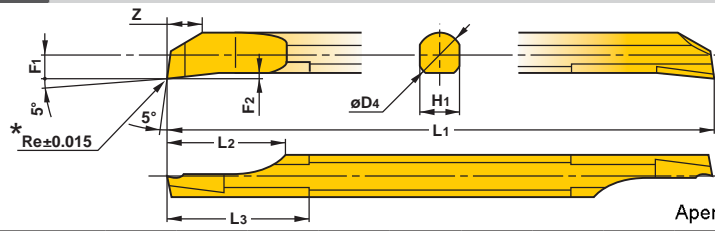
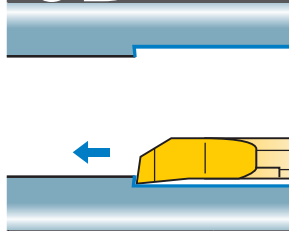


MICRO-MINI TWIN

CB

Para torneamento interno



Apenas suporte direito.

Referência para Pedido	Estoque		Quebra-cavacos	Diâmetro Min. de Corte (mm)		Dimensões (mm)								
	Microgrão	C/ Cobertura		l/d		Re	D4	L1	L2	L3	F1	F2	H1	Z
	TF15	VP15TF		< 3	> 3									
CB02RS	●	●	sem	2.2	3.6	0.05	2	50	5	6	1	0.25	1.8	1.4
02RS-B	●	●	com	2.2	3.9	0.05	2	50	5	6	1	0.25	1.8	1.4
02RS-01	●	●	sem	2.2	3.6	0.1	2	50	5	6	1	0.25	1.8	1.4
02RS-01B	●	●	com	2.2	4.2	0.1	2	50	5	6	1	0.25	1.8	1.4
02RS-02	●	●	sem	2.2	3.6	0.2	2	50	5	6	1	0.25	1.8	1.4
02RS-02B	●	●	com	2.2	4.9	0.2	2	50	5	6	1	0.25	1.8	1.4
03RS	●	●	sem	3.2	4.2	0.05	3	50	7.5	9	1.5	0.35	2.7	2.3
03RS-B	●	●	com	3.2	4.4	0.05	3	50	7.5	9	1.5	0.35	2.7	2.3
03RS-01	●	●	sem	3.2	4.2	0.1	3	50	7.5	9	1.5	0.35	2.7	2.3
03RS-01B	●	●	com	3.2	4.5	0.1	3	50	7.5	9	1.5	0.35	2.7	2.3
03RS-02	●	●	sem	3.2	4.2	0.2	3	50	7.5	9	1.5	0.35	2.7	2.3
03RS-02B	●	●	com	3.2	4.8	0.2	3	50	7.5	9	1.5	0.35	2.7	2.3
04RS	●	●	sem	4.2	5.1	0.05	4	60	10	12	2	0.45	3.6	3.1
04RS-B	●	●	com	4.2	5.2	0.05	4	60	10	12	2	0.45	3.6	3.1
04RS-01	●	●	sem	4.2	5.1	0.1	4	60	10	12	2	0.45	3.6	3.1
04RS-01B	●	●	com	4.2	5.3	0.1	4	60	10	12	2	0.45	3.6	3.1
04RS-02	●	●	sem	4.2	5.1	0.2	4	60	10	12	2	0.45	3.6	3.1
04RS-02B	●	●	com	4.2	5.5	0.2	4	60	10	12	2	0.45	3.6	3.1
05RS	●	●	sem	5.2	6.0	0.05	5	70	12.5	15	2.5	0.55	4.5	3.9
05RS-B	●	●	com	5.2	6.1	0.05	5	70	12.5	15	2.5	0.55	4.5	3.9
05RS-02	●	●	sem	5.2	6.0	0.2	5	70	12.5	15	2.5	0.55	4.5	3.9
05RS-02B	●	●	com	5.2	6.4	0.2	5	70	12.5	15	2.5	0.55	4.5	3.9
CB06RS	●	●	sem	6.2	7.2	0.05	6	75	12.5	18	3	0.65	5.4	4.7
06RS-B	●	●	com	6.2	7.3	0.05	6	75	12.5	18	3	0.65	5.4	4.7
06RS-02	●	●	sem	6.2	7.2	0.2	6	75	12.5	18	3	0.65	5.4	4.7
06RS-02B	●	●	com	6.2	7.8	0.2	6	75	12.5	18	3	0.65	5.4	4.7
CB07RS	●	●	sem	7.2	8.6	0.05	7	85	12.5	21	3.5	0.75	6.3	5.5
07RS-B	●	●	com	7.2	8.8	0.05	7	85	12.5	21	3.5	0.75	6.3	5.5
07RS-02	●	●	sem	7.2	8.6	0.2	7	85	12.5	21	3.5	0.75	6.3	5.5
07RS-02B	●	●	com	7.2	9.2	0.2	7	85	12.5	21	3.5	0.75	6.3	5.5
CB08RS	●	●	sem	8.2	9.5	0.05	8	95	15	24	4	0.85	7.2	6.3
08RS-B	●	●	com	8.2	9.6	0.05	8	95	15	24	4	0.85	7.2	6.3
08RS-02	●	●	sem	8.2	9.5	0.2	8	95	15	24	4	0.85	7.2	6.3
08RS-02B	●	●	com	8.2	9.8	0.2	8	95	15	24	4	0.85	7.2	6.3

* A dimensão do Re representa o tamanho antes de retificar o quebra-cavaco

CONDIÇÕES DE CORTE RECOMENDADAS

Material	Micro-Mini Twin CB				Micro-Mini Twin CR		
	Velocidade de Corte (m/min)	Avanço (mm/rot)	Prof. de Corte (mm)	l/d	Velocidade de Corte (m/min)	Avanço (mm/rot)	
						03RS/04RS	05RS
P Aço Carbono Aço Liga 180-350HB	80 (40-120)	0.03 (0.01-0.05)	0.2 (0.1-0.3)	3-5	80 (40-120)	0.02 (0.01-0.03)	0.03 (0.01-0.05)
M Aço Inoxidável <200HB	80 (40-120)	0.03 (0.01-0.05)	0.2 (0.1-0.3)	3-5	80 (40-120)	0.02 (0.01-0.03)	0.03 (0.01-0.05)
K Ferro Fundido Cinzento <350MPa	80 (40-120)	0.03 (0.01-0.05)	0.2 (0.1-0.3)	3-5	80 (40-120)	0.03 (0.01-0.05)	0.03 (0.01-0.05)
N Metais Não-Ferrosos	120 (80-160)	0.05 (0.01-0.08)	0.3 (0.1-0.5)	3-5	120 (80-160)	0.03 (0.01-0.05)	0.05 (0.01-0.08)

(Nota) Recomendada usinagem com refrigeração.

MANDRILAMENTO