

NEWS 216/7

NUOVE FRESE S9003.8W.. PER SPALLAMENTO
NEW CUTTERS S9003.8W.. FOR SHOULDER MILLING



S9003.8W..



NEW



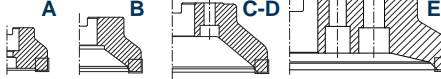
P **M** **K** LNMX

 **SAU**
QUALITY TOOLS ENGINEERING

S 9003.8W .. 13

Ø 50-125

γ_p -5°
 γ_r -15,8°/-9°
 γ_o -15,8°/-9°



LNMX
131308..
.F58



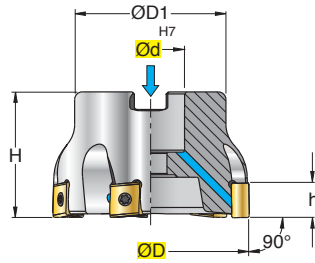
NEW

LNMX
131308..
.F61

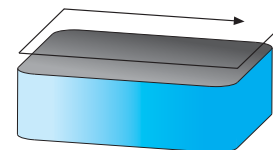
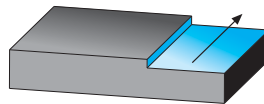
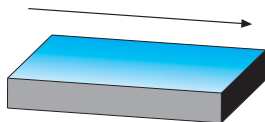


NEW

NEW



ART.	Prezzo Listino Price List €	(mm)						kg	Nm	ISO 6462	1313	1240P	5615P	VBSF10
		ØD	Ød	ØD1	H	h	Z							
S 9003.8W-050-05-13	330,00	50	22	42	40	12	5	0,30	3,8÷5,0	A	1313	1240P	5615P	VBSF10
S 9003.8W-050-06-13	360,00	50	22	42	40	12	6	0,29	3,8÷5,0	A				
S 9003.8W-063-06-13	410,00	63	22	48	40	12	6	0,51	3,8÷5,0	A				
S 9003.8W-063-08-13	450,00	63	22	48	40	12	8	0,50	3,8÷5,0	A				
S 9003.8W-080-07-13	490,00	80	27	60	50	12	7	1,00	3,8÷5,0	A-B	1313	1240P	5615P	AL 12x35
S 9003.8W-080-10-13	560,00	80	27	60	50	12	10	1,00	3,8÷5,0	A-B				
S 9003.8W-100-09-13	600,00	100	32	80	50	12	9	1,66	3,8÷5,0	A-B	1313	1240P	5615P	AL 16x35
S 9003.8W-100-13-13	680,00	100	32	80	50	12	13	1,64	3,8÷5,0	A-B				
S 9003.8W-125-11-13	780,00	125	40	95	63	12	11	3,20	3,8÷5,0	A-B	1313	1240P	5615P	AL 20x45
S 9003.8W-125-17-13	900,00	125	40	95	63	12	17	3,17	3,8÷5,0	A-B				



W = FORO PER LIQUIDO REFRIGERANTE - COOLANT BORE - KÜHLMITTELBOHRUNG - TROU DU LIQUIDE D'ARROSAGE

Scelta dell'inserto e parametri di lavoro - Choice of the insert and machining parameters
Auswahl der platte und schnittdaten - Choix de la plaquette et paramètres de travail

SCelta VELOCE - QUICK PICK



COD.	Prez. List. Price List €	Material Groups												HT		HW	HC			Dimensions									
		P			M			K			N			S			H			CERMET	NON RIV. CEMENTED CARBIDE GRADES	RIVESTITI COATED GRADES BESCHICHTET RECOUVERTS			l	d	s	d1	r
LNMX 131308	.F58	21,50	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○				■	■	■	13	13	7,94	4,6	0,8	-
LNMX 131308	.F61	21,50	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○				■	■	■	13	13	7,94	4,6	0,8	-

CON ADDUZIONE LUBROREFRIGERANTE - WITH COOLANT SUPPLY

SENZA ADDUZIONE LUBROREFRIGERANTE - WITHOUT COOLANT SUPPLY

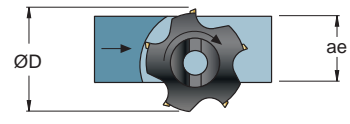
MATERIALI - MATERIALS	VDI 3323 GR.	HB Rm ⁽¹⁾ HRC ⁽²⁾	fz0 mm			Vc m/min										
			F	M	R	F3120	F1325	F1335								
P ACCIAIO NON LEGATO - NOT ALLOY STEEL	1-5	125-300	0,15	0,25	0,4	200	230	220								
	6-9	180-350	0,12	0,18	0,3	180	190	180								
	10-11	200-325	0,12	0,18	0,3	160	170	160								
	12-13	200-240	0,1	0,14	0,25	120										
M INOX AUST. DUPLEX - STAINLESS STEEL AUST	14.1-14.2	180-230	0,1	0,12	0,2		100	90								
K GHISA GRIGIA - GREY CAST IRON	15-16	180-260	0,15	0,3	0,5	280	220									
	17-18	160-250	0,15	0,25	0,4	260	180									
	19-20	130-230	0,12	0,2	0,35	240	160									
N ALLUMINIO E SUE LEGHE - ALUMINIUM	21-25	60-130														
RAME E SUE LEGHE - COPPER	26-28	90-110														
NON METALLICI - PLASTICS	29-30	/														
S LEGHE RESIST. CALORE - HIG. TEMP. ALLOY	31-35	200-320														
TITANIO E SUE LEGHE - TITANIUM	36-37	400-1050 ⁽¹⁾														
H ACCIAIO TEMPRATO - HARDENED STEEL	38-41	45-60 ^a														

$$n = \frac{Vc \cdot 1000}{\phi D \cdot 3,14} = \text{giri/min (min}^{-1}\text{)}$$

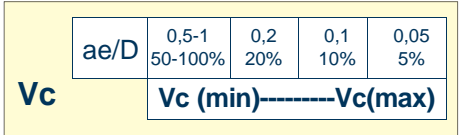
$$fz = fz0 \cdot Kae = \text{mm}$$

$$fn = fz \cdot z = \text{mm}$$

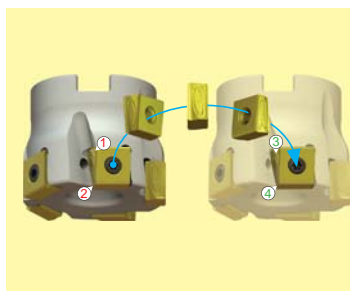
$$Vf = fz \cdot z \cdot n = \text{mm/min}$$



ae/D	0,5-1 50-100%	0,2 20%	0,1 10%	0,05 5%	0,02 2%
Kae	1	1,1	1,2	1,3	1,5



- F** = FINITURA, LAV. LEGGERA - FINISHING, LIGHT MACHINING
M = LAV. MEDIA, GENERICA - MEDIUM MACHINING, GENERIC
R = SGROSSATURA, LAV. PESANTE - ROUGHING, HEAVY MACHINING
- Vc** = m/min VELOCITÀ DI TAGLIO - CUTTING SPEED
n = giri/min (min⁻¹) NUMERO DI GIRI - NUMBER OF REVOLUTIONS
fz = mm AVANZAMENTO AL DENTE - TOOTH FEED
fn = mm AVANZAMENTO AL GIRO - FEED / REVOLUTION
Vf = mm/min VELOCITÀ DI AVANZAMENTO - FEED SPEED
Kae = FATTORE DI CORREZIONE - CORRECTION FACTOR



- 4 Taglienti "Utili" disponibili grazie all'inserto bilaterale.
- 4 "Useful" cutting-edges thanks to two-sided insert
- "Nützliche" schneidkanten dank zweiseitiger wendeschneidplatten
- Tranchants "Utiles" disponibles grace a la plaquette bilaterale

Made In Italy



**FILIALE DI MODENA
MODENA SUBSIDIARY**

Via Mozart, 47
41122 Modena (MO) Italy
Tel. 0039 059 280706
Fax. 0039 059 280109
saumodena@sautool.it
www.sautool.it

**FILIALE DI TORINO
TORINO SUBSIDIARY**

Strada Vicinale della Cebrosa 86-A
10156 Torino (TO) Italy
Tel. 0039 011 8960193
Fax. 0039 011 8960193
sautorino@sautool.it
www.sautool.it



SAU S.p.A.

Via dei Raseni, 6/B
41040 Polinago (MO) Italy
Tel. 0039 0536 47510
Fax. 0039 0536 47275
infosau@sautool.it
www.sautool.it