

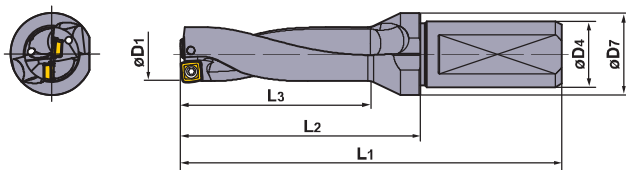
MVX

NEW

METAL DURO

Aço Carbono	Aço Endurecido	Aço Inoxidável	Ferro Fundido	Ligas Leves	Ligas Resistentes ao Calor
☉		○	☉		

	Tolerância do furo (meta)/mm
l/d=2-3	+ 0.25 0.00
l/d=4-5	+ 0.35 0.00
l/d=6	+ 0.45 0.00



Diâm. da Broca D1 (mm)	Prof. do Furo (l/d)	Referência para Pedido	Estoque	Número de Dentes	Dimensões (mm)					Ajuste radial (máx.)	Referência do Inserto	Parafuso de Fixação	Chave
					Compr. efetivo do canal	Compr. do Corpo	Comp. Total	Diâm. da Haste	Diâmetro do flange				
					L3	L2	L1	D4	D7				
17.0	2	MVX1700X2F20	●	2	41	56	99	20	25	0.5	SOMX063005-UM	TPS25	TIP07F
	3	1700X3F20	●	2	58	73	116	20	25	0.5	063005-UM	TPS25	TIP07F
	4	1700X4F20	●	2	75	90	133	20	25	0.5	063005-UM	TPS25	TIP07F
	5	1700X5F20	●	2	92	107	150	20	25	0.5	063005-UM	TPS25	TIP07F
	6	1700X6F20	●	2	109	124	167	20	25	0.5	063005-UM	TPS25	TIP07F
17.5	2	1750X2F25	●	2	42	62	112	25	32	0.45	063005-UM	TPS25	TIP07F
	3	1750X3F25	●	2	59.5	79.5	129.5	25	32	0.45	063005-UM	TPS25	TIP07F
	4	1750X4F25	●	2	77	97	147	25	32	0.45	063005-UM	TPS25	TIP07F
	5	1750X5F25	●	2	94.5	114.5	164.5	25	32	0.45	063005-UM	TPS25	TIP07F
	6	1750X6F25	●	2	112	132	182	25	32	0.45	063005-UM	TPS25	TIP07F
18.0	2	1800X2F25	●	2	43	63	113	25	32	0.4	063005-UM	TPS25	TIP07F
	3	1800X3F25	●	2	61	81	131	25	32	0.4	063005-UM	TPS25	TIP07F
	4	1800X4F25	●	2	79	99	149	25	32	0.4	063005-UM	TPS25	TIP07F
	5	1800X5F25	●	2	97	117	167	25	32	0.4	063005-UM	TPS25	TIP07F
	6	1800X6F25	●	2	115	135	185	25	32	0.4	063005-UM	TPS25	TIP07F
18.5	2	1850X2F25	●	2	44	64	114	25	32	0.35	063005-UM	TPS25	TIP07F
	3	1850X3F25	●	2	62.5	82.5	132.5	25	32	0.35	063005-UM	TPS25	TIP07F
	4	1850X4F25	●	2	81	101	151	25	32	0.35	063005-UM	TPS25	TIP07F
	5	1850X5F25	●	2	99.5	119.5	169.5	25	32	0.35	063005-UM	TPS25	TIP07F
	6	1850X6F25	●	2	118	138	188	25	32	0.35	063005-UM	TPS25	TIP07F
19.0	2	1900X2F25	●	2	45	65	115	25	32	0.3	063005-UM	TPS25	TIP07F
	3	1900X3F25	●	2	64	84	134	25	32	0.3	063005-UM	TPS25	TIP07F
	4	1900X4F25	●	2	83	103	153	25	32	0.3	063005-UM	TPS25	TIP07F
	5	1900X5F25	●	2	102	122	172	25	32	0.3	063005-UM	TPS25	TIP07F
	6	1900X6F25	●	2	121	141	191	25	32	0.3	063005-UM	TPS25	TIP07F
19.5	2	1950X2F25	●	2	46	66	116	25	32	0.25	063005-UM	TPS25	TIP07F
	3	1950X3F25	●	2	65.5	85.5	135.5	25	32	0.25	063005-UM	TPS25	TIP07F
	4	1950X4F25	●	2	85	105	155	25	32	0.25	063005-UM	TPS25	TIP07F
	5	1950X5F25	●	2	104.5	124.5	174.5	25	32	0.25	063005-UM	TPS25	TIP07F
	6	1950X6F25	●	2	124	144	194	25	32	0.25	063005-UM	TPS25	TIP07F
20.0	2	2000X2F25	●	2	47	67	117	25	32	0.6	073505-UM	TPS3	TIP10F
	3	2000X3F25	●	2	67	87	137	25	32	0.6	073505-UM	TPS3	TIP10F
	4	2000X4F25	●	2	87	107	157	25	32	0.6	073505-UM	TPS3	TIP10F
	5	2000X5F25	●	2	107	127	177	25	32	0.6	073505-UM	TPS3	TIP10F
	6	2000X6F25	●	2	127	147	197	25	32	0.6	073505-UM	TPS3	TIP10F

DESCRIÇÃO DO INSERTO > N215
 CONDIÇÕES DE CORTE > N216

UTILIZAÇÃO > N224

INFORMAÇÕES TÉCNICAS > Q001



N213

FURAÇÃO



FURAÇÃO (TIPO INTERCAMBIÁVEL)

METAL DURO


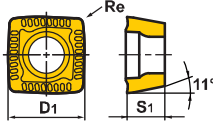
MVX NEW

Diâm. da Broca D1 (mm)	Prof. do Furo (l/d)	Referência para Pedido	Estoque	Número de Dentes	Dimensões (mm)					Ajuste radial (máx.)	Referência do Inserto		
					Compr. efetivo do canal	Compr. do Corpo	Comp. Total	Diâm. da Haste	Diâmetro do flange				
					L3	L2	L1	D4	D7			Parafuso de Fixação	Chave
20.5	2	MVX2050X2F25	●	2	48	68	118	25	32	0.55	SOMX073505-UM	TPS3	TIP10F
	3	2050X3F25	●	2	68.5	88.5	138.5	25	32	0.55	073505-UM	TPS3	TIP10F
21.0	2	2100X2F25	●	2	49	69	119	25	32	0.5	073505-UM	TPS3	TIP10F
	3	2100X3F25	●	2	70	90	140	25	32	0.5	073505-UM	TPS3	TIP10F
	4	2100X4F25	●	2	91	111	161	25	32	0.5	073505-UM	TPS3	TIP10F
	5	2100X5F25	●	2	112	132	182	25	32	0.5	073505-UM	TPS3	TIP10F
	6	2100X6F25	●	2	133	153	203	25	32	0.5	073505-UM	TPS3	TIP10F
21.5	2	2150X2F25	●	2	50	70	120	25	32	0.45	073505-UM	TPS3	TIP10F
	3	2150X3F25	●	2	71.5	91.5	141.5	25	32	0.45	073505-UM	TPS3	TIP10F
22.0	2	2200X2F25	●	2	51	71	121	25	32	0.4	073505-UM	TPS3	TIP10F
	3	2200X3F25	●	2	73	93	143	25	32	0.4	073505-UM	TPS3	TIP10F
	4	2200X4F25	●	2	95	115	165	25	32	0.4	073505-UM	TPS3	TIP10F
	5	2200X5F25	●	2	117	137	187	25	32	0.4	073505-UM	TPS3	TIP10F
	6	2200X6F25	●	2	139	159	209	25	32	0.4	073505-UM	TPS3	TIP10F
22.5	2	2250X2F25	●	2	52	72	122	25	32	0.35	073505-UM	TPS3	TIP10F
	3	2250X3F25	●	2	74.5	94.5	144.5	25	32	0.35	073505-UM	TPS3	TIP10F
23.0	2	2300X2F25	●	2	53	73	123	25	32	0.8	084005-UM	TPS351	TIP10F
	3	2300X3F25	●	2	76	96	146	25	32	0.8	084005-UM	TPS351	TIP10F
	4	2300X4F25	●	2	99	119	169	25	32	0.8	084005-UM	TPS351	TIP10F
	5	2300X5F25	●	2	122	142	192	25	32	0.8	084005-UM	TPS351	TIP10F
	6	2300X6F25	●	2	145	165	215	25	32	0.8	084005-UM	TPS351	TIP10F
23.5	2	2350X2F25	●	2	54	74	124	25	32	0.75	084005-UM	TPS351	TIP10F
	3	2350X3F25	●	2	77.5	97.5	147.5	25	32	0.75	084005-UM	TPS351	TIP10F
24.0	2	2400X2F25	●	2	55	75	125	25	32	0.7	084005-UM	TPS351	TIP10F
	3	2400X3F25	●	2	79	99	149	25	32	0.7	084005-UM	TPS351	TIP10F
	4	2400X4F25	●	2	103	123	173	25	32	0.7	084005-UM	TPS351	TIP10F
	5	2400X5F25	●	2	127	147	197	25	32	0.7	084005-UM	TPS351	TIP10F
	6	2400X6F25	●	2	151	171	221	25	32	0.7	084005-UM	TPS351	TIP10F
24.5	2	2450X2F25	●	2	56	76	126	25	32	0.65	084005-UM	TPS351	TIP10F
	3	2450X3F25	●	2	80.5	100.5	150.5	25	32	0.65	084005-UM	TPS351	TIP10F
25.0	2	2500X2F25	●	2	57	77	127	25	32	0.6	084005-UM	TPS351	TIP10F
	3	2500X3F25	●	2	82	102	152	25	32	0.6	084005-UM	TPS351	TIP10F
	4	2500X4F25	●	2	107	127	177	25	32	0.6	084005-UM	TPS351	TIP10F
	5	2500X5F25	●	2	132	152	202	25	32	0.6	084005-UM	TPS351	TIP10F
	6	2500X6F25	●	2	157	177	227	25	32	0.6	084005-UM	TPS351	TIP10F
25.5	2	2550X2F25	●	2	58	78	128	25	32	0.6	084005-UM	TPS351	TIP10F
	3	2550X3F25	●	2	83.5	103.5	153.5	25	32	0.6	084005-UM	TPS351	TIP10F
26.0	2	2600X2F32	●	2	59	79	134	32	42	0.5	084005-UM	TPS351	TIP10F
	3	2600X3F32	●	2	85	105	160	32	42	0.5	084005-UM	TPS351	TIP10F
	4	2600X4F32	●	2	111	131	186	32	42	0.5	084005-UM	TPS351	TIP10F
	5	2600X5F32	●	2	137	157	212	32	42	0.5	084005-UM	TPS351	TIP10F
	6	2600X6F32	●	2	163	183	238	32	42	0.5	084005-UM	TPS351	TIP10F
26.5	2	2650X2F32	●	2	60	80	135	32	42	0.5	084005-UM	TPS351	TIP10F
	3	2650X3F32	●	2	86.5	106.5	161.5	32	42	0.5	084005-UM	TPS351	TIP10F
27.0	2	2700X2F32	●	2	61	81	136	32	42	0.45	084005-UM	TPS351	TIP10F
	3	2700X3F32	●	2	88	108	163	32	42	0.45	084005-UM	TPS351	TIP10F
	4	2700X4F32	●	2	115	135	190	32	42	0.45	084005-UM	TPS351	TIP10F
	5	2700X5F32	●	2	142	162	217	32	42	0.45	084005-UM	TPS351	TIP10F
	6	2700X6F32	●	2	169	189	244	32	42	0.45	084005-UM	TPS351	TIP10F

●: Estoque mantido.

Diâm. da Broca D1 (mm)	Prof. do Furo (l/d)	Referência para Pedido	Estoque	Número de Dentes	Dimensões (mm)					Ajuste radial (máx.)	Referência do Inserto		
					Compr. efetivo do canal	Compr. do Corpo	Comp. Total	Diâm. da Haste	Diâmetro do flange				
					L3	L2	L1	D4	D7			Parafuso de Fixação	Chave
27.5	2	MX2750X2F32	●	2	62	82	137	32	42	0.4	SOMX084005-UM	TPS351	TIP10F
	3	2750X3F32	●	2	89.5	109.5	164.5	32	42	0.4	084005-UM	TPS351	TIP10F
28.0	2	2800X2F32	●	2	63	83	138	32	42	0.85	094506-UM	TPS4	TIP15W
	3	2800X3F32	●	2	91	111	166	32	42	0.85	094506-UM	TPS4	TIP15W
	4	2800X4F32	●	2	119	139	194	32	42	0.85	094506-UM	TPS4	TIP15W
	5	2800X5F32	●	2	147	167	222	32	42	0.85	094506-UM	TPS4	TIP15W
	6	2800X6F32	●	2	175	195	250	32	42	0.85	094506-UM	TPS4	TIP15W
28.5	2	2850X2F32	●	2	64	84	139	32	42	0.8	094506-UM	TPS4	TIP15W
	3	2850X3F32	●	2	92.5	112.5	167.5	32	42	0.8	094506-UM	TPS4	TIP15W
29.0	2	2900X2F32	●	2	65	85	140	32	42	0.75	094506-UM	TPS4	TIP15W
	3	2900X3F32	●	2	94	114	169	32	42	0.75	094506-UM	TPS4	TIP15W
	4	2900X4F32	●	2	123	143	198	32	42	0.75	094506-UM	TPS4	TIP15W
	5	2900X5F32	●	2	152	172	227	32	42	0.75	094506-UM	TPS4	TIP15W
	6	2900X6F32	●	2	181	201	256	32	42	0.75	094506-UM	TPS4	TIP15W
29.5	2	2950X2F32	●	2	66	86	141	32	42	0.7	094506-UM	TPS4	TIP15W
	3	2950X3F32	●	2	95.5	115.5	170.5	32	42	0.7	094506-UM	TPS4	TIP15W
30.0	2	3000X2F32	●	2	67	87	142	32	42	0.65	094506-UM	TPS4	TIP15W
	3	3000X3F32	●	2	97	117	172	32	42	0.65	094506-UM	TPS4	TIP15W
	4	3000X4F32	●	2	127	147	202	32	42	0.65	094506-UM	TPS4	TIP15W
	5	3000X5F32	●	2	157	177	232	32	42	0.65	094506-UM	TPS4	TIP15W
	6	3000X6F32	●	2	187	207	262	32	42	0.65	094506-UM	TPS4	TIP15W
30.5	3	3050X3F32	●	2	98.5	118.5	173.5	32	42	0.6	094506-UM	TPS4	TIP15W
31.0	2	3100X2F40	●	2	69	89	154	40	50	0.55	094506-UM	TPS4	TIP15W
	3	3100X3F40	●	2	100	120	185	40	50	0.55	094506-UM	TPS4	TIP15W
	4	3100X4F40	●	2	131	151	216	40	50	0.55	094506-UM	TPS4	TIP15W
	5	3100X5F40	●	2	162	182	247	40	50	0.55	094506-UM	TPS4	TIP15W
	6	3100X6F40	●	2	193	213	278	40	50	0.55	094506-UM	TPS4	TIP15W
31.5	3	3150X3F40	●	2	101.5	121.5	186.5	40	50	0.55	094506-UM	TPS4	TIP15W
32.0	2	3200X2F40	●	2	71	91	156	40	50	0.45	094506-UM	TPS4	TIP15W
	3	3200X3F40	●	2	103	123	188	40	50	0.45	094506-UM	TPS4	TIP15W
	4	3200X4F40	●	2	135	155	220	40	50	0.45	094506-UM	TPS4	TIP15W
	5	3200X5F40	●	2	167	187	252	40	50	0.45	094506-UM	TPS4	TIP15W
	6	3200X6F40	●	2	199	219	284	40	50	0.45	094506-UM	TPS4	TIP15W
32.5	3	3250X3F40	●	2	104.5	124.5	189.5	40	50	0.45	094506-UM	TPS4	TIP15W
33.0	2	3300X2F40	●	2	73	93	158	40	50	0.4	094506-UM	TPS4	TIP15W
	3	3300X3F40	●	2	106	126	191	40	50	0.4	094506-UM	TPS4	TIP15W
	4	3300X4F40	●	2	139	159	224	40	50	0.4	094506-UM	TPS4	TIP15W
	5	3300X5F40	●	2	172	192	257	40	50	0.4	094506-UM	TPS4	TIP15W
	6	3300X6F40	●	2	205	225	290	40	50	0.4	094506-UM	TPS4	TIP15W

INSERTOS

Foto	Diâm. da Broca	Referência do Inserto	Dimensões (mm)			Estoque			Geometria
			D1	S1	Re	VP15TF	MC1020	MC5020	
	ø17-ø19.5	SOMX063005-UM	6	3	0.5	●	●	●	
	ø20-ø22.5	073505-UM	7	3.5	0.5	●	●	●	
	ø23-ø27.5	084005-UM	8.3	4	0.5	●	●	●	
	ø28-ø33	094506-UM	9.7	4.5	0.6	●	●	●	

*Classes MC1020 e MC5020 somente para inserto periférico.

CONDIÇÕES DE CORTE > N216
 UTILIZAÇÃO > N224
 INFORMAÇÕES TÉCNICAS > Q001

N215

CONDIÇÕES DE CORTE RECOMENDADAS

Material	Dureza	Classe recomendada		&17 – &19.5				&20 – &23.5				
				Vel. de Corte (m/min)		Avanço (mm/rot)		Vel. de Corte (m/min)		Avanço (mm/rot)		
		Periférico	Central	l/d=2-6	l/d=2, 3	l/d=4, 5	l/d=6	l/d=2-6	l/d=2, 3	l/d=4, 5	l/d=6	
P Aço baixo carbono	< 180HB	MC1020	VP15TF	200 (180-235)	0.05 (0.04-0.06)	0.05 (0.04-0.06)	0.04 (0.04-0.05)	200 (180-235)	0.06 (0.04-0.08)	0.06 (0.04-0.07)	0.04 (0.04-0.05)	
	Aço Carbono Aço Liga	180-280HB	MC1020	VP15TF	140 (115-180)	0.08 (0.06-0.14)	0.08 (0.06-0.09)	0.05 (0.04-0.06)	140 (115-180)	0.10 (0.06-0.18)	0.09 (0.06-0.12)	0.07 (0.06-0.08)
	Aço Carbono Aço Liga	280-350HB	MC1020	VP15TF	100 (75-140)	0.08 (0.06-0.14)	0.08 (0.06-0.09)	0.05 (0.04-0.06)	100 (75-140)	0.10 (0.06-0.18)	0.09 (0.06-0.12)	0.07 (0.06-0.08)
	Aço liga ferramenta	< 350HB	MC1020	VP15TF	135 (100-170)	0.08 (0.06-0.14)	0.08 (0.06-0.09)	0.05 (0.04-0.06)	135 (100-170)	0.10 (0.06-0.18)	0.09 (0.06-0.12)	0.07 (0.06-0.08)
M Aço Inoxidável Austenítico	< 200HB	MC1020	VP15TF	140 (115-180)	0.06 (0.04-0.08)	0.05 (0.04-0.06)	0.04 (0.04-0.05)	140 (115-180)	0.08 (0.06-0.12)	0.07 (0.06-0.08)	0.06 (0.06-0.07)	
	Aço Inoxidável Austenítico	>200HB	MC1020	VP15TF	140 (115-180)	0.06 (0.04-0.08)	0.05 (0.04-0.06)	0.04 (0.04-0.05)	140 (115-180)	0.08 (0.06-0.12)	0.07 (0.06-0.08)	0.06 (0.06-0.07)
	Aço inoxidável ferrítico e endurecido por precipitação	< 200HB	MC1020	VP15TF	140 (115-165)	0.06 (0.04-0.08)	0.05 (0.04-0.06)	0.04 (0.04-0.05)	140 (115-165)	0.09 (0.06-0.14)	0.07 (0.06-0.09)	0.06 (0.06-0.07)
	Aço inoxidável ferrítico e endurecido por precipitação	>200HB	MC1020	VP15TF	140 (115-165)	0.06 (0.04-0.08)	0.05 (0.04-0.06)	0.04 (0.04-0.05)	140 (115-165)	0.09 (0.06-0.14)	0.07 (0.06-0.09)	0.06 (0.06-0.07)
K Ferro Fundido Cinzento	Resistência à Tração < 350MPa	MC5020	VP15TF	160 (130-195)	0.11 (0.08-0.14)	0.09 (0.08-0.10)	0.05 (0.04-0.06)	160 (130-195)	0.14 (0.10-0.18)	0.10 (0.10-0.12)	0.07 (0.06-0.08)	
	Ferro Fundido Nodular	Resistência à Tração < 450MPa	MC5020	VP15TF	100 (80-135)	0.11 (0.08-0.14)	0.09 (0.08-0.10)	0.05 (0.04-0.06)	100 (80-135)	0.13 (0.10-0.16)	0.10 (0.10-0.11)	0.07 (0.06-0.08)
	Ferro Fundido Nodular	Resistência à Tração < 800MPa	MC5020	VP15TF	100 (70-125)	0.11 (0.08-0.14)	0.09 (0.08-0.10)	0.05 (0.04-0.06)	100 (70-125)	0.13 (0.10-0.16)	0.10 (0.10-0.11)	0.07 (0.06-0.08)

Material	Dureza	Classe recomendada		&24 – &29.5				&30 – &33				
				Vel. de Corte (m/min)		Avanço (mm/rot)		Vel. de Corte (m/min)		Avanço (mm/rot)		
		Periférico	Central	l/d=2-6	l/d=2, 3	l/d=4, 5	l/d=6	l/d=2-6	l/d=2, 3	l/d=4, 5	l/d=6	
P Aço baixo carbono	< 180HB	MC1020	VP15TF	200 (180-235)	0.07 (0.04-0.08)	0.06 (0.04-0.07)	0.05 (0.04-0.06)	200 (180-235)	0.08 (0.06-0.10)	0.07 (0.06-0.08)	0.06 (0.06-0.07)	
	Aço Carbono Aço Liga	180-280HB	MC1020	VP15TF	140 (115-180)	0.12 (0.08-0.18)	0.10 (0.08-0.12)	0.09 (0.08-0.10)	140 (115-180)	0.14 (0.08-0.24)	0.12 (0.08-0.16)	0.11 (0.10-0.12)
	Aço Carbono Aço Liga	280-350HB	MC1020	VP15TF	100 (75-140)	0.12 (0.08-0.18)	0.10 (0.08-0.12)	0.09 (0.08-0.10)	100 (75-140)	0.14 (0.08-0.24)	0.12 (0.08-0.16)	0.11 (0.10-0.12)
	Aço liga ferramenta	< 350HB	MC1020	VP15TF	135 (100-170)	0.12 (0.08-0.18)	0.10 (0.08-0.12)	0.09 (0.08-0.10)	135 (100-170)	0.14 (0.08-0.24)	0.12 (0.08-0.16)	0.10 (0.08-0.12)
M Aço Inoxidável Austenítico	< 200HB	MC1020	VP15TF	140 (115-180)	0.09 (0.06-0.12)	0.08 (0.06-0.09)	0.07 (0.06-0.08)	140 (115-180)	0.11 (0.06-0.16)	0.08 (0.06-0.11)	0.07 (0.06-0.10)	
	Aço Inoxidável Austenítico	>200HB	MC1020	VP15TF	140 (115-180)	0.09 (0.06-0.12)	0.08 (0.06-0.09)	0.07 (0.06-0.08)	140 (115-180)	0.11 (0.06-0.16)	0.08 (0.06-0.11)	0.07 (0.06-0.10)
	Aço inoxidável ferrítico e endurecido por precipitação	< 200HB	MC1020	VP15TF	140 (115-165)	0.10 (0.06-0.14)	0.08 (0.06-0.09)	0.07 (0.06-0.08)	140 (115-165)	0.11 (0.06-0.16)	0.09 (0.06-0.11)	0.08 (0.06-0.10)
	Aço inoxidável ferrítico e endurecido por precipitação	>200HB	MC1020	VP15TF	140 (115-165)	0.10 (0.06-0.14)	0.08 (0.06-0.09)	0.07 (0.06-0.08)	140 (115-165)	0.11 (0.06-0.16)	0.09 (0.06-0.11)	0.08 (0.06-0.10)
K Ferro Fundido Cinzento	Resistência à Tração < 350MPa	MC5020	VP15TF	160 (130-195)	0.15 (0.10-0.20)	0.11 (0.10-0.13)	0.09 (0.08-0.10)	160 (130-195)	0.15 (0.10-0.20)	0.12 (0.10-0.13)	0.11 (0.10-0.12)	
	Ferro Fundido Nodular	Resistência à Tração < 450MPa	MC5020	VP15TF	100 (80-135)	0.14 (0.10-0.18)	0.11 (0.10-0.12)	0.09 (0.08-0.10)	100 (80-135)	0.15 (0.10-0.20)	0.12 (0.10-0.13)	0.11 (0.10-0.12)
	Ferro Fundido Nodular	Resistência à Tração < 800MPa	MC5020	VP15TF	100 (70-125)	0.14 (0.10-0.18)	0.11 (0.10-0.12)	0.09 (0.08-0.10)	100 (70-125)	0.15 (0.10-0.20)	0.12 (0.10-0.13)	0.11 (0.10-0.12)

1) Quando usar VP15TF como inserto periférico, reduza a velocidade de corte em aprox. 30%.

2) Quando usar refrigeração externa, a profundidade máxima de corte deve ser L/D=3. Não é recomendado usar profundidades de corte maiores.

3) Para usinagem de aço inoxidável, use sempre refrigeração interna.