

# TF100

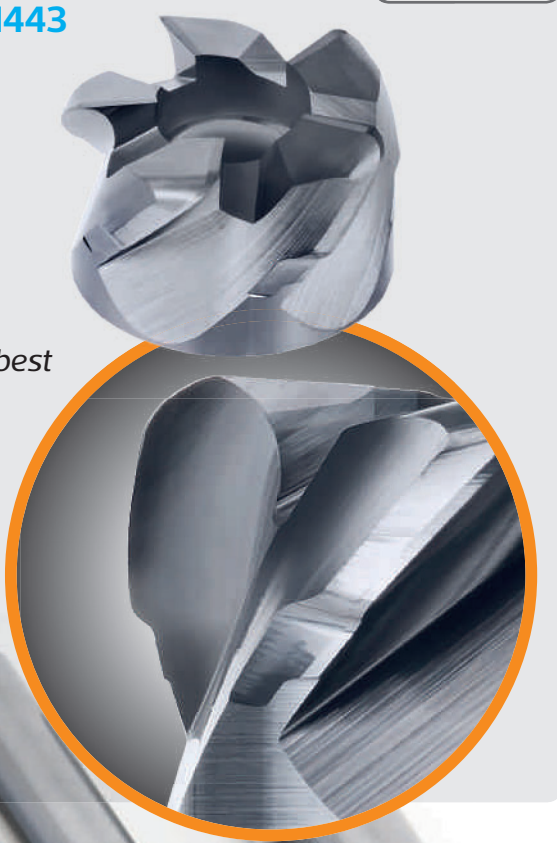
FRESA PER SUPERFINITURA  
 Superfinishing end mill  
 Feinschlichtenfräser



Nuovo sistema **BREVETTATO - 202019000001443** di finitura ad inserti.  
 La geometria torica e pluritagliente della testina rappresenta la soluzione ideale nelle lavorazioni di semifinitura e finitura di stampi.

New **patented** insert finishing system.  
 The toric and multi-cutting geometry of the head is the best choice for semi-finishing and finishing of moulds.

Neus **patentiertes** System von Schlichten-WSP.  
 Die torische und mehrschneidige Geometrie des Kopfe sind die ideale Lösung für Schlichten und Feinschlichten von Formen.



**3 dimensioni di testine**  
 3 heads sizes  
 3 Größen Köpfen  
**12 - 16 - 20**

**4 raggi di punta**  
 4 tip radius  
 4 Radius WSP  
**0,5 - 1,0 - 2,0 - 3,0**

**TF 100**

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Superfinishing end mill

Feinschliffenfräser

FRESE AD INSERTI

INSERT MILLING CUTTERS

WENDEPLATTEN-FRÄSWERKZEUGE

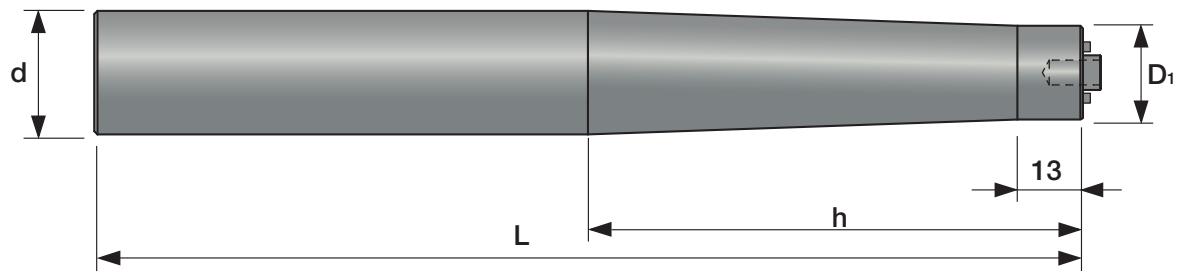
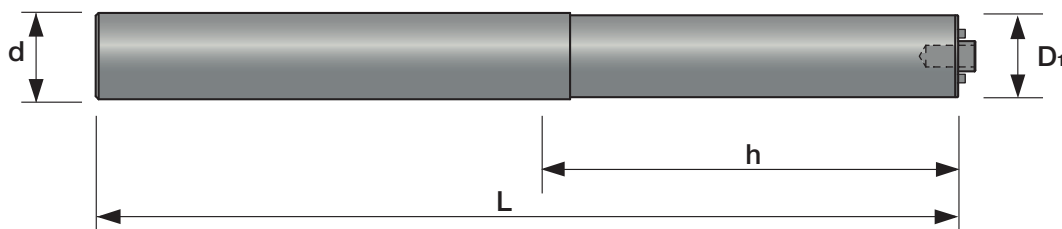
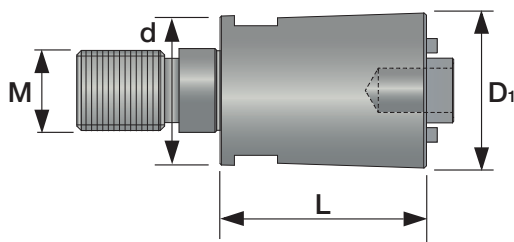
**TF100R****TF100C**

Fig. A

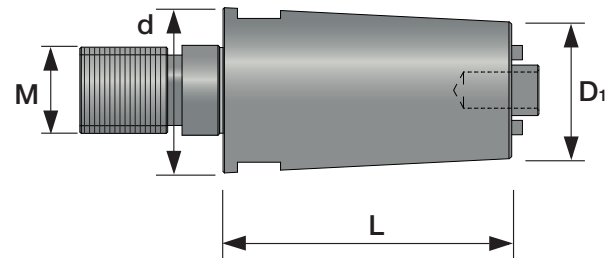


Fig. B

**TF100M**

| CODICE<br>CODE |                 | DIMENSIONI / DIMENSIONS / MAßE |     |    |      |    |      |               |       |       |
|----------------|-----------------|--------------------------------|-----|----|------|----|------|---------------|-------|-------|
|                |                 | h                              | L   | D1 | d    | M  | fig. |               |       |       |
| <b>TF100R</b>  | <b>012 L060</b> | 60                             | 120 | 11 | 16   | -  | -    | TF100H 012... | VTX25 |       |
|                | <b>016 L080</b> | 80                             | 160 | 15 | 20   | -  | -    | TF100H 016... |       | -     |
|                | <b>020 L100</b> | 100                            | 200 | 19 | 25   | -  | -    | TF100H 020... | VTA12 |       |
| <b>TF100C</b>  | <b>012 L024</b> | 24                             | 120 | 11 | 12   | -  | -    | TF100H 012... | VTX25 |       |
|                | <b>012 L054</b> | 54                             | 120 | 11 | 12   | -  | -    |               |       |       |
|                | <b>016 L032</b> | 32                             | 160 | 15 | 16   | -  | -    | TF100H 016... |       | -     |
|                | <b>016 L072</b> | 72                             | 160 | 15 | 16   | -  | -    |               | VTA12 |       |
|                | <b>020 L040</b> | 40                             | 200 | 19 | 20   | -  | -    | TF100H 020... |       |       |
|                | <b>020 L090</b> | 90                             | 200 | 19 | 20   | -  | -    |               |       |       |
| <b>TF100M</b>  | <b>06 012</b>   | -                              | 13  | 11 | 10,8 | 6  | A    | TF100H 012... | VTX25 | CH 9  |
|                | <b>08 012</b>   | -                              | 13  | 11 | 12,8 | 8  | B    |               |       | CH 10 |
|                | <b>08 016</b>   | -                              | 13  | 15 | 12,8 | 8  | A    | TF100H 016... |       | CH 11 |
|                | <b>10 016</b>   | -                              | 32  | 15 | 17,8 | 10 | B    |               | VTA12 | CH 15 |
|                | <b>10 020</b>   | -                              | 13  | 19 | 17,8 | 10 | A    | TF100H 020... |       | CH 16 |
|                | <b>12 020</b>   | -                              | 40  | 19 | 23,0 | 12 | B    |               |       | CH 20 |

# TF 100

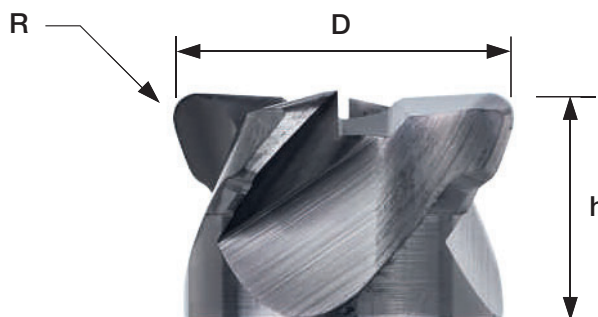
FRESA PER SUPERFINITURA  
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**FRESE AD INSERTI**  
**INSERT MILLING CUTTERS**  
**WENDEPLATTEN-FRÄSWERKZEUGE**



## i-TF100H

INSERTI PER FRESA TF100  
 Insert for TF100 milling cutter / WSP für TF100 Fräser



TF 100

FRESE AD INSERTI INSERT MILLING CUTTERS WENDEPLATTEN-FRÄSWERKZEUGE

| CODICE<br>CODE   | DIMENSIONI<br>DIMENSIONS<br>MAßE |     |    |   | P     | M             | H     |
|------------------|----------------------------------|-----|----|---|-------|---------------|-------|
|                  | D                                | R   | h  | Z |       |               |       |
| i-TF100H 120 R05 | 12                               | 0,5 | 8  | 4 | KH100 | KH100<br>KH58 | KH100 |
| i-TF100H 120 R10 |                                  | 1,0 |    |   |       |               |       |
| i-TF100H 120 R20 |                                  | 2,0 |    |   |       |               |       |
| i-TF100H 120 R30 |                                  | 3,0 |    |   |       |               |       |
| i-TF100H 160 R05 | 16                               | 0,5 | 10 | 5 | KH100 | KH100<br>KH58 | KH100 |
| i-TF100H 160 R10 |                                  | 1,0 |    |   |       |               |       |
| i-TF100H 160 R20 |                                  | 2,0 |    |   |       |               |       |
| i-TF100H 160 R30 |                                  | 3,0 |    |   |       |               |       |
| i-TF100H 200 R05 | 20                               | 0,5 | 10 | 5 | KH100 | KH100<br>KH58 | KH100 |
| i-TF100H 200 R10 |                                  | 1,0 |    |   |       |               |       |
| i-TF100H 200 R20 |                                  | 2,0 |    |   |       |               |       |
| i-TF100H 200 R30 |                                  | 3,0 |    |   |       |               |       |



**TF 100**

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**Parametri di taglio per fresa TF100**

Cutting data TF100 milling cutter

Schnittparameter für TF100 Fräser

| Mat. | HB<br>N/mm<br>HrC | Kc   | Sgrossatura a terrazzamento / Terraced roughing / 3D Formteil schruppen |            |                     |                     |
|------|-------------------|------|---|------------|---------------------|---------------------|
|      |                   |      | KH100   | KH58       | 1° scelta           | 2° scelta           |
|      |                   |      | Vt (m/min)  | Vt (m/min) | inserto con RdP = 3 | inserto con RdP = 2 |
| P8   | 300(a) / 1000(b)  | 1750 | 140   | 130        | Ap = 0,20-0,50      | Ap = 0,20-0,35      |
| P9   | 350(a) / 1200(b)  | 1800 | 130   | 115        |                     |                     |
| P10  | 200(a) / 680(b)   | 2450 | 110   | 100        | Fz = 0,20-0,50      | Fz = 0,15-0,30      |
| P11  | 325(a) / 1100(b)  | 2500 | 100   | 85         |                     |                     |
| M12  | 200(a) / 680(b)   | 1875 |   | 100        | Ae = D-2R           | Ae = D-2R           |
| M13  | 240(a) / 820(b)   | 1875 |   | 70         |                     |                     |
| M14  | 180(a) / 600(b)   | 2150 |   | 60         |                     |                     |
| H38  | 45-55(c)          | 4600 | 150   |            | a = 1°              | a = 1°              |
| H39  | >55(c)            | 4700 | 130   |            |                     |                     |

| Mat. | HB<br>N/mm<br>HrC | Kc   | Finitura / Finishing / Feinbearbeitung |      |  |                 |                 |                 |  |                 |                 |                 |
|------|-------------------|------|--|------|--|-----------------|-----------------|-----------------|--|-----------------|-----------------|-----------------|
|      |                   |      | KH100                                  | KH58 | Contornatura di pareti inclinate<br>Contouring of sloping surfaces<br>Konturbearbeitung schräger Wände |                 |                 |                 | Contornatura di pareti diritte<br>Contouring of straight surfaces<br>Konturbearbeitung senkrechter Wände |                 |                 |                 |
|      |                   |      |  |      | Vt (m/min)   | Vt (m/min)      | R = 0,5         | R = 1,0         | R = 2,0  | R = 3,0         | R = 0,5         | R = 1,0         |
| P8   | 300(a) / 1000(b)  | 1750 | 140                                    | 130  | Ap<br>0,12   | Ap<br>0,16      | Ap<br>0,20      | Ap<br>0,25      | Ap<br>0,50   | Ap<br>0,50      | Ap<br>0,50      | Ap<br>0,50      |
| P9   | 350(a) / 1200(b)  | 1800 | 130                                    | 115  |  |                 |                 |                 |  |                 |                 |                 |
| P10  | 200(a) / 680(b)   | 2450 | 110                                    | 100  |  |                 |                 |                 |  |                 |                 |                 |
| P11  | 325(a) / 1100(b)  | 2500 | 100                                    | 85   | Fz<br>0,10-0,20  | Fz<br>0,12-0,22 | Fz<br>0,14-0,24 | Fz<br>0,15-0,30 | Fz<br>0,10-0,20  | Fz<br>0,12-0,22 | Fz<br>0,14-0,24 | Fz<br>0,15-0,30 |
| M12  | 200(a) / 680(b)   | 1875 |  | 100  |  |                 |                 |                 |  |                 |                 |                 |
| M13  | 240(a) / 820(b)   | 1875 |  | 70   |  |                 |                 |                 |  |                 |                 |                 |
| M14  | 180(a) / 600(b)   | 2150 |  | 60   | Fz<br>0,10-0,20  | Fz<br>0,12-0,22 | Fz<br>0,14-0,24 | Fz<br>0,15-0,30 | Fz<br>0,10-0,20  | Fz<br>0,12-0,22 | Fz<br>0,14-0,24 | Fz<br>0,15-0,30 |
| H38  | 45-55(c)          | 4600 | 150                                    |      |  |                 |                 |                 |  |                 |                 |                 |
| H39  | >55(c)            | 4700 | 130                                    |      |  |                 |                 |                 |  |                 |                 |                 |

| Mat. | HB<br>N/mm<br>HrC | Kc   | Finitura / Finishing / Feinbearbeitung |      |   |                 |                 |        |
|------|-------------------|------|--|------|---|-----------------|-----------------|--------|
|      |                   |      | KH100                                  | KH58 | Passate parallele<br>Parallel passes / Schruppen von parallelen Durchgängen |                 |                 |        |
|      |                   |      |  |      | Vt (m/min)  | Vt (m/min)      | D = 12          | D = 16 |
| P8   | 300(a) / 1000(b)  | 1750 | 140                                    | 130  | Ae<br>0,45  | Ae<br>0,50      | Ae<br>0,60      |        |
| P9   | 350(a) / 1200(b)  | 1800 | 130                                    | 115  |   |                 |                 |        |
| P10  | 200(a) / 680(b)   | 2450 | 110                                    | 100  |   |                 |                 |        |
| P11  | 325(a) / 1100(b)  | 2500 | 100                                    | 85   | Fz<br>0,10-0,20   | Fz<br>0,10-0,20 | Fz<br>0,10-0,20 |        |
| M12  | 200(a) / 680(b)   | 1875 |  | 100  |   |                 |                 |        |
| M13  | 240(a) / 820(b)   | 1875 |  | 70   |   |                 |                 |        |
| M14  | 180(a) / 600(b)   | 2150 |  | 60   | Fz<br>0,10-0,20   | Fz<br>0,10-0,20 | Fz<br>0,10-0,20 |        |
| H38  | 45-55(c)          | 4600 | 150                                    |      |   |                 |                 |        |
| H39  | >55(c)            | 4700 | 130                                    |      |   |                 |                 |        |