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SUMITOMO CARBIDE - CBN - DIAMOND · ZCC-CT · Carmex Precision Tools Ltd. · GERARDI · YAMAWA · KORLOY · SILMAX · KINTEK



DRS SYSTEM

Ampia gamma di soluzioni per la foratura

PROMO
6XD - 9XD

PUNTA A SCONTO 50%

ACQUISTANDO SOLO 10 INSERTI!

nikko TOOLS

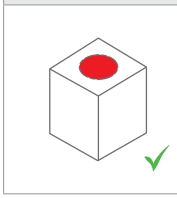
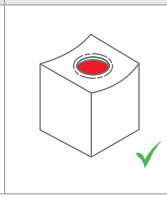
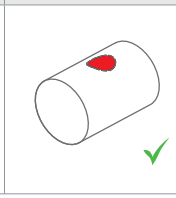
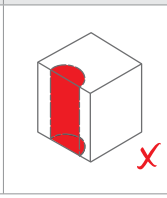
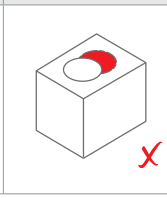
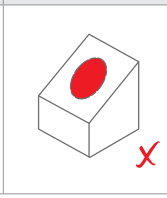
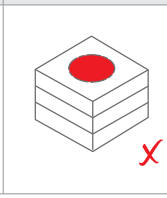
ADDA UTENSILI

DRSPILOT 6XD 9XD

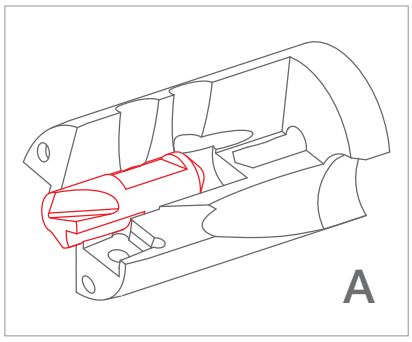
Centraggio perfetto anche su fori extra lunghi



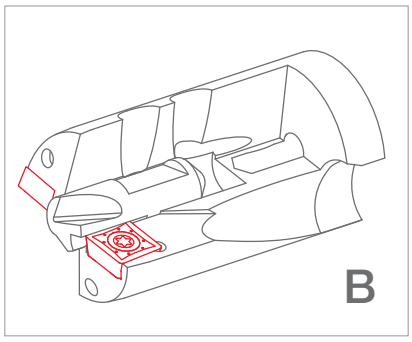
1. Quando è applicabile DRSPILOT?

SUPERFICIE PIANA	SUPERFICIE CONCAVA	TUBI	MEZZI FORI	ESPANSIONE FORI	SUPERFICIE INCLINATA	FORATURA A PACCO
						

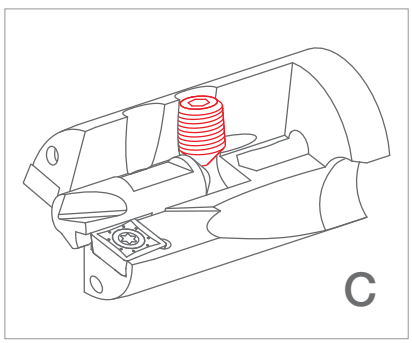
2. Installazione degli inserti e della punta pilota



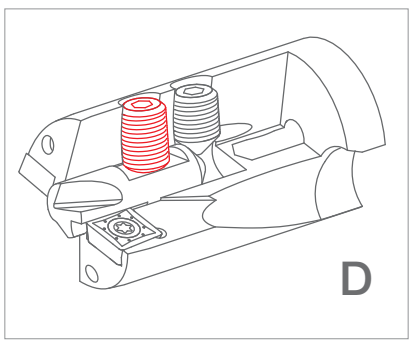
Inserire DRSP Pilota nel corpo della punta.



Installare gli inserti SPMX/ SPGX.



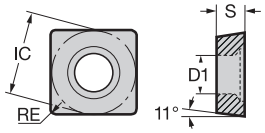
Regolare l'altezza del DRSP Pilota usando il grano di regolazione come mostrato nel disegno, seguendo la tabella a pag.11.



Avvitare con forza il grano di fissaggio.

SP□X

DRS PILOT
inserti a 4 taglienti



4 edges

Dimensioni	IC	S	D1	RE
05	5.00	2.38	2.50	0.40
06	6.00	2.38	2.80	0.40
07	7.94	3.97	2.80	0.80

ISO513	HC-PVD JP5625	HC-PVD JP5530	HC-PVD JP9635	HW JU6520
P	60 220	60 220		
M			40 160	
K	100 190	100 190		
N				150 300
S				
H				

AREA DI APPLICAZIONE DEL GRADO
- applicazione principale
- applicabile

Condizioni di taglio stabili
Condizioni di taglio medie
Condizioni di taglio instabili

Durezza + / – ; tenacità – / +

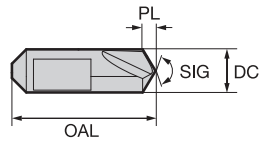
GENERALE	GP P M K	SPMX 050204-GP	6xD	f_n ▸	0.08	**0.10**	0.12	●	●	●			
			9xD	f_n ▸	0.06	**0.08**	0.10						
		SPMX 060204-GP	6xD	f_n ▸	0.08	**0.10**	0.12	●	●	●			
			9xD	f_n ▸	0.06	**0.08**	0.10						
		SPMX 07T308-GP	6xD	f_n ▸	0.09	**0.11**	0.13	●	●	●			
			9xD	f_n ▸	0.07	**0.09**	0.11						
ALLUMINIO	AL N	SPGX 050204-AL	6xD	f_n ▸	0.05	**0.07**	0.09				●		
			9xD	f_n ▸	0.04	**0.06**	0.08						
		SPGX 060204-AL	6xD	f_n ▸	0.05	**0.07**	0.09				●		
			9xD	f_n ▸	0.04	**0.06**	0.08						
		SPGX 07T308-AL	6xD	f_n ▸	0.06	**0.08**	0.10				●		
			9xD	f_n ▸	0.05	**0.07**	0.09						

superficie lappata

● stock standard

DRSP

DRS PILOT
punta centrante intercambiabile

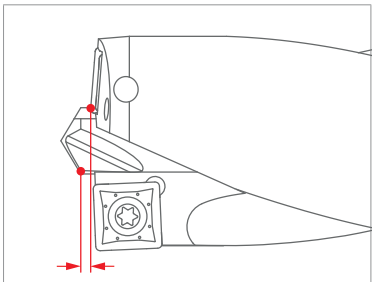


Dimensioni	DC	OAL	PL	SIG
06	6	20	1.5	118°
08	8	25	2.1	118°

GENERALE GP P M K N	DRSP 06-GP HSS TIN	●
	DRSP 08-GP HSS TIN	●

● stock standard

REGOLAZIONE ALTEZZA

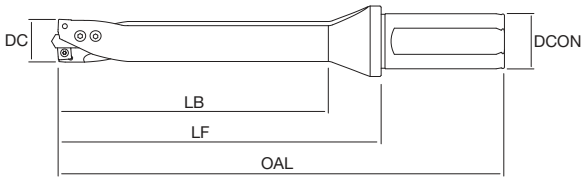


MATERIALE	6xD	9xD
P M K	1.0 mm	1.4 mm
N	1.5 mm	1.7 mm

MATERIALI

P M K N S H p. 14-15





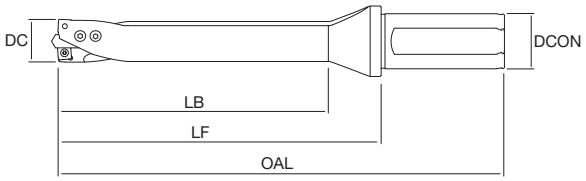
		DRS PILOT 6XD		DC	DCON	OAL	LF	LB		MIID (Inserto)	MIID (Pilota)
05	NT-DRS-6D	D18.00-S25-05P6	●	18	25	191	135	112		SPMX05 SPGX05	DRSP06
		D19.00-S25-05P6	●	19	25	197	141	118			
06	NT-DRS-6D	D20.00-S25-06P6	●	20	25	203	147	124		SPMX06 SPGX06	DRSP06
		D21.00-S25-06P6	●	21	25	209	153	130			
		D22.00-S25-06P6	●	22	25	215	159	136			
		D23.00-S32-06P6	●	23	32	228	168	142			
		D24.00-S32-06P6	●	24	32	234	174	148			
		D25.00-S32-06P6	●	25	32	240	180	154			
07	NT-DRS-6D	D26.00-S32-07P8	●	26	32	246	186	160		SPMX07 SPGX07	DRSP08
		D27.00-S32-07P8	●	27	32	252	192	166			
		D28.00-S32-07P8	●	28	32	258	198	172			
		D29.00-S32-07P8	●	29	32	264	204	178			
		D30.00-S32-07P8	●	30	32	270	210	184			

● stock standard

Ricambi	VITE INSERTO	CHIAVE INSERTO
NT-DRS-6D D□□.□□-S□□-05P6	NT-ST059	NT-FTB06
NT-DRS-6D D□□.□□-S□□-06P6	NT-ST061	NT-FTB06
NT-DRS-6D D□□.□□-S□□-07P8	NT-ST062	NT-FTB07

Ricambi	GRANO DI SERRAGGIO	GRANO DI REGOLAZIONE	CHIAVE GRANO
DC 18÷22	NT-ST042	NT-ST043	NT-WR025
DC 23÷25	NT-ST044	NT-ST045	
DC 26÷30	NT-ST046	NT-ST047	NT-WR030





	DRS PILOT 9XD			DC	DCON	OAL	LF	LB		MIID (Inserto)	MIID (Pilota)
05	NT-DRS-9D	D18.00-S25-05P6	●	18	25	245	189	166		SPMX05 SPGX05	DRSP06
		D19.00-S25-05P6	●	19	25	254	198	175			
06	NT-DRS-9D	D20.00-S25-06P6	●	20	25	263	207	184		SPMX06 SPGX06	DRSP06
		D21.00-S25-06P6	●	21	25	272	216	193			
		D22.00-S25-06P6	●	22	25	281	225	202			
		D23.00-S32-06P6	●	23	32	297	237	211			
		D24.00-S32-06P6	●	24	32	306	246	220			
		D25.00-S32-06P6	●	25	32	315	255	229			
07	NT-DRS-9D	D26.00-S32-07P8	●	26	32	324	264	238		SPMX07 SPGX07	DRSP08
		D27.00-S32-07P8	●	27	32	333	273	247			
		D28.00-S32-07P8	●	28	32	342	282	256			
		D29.00-S32-07P8	●	29	32	351	291	265			
		D30.00-S32-07P8	●	30	32	360	300	274			

● stock standard

Ricambi	VITE INSERTO	CHIAVE INSERTO
NT-DRS-9D D□□.□□-S□□-05P6	NT-ST059	NT-FTB06
NT-DRS-9D D□□.□□-S□□-06P6	NT-ST061	NT-FTB06
NT-DRS-9D D□□.□□-S□□-07P8	NT-ST062	NT-FTB07

Ricambi	GRANO DI SERRAGGIO	GRANO DI REGOLAZIONE	CHIAVE GRANO
DC 18÷22	NT-ST042	NT-ST043	NT-WR025
DC 23÷25	NT-ST044	NT-ST045	
DC 26÷30	NT-ST046	NT-ST047	NT-WR030

VELOCITÀ DI TAGLIO [m/min]

	MATERIALi	DUREZZA/Rm	W.-Nr	DIN	AISI-ASTM	TRADE MARK
P1	Acciai automatici e acciai strutturali	< 500 N/mm²	1.0715 1.0765	9 SMn 28 36 SMnPb 14	1213 A29	AVP PR80
P2	Acciai al carbonio e acciai basso legati	500-700 N/mm²	1.7147 1.0511	20 MnCr 5 C 40	5120 1040	- -
P3	Acciai medio legati e acciai da bonifica	600-800 N/mm²	1.1201 1.6511	42 CrMo 4 36 CrNiMo 4	4142, 4140 9840	- -
P4	Acciai alto legati	800-1000 N/mm²	1.1663 1.3505	C 125 W 100 Cr 6	W1 52100	- -
P5	Acciai per utensili	900-1200 N/mm²	1.2080 1.2379	X 210 Cr 12 X 155 CrVMo 12 1	D3 -	K100 K110
M1	Acciai inossidabili ferritici	400-700 N/mm²	1.4016 1.4104	X 6 Cr 17 X 12 CrMoS 17	430 430 F	- -
M2	Acciai inossidabili austenitici - buona lavorabilità	500-750 N/mm²	1.4305 1.4301	X 10 CrNiS 18 9 X 6 CrNi 18 10	303 304, 304 H	- -
M3	Acciai inossidabili austenitici - media lavorabilità	550-850 N/mm²	1.4401 1.4462	X 5 CrNiMo 17 12 2 X 2 CrNiMoN 22 5	316 F 51-329 A	- DUPLEX
M4	Acciai inossidabili martensitici	650-950 N/mm²	1.4021 1.4410	X 20 Cr 13 X 2 CrNiMoN 25 7 4	420 F 53-329 S1	- SUPER DUPLEX
M5	Acciai inossidabili PH - indurenti per precipitazione	800-1250 N/mm²	1.4540 1.4542	X 4 CrNiCuNb 16 4 X 5 CrNiNb 16 4	XM-12 631	15-5-PH 17-4-PH
K1	Ghise grigie	150-250 HB	0.6020 0.6025	GG-20 GG-25	A48 30 B A48 35 B	- -
K2	Ghise sferoidali	150-350 HB	0.7050 0.7070	GGG-50 GGG-70	A536 80-55-6 A536 100-70-03	- -
N1	Leghe di alluminio ≤ 12% Si		3.3547 3.2315	AlMg4.5Mn AlMgSi 1	5083 6082	Peraluman 440 Anticorodal 100
N2	Leghe di alluminio > 12% Si		3.2582	GD-AlSi12 G-AlSi6Cu4	A413.0 319	
N3	Rame		2.0940-01 2.1176	CuAl10Fe CuPb10Sn	CA952 CA937	
N4	Bronzo e ottone		2.0401	Cu Zn39Pb3		OT58 AMPCO 18

DRSDRILL				DRSPILOT						
JP5625	JP5530	JP9635	JU6520	JP5625	JP5530	JP9635	JU6520	MATERIALi	DUREZZA/Rm	
180÷300	180÷300			130÷220	130÷220			Acciai automatici e acciai strutturali	< 500 N/mm²	P1
140÷240	140÷240			100÷180	100÷180			Acciai al carbonio e acciai basso legati	500-700 N/mm²	P2
100÷220	100÷220			80÷170	80÷170			Acciai medio legati e acciai da bonifica	600-800 N/mm²	P3
100÷180	100÷180			80÷140	80÷140			Acciai alto legati	800-1000 N/mm²	P4
80÷150	80÷150			60÷120	60÷120			Acciai per utensili	900-1200 N/mm²	P5
		120÷220				90÷160		Acciai inossidabili ferritici	400-700 N/mm²	M1
		80÷180				60÷130		Acciai inossidabili austenitici - buona lavorabilità	500-750 N/mm²	M2
		60÷150				50÷110		Acciai inossidabili austenitici - media lavorabilità	550-850 N/mm²	M3
		60÷150				50÷110		Acciai inossidabili martensitici	650-950 N/mm²	M4
		50÷120				40÷100		Acciai inossidabili PH - indurenti per precipitazione	800-1250 N/mm²	M5
180÷250	180÷250			130÷190	130÷190			Ghise grigie	150-250 HB	K1
120÷180	120÷180			100÷140	100÷140			Ghise sferoidali	150-350 HB	K2
			250÷400				200÷300	Leghe di alluminio ≤ 12% Si		N1
			150÷300				120÷240	Leghe di alluminio > 12% Si		N2
			200÷300				150÷240	Rame		N3
			200÷300				150÷240	Bronzo e ottone		N4

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