

FRESE AD INSERTI
INSERT MILLING CUTTERS
WENDEPLATTEN-FRÄSWERKZEUGE

T475

FRESE AD INSERTI INSERT MILLING CUTTERS WENDEPLATTEN-FRÄSWERKZEUGE

T475

FRESA PER SPIANATURA
 Face milling cutter
 Planfräser



HEAVY DUTY

Fresa a spianare a 75°.
 Permette elevate asportazioni sfruttando tutti i KW.

75° face milling cutter.
 It allows high material removal using all the KW at disposal.

Planfräser 75°.
 Ermöglicht eine große Spanabfuhr durch Nutzung aller KW.



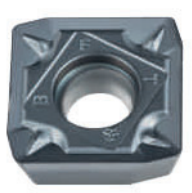
P M K S

Ø 100 ÷ 250

SPMT 1906...

EDER

Per lavorazioni standard
 Standard machining
 Für universelle Bearbeitungen

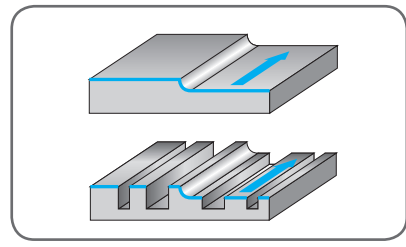


EDTR

Per lavorazioni pezzi forgiati
 Forged parts machining
 Für geschmiedete Rohteile



High Quality STEEL



A_p MAX 15,0 mm
 F_z MAX 0,7 mm

i

CARTUCCIA
 Cartridge / Kassette



Volume truciolo oltre 2.000 cm³/min
 Chip volume over 2,000cm³/min
 Spanvolumen über 2000cm³/min



Fori di lubrorefrigerazione
 Coolant holes
 Kühlmittelbohrungen

**T475**

FRESA PER SPIANATURA

Face milling cutter

Planfräse

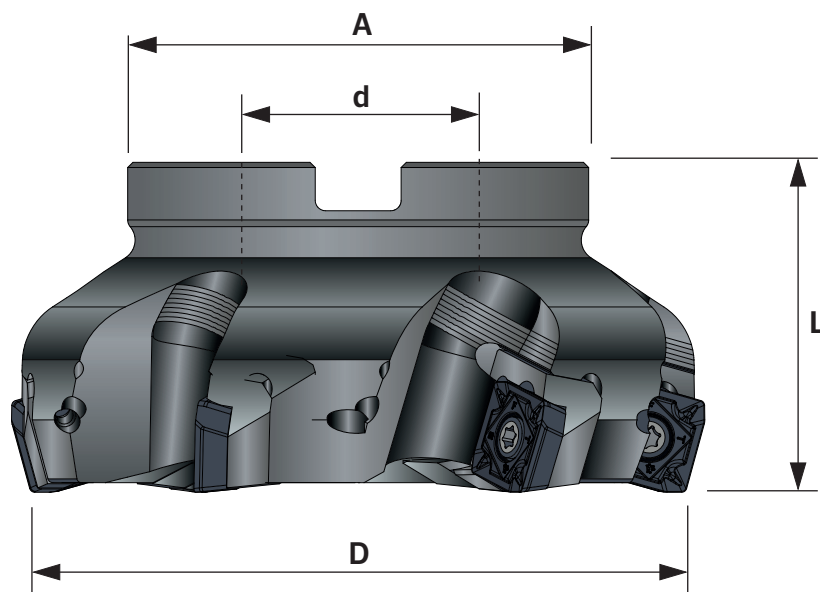
FRESE AD INSERTI

INSERT MILLING CUTTERS

WENDEPLATTEN-FRÄSWERKZEUGE



Con fori di
lubrorefrigerazione
Coolant holes
Mit Kühlmittelbohrungen



CODICE CODE	DIMENSIONI / DIMENSIONS / MAßE					INSERTO INSERT WSP						
	D	Z	L	d	A							
T475 PM 100.SP19 Z5 W	100	5	63	32	78	SPMT 1906...	VTRM20 (5,2-5,6 Nm)	CVT25	CA475.19	VTA21 (2x)	CVT15P	-
T475 PM 125.SP19 Z6 W	125	6	63	40	88							TPP160
T475 PM 160.SP19 Z8 W*	160	8	63	40	101							TPP200
T475 PM 200.SP19 Z10 W*	200	10	63	60	153							
T475 PM 250.SP19 Z12 W*	250	12	63	60	190							

*Fresa fornita senza tappo TPP..., ordinare il ricambio separatamente.

*End mill without TPP... plate, order separately.

*Fräser ohne TPP - Deckel, Ersatzteile separat bestellen.

T475

FRESA PER SPIANATURA

Face milling cutter

Planfräse

FRESE AD INSERTI

INSERT MILLING CUTTERS

WENDEPLATTEN-FRÄSWERKZEUGE



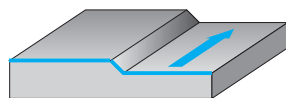
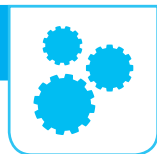
Inserti per fresa T475

Inserts for T475 milling cutter / WSP für T475 Fräser



CODICE CODE	DIMENSIONI DIMENSIONS MAßE		Fz (mm)	P	M	K	S
	L	S	Ap (mm)				
SPMT 1906 EDER	19,00	6,35	0,3 - 0,7	CPS30 CPX35	CCD40 CPX35	CPS30	CCD40
			15,0 - 8,0				
SPMT 1906 EDTR	19,00	6,35	0,3 - 0,7	KC84BP CPS30	KC84BP	KC84BP	
			15,0 - 8,0				

Esempi di lavorazione / Application example / Anwendungsbeispiele



Materiale	Material	Material	39 NiCrMo3
Trattamento termico	Heat treatment	Wärmebehandlung	Forgiato Foreged / Geschmiedet
Fresa	Milling cutter	Fräser	T475PM 160.SP19 Z8
Inserti	Inserts	Wendescheidplatte	SDMT 1906EDER CPX35
Refrigerante	Coolant	Kühlmittel	A secco
Velocità di taglio (V _c)	Cutting speed (V _c)	Schnittgeschwindigkeit (V _c)	80 m/min
Numero di giri (rpm)	Number of revolutions(rpm)	Drehzahl (rpm)	160 rpm
Avanzamento tagliente (F _z)	Tooth feed (F _z)	Schneidkantenvorschub (F _z)	0,62 mm
Avanzamento (F)	Feed rate (F)	Vorschub (F)	800 mm/min
Profondità di taglio radiale (A _e)	Cutting width (A _e)	Radiale Schnitttiefe	140 mm
Profondità di taglio assiale (A _p)	Cutting depth (A _p)	Axiale Schnitttiefe (A _p)	12 mm
Volume truciolo (Q)	Chip volume (Q)	Zeitspanvolumen (Q)	1344 cm ³ /min

**T475**

FRESA PER SPIANATURA

Face milling cutter

Planfräse

FRESE AD INSERTI

INSERT MILLING CUTTERS

WENDEPLATTEN-FRÄSWERKZEUGE

**Parametri di taglio per fresa T475**

Cutting data T475 milling cutter

Schnittparameter für T475 Fräser

Mat.	HB ^(a) N/mm ² ^(b) HrC ^(c)	Kc ^(f)	Chipbreaker	Medium		Chipbreaker	Roughing		Vc			
				Ap	Fz ₀		Ap	Fz ₀	CPS30	KC84BP	CPX35	CCD40
P1	125(a) / 420(b)	1350	EDER	8,0-10,0	0,35-0,70	EDTR	10,0-15,0	0,30-0,65	80-160	100-200	70-130	
P2	190(a) / 650(b)	1500			0,35-0,70			0,35-0,65				
P3	250(a) / 850(b)	1675			0,30-0,60			0,30-0,55				
P4	220(a) / 750(b)	1700			0,35-0,70			0,30-0,65				
P5	300(a) / 1000(b)	1900			0,30-0,60			0,30-0,55				
P6	200(a) / 600(b)	1775			0,35-0,70			0,30-0,65				
P7	275(a) / 930(b)	1675			0,30-0,60			0,30-0,55				
P8	300(a) / 1000(b)	1725			0,30-0,40			0,30-0,35				
P9	350(a) / 1200(b)	1800			0,27-0,50			0,25-0,45				
P10	200(a) / 680(b)	2450			0,30-0,60			0,30-0,55				
P11	325(a) / 1100(b)	2500			0,27-0,50			0,25-0,45				
M12	200(a) / 680(b)	1875	EDER	7,0-9,0	0,35-0,70	EDTR	8,0-12,0	0,35-0,65			60-100	60-120
M13	240(a) / 820(b)	1875			0,30-0,60			0,30-0,55			30-50	40-60
M14	180(a) / 600(b)	2150										
K15	180(a)	1150	EDER	8,0-10,0	0,40-0,70	EDTR	10,0-15,0	0,35-0,65	100-200	150-250	70-130	
K16	260(a)	1350			0,35-0,70			0,35-0,65				
K17	160(a)	1225			0,40-0,70			0,35-0,65				
K18	250(a)	1350			0,35-0,70			0,35-0,65				
S31	200(a)	2600	EDER	7,0-9,0	0,35-0,55	EDTR	8,0-12,0	0,30-0,45				30-80
S32	280(a)	3100			0,35-0,55			0,30-0,45				
S33	250(a)	3300			0,35-0,55			0,30-0,45				
S34	350(a)	3300			0,30-0,50			0,30-0,45				
S35	320(a)	3300			0,30-0,50			0,30-0,45				
S36	400(b)	1700			0,35-0,55			0,30-0,45				
S37	1050(b)	2110			0,30-0,50			0,30-0,45				