SAL

SWISS AUTOMATIC LATHES

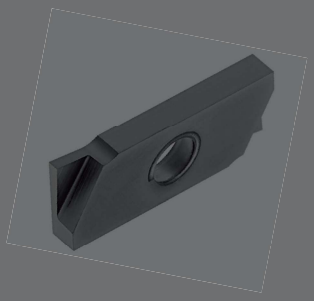


The SAL is a set of tools specifically tailored for grooving, parting off, turning, and threading applications on Swiss lathe machines. It optimizes performance and enhances productivity in precision manufacturing processes.

O SAL é um conjunto de ferramentas especialmente projetado para aplicações de canais, corte, torneamento e roscagem em máquinas de torno. Otimiza o desempenho e aumenta a produtividade nos processos de fabricação de precisão.

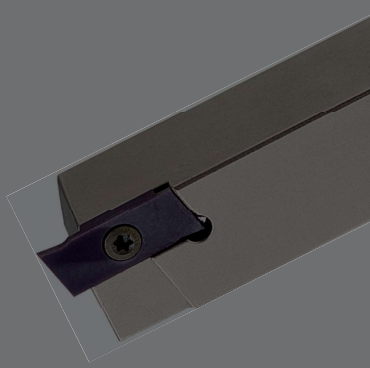
El SAL es un conjunto de herramientas diseñadas específicamente para aplicaciones de ranurado, corte, torneado y roscado en máquinas de torno. Optimiza el rendimiento y mejora la productividad en procesos de fabricación de precisión.

INSERTS > page 910



- Square and Round Grooving
  Ranhura quadrada e redonda | Ranurado cuadrado y redondo
- Parting Off
  Sangramento | Tronzado
- Threading
  Roscagem | Roscado
- Turning
  Torneamento | Torneado

EXTERNAL TOOLHOLDERS > page 914



- Inserts SAL...L and SAL...R
  Pastilhas SAL...L e SAL...R | Plaquitas SAL...L y SAL...R
- Right and Left
  Esquerdo e Direito | Izquierdo y derecho

SAL - SWISS AUTOMATIC LATHES Maquinação de precisão | Herramientas para tornos automáticos

INSERTS CODE KEY Chave de codificação para pastilhas | Llave de codificación de plaquitas

Grooving Inserts

SAL	25	G	050	R	-	GS
1	2	5	6	8		11

Parting Off Inserts

SAL	11	P	100	R	N	-	P07
1	3	5	6	8	9		11

Threading Inserts

SAL	100	H	010	R	60	-	PT
1	4	5	7	8	10		11

Turning Inserts

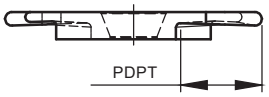
SAL	60	T	300	R	-	TP
1	2	5	6	8		11

1 - Product line

SAL - Swiss Automatic Lathes Line

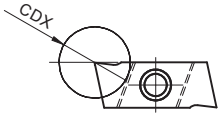
2 - Maximum depth of cut (Turning and Grooving inserts)

25 - 2,5mm | 60 - 6,0mm



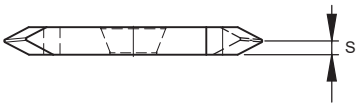
3 - Maximum Cutting Diameter (Parting Off Inserts)

11 - 11,0mm | 13 - 13,0mm

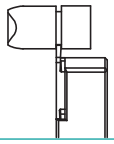
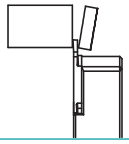
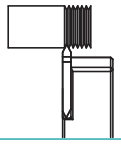
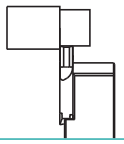


4 - Center distance (Threading Inserts)

050 - 0,5mm | 100 - 1,00mm

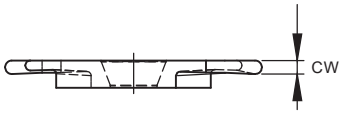


5 - Operations type

G - Grooving	P - Parting off	H - Threading	T - Turning
			

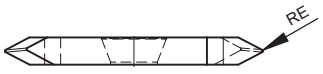
6 - Cut thickness (Grooving, Parting Off and Turning Inserts)

050 - 0,50mm | 070 - 0,70mm | 080 - 0,80mm
090 - 0,90mm | 100 - 1,00mm | 110 - 1,10mm
130 - 1,30mm | 150 - 1,50mm | 160 - 1,60mm
185 - 1,85mm | 200 - 2,00 mm | 300 - 3,00 mm



7 - Corner radius (Threading Inserts)

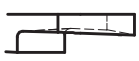
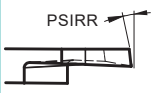
005 - 0,05mm | 010 - 0,10mm
012 - 0,12mm



8- Insert / toolholder side

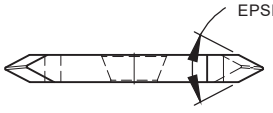
L - Left hand	R - Right hand
	

9 - Front angle (Parting off)

N - Neutral	R - Right	L - Left
		

10 - Angle (Threading Inserts)

55 - 55° | 60 - 60°



11 - Chip Breaker (Turning, Grooving, Parting Off and Threading Inserts)

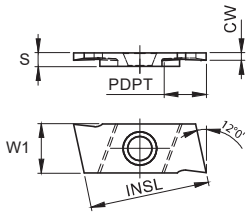
Turning	TP - Turning steel
Grooving	GS - Square Grooving GR - Round Grooving
Parting Off	P00 - Front angle 0° P07 - Front angle 7°
Threading	PT - Partial Profile

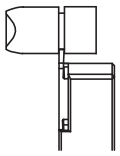
GS SERIES Inserts | Pastilhas | Plaquitas



Right hand style show

For square grooving
Para grooving quadrado
Para ranurado quadrado





Grooving

(1) Geometry code	(2) Grade code ISO Reference	ANSI Reference	P PVD G1 PH7910	P PVD G4 PH7920	M PVD G4 PH7920	M PVD P8 PH7135	K PVD G4 PH7920	K PVD P8 PH7135	S PVD G4 PH7920	S PVD P8 PH7135	Dimensions Dimensões Dimensiones (mm) CW	INSL	S	W1	PDPT	Cutting conditions Condições de corte Condiciones de corte fn (mm/r)	Min.	Max.
1130441	SAL25G050R-GS	SAL25G050R-GS	○	◈	◈	○	◈	○	◈	○	0,50	17,00	2,00	7,00	2,50	0,04	0,02	0,06
1130475	SAL25G070R-GS	SAL25G070R-GS	○	◈	◈	○	◈	○	◈	○	0,70	17,00	2,00	7,00	2,50	0,05	0,02	0,08
1130477	SAL25G080R-GS	SAL25G080R-GS	○	◈	◈	○	◈	○	◈	○	0,80	17,00	2,00	7,00	2,50	0,05	0,02	0,09
1130479	SAL25G090R-GS	SAL25G090R-GS	○	◈	◈	○	◈	○	◈	○	0,90	17,00	2,00	7,00	2,50	0,06	0,02	0,10
1130488	SAL60G110R-GS	SAL60G110R-GS	○	◈	◈	○	◈	○	◈	○	1,10	17,00	2,00	7,00	6,00	0,06	0,02	0,11
1130490	SAL60G130R-GS	SAL60G130R-GS	○	◈	◈	○	◈	○	◈	○	1,30	17,00	2,00	7,00	6,00	0,07	0,02	0,12
1130442	SAL60G160R-GS	SAL60G160R-GS	○	◈	◈	○	◈	○	◈	○	1,60	17,00	2,00	7,00	6,00	0,07	0,02	0,13
1130495	SAL60G185R-GS	SAL60G185R-GS	○	◈	◈	○	◈	○	◈	○	1,85	17,00	2,00	7,00	6,00	0,08	0,02	0,14
1130473	SAL25G050L-GS	SAL25G050L-GS	○	◈	◈	○	◈	○	◈	○	0,50	17,00	2,00	7,00	2,50	0,04	0,02	0,06
1130474	SAL25G070L-GS	SAL25G070L-GS	○	◈	◈	○	◈	○	◈	○	0,70	17,00	2,00	7,00	2,50	0,05	0,02	0,08
1130476	SAL25G080L-GS	SAL25G080L-GS	○	◈	◈	○	◈	○	◈	○	0,80	17,00	2,00	7,00	2,50	0,05	0,02	0,09
1130478	SAL25G090L-GS	SAL25G090L-GS	○	◈	◈	○	◈	○	◈	○	0,90	17,00	2,00	7,00	2,50	0,06	0,02	0,10
1130487	SAL60G110L-GS	SAL60G110L-GS	○	◈	◈	○	◈	○	◈	○	1,10	17,00	2,00	7,00	6,00	0,06	0,02	0,11
1130489	SAL60G130L-GS	SAL60G130L-GS	○	◈	◈	○	◈	○	◈	○	1,30	17,00	2,00	7,00	6,00	0,07	0,02	0,12
1130493	SAL60G160L-GS	SAL60G160L-GS	○	◈	◈	○	◈	○	◈	○	1,60	17,00	2,00	7,00	6,00	0,07	0,02	0,13
1130494	SAL60G185L-GS	SAL60G185L-GS	○	◈	◈	○	◈	○	◈	○	1,85	17,00	2,00	7,00	6,00	0,08	0,02	0,14

◈ Stock item | Produto de stock | Itens de stock

○ Available under request with delivery time 4 weeks
Disponível sobre consulta com prazo de entrega de 4 semanas
Disponible bajo consulta, con fecha de entrega en 4 semanas

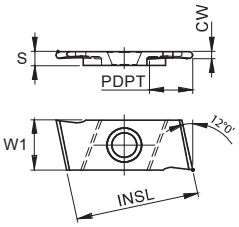
Order code = (1) Geometry code + (2) Grade code

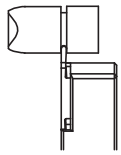
GR SERIES Inserts | Pastilhas | Plaquitas



Right hand style show

For round grooving
Para grooving redondo
Para ranurado redondo





Grooving

(1) Geometry code	(2) Grade code ISO Reference	ANSI Reference	P PVD G1 PH7910	P PVD G4 PH7920	M PVD G4 PH7920	M PVD P8 PH7135	K PVD G4 PH7920	K PVD P8 PH7135	S PVD G4 PH7920	S PVD P8 PH7135	Dimensions (mm) Dimensões (mm) Dimensiones (mm) CW	INSL	S	W1	PDPT	Cutting conditions Condições de corte Condiciones de corte fn (mm/r)	Min.	Max.
1130443	SAL60G100R-GR	SAL60G100R-GR	○	◈	◈	○	◈	○	◈	○	1,00	17,00	2,00	7,00	6,00	0,06	0,02	0,10
1130492	SAL60G150R-GR	SAL60G150R-GR	○	◈	◈	○	◈	○	◈	○	1,50	17,00	2,00	7,00	6,00	0,08	0,02	0,12
1130497	SAL60G200R-GR	SAL60G200R-GR	○	◈	◈	○	◈	○	◈	○	2,00	17,00	2,00	7,00	6,00	0,08	0,03	0,14
1130486	SAL60G100L-GR	SAL60G100L-GR	○	◈	◈	○	◈	○	◈	○	1,00	17,00	2,00	7,00	6,00	0,06	0,02	0,10
1130491	SAL60G150L-GR	SAL60G150L-GR	○	◈	◈	○	◈	○	◈	○	1,50	17,00	2,00	7,00	6,00	0,08	0,02	0,12
1130496	SAL60G200L-GR	SAL60G200L-GR	○	◈	◈	○	◈	○	◈	○	2,00	17,00	2,00	7,00	6,00	0,08	0,03	0,14

◈ Stock item | Produto de stock | Itens de stock

○ Available under request with delivery time 4 weeks
Disponível sobre consulta com prazo de entrega de 4 semanas
Disponible bajo consulta, con fecha de entrega en 4 semanas

Order code = (1) Geometry code + (2) Grade code

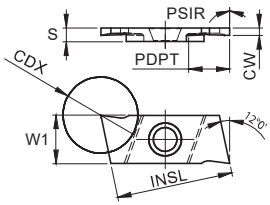
SAL - SWISS AUTOMATIC LATHES Maquinação de precisão | Herramientas para tornos automáticos

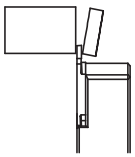
P(P00) SERIES Inserts | Pastilhas | Plaquitas



Right hand style show

Without front angle
Sem ângulo frontal
Sín angulo frontal





Parting off

(1) Geometry code	(2) Grade code ISO Reference	ANSI Reference	P PVD G1 PH7910	P PVD G4 PH7920	M PVD G4 PH7920	M PVD P8 PH7135	K PVD G4 PH7920	K PVD P8 PH7135	S PVD G4 PH7920	S PVD P8 PH7135	Dimensions (mm) Dimensões (mm) Dimensiones (mm) CW	INSL	S	W1	PDPT	PSIRR/L	CDX	Cutting conditions Condições de corte Condiciones de corte fn (mm/r)	Min.	Max.
1130444	SAL11P100RN-P00	SAL11P100RN-P00	○	◈	◈	○	◈	○	◈	○	1,00	17,00	2,00	7,00	6,00	0	11,00	0,06	0,02	0,10
1130462	SAL11P150RN-P00	SAL11P150RN-P00	○	◈	◈	○	◈	○	◈	○	1,50	17,00	2,00	7,00	6,00	0	11,00	0,08	0,02	0,12
1130468	SAL13P200RN-P00	SAL13P200RN-P00	○	◈	◈	○	◈	○	◈	○	2,00	17,00	2,00	7,00	6,00	0	13,00	0,08	0,03	0,14
1130456	SAL11P100LN-P00	SAL11P100LN-P00	○	◈	◈	○	◈	○	◈	○	1,00	17,00	2,00	7,00	6,00	0	11,00	0,06	0,02	0,10
1130459	SAL11P150LN-P00	SAL11P150LN-P00	○	◈	◈	○	◈	○	◈	○	1,50	17,00	2,00	7,00	6,00	0	11,00	0,08	0,02	0,12
1130465	SAL13P200LN-P00	SAL13P200LN-P00	○	◈	◈	○	◈	○	◈	○	2,00	17,00	2,00	7,00	6,00	0	13,00	0,08	0,03	0,14

◈ Stock item | Produto de stock | Itens de stock

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Disponible bajo consulta, con fecha de entrega en 4 semanas

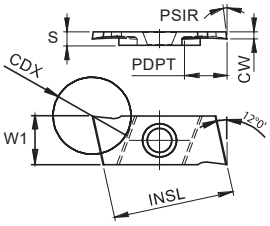
Order code = (1) Geometry code + (2) Grade code

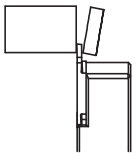
P(P07) SERIES Inserts | Pastilhas | Plaquitas



Right hand style show

Front angle 7°
Ângulo frontal de 7°
Angulo frontal de 7°





Parting off

(1) Geometry code	(2) Grade code ISO Reference	ANSI Reference	P PVD G1 PH7910	P PVD G4 PH7920	M PVD G4 PH7920	M PVD P8 PH7135	K PVD G4 PH7920	K PVD P8 PH7135	S PVD G4 PH7920	S PVD P8 PH7135	Dimensions (mm) Dimensões (mm) Dimensiones (mm) CW	INSL	S	W1	PDPT	PSIRR/L	CDX	Cutting conditions Condições de corte Condiciones de corte fn (mm/r)	Min.	Max.
1130445	SAL11P100RR-P07	SAL11P100RR-P07	○	◈	◈	○	◈	○	◈	○	1,00	17,00	2,00	7,00	6,00	7	11,00	0,05	0,02	0,08
1130446	SAL11P100RL-P07	SAL11P100RL-P07	○	◈	◈	○	◈	○	◈	○	1,00	17,00	2,00	7,00	6,00	7	11,00	0,05	0,02	0,08
1130463	SAL11P150RR-P07	SAL11P150RR-P07	○	◈	◈	○	◈	○	◈	○	1,50	17,00	2,00	7,00	6,00	7	11,00	0,06	0,02	0,10
1130461	SAL11P150RL-P07	SAL11P150RL-P07	○	◈	◈	○	◈	○	◈	○	1,50	17,00	2,00	7,00	6,00	7	11,00	0,06	0,02	0,10
1130469	SAL13P200RR-P07	SAL13P200RR-P07	○	◈	◈	○	◈	○	◈	○	2,00	17,00	2,00	7,00	6,00	7	13,00	0,06	0,03	0,12
1130467	SAL13P200RL-P07	SAL13P200RL-P07	○	◈	◈	○	◈	○	◈	○	2,00	17,00	2,00	7,00	6,00	7	13,00	0,06	0,03	0,12
1130457	SAL11P100LR-P07	SAL11P100LR-P07	○	◈	◈	○	◈	○	◈	○	1,00	17,00	2,00	7,00	6,00	7	11,00	0,05	0,02	0,08
1130455	SAL11P100LL-P07	SAL11P100LL-P07	○	◈	◈	○	◈	○	◈	○	1,00	17,00	2,00	7,00	6,00	7	11,00	0,05	0,02	0,08
1130460	SAL11P150LR-P07	SAL11P150LR-P07	○	◈	◈	○	◈	○	◈	○	1,50	17,00	2,00	7,00	6,00	7	11,00	0,06	0,02	0,10
1130458	SAL11P150LL-P07	SAL11P150LL-P07	○	◈	◈	○	◈	○	◈	○	1,50	17,00	2,00	7,00	6,00	7	11,00	0,06	0,02	0,10
1130466	SAL13P200LR-P07	SAL13P200LR-P07	○	◈	◈	○	◈	○	◈	○	2,00	17,00	2,00	7,00	6,00	7	13,00	0,06	0,03	0,12
1130464	SAL13P200LL-P07	SAL13P200LL-P07	○	◈	◈	○	◈	○	◈	○	2,00	17,00	2,00	7,00	6,00	7	13,00	0,06	0,03	0,12

◈ Stock item | Produto de stock | Itens de stock

○ Available under request with delivery time 4 weeks
Disponível sobre consulta com prazo de entrega de 4 semanas
Disponible bajo consulta, con fecha de entrega en 4 semanas

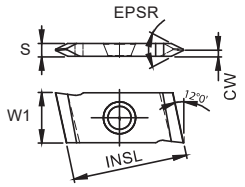
Order code = (1) Geometry code + (2) Grade code

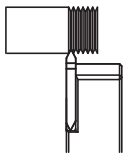
PT SERIES Inserts | Pastilhas | Plaquitas



Right hand style show

For partial profile threading
Para perfil parcial de roscagem
Para perfil parcial de roscado





Threading

(1) Geometry code	(2) Grade code ISO Reference	ANSI Reference	P PVD G1 PH7910	P PVD G4 PH7920	M PVD G4 PH7920	M PVD P8 PH7135	K PVD G4 PH7920	K PVD P8 PH7135	S PVD G4 PH7920	S PVD P8 PH7135	Dimensions (mm) Dimensões (mm) Dimensiones (mm) CW	INSL	S	W1	PDPT	EPSR	Cutting conditions Condições de corte Condiciones de corte fn (mm/r)	Min.	Max.
1130472	SAL100H012R55-PT	SAL100H012R55-PT	○	◈	◈	○	◈	○	◈	○	1,09	17,00	2,00	7,00	0,12	55	0,80	0,20	2,00
1130447	SAL100H012R60-PT	SAL100H012R60-PT	○	◈	◈	○	◈	○	◈	○	1,09	17,00	2,00	7,00	0,12	60	0,80	0,20	2,00
1130470	SAL100H012L55-PT	SAL100H012L55-PT	○	◈	◈	○	◈	○	◈	○	1,09	17,00	2,00	7,00	0,12	55	0,80	0,20	2,00
1130471	SAL100H012L60-PT	SAL100H012L60-PT	○	◈	◈	○	◈	○	◈	○	1,09	17,00	2,00	7,00	0,12	60	0,80	0,20	2,00

◈ Stock item | Produto de stock | Itens de stock

○ Available under request with delivery time 4 weeks
Disponível sobre consulta com prazo de entrega de 4 semanas
Disponible bajo consulta, con fecha de entrega en 4 semanas

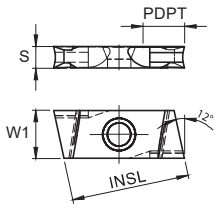
Order code = (1) Geometry code + (2) Grade code

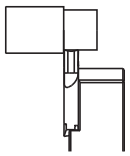
TP SERIES Inserts | Pastilhas | Plaquitas



Right hand style show

For turning
Para torneamento
Para torneado





Turning

(1) Geometry code	(2) Grade code ISO Reference	ANSI Reference	P PVD G1 PH7910	P PVD G4 PH7920	M PVD G4 PH7920	M PVD P8 PH7135	K PVD G4 PH7920	K PVD P8 PH7135	S PVD G4 PH7920	S PVD P8 PH7135	Dimensions (mm) Dimensões (mm) Dimensiones (mm) INSL	S	W1	PDPT	Cutting conditions Condições de corte Condiciones de corte fn (mm/r)	Min.	Max.
1130501	SAL60T300R-TP	SAL60T300R-TP	○	◈	◈	○	◈	○	◈	○	17,00	3,17	7,00	6,00	0,08	0,02	0,12
1130499	SAL60T300L-TP	SAL60T300L-TP	○	◈	◈	○	◈	○	◈	○	17,00	3,17	7,00	6,00	0,08	0,02	0,12

◈ Stock item | Produto de stock | Itens de stock

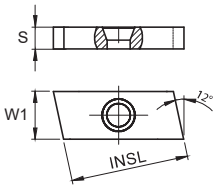
○ Available under request with delivery time 4 weeks
Disponível sobre consulta com prazo de entrega de 4 semanas
Disponible bajo consulta, con fecha de entrega en 4 semanas

Order code = (1) Geometry code + (2) Grade code

BLANKS FOR GRINDING Blanks para personalizar | Blanks para personalizar



Right hand style show



Inserts blanks “do it yourself” grinding are available allowing modifications of the insert for any machining operation.

As pastilhas de blank “faça você mesmo” permitem a personalização da pastilha para qualquer operação de maquinação.

Las plaquitas de blank “haga usted mismo” permiten la personalización de la plaquita para qualquiera operación de maquinación.

(1) Geometry code	(2) Grade code ISO Reference	ANSI Reference	Uncoated 10 PH0910	Uncoated 12 PH0920	Uncoated 14 PH0135	Dimensions (mm) Dimensões (mm) Dimensiones (mm) INSL	S	W1
1130440	BLANK SALR 17x7x2	BLANK SALR 17x7x2	◈	◈	◈	17,50	2,00	7,50
1130504	BLANK SALR 17x7x3,17	BLANK SALR 17x7x3,17	◈	◈	◈	17,50	3,17	7,50
1130453	BLANK SALL 17x7x2	BLANK SALL 17x7x2	◈	◈	◈	17,50	2,00	7,50
1130505	BLANK SALL 17x7x3,17	BLANK SALL 17x7x3,17	◈	◈	◈	17,50	3,17	7,50

◈ Stock item | Produto de stock | Itens de stock

○ Available under request | Disponível sobre consulta | Disponible bajo consulta

Order code = (1) Geometry code + (2) Grade code

SAL - SWISS AUTOMATIC LATHES Maquinação de precisão | Herramientas para tornos automáticos

TOOLHOLDERS CODE KEY Chave de codificação para suportes | Llave de codificación de herramienta

SAL	H	E	R	-	08	08	-	M	07
1	2	3	4	-	5	6	-	7	8

1 - Product line

SAL - Swiss Automatic Lathes Line

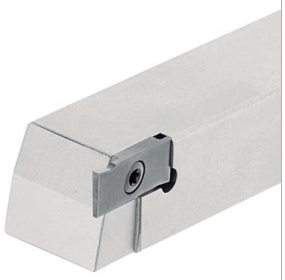
2 - Tool type

H - Holder

3 - Internal or External

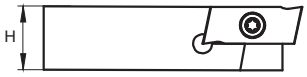
E - External

4 - Insert / toolholder side

L - Left hand	R - Right hand
	

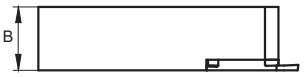
5 - Shank height

- 08 - 8 mm
- 10 - 10 mm
- 12 - 12 mm
- 16 - 16 mm



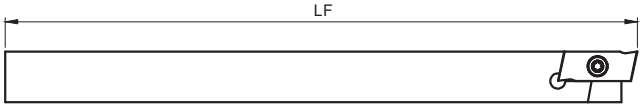
6 - Shank width

- 08 - 8 mm
- 10 - 10 mm
- 12 - 12 mm
- 16 - 16 mm



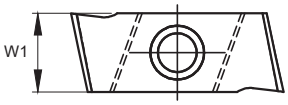
7 - Shank lenght (mm)

- L - 140 mm
- M - 150 mm

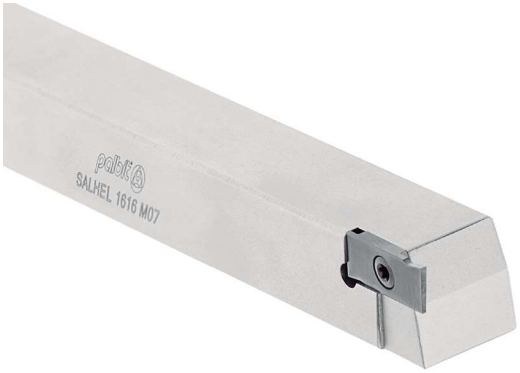


8 - Insert cutting edge lenght (mm)

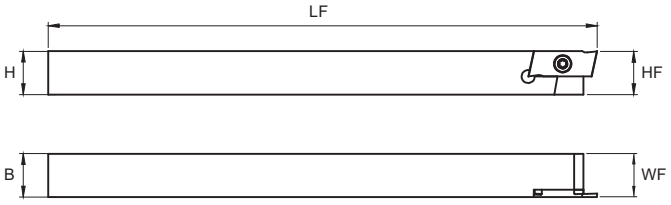
07 - 7,0 mm



EXTERNAL TOOLHOLDERS Suportes exteriores | herramientas de tronzado exterior



Left hand style show

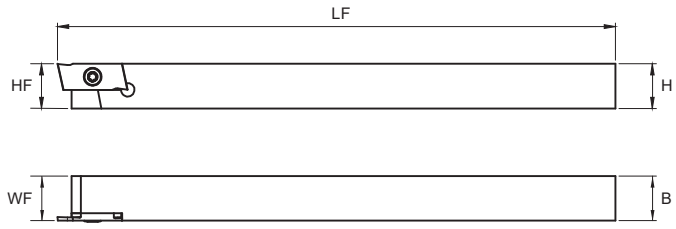


Order code Código	Reference Referência Referencia	Dimensions | Dimensões | Dimensiones (mm)					* Insert	Screw	Wrench	Stock
		B	H	HF	LF	WF				
213023600	SALHEL 0808 M07	8,00	8,00	8,00	150,00	8,00	SAL...L	P0300900	XT 08	⚙
213023700	SALHEL 1010 M07	10,00	10,00	10,00	150,00	10,00	SAL...L	P0300900	XT 08	⚙
213023800	SALHEL 1212 M07	12,00	12,00	12,00	150,00	12,00	SAL...L	P0300900	XT 08	⚙
213023900	SALHEL 1616 M07	16,00	16,00	16,00	150,00	16,00	SAL...L	P0300900	XT 08	⚙
213029700	SALHEL 2020 M07	20,00	20,00	20,00	150,00	20,00	SAL...L	P0300900	XT 08	⚙
213029900	SALHEL 2525 M07	25,00	25,00	25,00	150,00	25,00	SAL...L	P0300900	XT 08	⚙

⚙ Stock item | Produto de stock | Itens de stock ◯ Available under request | Disponível sobre consulta | Disponible bajo consulta * Left insert only fits on left toolholder



Right hand style show

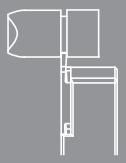


Order code Código	Reference Referência Referencia	Dimensions | Dimensões | Dimensiones (mm)					* Insert	Screw	Wrench	Stock
		B	H	HF	LF	WF				
213023200	SALHER 0808 M07	8,00	8,00	8,00	150,00	8,00	SAL...R	P0300900	XT 08	⚙
213023300	SALHER 1010 M07	10,00	10,00	10,00	150,00	10,00	SAL...R	P0300900	XT 08	⚙
213023400	SALHER 1212 M07	12,00	12,00	12,00	150,00	12,00	SAL...R	P0300900	XT 08	⚙
213023500	SALHER 1616 M07	16,00	16,00	16,00	150,00	16,00	SAL...R	P0300900	XT 08	⚙
213029600	SALHER 2020 M07	20,00	20,00	20,00	150,00	20,00	SAL...R	P0300900	XT 08	⚙
213029800	SALHER 2525 M07	25,00	25,00	25,00	150,00	25,00	SAL...R	P0300900	XT 08	⚙

⚙ Stock item | Produto de stock | Itens de stock ◯ Available under request | Disponível sobre consulta | Disponible bajo consulta * Right insert only fits on right toolholder

SAL - SWISS AUTOMATIC LATHES Maquinação de precisão | Herramientas para tornos automáticos

GROOVING Canais | Ranurado



- High precision
- Close tolerances
- Wide variety of insert widths

GS

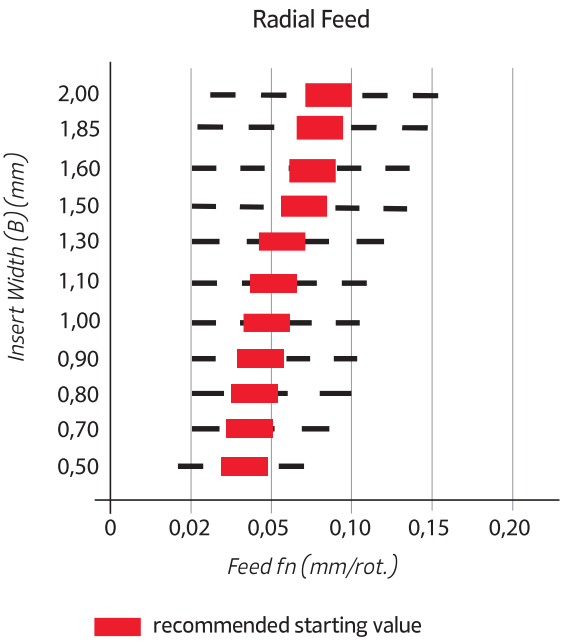


Square grooving

GR



Round grooving



Recomended cutting conditions

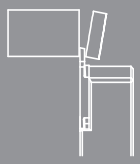
P	M	K	S
60-200	60-180	60-150	20-50

Recomended grade PH7920, (Vc) m/min.

Grade PH7910 and PH7135

Available under request (4 weeks delivery time)

PARTING OFF Corte | Tronzado



- When parting off with a sub-spindle, it is more productive to use a straight cutting edge. This is a more stable parting method and will generate the best surface finish.
- When parting off without a sub-spindle, we recommend you use an insert with a maximum 7° front angle to minimize the risk of burr and pips on the component.
- When parting off with 7° front angled inserts, we recommend reducing the feed rate by approximately 30%.

P00

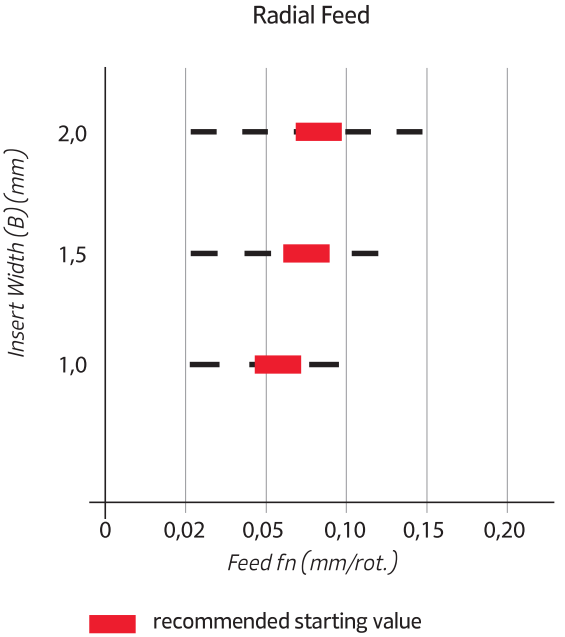


0º Relief angle

P07



7º Relief angle



Recomended cutting conditions

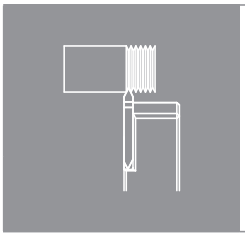
P	M	K	S
60-200	60-180	60-150	20-50

Recomended grade PH7920, (Vc) m/min.

Grade PH7910 and PH7135

Available under request (4 weeks delivery time)

THREADING Roscagem | Roscado



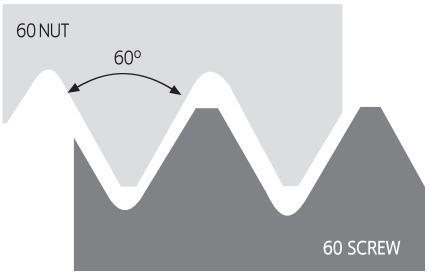
Two types of threading:
- Partial profile 55º
- Partial profile 60º

Pitch from 12 - 94 TPI / 0,25 - 2,0 mm

PT



Partial profile

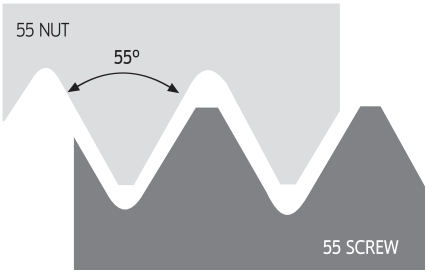


Recomended cutting conditions

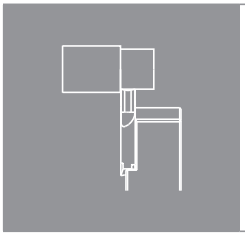
P	M	K	S
60-200	60-180	60-150	20-50

Recomended grade PH7920, (Vc) m/min.

Grade PH7910 and PH7135
Available under request (4 weeks delivery time)



TURNING Torneamento | Torneado



- Insert for turning
- Maximum depth of cut of 2,50 mm
- Excesssively low cutting speeds will result in inadequate tool life.

TP



Turning steel

Recomended cutting conditions

P	M	K	S
60-200	60-180	60-150	20-50

Recomended grade PH7920, (Vc) m/min.

Grade PH7910 and PH7135
Available under request (4 weeks delivery time)

