	●	4	40								0.4	23,900				
	35S32-09T5C	●	5	40	32	130	40					0.7	21,200				
	40S32-09T4C	●	6	50								0.3	26,600				
	40S32-09T6C	●	7	50	32	100	26					0.6	23,900				
	50S32-09T5C	●	5	50								1.1	21,200				
Same size shank	MA90 - 16S16-09T2C	●	2	16	16	100	26	Fig.2	Yes	0.1	29,500						
	20S20-09T2C	●		20	20	110	30				0.2	26,600					
	20S20-09T3C	●	3	25	25	120	32				0.4	23,900					
	25S25-09T3C	●		25	32	130	40					0.7	21,200				
	25S25-09T4C	●	4	32								0.3	26,600				
	32S32-09T4C	●		32								0.6	23,900				
	32S32-09T5C	●	5	32								1.1	21,200				
Long shank	MA90 - 20S18-09T2CL	●	2	20	18	150	30	Fig.1	Yes	0.3	26,600						
	20S20-09T2CL	●		20	20	150	40				0.6	23,900					
	25S25-09T2CL	●		25	25	170	50				1.1	21,200					
	32S32-09T2CL	●		32	32	200	65				0.9	20,300					

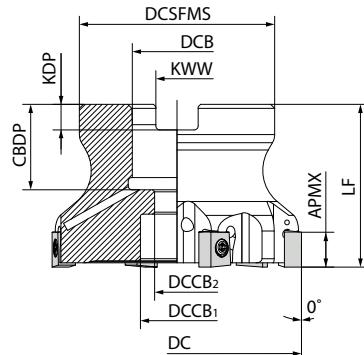
**ODGOVARAJUĆE PLOČICE LOGU 12**

Description		Avail-ability	Number of inserts	Dimensions (mm)					Coolant hole	Shape	Weight (kg)	Maximum number of revolutions (min <sup>-1</sup> )							
				DC	DCON	LF	LH	APMX											
Standard shank	MA90 - 25S20-12T2C	●	2	25	20	120	29	12	Yes	Fig.1	0.3	18,300							
	28S25-12T2C	●		28	30						0.4	17,300							
	30S25-12T2C	●	3	32	25	130	32				0.5	16,800							
	30S25-12T3C	●										16,300							
	32S25-12T2C	●										0.9	15,600						
	32S25-12T3C	●	3	35	40	150	50						14,600						
	35S32-12T3C	●					0.8					13,100							
	40S32-12T3C	●	4	50	32	120						40						0.7	16,300
	40S32-12T4C	●					0.6					18,300							
	50S32-12T4C	●										16,300							
	50S32-12T6C	●	6	2	32	32	130	40	12	Yes	Fig.2	0.6	18,300						
Same size shank	MA90 - 25S25-12T2C	●	0.7										16,300						
	32S32-12T2C	●	3	32	32	130	40												
	32S32-12T3C	●																	
Long shank	MA90 - 25S25-12T2CL	●	2	25	25	170	50	12	Yes	Fig.2	0.6	18,300	1.1	16,300					
	32S32-12T2CL	●		32	32	200	65												

Maximum number of revolutions

Do not use the End mill or cutter at the maximum revolution or higher since the centrifugal force may cause chips and parts to scatter even under no load.





**KYOCERA**

**MEGACOAT  
NANO EX | Milling |**

Fig.1

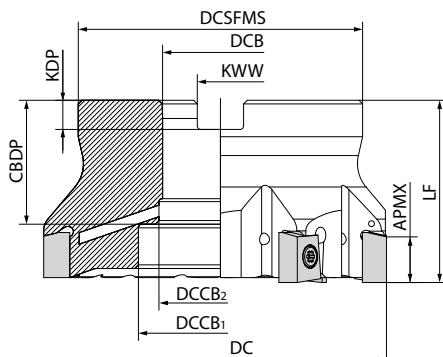
#### Dimenziije glodače glave

#### ODGOVARAJUĆE PLOČICE LOGU 09

Description	Avail-ability	Number of inserts	Dimensions (mm)										Coolant hole	Shape	Weight (kg)	Maximum number of revolutions (min <sup>-1</sup> )	
			DC	DCSFMS	DCB	DCCB <sub>1</sub>	DCCB <sub>2</sub>	LF	CBDP	KDP	KWW	APMX					
MA90 -	040R-09T4C-M	●	4	40	38	16	15	9	40	19	5.6	8.4	8	Yes	Fig.1	0.2	26,600
	040R-09T6C-M	●	6													0.4	23,900
	050R-09T5C-M	●	5		50											0.5	
	050R-09T7C-M	●	7		48	22	18	11		21	6.3	10.4				0.4	21,200
	063R-09T6C-M	●	6		63												
	063R-09T9C-M	●	9														

Maximum number of revolutions

Do not use the End mill or cutter at the maximum revolution or higher since the centrifugal force may cause chips and parts to scatter even under no load.



**KUPNJOM 10  
PLOČICA po ležištu  
glodala cijena  
glodače glave 1€**

Fig.2

#### Dimenziije glodače glave

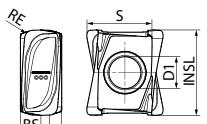
#### ODGOVARAJUĆE PLOČICE LOGU12

Description	Avail-ability	Number of inserts	Dimensions (mm)										Coolant hole	Shape	Weight (kg)	Maximum number of revolutions (min <sup>-1</sup> )		
			DC	DCSFMS	DCB	DCCB <sub>1</sub>	DCCB <sub>2</sub>	LF	CBDP	KDP	KWW	APMX						
MA90 -	040R-12T3C-M	●	3	40	38	16	14	9	40	19	5.68	.4	12	Yes	Fig.1	0.2	14,600	
	040R-12T4C-M	●	4													0.3	13,100	
	050R-12T4C-M	●			50					21	6.3	10.4				0.4	11,700	
	050R-12T6C-M	●	6	48	22	18	11	50		24	7	12.41				.2	10,400	
	063R-12T6C-M	●			63					30	8	14.4	Fig.2	Yes	Fig.2	1.59	,300	
	063R-12T8C-M	●								63	33	9	16.42			.5	8,300	
	080R-12T7C-M	●	7	80	70	27	20	50										
	080R-12T10C-M	●			100	78	32			30	8	14.4						
	100R-12T9C-M	●	9	100				63										
	100R-12T13C-M	●	13															
	125R-12T12C-M	●	12	125	89	40	55	63										
	125R-12T16C-M	●	16															

Maximum number of revolutions

Do not use the End mill or cutter at the maximum revolution or higher since the centrifugal force may cause chips and parts to scatter even under no load.

Odgovarajuće pločice (G-klasa)

Usage classification		P	Carbon steel/Alloy steel			★	☆							
			Mold Steel			★	☆							
★: 1st recommendation ☆: 2nd recommendation		M Stainless steel	Austenitic											
			Martensitic											
			Precipitation hardened											
		K	Gray cast iron											
			Ductile cast iron											
			Heat-resistant alloys											
		S	Titanium alloy											
			Hardened material											
Shape		Description	Dimensions (mm)						MEGACOAT (PVD coating)					
			W1	S	D1	INSL	BS	RE	PR1825	PR1835	PR1810			
General purpose	 	LOGU 090404ER-GM	4.3	6.77	3.33	8.89	1.29	0.4	●	●	●	-	●	
		090408ER-GM		6.71			0.90	0.8	●	●	●	-	●	
		090412ER-GM		6.65			0.49	1.2	●	●	●	-	●	
		090416ER-GM		6.59			0.10	1.6	●	●	●	-	●	
Low cutting force		LOGU 090404ER-SM	4.3	6.77	3.33	8.89	1.29	0.4	●	●	-	-	●	
		090408ER-SM		6.71			0.89	0.8	●	●	-	-	●	
		090412ER-SM		6.65			0.49	1.2	●	●	-	-	●	
		090416ER-SM		6.59			0.10	1.6	●	●	-	-	●	
Tough edge	 	LOGU 090408ER-GH	4.3	6.71	3.33	8.89	0.90	0.8	●	●	●	●	-	
General purpose		LOGU 120604ER-GM	6.6	10.10	4.55	13.28	2.50	0.4	●	●	●	-	●	
		120608ER-GM		10.04			2.14	0.8	●	●	●	-	●	
		120612ER-GM		9.97			1.79	1.2	●	●	●	-	●	
		120616ER-GM		9.92			1.44	1.6	●	●	●	-	●	
		120620ER-GM		9.85			1.08	2.0	●	●	●	-	●	
		120624ER-GM		9.79			0.72	2.4	●	●	●	-	●	
		120630ER-GM		9.69			0.20	3.0	●	●	●	-	●	
Low cutting force	 	LOGU 120604ER-SM	6.6	10.10	4.55	13.28	2.50	0.4	●	●	-	-	●	
		120608ER-SM		10.04			2.14	0.8	●	●	-	-	●	
		120612ER-SM		9.97			1.79	1.2	●	●	-	-	●	
		120616ER-SM		9.92			1.44	1.6	●	●	-	-	●	
		120620ER-SM		9.85			1.08	2.0	●	●	-	-	●	
		120624ER-SM		9.79			0.72	2.4	●	●	-	-	●	
		120630ER-SM		9.69			0.20	3.0	●	●	-	-	●	
Tough edge	 	LOGU 120608ER-GH	6.6	10.16	4.55	13.25	2.26	0.8	●	●	●	●	-	



Preporučeni režimi rada

★ 1. izbor

★ 2. izbor

Type	Workpiece material	Toolholder description and feed rate (fz: mm/t)				Recommended insert grade (Vc: m/min)				
		09 size (LOGU09...)		12 size (LOGU12...)		MEGACOAT NANO EX		MEGACOAT HARD	CVD coating	
		MA90-16~MA90-18	MA90-20~MA90-50 MA90-040~MA90-063	MA90-25~MA90-30	MA90-32~MA90-50 MA90-040~MA90-125	PR1825	PR1835	PR1810	PR015S	CA6535
General purpose GM	Carbon steel	0.05 – <b>0.1</b> – 0.14	0.05 – <b>0.1</b> – 0.16	0.05 – <b>0.1</b> – 0.18	0.06 – <b>0.15</b> – 0.23	★ 120 – <b>180</b> – 250	☆ 120 – <b>180</b> – 250	–	–	–
	Alloy steel	0.05 – <b>0.08</b> – 0.12	0.05 – <b>0.1</b> – 0.14	0.05 – <b>0.1</b> – 0.16	0.06 – <b>0.13</b> – 0.2	★ 100 – <b>160</b> – 220	☆ 100 – <b>160</b> – 220	–	–	–
	Mold steel	0.05 – <b>0.08</b> – 0.1	0.05 – <b>0.1</b> – 0.12	0.05 – <b>0.1</b> – 0.14	0.06 – <b>0.12</b> – 0.18	★ 80 – <b>140</b> – 180	☆ 80 – <b>140</b> – 180	–	–	–
	Austenitic stainless steel	0.05 – <b>0.08</b> – 0.1	0.05 – <b>0.1</b> – 0.12	0.05 – <b>0.1</b> – 0.14	0.06 – <b>0.12</b> – 0.18	☆ 100 – <b>160</b> – 200	★ 100 – <b>160</b> – 200	–	–	–
	Martensitic stainless steel	0.05 – <b>0.08</b> – 0.1	0.05 – <b>0.1</b> – 0.12	0.05 – <b>0.1</b> – 0.14	0.06 – <b>0.12</b> – 0.18	–	☆ 150 – <b>200</b> – 250	–	–	★ 180 – <b>240</b> – 300
	Precipitation hardened stainless steel	0.05 – <b>0.08</b> – 0.1	0.05 – <b>0.1</b> – 0.12	0.05 – <b>0.1</b> – 0.14	0.06 – <b>0.12</b> – 0.18	–	★ 90 – <b>120</b> – 150	–	–	–
	Grey cast iron	0.05 – <b>0.1</b> – 0.14	0.05 – <b>0.1</b> – 0.16	0.05 – <b>0.1</b> – 0.18	0.06 – <b>0.15</b> – 0.23	–	–	☆ 120 – <b>180</b> – 250	–	–
	Ductile cast iron	0.05 – <b>0.08</b> – 0.1	0.05 – <b>0.1</b> – 0.12	0.05 – <b>0.1</b> – 0.14	0.06 – <b>0.12</b> – 0.18	–	–	☆ 100 – <b>150</b> – 200	–	–
	Ni-based heat resistant alloys	0.05 – <b>0.06</b> – 0.08	0.05 – <b>0.08</b> – 0.1	0.05 – <b>0.08</b> – 0.12	0.06 – <b>0.1</b> – 0.15	–	–	–	–	★ 20 – <b>30</b> – 50
	Titanium alloy (Ti-6Al-4 V)	0.05 – <b>0.08</b> – 0.1	0.05 – <b>0.09</b> – 0.12	0.05 – <b>0.09</b> – 0.12	0.06 – <b>0.1</b> – 0.15	–	☆ 30 – <b>50</b> – 70	–	–	–
Low cutting force SM	Carbon steel	0.05 – <b>0.08</b> – 0.11	0.05 – <b>0.1</b> – 0.14	0.05 – <b>0.1</b> – 0.14	0.06 – <b>0.1</b> – 0.18	★ 120 – <b>180</b> – 250	☆ 120 – <b>180</b> – 250	–	–	–
	Alloy steel	0.05 – <b>0.07</b> – 0.1	0.05 – <b>0.08</b> – 0.12	0.05 – <b>0.08</b> – 0.12	0.06 – <b>0.1</b> – 0.14	★ 100 – <b>160</b> – 220	☆ 100 – <b>160</b> – 220	–	–	–
	Mold steel	0.05 – <b>0.07</b> – 0.1	0.05 – <b>0.08</b> – 0.1	0.05 – <b>0.08</b> – 0.12	0.06 – <b>0.1</b> – 0.14	★ 80 – <b>140</b> – 180	☆ 80 – <b>140</b> – 180	–	–	–
	Austenitic stainless steel	0.05 – <b>0.08</b> – 0.11	0.05 – <b>0.08</b> – 0.12	0.05 – <b>0.08</b> – 0.12	0.06 – <b>0.1</b> – 0.14	☆ 100 – <b>160</b> – 200	★ 100 – <b>160</b> – 200	–	–	–
	Martensitic stainless steel	0.05 – <b>0.08</b> – 0.11	0.05 – <b>0.08</b> – 0.12	0.05 – <b>0.08</b> – 0.12	0.06 – <b>0.1</b> – 0.14	–	☆ 150 – <b>200</b> – 250	–	–	★ 180 – <b>240</b> – 300
	Precipitation hardened stainless steel	0.05 – <b>0.08</b> – 0.11	0.05 – <b>0.08</b> – 0.12	0.05 – <b>0.08</b> – 0.12	0.06 – <b>0.1</b> – 0.14	–	★ 90 – <b>120</b> – 150	–	–	–
	Ni-based heat resistant alloys	0.05 – <b>0.06</b> – 0.08	0.05 – <b>0.08</b> – 0.1	0.05 – <b>0.08</b> – 0.1	0.06 – <b>0.08</b> – 0.12	–	–	–	–	★ 20 – <b>30</b> – 50
	Titanium alloy (Ti-6Al-4 V)	0.05 – <b>0.08</b> – 0.1	0.05 – <b>0.08</b> – 0.12	0.05 – <b>0.08</b> – 0.12	0.06 – <b>0.09</b> – 0.12	–	★ 30 – <b>50</b> – 70	–	–	–
Tough edge GH	Carbon steel	0.05 – <b>0.1</b> – 0.14	0.05 – <b>0.1</b> – 0.16	0.05 – <b>0.1</b> – 0.18	0.06 – <b>0.15</b> – 0.23	★ 120 – <b>180</b> – 250	☆ 120 – <b>180</b> – 250	–	–	–
	Alloy steel	0.05 – <b>0.08</b> – 0.12	0.05 – <b>0.1</b> – 0.14	0.05 – <b>0.1</b> – 0.16	0.06 – <b>0.13</b> – 0.2	★ 100 – <b>160</b> – 220	☆ 100 – <b>160</b> – 220	–	–	–
	Mold steel	0.05 – <b>0.08</b> – 0.1	0.05 – <b>0.1</b> – 0.12	0.05 – <b>0.1</b> – 0.14	0.06 – <b>0.12</b> – 0.18	★ 80 – <b>140</b> – 180	☆ 80 – <b>140</b> – 180	–	–	–
	Austenitic stainless steel	0.05 – <b>0.08</b> – 0.1	0.05 – <b>0.1</b> – 0.12	0.05 – <b>0.1</b> – 0.14	0.06 – <b>0.12</b> – 0.18	☆ 100 – <b>160</b> – 200	☆ 100 – <b>160</b> – 200	–	–	–
	Martensitic stainless steel	0.05 – <b>0.08</b> – 0.1	0.05 – <b>0.1</b> – 0.12	0.05 – <b>0.1</b> – 0.14	0.06 – <b>0.12</b> – 0.18	–	☆ 150 – <b>200</b> – 250	–	–	–
	Precipitation hardened stainless steel	0.05 – <b>0.08</b> – 0.1	0.05 – <b>0.1</b> – 0.12	0.05 – <b>0.1</b> – 0.14	0.06 – <b>0.12</b> – 0.18	–	☆ 90 – <b>120</b> – 150	–	–	–
	Grey cast iron	0.05 – <b>0.1</b> – 0.14	0.05 – <b>0.1</b> – 0.16	0.05 – <b>0.1</b> – 0.18	0.06 – <b>0.15</b> – 0.23	–	–	★ 120 – <b>180</b> – 250	–	–
	Ductile cast iron	0.05 – <b>0.08</b> – 0.1	0.05 – <b>0.1</b> – 0.12	0.05 – <b>0.1</b> – 0.14	0.06 – <b>0.12</b> – 0.18	–	–	★ 100 – <b>150</b> – 200	–	–
	Ni-based heat resistant alloys	0.05 – <b>0.06</b> – 0.08	0.05 – <b>0.08</b> – 0.1	0.05 – <b>0.08</b> – 0.12	0.06 – <b>0.1</b> – 0.15	–	–	–	–	–
	Titanium alloy (Ti-6Al-4 V)	0.05 – <b>0.08</b> – 0.1	0.05 – <b>0.09</b> – 0.12	0.05 – <b>0.09</b> – 0.12	0.06 – <b>0.1</b> – 0.15	–	☆ 30 – <b>50</b> – 70	–	–	–

THE NEW VALUE FRONTIER



# MB45

**Za opću uporabu 45°****NOVO****Iznimno svestrano glodanje , visoke performanse, visoke kvalitete, dugi vijek trajanja**

Pruža prednosti "male sile rezanja" pozitivnih pločica i prednosti otpornosti na lomljenje negativnih pločica te pruža izvrsnu završnu obradu površine.

Širok izbor primjena strojne obrade uključujući čelik, nehrđajući čelik, lijevano željezo, aluminijске legure i legure otporne na toplinu.

**KUPNJOM 10 PLOČICA  
po ležištu glodala cijena  
glodače glave 1€**





# MB45



1€

**MEGACOAT**  
**NANO EX** | Milling |

## Dimenzije glodače glave

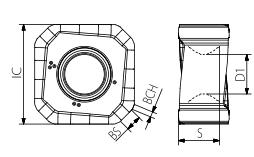
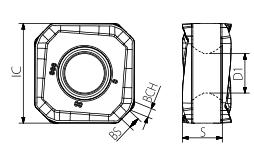
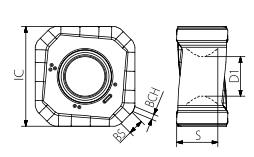
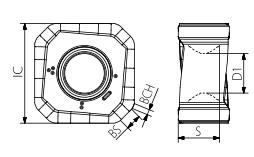
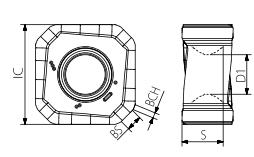
Description		Availability	Number of inserts	Dimensions (mm)												Coolant hole	A.R. max.(°)	R.R.(°)	Weight (kg)	Maximum number of revolutions (min⁻¹)	Shape								
				D <sub>C</sub>	D <sub>CX</sub>	D <sub>SMS</sub>	D <sub>B</sub>	D <sub>CB1</sub>	D <sub>CB2</sub>	D <sub>CB3</sub>	D <sub>CB4</sub>	D <sub>CI</sub>	L <sub>F</sub>	C <sub>DP</sub>	K <sub>DP</sub>	K <sub>WW</sub>	A <sub>PMX</sub>												
Coarse pitch	MB45 -	040R-14T2C-M	●	2	40	53	38	16	13.5	9								Yes	0.4	12,700	Fig.1								
		050R-14T3C-M	●	3	50	63	48	22	18	11									0.5	11,400									
		063R-14T4C-M	●	4	63	76	50												0.7	10,100									
		080R-14T5C-M	●	5	80	93	70												1.4	9,000									
		100R-14T5C-M	●	5	100	113	78												1.9	8,000	Fig.2								
		125R-14T6C-M	●	6	125	138	89				40	55						6		3.2	7,200								
		160R-14T7-M	●	7	160	173	110				5.1	6,300						Fig.3											
		200R-14T8-M	●	8	200	213					60	110						13		7.3	5,700								
		250R-14T10-M	●	10	250	263					10.5	5,100																	
		315R-14T14-M	MTO	14	315	328	222				19.4	4,500						Fig.4											
Fine pitch	MB45 -	040R-14T3C-M	●	3	40	53	38	16	13.5	9							6	Yes	0.3	12,700	Fig.1								
		050R-14T4C-M	●	4	50	63	48	22	18	11									0.4	11,400									
		063R-14T5C-M	●	5	63	76	50												0.6	10,100									
		080R-14T6C-M	●	6	80	93	70												1.4	9,000									
		100R-14T8C-M	●	8	100	113	78												1.8	8,000	Fig.2								
		125R-14T10C-M	●	10	125	138	89				40	55					6	13		3.0	7,200								
		160R-14T12-M	●	12	160	173	110				4.9	6,300						Fig.3											
		200R-14T14-M	●	14	200	213				142		60					13		-12	7.0	5,700								
		250R-14T16-M	●	16	250	263				10.2		5,100																	
		315R-14T18-M	MTO	18	315	328	222			19.2		4,500						Fig.4											
Extra fine pitch	MB45 -	040R-14T4C-M	●	4	40	53	38	16	13.5	9							6	Yes	0.3	12,700	Fig.1								
		050R-14T5C-M	●	5	50	63	48	22	18	11									0.4	11,400									
		063R-14T6C-M	●	6	63	76	50												0.6	10,100									
		080R-14T8C-M	●	8	80	93	70												1.3	9,000	Fig.2								
		100R-14T10C-M	●	10	100	113	78												1.7	8,000									
		125R-14T13C-M	●	13	125	138	89				40	55					6	13		2.9	7,200	Fig.3							
		160R-14T16-M	●	16	160	173	110				4.8	6,300																	
		200R-14T18-M	●	18	200	213				142	60	110					13	-12	6.9	5,700									
		250R-14T20-M	●	20	250	263				10.1	5,100	Fig.3																	

### Maximum number of revolutions

Set the number of revolutions per minute within the recommended cutting speed specified by the workpiece on page 10.

Set the number of revolutions per minute within the recommended cutting speed specified by the workpiece on page 10.

Do not use the face mill or shank type at the maximum revolution or higher since the centrifugal force may cause chips and parts to scatter even under no load.

Usage classification	P	Steel					★	☆			■				
		Mold steel					★	☆			■				
★: Roughing/ 1st recommendation ☆: Roughing/ 2nd recommendation ■: Finishing/ 1st recommendation □: Finishing/ 2nd recommendation (Hardened material is 40 HRC or less)	M	Austenitic stainless steel					☆	★							
		Martensitic stainless steel					☆			★					
	K	Precipitation hardening stainless steel					★				★				
		Gray cast iron							★						
	N	Ductile cast iron							★						
		Nonferrous metal									★		☆		
	S	Heat resistant alloys (Ni-based heat resistant alloys)								★					
Shape		Description	Dimensions (mm)					MEGACOAT NANO EX		NOVO	MEGACOAT HARD	CVD	Cermet	DLC	uncoated
			IC	S	BCH	BS	D1	PR1825	PR1835	PR1810	PRO15S	CA6535	TN620M	PDL025	GW25
	General purpose (M-Class)		SNMU1406ANER-GM	14.7	6.07	0.8	2.3	5.8	●	●	●	●	●		
	Tough edge (M-Class)		SNMU1406ANER-GH	14.7	5.89	1.4	1.7	5.8	●	●	●	●	●		
	General purpose (E-Class)		SNEU1406ANER-GM	14.7	6.07	0.8	2.3	5.8	●	●	●	●	●		
	Low cutting force (E-Class)		SNEU1406ANER-SM	14.7	6.07	0.8	2.3	5.8	●	●		●			
	Aluminum and non-ferrous metals (E-Class)		SNEU1406ANFR-AM	14.7	6.07	0.8	2.3	5.8					●	●	



**KUPNJOM 10 PLOČICA po ležištu glodala cijena glodače glave 1€**

Preporučeni režimi rada

★ 1. izbor

☆ 2. izbor

Chipbreaker	Workpiece	Feed fz (mm/t)	Recommended insert grade (Vc: m/min)							
			PVD coating				CVD coating	Cermet	DLC coating	Carbide
			MEGACOAT NANO EX		MEGACOAT HARD					
General GM	Carbon steel	0.1 – <b>0.2</b> – 0.4 (0.06 – <b>0.12</b> – 0.20)	120 – <b>180</b> – 250	★ 120 – <b>180</b> – 250	–	–	–	★ 200 – <b>250</b> – 300	–	–
	Alloy steel	0.1 – <b>0.2</b> – 0.4 (0.06 – <b>0.12</b> – 0.20)	100 – <b>160</b> – 220	★ 100 – <b>160</b> – 220	–	–	–	★ 180 – <b>220</b> – 250	–	–
	Mold steel	0.1 – <b>0.2</b> – 0.35 (0.06 – <b>0.08</b> – 0.15)	80 – <b>140</b> – 180	★ 80 – <b>140</b> – 180	–	–	–	★ 150 – <b>180</b> – 220	–	–
	Austenitic stainless steel	0.1 – <b>0.2</b> – 0.4	100 – <b>160</b> – 200	★ 100 – <b>160</b> – 200	–	–	–	–	–	–
	Martensitic stainless steel	0.1 – <b>0.2</b> – 0.4	150 – <b>200</b> – 250	★ 150 – <b>200</b> – 250	–	–	–	★ 180 – <b>240</b> – 300	–	–
	Precipitation hardening stainless steel	0.1 – <b>0.2</b> – 0.3	90 – <b>120</b> – 150	★ 90 – <b>120</b> – 150	–	–	–	–	–	–
	Gray cast iron	0.1 – <b>0.2</b> – 0.4	–	–	★ 120 – <b>180</b> – 250	–	–	–	–	–
	Ductile cast iron	0.1 – <b>0.2</b> – 0.35	–	–	★ 100 – <b>150</b> – 200	–	–	–	–	–
Low cutting force SM	Ni-based heat resistant alloys	0.1 – <b>0.12</b> – 0.2	20 – <b>30</b> – 50	★ 20 – <b>30</b> – 50	–	–	–	★ 20 – <b>30</b> – 50	–	–
	Carbon Steel	0.06 – <b>0.12</b> – 0.25	120 – <b>180</b> – 250	★ 120 – <b>180</b> – 250	–	–	–	–	–	–
	Alloy Steel	0.06 – <b>0.12</b> – 0.25	100 – <b>160</b> – 220	★ 100 – <b>160</b> – 220	–	–	–	–	–	–
	Mold steel	0.06 – <b>0.1</b> – 0.2	80 – <b>140</b> – 180	★ 80 – <b>140</b> – 180	–	–	–	–	–	–
	Austenitic stainless steel	0.06 – <b>0.12</b> – 0.25	100 – <b>160</b> – 200	★ 100 – <b>160</b> – 200	–	–	–	–	–	–
	Martensitic stainless steel	0.06 – <b>0.12</b> – 0.25	150 – <b>200</b> – 250	★ 150 – <b>200</b> – 250	–	–	–	★ 180 – <b>240</b> – 300	–	–
	Precipitation hardening stainless steel	0.06 – <b>0.12</b> – 0.25	90 – <b>120</b> – 150	★ 90 – <b>120</b> – 150	–	–	–	–	–	–
	Gray cast iron	0.06 – <b>0.12</b> – 0.25	–	–	★ 120 – <b>180</b> – 250	–	–	–	–	–
	Ductile cast iron	0.06 – <b>0.1</b> – 0.2	–	–	★ 100 – <b>150</b> – 200	–	–	–	–	–
Tough edge GH	Ni-based heat resistant alloys	0.06 – <b>0.1</b> – 0.15	20 – <b>30</b> – 50	★ 20 – <b>30</b> – 50	–	–	–	★ 20 – <b>30</b> – 50	–	–
	Titanium alloy	0.06 – <b>0.08</b> – 0.15	40 – <b>60</b> – 80	★ 40 – <b>60</b> – 80	–	–	–	–	–	–
	Carbon Steel	0.2 – <b>0.3</b> – 0.5	120 – <b>180</b> – 250	★ 120 – <b>180</b> – 250	–	–	–	–	–	–
	Alloy Steel	0.2 – <b>0.3</b> – 0.5	100 – <b>160</b> – 220	★ 100 – <b>160</b> – 220	–	–	–	–	–	–
	Mold steel	0.2 – <b>0.3</b> – 0.45	80 – <b>140</b> – 180	★ 80 – <b>140</b> – 180	–	–	–	–	–	–
	Austenitic stainless steel	0.2 – <b>0.3</b> – 0.4	100 – <b>160</b> – 200	★ 100 – <b>160</b> – 200	–	–	–	–	–	–
	Martensitic stainless steel	0.2 – <b>0.3</b> – 0.4	150 – <b>200</b> – 250	★ 150 – <b>200</b> – 250	–	–	–	★ 180 – <b>240</b> – 300	–	–
	Precipitation hardening stainless steel	0.2 – <b>0.3</b> – 0.4	90 – <b>120</b> – 150	★ 90 – <b>120</b> – 150	–	–	–	–	–	–
	Gray cast iron	0.2 – <b>0.3</b> – 0.5	–	–	★ 120 – <b>180</b> – 250	–	–	–	–	–
	Ductile cast iron	0.2 – <b>0.3</b> – 0.45	–	–	★ 100 – <b>150</b> – 200	–	–	–	–	–
AM	Ni-based heat resistant alloys	0.1 – <b>0.2</b> – 0.3	20 – <b>30</b> – 50	★ 20 – <b>30</b> – 50	–	–	–	★ 20 – <b>30</b> – 50	–	–
	Hardened material (40 HRC or less)	0.05 – <b>0.1</b> – 0.2	–	–	–	–	–	★ 50 – <b>80</b> – 100	–	–
AM	Aluminum alloy	0.1 – <b>0.2</b> – 0.4	–	–	–	–	–	–	–	★ 200 – <b>600</b> – 900
AM	Aluminum alloy	0.1 – <b>0.2</b> – 0.4	–	–	–	–	–	–	–	★ 200 – <b>500</b> – 800

THE NEW VALUE FRONTIER

**NOVO**

# CA115P/CA125P

**Nova CVD presvlaka za čelik****Duži vijek trajanja alata u širokom rasponu primjene**

Nova presvlaka i substrat od tvrdog metala pružaju izvrsnu otpornost na trošenje i lom.

Duži vijek trajanja alata za širok raspon primjene.

PMG lomač strugotine za srednju i grubu obradu.

**Pri kupnji 30 pločica dobivate  
10 dodatnih pločica + majica  
GRATIS!!!**

**CA115P**

- kontinuirano do malo isprekidano tokarenje

**CA125P**

- kontinuirano do jako isprekidano tokarenje



**NOVA CVD PRESVLAKA ZA OBRADU ČELIKA****CA115P/CA125P****Novi standard za obradu čelika****Duži vijek trajanja alata u širokom rasponu okruženja obrade****Proširena linija lomača strugotine za strojnu obradu čelika u različitim primjenama****CA115P/ CA125P drastično povećava vijek trajanja alata**

- smanjenje troškova
- skraćeno vrijeme zastoja
- skraćeno vrijeme mijenjanja pločice
- dosljedna kvaliteta obrade
- automatizacija linije i ušteda radne snage
- promiče ugljičnu neutralnost smanjenjem količine otpada

**Nova presvlaka i nova karbidna podloga**

Crna i Zlatna  
Izvrsna otpornost  
na habanje i lomove

**Napredne tehnologije povećavaju dugovječnost alata****ZA SREDNJE-GRUBU OBRADU****PMG lomač****Struktura stepenastog lomača strugotine**

Suzbijanje namotavanje strugotine čak i pri većim dubinama rezanja  
Smanjuje trošenje lomača strugotine i promjene oblika strugotine



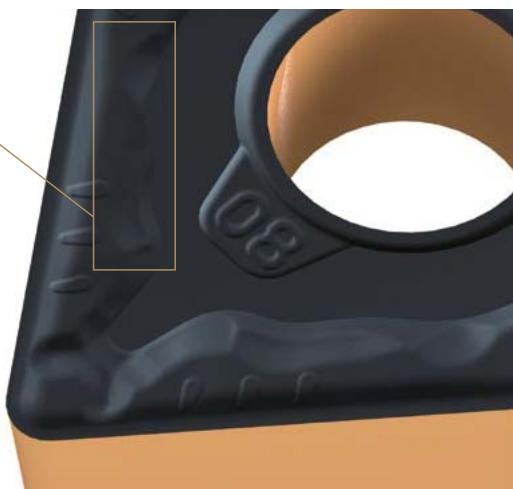
A-A'Section



Pokriva širok raspon primjena strojne obrade  
od srednje obrade do grube obrade.

Izvrsna otpornost na trošenje s dizajnom oštice za male sile rezanja.

Smanjuje nedosljednosti oblika strugotine i produljuje  
vijek trajanja alata.

**Preporučeni režim rada Vc (m/min)**

		Low carbon steel Low carbon alloy steel	Medium carbon steel Medium carbon alloy steel	High carbon alloy steel
		150 HB or below	250 HB or below	300 HB or below
CA115P	Negative	150 ~300 ~ 400		150 ~280 ~ 360
	Positive	120 ~240 ~ 320		110 ~220 ~ 290
CA125P	Negative	150 ~240 ~ 320		150 ~220 ~ 280
	Positive	120 ~190 ~ 260		110 ~170 ~ 230

THE NEW VALUE FRONTIER



# PV710 / 720 / 730 TN610 / 620

Hibridni cermet za obradu čelika



Visokokvalitetna obrada površine i visokoučinkovita strojna obrada

Široki raspon primjene strojne obrade.

Najtvrdi cermet u povijesti KYOCERE - NOVI PV730

**Pri kupnji 30 pločica dobivate  
10 dodatnih pločica + majica  
GRATIS!!!**

**Preporučeni režim rada**

Cutting speed: Vc (m/min)

	Low carbon steel Low-carbon alloy steel 150 HB or less	Medium-carbon steel Medium-carbon alloy steel 250 HB or less	High-carbon alloy steel 300 HB or less
TN610	150 – 250 – 350	150 – 230 – 300	
TN620	100 – 200 – 300	100 – 180 – 250	

	Low carbon steel Low-carbon alloy steel 150 HB or less	Medium-carbon steel Medium-carbon alloy steel 250 HB or less	High-carbon alloy steel 300 HB or less
PV710	150 – 300 – 400	150 – 250 – 330	
PV720	100 – 250 – 350	100 – 200 – 280	
PV730	100 – 180 – 250	100 – 180 – 250	



**PV730**  
orijentiran na stabilnost

**NOVO**

THE NEW VALUE FRONTIER



# PR115S/PR120S

PVD presvlaka za legure otporne na toplinu

NOVO



Rješava različite problema obrade nehrđajućeg čelika i legura otpornih na toplinu

Dulji vijek trajanja alata pri obradi legura otpornih na toplinu.

Jedinstvena karbidna podloga otporna na toplinu i novorazvijena tehnologija PVD presvlake.

**Pri kupnji 30 pločica dobivate  
10 dodatnih pločica + majica  
GRATIS!!!**



Dostupni su specijalni lomači za legure otporne na toplinu.

Dostupne su pozitivne pločice za obradu manjih dijelova.



Negative type inserts (M Class)						
CNMG	CNMM	DNMG	SNMG	TNMG	VNMG	
Finishing-Medium Medium-Roughing Roughing	Roughing/Single-sided	Finishing-Medium Medium-Roughing Roughing	Finishing-Medium Medium-Roughing Roughing	Finishing-Medium Medium-Roughing Roughing	Finishing-Medium Medium-Roughing Roughing	
Negative type inserts (G Class)						
CNCG	DNCG	TNGC	VNCG			
Finishing-Medium /Sharp edge / Polished	Finishing-Medium /Sharp edge / Polished	Finishing-Medium /Sharp edge / Polished	Finishing-Medium /Sharp edge / Polished			
Positive type inserts						
CCGT	CCMT	DCGT	DCMT	VCGT	VPGT	
Finishing /Sharp edge / Polished Finishing-Medium	Finishing-Medium	Finishing /Sharp edge / Polished Finishing-Medium	Finishing-Medium	Finishing /Sharp edge / Polished	Finishing /Sharp edge / Polished	
Workpiece	Cutting range	Recommended chipbreaker	Recommended grade	Min. – Recommendation – Max.		
				Vc (m/min)	ap (mm)	f (mm/rev)
Heat-resistant alloys	Finishing	MQ	PR115S	25 – 45 – 70	0.5 – 1.0 – 1.5	0.05 – 0.1 – 0.15
			PR120S	25 – 40 – 60		
			PR153S	25 – 30 – 45		0.08 – 0.15 – 0.2
		SKS	PR115S	25 – 45 – 70	0.1 – 0.3 – 0.5	0.03 – 0.05 – 0.1
			PR120S	25 – 40 – 60		0.05 – 0.1 – 0.15
			PR153S	25 – 30 – 45	0.3 – 0.5 – 1.0	0.03 – 0.08 – 0.12
		SK	PR115S	25 – 45 – 70	0.5 – 1.0 – 2.0	0.05 – 0.1 – 0.15
			PR120S	25 – 40 – 60		0.03 – 0.08 – 0.12
			PR153S	25 – 30 – 45	0.5 – 1.5 – 3.0	0.05 – 0.1 – 0.15
	Finishing-Medium	GQ	PR115S	25 – 45 – 70	1.0 – 1.5 – 2.5	0.02 – 0.05 – 0.08
			PR120S	25 – 40 – 60		0.04 – 0.07 – 0.1
			PR153S	25 – 30 – 45	1.0 – 3.0 – 5.0	0.02 – 0.05 – 0.08
Stainless steel (Austenitic related)	Finishing	MQ	PR120S	80 – 100 – 120	0.3 – 0.5 – 1.0	0.05 – 0.1 – 0.15
			PR153S	60 – 80 – 100	0.5 – 1.0 – 1.5	0.08 – 0.15 – 0.2
		SKS	PR120S	80 – 100 – 120	0.1 – 0.3 – 0.5	0.03 – 0.05 – 0.1
			PR153S	60 – 80 – 100	0.3 – 0.5 – 1.0	0.05 – 0.1 – 0.15
		SK	PR120S	80 – 100 – 120	0.5 – 1.0 – 2.0	0.03 – 0.08 – 0.12
			PR153S	60 – 80 – 100	0.5 – 1.5 – 3.0	0.05 – 0.1 – 0.15
	Finishing-Medium	GQ	PR120S	80 – 100 – 120	1.0 – 1.5 – 2.5	0.02 – 0.05 – 0.08
			PR153S	60 – 80 – 100	1.0 – 3.0 – 5.0	0.04 – 0.07 – 0.1
Stainless steel (Precipitation hardened)	Finishing	MQ	PR120S	40 – 60 – 80	0.3 – 0.5 – 1.0	0.05 – 0.1 – 0.15
			PR153S	30 – 50 – 70	0.5 – 1.0 – 1.5	0.08 – 0.15 – 0.2
		SKS	PR120S	40 – 60 – 80	0.1 – 0.3 – 0.5	0.03 – 0.05 – 0.1
			PR153S	30 – 50 – 70	0.3 – 0.5 – 1.0	0.05 – 0.1 – 0.15
		SK	PR120S	40 – 60 – 80	0.5 – 1.0 – 2.0	0.03 – 0.08 – 0.12
			PR153S	30 – 50 – 70	0.5 – 1.5 – 3.0	0.05 – 0.1 – 0.15
	Finishing-Medium	GQ	PR120S	40 – 60 – 80	1.0 – 1.5 – 2.5	0.02 – 0.05 – 0.08
			PR153S	30 – 50 – 70	1.0 – 3.0 – 5.0	0.04 – 0.07 – 0.1

The center value indicates recommended cutting condition.

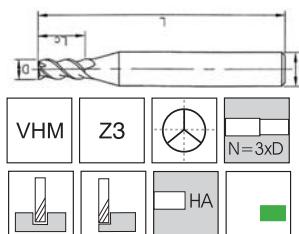


# T-REX GLODALA

## T-REX TROPERNO GLODALO ZA ALUMINIJ



- DLC presvlaka
- Geometrija s dvostrukom oštricom osigurava odličnu završnu obradu
- 3 oštice učinkovito ublažavaju vibracije i pridonose stabilnoj obradi

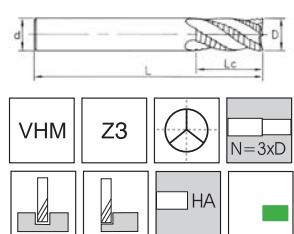


KATALOŠKI BROJ	D	Lc	d	L	Cijena	€
PFE-T-REXDLCFI3	3	9	4	50	12,54	
PFE-T-REXDLCFI4	4	12	4	50	12,54	
PFE-T-REXDLCFI5	5	15	5	50	13,54	
PFE-T-REXDLCFI6	6	18	6	50	13,54	
PFE-T-REXDLCFI8	8	24	8	60	18,59	
PFE-T-REXDLCFI10	10	30	10	75	26,56	
PFE-T-REXDLCFI12	12	36	12	75	36,65	
PFE-T-REXDLCFI16	16	45	16	100	64,80	

## T-REX TROPERNO GLODALO ZA ALUMINIJ



- DLC presvlaka
- Vrlo visoka površinska tvrdoća i odlična otpornost na trošenje
- Oštra geometrija rezne oštice, spirala pod 35° poboljšava odvodenje strugotine
- Za grubu obradu



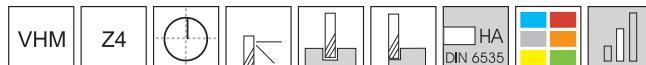
KATALOŠKI BROJ	D	Lc	d	L	Cijena	€
PFE-T-REXRouFI6	6	18	6	50	17,60	
PFE-T-REXRouFI8	8	24	8	60	23,90	
PFE-T-REXRouFI10	10	30	10	75	34,55	
PFE-T-REXRouFI12	12	36	12	75	47,60	
PFE-T-REXRouFI16	16	45	16	100	79,50	

## T-REX ČETVEROPERNO GLODALO



**SET 6-16  
138 €**

- AlTiSiN black presvlaka
- HRC60
- Četveroperno glodalo 35°



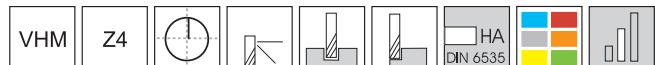
KATALOŠKI BROJ	D	Lc	d	L	Cijena	€
PFE-T-REXHRC60FI3	3	8	3	50	7,56	
PFE-T-REXHRC60FI4	4	10	4	50	7,56	
PFE-T-REXHRC60FI5	5	13	6	50	10,22	
PFE-T-REXHRC60FI6	6	15	6	50	10,22	
PFE-T-REXHRC60FI8	8	20	8	60	15,27	
PFE-T-REXHRC60FI10	10	25	10	75	25,23	
PFE-T-REXHRC60FI12	12	30	12	75	36,52	
PFE-T-REXHRC60FI16	16	45	16	100	75,03	
PFE-T-REXHRC60FI20	20	45	20	100	123,50	

## T-REX ČETVEROPERNO GLODALO



**SET 6-16  
169 €**

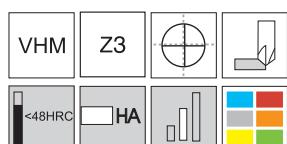
- AlTiSiN blue presvlaka
- HRC65
- Četveroperno glodalo



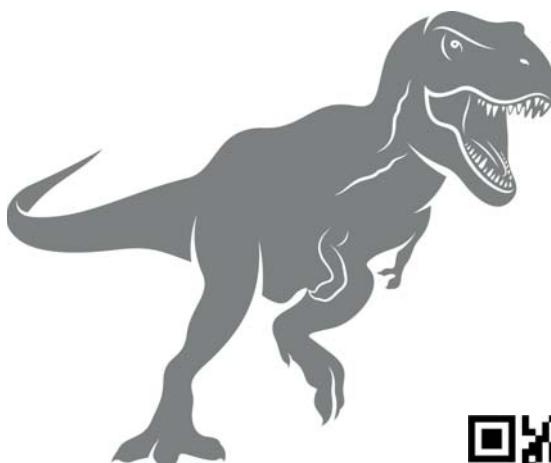
KATALOŠKI BROJ	D	Lc	d	L	Cijena	€
PFE-T-REXHRC65FI3	3	8	4	50	8,56	
PFE-T-REXHRC65FI4	4	10	4	50	8,56	
PFE-T-REXHRC65FI5	5	13	4	50	13,54	
PFE-T-REXHRC65FI6	6	15	6	50	13,54	
PFE-T-REXHRC65FI8	8	20	8	60	20,58	
PFE-T-REXHRC65FI10	10	25	10	75	32,53	
PFE-T-REXHRC65FI12	12	30	12	75	43,82	
PFE-T-REXHRC65FI16	16	45	16	100	90,96	
PFE-T-REXHRC65FI20	20	45	20	100	131,47	

## T-REX GLODALO ZA SKIDANJE BRIDA

AlTiSiN black presvlaka

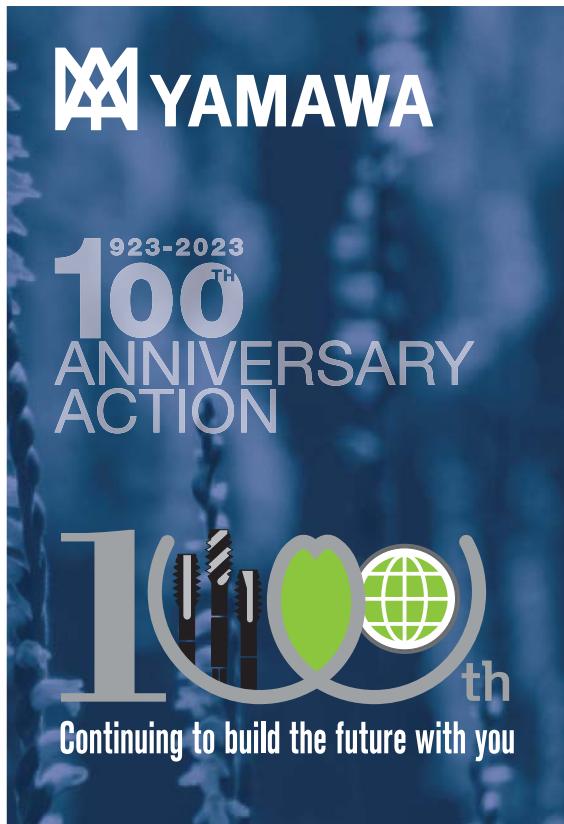


KATALOŠKI BROJ	D	Lc	d	L	Cijena	€
PFE-T-REXCHAFI4	4	8	4	50	11,90	
PFE-T-REXCHAFI6	6	12	6	50	15,90	
PFE-T-REXCHAFI8	8	16	8	60	19,90	
PFE-T-REXCHAFI10	10	20	10	60	29,90	
PFE-T-REXCHAFI12	12	24	12	60	34,90	



REŽIME RADA  
MOŽETE  
POGLEDATI  
OVDJE





### BLIND HOLE

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.

SP-VA	ZEN-B	ZET-B			
HSS-E	OX	HSS-P	OX	HSS-P	NI
TCTR (tolerance)		ISO2(6H)		ISO2X(6HX)	
THCHT (chamfer)		2.5P		3P	

Size (TD)	Pitch(TP)	Drill Ø(mm)	Hole Ø (mm)	edp	€	edp	€	edp	€
M3 DIN 371	0.5	2.50	2.56	SD3.0GAGEX	8,49	SD3.0GBJPX	16,70	SD3.0GBIPN	17,52
M4 DIN 371	0.7	3.30	3.38	SD4.0IAGEX	8,49	SD4.0IBJPX	16,70	SD4.0IBIPN	16,70
M5 DIN 371	0.8	4.20	4.28	SD5.0KAGEX	8,75	SD5.0KBJPX	17,27	SD5.0KBIPN	17,27
M6 DIN 371	1	5.00	5.09	SD6.0MAGEX	8,84	SD6.0MBJPX	17,27	SD6.0MBIPN	17,27
M8 DIN 371	1.25	6.80	6.85	SD8.0NAGEX	10,68	SD8.0NBJPX	21,57	SD8.0NBIPN	21,57
M10 DIN 371	1.5	8.50	8.60	SD0100AGEX	12,78	SD0100BJPX	25,94	SD0100BIPN	25,94
M12 DIN 376	1.75	10.30	10.36	SG012PAGEX	16,45	SG012PBJPX	33,68	SG012PBIPN	33,68

Vc (m/min )

ISO M	<10	★	5 ÷ 15	★	
ISO P	<10	★	5 ÷ 15	★	
ISO S Ni <35HRC			3 ÷ 10	★	
ISO S Ni >35HRC					3 ÷ 6 ★
ISO S Ti					5 ÷ 10 ★

H 1st choice  
I suitable



Continuing to build the future with you



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.



**THROUGH  
HOLE**

TCTR (tolerance)

THCHT (chamfer)



PO-VA	ZEN-P	ZET-P			
HSS-E	OX	HSS-P	NX	HSS-P	NI

Size (TD)	Pitch(TP)	Drill Ø(mm)	Hole Ø (mm)	edp	€	edp	€	edp	€
M3 DIN 371	0.5	2.50	2.56	PD3.0GBGEX	8,27	PD3.0GBJPW	16,79	LD3.0GBIPN	17,52
M4 DIN 371	0.7	3.30	3.38	PD4.0IBGEX	8,27	PD4.0IBJPW	16,79	LD4.0IBIPN	17,52
M5 DIN 371	0.8	4.20	4.28	PD5.0KBGEX	8,61	PD5.0KBJPW	17,27	LD5.0KBIPN	18,09
M6 DIN 371	1	5.00	5.09	PD6.0MBGEX	8,69	PD6.0MBJPW	17,27	LD6.0MBIPN	17,27
M8 DIN 371	1.25	6.80	6.85	PD8.0NBGEX	10,41	PD8.0NBJPW	21,57	LD8.0NBIPN	21,57
M10 DIN 371	1.5	8.50	8.60	PDO100BGEX	12,46	PDO100BJPW	25,59	LD0100BIPN	27,23
M12 DIN 376	1.75	10.30	10.36	PG012PBGEX	16,08	PG012PBJPW	33,68	LG012PBIPN	33,99

Vc (m/min )

ISO M	<10	★	5 ÷ 15	★	
ISO P	<10	★	5 ÷ 15	★	
ISO S Ni <35HRC			3 ÷ 10	★	
ISO S Ni >35HRC					3 ÷ 6 ★
ISO S Ti					5 ÷ 10 ★

H 1st choice  
I suitable



#### POSLOVNI CENTAR ČAKOVEC

Špinčićeva 2a  
40 000 Čakovec

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+385 40/391-123

**Tehnika - Tehnologija - Informacija**

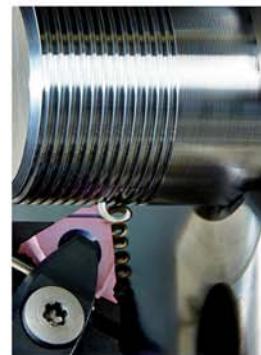
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