
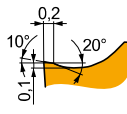

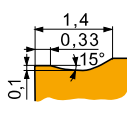

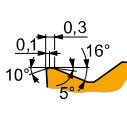

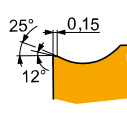




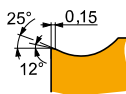
Zalecane początkowe wartości dla prędkości skrawania (vc), posuwu (f) i głębokości skrawania (ap). Więcej opcji można znaleźć w naszej aplikacji Kalkulator Parametrów Skrawania.

| Product | RE (mm) | P | | | M | | | K | | | N | | | S | | | H | | | | |
|---|--------------|---------------|---------------|------------|---------------|---------------|------------|---------------|---------------|------------|---------------|---------------|------------|---------------|---------------|------------|---------------|---------------|------------|------|-----|
| | | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) | | |
|   Geometria FM do obróbki wykańczającej i średniej, do ciągłych i lekko przerywanych warunków pracy. | T8330 | 0.8 | 170 | 0.20 | 1.7 | 100 | 0.18 | 1.7 | 160 | 0.20 | 1.7 | — | — | — | 40 | 0.16 | 1.4 | — | — | — | |
| | T8430 | 0.8 | 195 | 0.20 | 1.7 | 105 | 0.18 | 1.7 | 160 | 0.20 | 1.7 | — | — | — | 40 | 0.16 | 1.4 | — | — | — | |
| | T9315 | 0.8 | 265 | 0.20 | 1.7 | — | — | — | 250 | 0.20 | 1.7 | — | — | — | — | — | — | — | — | — | |
| | T9325 | 0.8 | 235 | 0.20 | 1.7 | 140 | 0.18 | 1.7 | 220 | 0.20 | 1.7 | — | — | — | 50 | 0.16 | 1.4 | — | — | — | |
|   Geometria KR do obróbki do średniej do zgrubnej, do ciągłych i przerywanych warunków pracy. | T5305 | 0.8 | 220 | 0.35 | 3.0 | — | — | — | 205 | 0.35 | 3.0 | — | — | — | — | — | — | 40 | 0.15 | 1.0 | |
| | T5315 | 0.8 | 200 | 0.35 | 3.0 | — | — | — | 190 | 0.35 | 3.0 | — | — | — | — | — | — | — | 40 | 0.15 | 1.0 |
|   Geometria M do obróbki wykańczającej i średniej, do ciągłych i przerywanych warunków pracy. | T5315 | 0.4 | 215 | 0.20 | 1.6 | — | — | — | 200 | 0.20 | 1.6 | — | — | — | — | — | — | 40 | 0.15 | 1.0 | |
| | T9315 | 0.4 | 205 | 0.20 | 1.6 | — | — | — | 190 | 0.20 | 1.6 | — | — | — | — | — | — | — | 40 | 0.15 | 1.0 |
| | T9325 | 0.4 | 180 | 0.20 | 1.6 | — | — | — | 170 | 0.20 | 1.6 | — | — | — | — | — | — | — | — | — | |
| | T9335 | 0.4 | 155 | 0.20 | 1.6 | — | — | — | — | — | — | — | — | — | — | — | — | — | — | — | |
| TNMG 160408E-M | T5305 | 0.8 | 250 | 0.30 | 1.6 | — | — | — | 235 | 0.30 | 1.6 | — | — | — | — | — | — | — | 50 | 0.15 | 1.0 |
| | T5315 | 0.8 | 225 | 0.30 | 1.6 | — | — | — | 210 | 0.30 | 1.6 | — | — | — | — | — | — | — | 45 | 0.15 | 1.0 |
| | T9310 | 0.8 | 220 | 0.30 | 1.6 | — | — | — | 205 | 0.30 | 1.6 | — | — | — | — | — | — | — | 40 | 0.15 | 1.0 |
| | T9315 | 0.8 | 205 | 0.30 | 1.6 | — | — | — | 190 | 0.30 | 1.6 | — | — | — | — | — | — | — | 40 | 0.15 | 1.0 |
| | T9325 | 0.8 | 185 | 0.30 | 1.6 | — | — | — | 175 | 0.30 | 1.6 | — | — | — | — | — | — | — | — | — | |
| TNMG 160412E-M | T5315 | 1.2 | 215 | 0.40 | 1.6 | — | — | — | 200 | 0.40 | 1.6 | — | — | — | — | — | — | — | 40 | 0.15 | 1.0 |
| | T9315 | 1.2 | 190 | 0.40 | 1.6 | — | — | — | 180 | 0.40 | 1.6 | — | — | — | — | — | — | — | 35 | 0.15 | 1.0 |
| | T9325 | 1.2 | 170 | 0.40 | 1.6 | — | — | — | 160 | 0.40 | 1.6 | — | — | — | — | — | — | — | — | — | |
| | T9335 | 1.2 | 145 | 0.40 | 1.6 | — | — | — | — | — | — | — | — | — | — | — | — | — | — | — | |
| TNMG 220408E-M | T5305 | 0.8 | 245 | 0.30 | 2.1 | — | — | — | 230 | 0.30 | 2.1 | — | — | — | — | — | — | — | 45 | 0.15 | 1.0 |
| | T5315 | 0.8 | 215 | 0.30 | 2.1 | — | — | — | 200 | 0.30 | 2.1 | — | — | — | — | — | — | — | 40 | 0.15 | 1.0 |
| | T9310 | 0.8 | 215 | 0.30 | 2.1 | — | — | — | 200 | 0.30 | 2.1 | — | — | — | — | — | — | — | 40 | 0.15 | 1.0 |
| | T9315 | 0.8 | 200 | 0.30 | 2.1 | — | — | — | 190 | 0.30 | 2.1 | — | — | — | — | — | — | — | 40 | 0.15 | 1.0 |
| | T9325 | 0.8 | 180 | 0.30 | 2.1 | — | — | — | 170 | 0.30 | 2.1 | — | — | — | — | — | — | — | — | — | |
| TNMG 220412E-M | T5315 | 1.2 | 205 | 0.40 | 2.1 | — | — | — | 190 | 0.40 | 2.1 | — | — | — | — | — | — | — | 40 | 0.15 | 1.0 |
| | T9315 | 1.2 | 185 | 0.40 | 2.1 | — | — | — | 175 | 0.40 | 2.1 | — | — | — | — | — | — | — | 35 | 0.15 | 1.0 |
| | T9325 | 1.2 | 165 | 0.40 | 2.1 | — | — | — | 155 | 0.40 | 2.1 | — | — | — | — | — | — | — | — | — | |
| | T9335 | 1.2 | 140 | 0.40 | 2.1 | — | — | — | — | — | — | — | — | — | — | — | — | — | — | — | |
|   Wysoce pozytywna geometria NF zaprojektowana do obróbki od superwykańczającej do średniej, do ciągłych warunków pracy. | HF7 | 0.4 | — | — | — | 90 | 0.14 | 1.4 | 140 | 0.15 | 1.4 | 450 | 0.18 | 1.4 | — | — | — | — | — | — | |
| | T6310 | 0.4 | 150 | 0.17 | 1.4 | 105 | 0.15 | 1.4 | 120 | 0.17 | 1.4 | 450 | 0.20 | 1.4 | 45 | 0.15 | 1.1 | — | — | — | |
| | T7325 | 0.4 | 170 | 0.18 | 1.4 | 130 | 0.16 | 1.4 | — | — | — | — | — | 55 | 0.16 | 1.1 | — | — | — | | |
| | T7335 | 0.4 | 165 | 0.18 | 1.4 | 125 | 0.16 | 1.4 | — | — | — | — | — | 50 | 0.16 | 1.1 | — | — | — | | |
| | T8315 | 0.4 | 160 | 0.17 | 1.4 | 95 | 0.15 | 1.4 | 150 | 0.17 | 1.4 | 480 | 0.20 | 1.4 | 40 | 0.15 | 1.1 | — | — | — | |
| | T8330 | 0.4 | 155 | 0.17 | 1.4 | 90 | 0.15 | 1.4 | 145 | 0.17 | 1.4 | 465 | 0.20 | 1.4 | 35 | 0.15 | 1.1 | — | — | — | |
| | T8430 | 0.4 | 175 | 0.17 | 1.4 | 95 | 0.15 | 1.4 | 140 | 0.17 | 1.4 | 480 | 0.20 | 1.4 | 35 | 0.15 | 1.1 | — | — | — | |
| | T9315 | 0.4 | 255 | 0.15 | 1.4 | — | — | — | 240 | 0.15 | 1.4 | — | — | — | — | — | — | — | — | — | |
| T9325 | 0.4 | 215 | 0.18 | 1.4 | 125 | 0.16 | 1.4 | 200 | 0.18 | 1.4 | — | — | — | 45 | 0.16 | 1.1 | — | — | — | | |



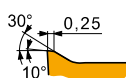
Zalecane początkowe wartości dla prędkości skrawania (vc), posuwu (f) i głębokości skrawania (ap). Więcej opcji można znaleźć w naszej aplikacji Kalkulator Parametrów Skrawania.

| Product | RE (mm) | P | | | M | | | K | | | N | | | S | | | H | | |
|---------|------------|---------------|---------------|------------|---------------|---------------|------------|---------------|---------------|------------|---------------|---------------|------------|---------------|---------------|------------|---------------|---------------|------------|
| | | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) | vc (m/min) | f (mm/rev) | ap (mm) |



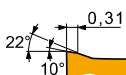
Wysoko pozytywna geometria NF zaprojektowana do obróbki od superwykańczającej do średniej, do ciągłych warunków pracy.

| | | | | | | | | | | | | | | | | | | | | |
|-----------------|-------|-----|-----|------|-----|-----|------|-----|-----|------|-----|-----|------|-----|----|------|-----|---|---|---|
| TNMG 160408E-NF | HF7 | 0.8 | – | – | – | 100 | 0.15 | 1.4 | 160 | 0.17 | 1.4 | 510 | 0.20 | 1.4 | – | – | – | – | – | – |
| | T6310 | 0.8 | 180 | 0.18 | 1.4 | 125 | 0.16 | 1.4 | 145 | 0.18 | 1.4 | 540 | 0.22 | 1.4 | 50 | 0.16 | 1.1 | – | – | – |
| | T7325 | 0.8 | 200 | 0.18 | 1.4 | 155 | 0.16 | 1.4 | – | – | – | – | – | – | 65 | 0.16 | 1.1 | – | – | – |
| | T7335 | 0.8 | 195 | 0.18 | 1.4 | 150 | 0.16 | 1.4 | – | – | – | – | – | – | 60 | 0.16 | 1.1 | – | – | – |
| | T8315 | 0.8 | 190 | 0.18 | 1.4 | 110 | 0.16 | 1.4 | 180 | 0.18 | 1.4 | 570 | 0.22 | 1.4 | 45 | 0.16 | 1.1 | – | – | – |
| | T8330 | 0.8 | 180 | 0.18 | 1.4 | 105 | 0.16 | 1.4 | 170 | 0.18 | 1.4 | 540 | 0.22 | 1.4 | 45 | 0.16 | 1.1 | – | – | – |
| | T8430 | 0.8 | 205 | 0.18 | 1.4 | 110 | 0.16 | 1.4 | 170 | 0.18 | 1.4 | 570 | 0.22 | 1.4 | 45 | 0.16 | 1.1 | – | – | – |
| | T9315 | 0.8 | 290 | 0.17 | 1.4 | – | – | – | 275 | 0.17 | 1.4 | – | – | – | – | – | – | – | – | – |
| | T9325 | 0.8 | 255 | 0.18 | 1.4 | 150 | 0.16 | 1.4 | 240 | 0.18 | 1.4 | – | – | – | 55 | 0.16 | 1.1 | – | – | – |



Wysoko pozytywna geometria NM zaprojektowana do obróbki wykańczającej, średniej i zgrubnej, do ciągłych warunków pracy.

| | | | | | | | | | | | | | | | | | | | | |
|-----------------|-------|-----|-----|------|-----|-----|------|-----|---|---|---|-----|------|-----|----|------|-----|---|---|---|
| TNMG 160404E-NM | T7325 | 0.4 | 170 | 0.20 | 1.9 | 130 | 0.18 | 1.9 | – | – | – | – | – | – | 55 | 0.20 | 1.5 | – | – | – |
| | T7335 | 0.4 | 160 | 0.20 | 1.9 | 120 | 0.18 | 1.9 | – | – | – | – | – | – | 50 | 0.20 | 1.5 | – | – | – |
| | T8315 | 0.4 | 160 | 0.20 | 1.9 | 95 | 0.18 | 1.9 | – | – | – | 480 | 0.24 | 1.9 | 40 | 0.20 | 1.5 | – | – | – |
| | T8330 | 0.4 | 145 | 0.20 | 1.9 | 85 | 0.18 | 1.9 | – | – | – | 435 | 0.24 | 1.9 | 35 | 0.20 | 1.5 | – | – | – |
| | T8430 | 0.4 | 170 | 0.20 | 1.9 | 90 | 0.18 | 1.9 | – | – | – | 465 | 0.24 | 1.9 | 35 | 0.20 | 1.5 | – | – | – |
| | T9325 | 0.4 | 210 | 0.20 | 1.9 | 125 | 0.18 | 1.9 | – | – | – | – | – | – | 45 | 0.20 | 1.5 | – | – | – |
| TNMG 160408E-NM | T7325 | 0.8 | 190 | 0.25 | 1.9 | 145 | 0.23 | 1.9 | – | – | – | – | – | – | 60 | 0.20 | 1.5 | – | – | – |
| | T7335 | 0.8 | 180 | 0.25 | 1.9 | 140 | 0.23 | 1.9 | – | – | – | – | – | – | 55 | 0.20 | 1.5 | – | – | – |
| | T8315 | 0.8 | 175 | 0.25 | 1.9 | 105 | 0.23 | 1.9 | – | – | – | 525 | 0.30 | 1.9 | 40 | 0.20 | 1.5 | – | – | – |
| | T8330 | 0.8 | 165 | 0.25 | 1.9 | 95 | 0.23 | 1.9 | – | – | – | 495 | 0.30 | 1.9 | 40 | 0.20 | 1.5 | – | – | – |
| | T8430 | 0.8 | 185 | 0.25 | 1.9 | 100 | 0.23 | 1.9 | – | – | – | 510 | 0.30 | 1.9 | 40 | 0.20 | 1.5 | – | – | – |
| | T9315 | 0.8 | 250 | 0.25 | 1.9 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| TNMG 220408E-NM | T7325 | 0.8 | 190 | 0.25 | 1.7 | 145 | 0.23 | 1.7 | – | – | – | – | – | – | 60 | 0.20 | 1.4 | – | – | – |
| | T7335 | 0.8 | 185 | 0.25 | 1.7 | 140 | 0.23 | 1.7 | – | – | – | – | – | – | 60 | 0.20 | 1.4 | – | – | – |
| | T8315 | 0.8 | 175 | 0.25 | 1.7 | 105 | 0.23 | 1.7 | – | – | – | 525 | 0.30 | 1.7 | 40 | 0.20 | 1.4 | – | – | – |
| | T8330 | 0.8 | 165 | 0.25 | 1.7 | 95 | 0.23 | 1.7 | – | – | – | 495 | 0.30 | 1.7 | 40 | 0.20 | 1.4 | – | – | – |
| | T8430 | 0.8 | 185 | 0.25 | 1.7 | 100 | 0.23 | 1.7 | – | – | – | 510 | 0.30 | 1.7 | 40 | 0.20 | 1.4 | – | – | – |
| | T9315 | 0.8 | 255 | 0.25 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| TNMG 220412E-NM | T7325 | 1.2 | 190 | 0.30 | 1.7 | 145 | 0.27 | 1.7 | – | – | – | – | – | – | 60 | 0.24 | 1.4 | – | – | – |
| | T7335 | 1.2 | 180 | 0.30 | 2.1 | 140 | 0.27 | 2.1 | – | – | – | – | – | – | 55 | 0.24 | 1.7 | – | – | – |
| | T9325 | 1.2 | 215 | 0.30 | 2.1 | 125 | 0.27 | 2.1 | – | – | – | – | – | – | 45 | 0.24 | 1.7 | – | – | – |



Pozytywna geometria NMR zaprojektowana do obróbki od średniej do zgrubnej, do ciągłych warunków pracy.

| | | | | | | | | | | | | | | | | | | | | |
|------------------|-------|-----|------|------|-----|------|------|-----|---|---|---|---|---|----|------|------|-----|---|---|---|
| TNMG 160404E-NMR | T6310 | 0.4 | 130 | 0.20 | 1.7 | 90 | 0.18 | 1.7 | – | – | – | – | – | – | 35 | 0.18 | 1.4 | – | – | – |
| | T7325 | 0.4 | 145 | 0.20 | 1.7 | 110 | 0.18 | 1.7 | – | – | – | – | – | – | 45 | 0.18 | 1.4 | – | – | – |
| | T7335 | 0.4 | 145 | 0.20 | 1.7 | 110 | 0.18 | 1.7 | – | – | – | – | – | – | 45 | 0.18 | 1.4 | – | – | – |
| | T8330 | 0.4 | 130 | 0.20 | 1.7 | 75 | 0.18 | 1.7 | – | – | – | – | – | – | 30 | 0.18 | 1.4 | – | – | – |
| | T8430 | 0.4 | 145 | 0.20 | 1.7 | 80 | 0.18 | 1.7 | – | – | – | – | – | – | 30 | 0.18 | 1.4 | – | – | – |
| | T9315 | 0.4 | 200 | 0.20 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| TNMG 160408E-NMR | T9325 | 0.4 | 180 | 0.20 | 1.7 | 105 | 0.18 | 1.7 | – | – | – | – | – | – | 40 | 0.18 | 1.4 | – | – | – |
| | T6310 | 0.8 | 140 | 0.30 | 1.7 | 100 | 0.27 | 1.7 | – | – | – | – | – | – | 40 | 0.24 | 1.4 | – | – | – |
| | T7325 | 0.8 | 155 | 0.30 | 1.7 | 120 | 0.27 | 1.7 | – | – | – | – | – | – | 50 | 0.24 | 1.4 | – | – | – |
| | T7335 | 0.8 | 145 | 0.30 | 1.7 | 110 | 0.27 | 1.7 | – | – | – | – | – | – | 45 | 0.24 | 1.4 | – | – | – |
| | T8330 | 0.8 | 140 | 0.30 | 1.7 | 80 | 0.27 | 1.7 | – | – | – | – | – | – | 35 | 0.24 | 1.4 | – | – | – |
| | T8430 | 0.8 | 150 | 0.30 | 1.7 | 80 | 0.27 | 1.7 | – | – | – | – | – | – | 30 | 0.24 | 1.4 | – | – | – |
| | T9315 | 0.8 | 205 | 0.30 | 1.7 | – | – | – | – | – | – | – | – | – | – | – | – | – | – | – |
| T9325 | 0.8 | 185 | 0.30 | 1.7 | 110 | 0.27 | 1.7 | – | – | – | – | – | – | 40 | 0.24 | 1.4 | – | – | – | |