

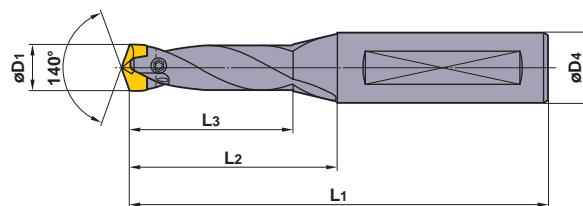
# FURAÇÃO (TIPO INTERCAMBIÁVEL)

## S-TAW

- Aresta de corte em hélice para melhor controle do cavaco.
- Sistema de fixação altamente rígida oferece estabilidade e confiabilidade na usinagem de furos pequenos.

Broca intercambiável de diâmetro pequeno

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



### SUPORTES

Diâmetros Disponíveis das Brocas D1 (mm)	Prof. de Furo (l/d)	Suporte		Dimensões (mm)				Chave	Diâm. da Broca D1 (mm)	Inserto			
		Referência para Pedido	Estoque	Compr. efetivo do canal	Compr. do Corpo	Comp. Total	Diâm. da Haste			Referência para Pedido	VP15TF	VP10H	DP5010
10.0   10.4	1.5	STAWSS1000S16	●	22	32	80	16	TIP06F	10.0	STAWN1000TH	●	□	
										STAWK1000TG			●
	3	STAWSN1000S16	●	37	47	95	16	TIP06F	10.1	STAWN1010TH	●	□	
										STAWK1010TG			●
	5	STAWMN1000S16	●	57	67	115	16	TIP06F	10.2	STAWN1020TH	●	□	
										STAWK1020TG			●
	8	STAWLN1000S16	●	87	97	145	16	TIP06F	10.3	STAWN1030TH	●	□	
										STAWK1030TG			●
10.5   10.9	1.5	STAWSS1050S16	●	22	32	80	16	TIP06F	10.4	STAWN1040TH	●	□	
										STAWK1040TG			●
	3	STAWSN1050S16	●	37	47	95	16	TIP06F	10.5	STAWN1050TH	●	□	
										STAWK1050TG			●
	5	STAWMN1050S16	●	57	67	115	16	TIP06F	10.6	STAWN1060TH	●	□	
										STAWK1060TG			●
	8	STAWLN1050S16	●	87	97	145	16	TIP06F	10.7	STAWN1070TH	●	□	
										STAWK1070TG			●
11.0   11.4	1.5	STAWSS1100S16	●	25	36	84	16	TIP06F	10.8	STAWN1080TH	●	□	
										STAWK1080TG			●
	3	STAWSN1100S16	●	41	52	100	16	TIP06F	10.9	STAWN1090TH	●	□	
										STAWK1090TG			●
	5	STAWMN1100S16	●	66	77	125	16	TIP06F	11.0	STAWN1100TH	●	□	
										STAWK1100TG			●
	8	STAWLN1100S16	●	96	107	155	16	TIP06F	11.1	STAWN1110TH	●	□	
										STAWK1110TG			●
11.5   11.9	1.5	STAWSS1150S16	●	25	36	84	16	TIP06F	11.2	STAWN1120TH	●	□	
										STAWK1120TG			●
	3	STAWSN1150S16	●	41	52	100	16	TIP06F	11.3	STAWN1130TH	●	□	
										STAWK1130TG			●
	5	STAWMN1150S16	●	66	77	125	16	TIP06F	11.4	STAWN1140TH	●	□	
										STAWK1140TG			●
	8	STAWLN1150S16	●	96	107	155	16	TIP06F	11.5	STAWN1150TH	●	□	
										STAWK1150TG			●
12.0   12.4	1.5	STAWSS1200S16	●	27	39	87	16	TIP06F	11.6	STAWN1160TH	●	□	
										STAWK1160TG			●
	3	STAWSN1200S16	●	45	57	105	16	TIP06F	11.7	STAWN1170TH	●	□	
										STAWK1170TG			●
	5	STAWMN1200S16	●	70	82	130	16	TIP06F	11.8	STAWN1180TH	●	□	
										STAWK1180TG			●
	8	STAWLN1200S16	●	105	117	165	16	TIP06F	11.9	STAWN1190TH	●	□	
										STAWK1190TG			●
12.0   12.4	1.5	STAWSS1200S16	●	27	39	87	16	TIP06F	12.0	STAWN1200TH	●	□	
										STAWK1200TG			●
	3	STAWSN1200S16	●	45	57	105	16	TIP06F	12.1	STAWN1210TH	●	□	
										STAWK1210TG			●
	5	STAWMN1200S16	●	70	82	130	16	TIP06F	12.2	STAWN1220TH	●	□	
										STAWK1220TG			●
	8	STAWLN1200S16	●	105	117	165	16	TIP06F	12.3	STAWN1230TH	●	□	
										STAWK1230TG			●
									12.4	STAWN1240TH	●	□	
										STAWK1240TG			●

(Nota 1) As dimensões acima correspondem à montagem do inserto STAWN (VP15TF).

(Nota 2) Por favor entre em contato para qualquer geometria que não conste no catálogo (ex.: diâmetro e comprimento diferente.).

● : Estoque mantido. □ : Sem estoque, produzido somente por pedido.

(Nota: 1 inserto por embalagem)

Diâmetros Disponíveis das Brocas D1 (mm)	Prof. de Furo (l/d)	Suporte		Dimensões (mm)				① ② Chave	Diâm. da Broca D1 (mm)	Inserto			
		Referência para Pedido	Estoque	Compr. efetivo do canal L3	Compr. do Corpo L2	Comp. Total L1	Diâm. da Haste D4			Referência para Pedido	Estoque		
								VP15TF			VP10H	DP5010	
12.5   12.9	1.5	STAWSS1250S16	●	27	39	87	16	①TIP06F	12.5	STAWN1250TH	●	□	●
										STAWK1250TG			●
	3	STAWSN1250S16	●	45	57	105	16	①TIP06F	12.6	STAWN1260TH	●	□	●
										STAWK1260TG			●
	5	STAWMN1250S16	●	70	82	130	16	①TIP06F	12.7	STAWN1270TH	●	□	●
										STAWK1270TG			●
	8	STAWLN1250S16	●	105	117	165	16	①TIP06F	12.8	STAWN1280TH	●	□	●
										STAWK1280TG			●
									12.9	STAWN1290TH	●	□	●
										STAWK1290TG			●
13.0   13.4	1.5	STAWSS1300S16	●	30	43	91	16	②TIP08W	13.0	STAWN1300TH	●	□	●
										STAWK1300TG			●
	3	STAWSN1300S16	●	49	62	110	16	②TIP08W	13.1	STAWN1310TH	●	□	●
										STAWK1310TG			●
	5	STAWMN1300S16	●	74	87	135	16	②TIP08W	13.2	STAWN1320TH	●	□	●
										STAWK1320TG			●
	8	STAWLN1300S16	●	114	127	175	16	②TIP08W	13.3	STAWN1330TH	●	□	●
										STAWK1330TG			●
									13.4	STAWN1340TH	●	□	●
										STAWK1340TG			●
13.5   13.9	1.5	STAWSS1350S16	●	30	43	91	16	②TIP08W	13.5	STAWN1350TH	●	□	●
										STAWK1350TG			●
	3	STAWSN1350S16	●	49	62	110	16	②TIP08W	13.6	STAWN1360TH	●	□	●
										STAWK1360TG			●
	5	STAWMN1350S16	●	74	87	135	16	②TIP08W	13.7	STAWN1370TH	●	□	●
										STAWK1370TG			●
	8	STAWLN1350S16	●	114	127	175	16	②TIP08W	13.8	STAWN1380TH	●	□	●
										STAWK1380TG			●
									13.9	STAWN1390TH	●	□	●
										STAWK1390TG			●
14.0   14.4	1.5	STAWSS1400S16	●	31	45	93	16	②TIP08W	14.0	STAWN1400TH	●		●
										STAWK1400TG			●
	3	STAWSN1400S16	●	53	67	115	16	②TIP08W	14.1	STAWN1410TH	●		●
										STAWK1410TG			●
	5	STAWMN1400S16	●	83	97	145	16	②TIP08W	14.2	STAWN1420TH	●		●
										STAWK1420TG			●
	8	STAWLN1400S16	●	122	137	185	16	②TIP08W	14.3	STAWN1430TH	●		●
										STAWK1430TG			●
									14.4	STAWN1440TH	●		●
										STAWK1440TG			●
14.5   14.9	1.5	STAWSS1450S16	●	31	45	93	16	②TIP08W	14.5	STAWN1450TH	●		●
										STAWK1450TG			●
	3	STAWSN1450S16	●	53	67	115	16	②TIP08W	14.6	STAWN1460TH	●		●
										STAWK1460TG			●
	5	STAWMN1450S16	●	83	97	145	16	②TIP08W	14.7	STAWN1470TH	●		●
										STAWK1470TG			●
	8	STAWLN1450S16	●	122	137	185	16	②TIP08W	14.8	STAWN1480TH	●		●
										STAWK1480TG			●
									14.9	STAWN1490TH	●		●
										STAWK1490TG			●
15.0   15.4	1.5	STAWSS1500S20	●	33	48	98	20	②TIP08W	15.0	STAWN1500TH	●		●
										STAWK1500TG			●
	3	STAWSN1500S20	●	60	75	125	20	②TIP08W	15.1	STAWN1510TH	●		●
										STAWK1510TG			●
	5	STAWMN1500S20	●	90	105	155	20	②TIP08W	15.2	STAWN1520TH	●		●
										STAWK1520TG			●
	8	STAWLN1500S20	●	130	148	198	20	②TIP08W	15.3	STAWN1530TH	●		●
										STAWK1530TG			●
									15.4	STAWN1540TH	●		●
										STAWK1540TG			●

(Nota 1) As dimensões acima correspondem à montagem do inserto STAWN (VP15TF).

(Nota 2) Por favor entre em contato para qualquer geometria que não conste no catálogo (ex.: diâmetro e comprimento diferente.).


DESCRIÇÃO DO INSERTO > N193  
 CONDIÇÕES DE CORTE > N197  
 UTILIZAÇÃO > N198  
 INFORMAÇÕES TÉCNICAS > Q001

# FURAÇÃO (TIPO INTERCAMBIÁVEL)

## S-TAW

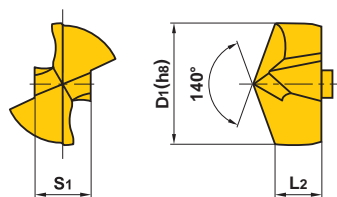
Broca intercambiável de diâmetro pequeno

METAL DURO

Diâmetros Disponíveis das Brocas D1 (mm)	Prof. de Furo (l/d)	Suporte		Dimensões (mm)				 Chave	Inserto				
		Referência para Pedido	Estoque	Compr. efetivo do canal	Compr. do Corpo	Comp. Total	Diâm. da Haste		Diâm. da Broca D1 (mm)	Referência para Pedido	Estoque		
				L3	L2	L1	D4				VP15TF	VP10H	DP5010
NEW 15.5   16.4	1.5	STAWSS1600S20	●	34	50	100	20	TIP10W	15.5	STAWN1550T	●		●
										STAWK1550TG			
									15.6	STAWN1560T	●		●
	3	STAWSN1600S20	●	60	80	130	20	TIP10W	15.7	STAWN1570T	●		●
										STAWK1570TG			
									15.8	STAWN1580T	●		●
	5	STAWMN1600S20	●	90	115	165	20	TIP10W	15.9	STAWN1590T	●		●
										STAWK1590TG			
									16.0	STAWN1600T	●		●
	8	STAWLN1600S20	●	138	158	208	20	TIP10W	16.1	STAWN1610T	●		●
										STAWK1610TG			
									16.2	STAWN1620T	●		●
									STAWK1620TG				
NEW 16.5   17.4	1.5	STAWSS1700S20	●	36	53	103	20	TIP10W	16.3	STAWN1630T	●		●
										STAWK1630TG			
									16.4	STAWN1640T	●		●
	3	STAWSN1700S20	●	61	85	135	20	TIP10W	16.5	STAWN1650T	●		●
										STAWK1650TG			
									16.6	STAWN1660T	●		●
	5	STAWMN1700S20	●	95	120	170	20	TIP10W	16.7	STAWN1670T	●		●
										STAWK1670TG			
									16.8	STAWN1680T	●		●
	8	STAWLN1700S20	●	146	166	216	20	TIP10W	16.9	STAWN1690T	●		●
										STAWK1690TG			
									17.0	STAWN1700T	●		●
									STAWK1700TG				
NEW 17.5   18.4	1.5	STAWSS1800S20	●	37	55	105	20	TIP10W	17.1	STAWN1710T	●		●
										STAWK1710TG			
									17.2	STAWN1720T	●		●
	3	STAWSN1800S20	●	64	90	140	20	TIP10W	17.3	STAWN1730T	●		●
										STAWK1730TG			
									17.4	STAWN1740T	●		●
	5	STAWMN1800S20	●	100	125	175	20	TIP10W	17.5	STAWN1750T	●		●
										STAWK1750TG			
									17.6	STAWN1760T	●		●
	8	STAWLN1800S20	●	154	174	224	20	TIP10W	17.7	STAWN1770T	●		●
										STAWK1770TG			
									17.8	STAWN1780T	●		●
									STAWK1780TG				
17.9	STAWN1790T	●					TIP10W	17.9	STAWN1790T	●		●	
									STAWK1790TG				
								18.0	STAWN1800T	●		●	
									STAWK1800TG				
18.1	STAWN1810T	●					TIP10W	18.1	STAWN1810T	●		●	
									STAWK1810TG				
								18.2	STAWN1820T	●		●	
									STAWK1820TG				
18.3	STAWN1830T	●					TIP10W	18.3	STAWN1830T	●		●	
									STAWK1830TG				
18.4	STAWN1840T	●					TIP10W	18.4	STAWN1840T	●		●	
									STAWK1840TG				

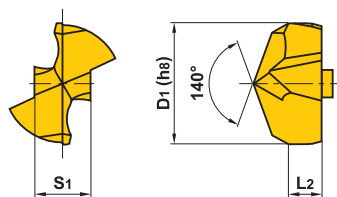
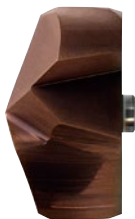
● : Estoque mantido. □ : Sem estoque, produzido somente por pedido.  
(Nota: 1 inserto por embalagem)

## INSERTOS



Referência para Pedido	Estoque		Dimensões (mm)			Suporte Correspondente
	VP15TF	VP10H	D1	L2	S1	
<b>STAWN1000TH</b>	●	□	10.0	3.8	4.6	STAWSS1000S16
<b>1010TH</b>	●	□	10.1	3.8	4.6	STAWSN1000S16
<b>1020TH</b>	●	□	10.2	3.8	4.6	STAWMN1000S16
<b>1030TH</b>	●	□	10.3	3.8	4.6	STAWLN1000S16
<b>1040TH</b>	●	□	10.4	3.8	4.6	
<b>1050TH</b>	●	□	10.5	4.0	4.8	STAWSS1050S16
<b>1060TH</b>	●	□	10.6	4.0	4.8	STAWSN1050S16
<b>1070TH</b>	●	□	10.7	4.0	4.8	STAWMN1050S16
<b>1080TH</b>	●	□	10.8	4.0	4.8	STAWLN1050S16
<b>1090TH</b>	●	□	10.9	4.0	4.8	
<b>1100TH</b>	●	□	11.0	4.2	5.1	STAWSS1100S16
<b>1110TH</b>	●	□	11.1	4.2	5.1	STAWSN1100S16
<b>1120TH</b>	●	□	11.2	4.2	5.1	STAWMN1100S16
<b>1130TH</b>	●	□	11.3	4.2	5.1	STAWLN1100S16
<b>1140TH</b>	●	□	11.4	4.2	5.1	
<b>1150TH</b>	●	□	11.5	4.4	5.3	STAWSS1150S16
<b>1160TH</b>	●	□	11.6	4.4	5.3	STAWSN1150S16
<b>1170TH</b>	●	□	11.7	4.4	5.3	STAWMN1150S16
<b>1180TH</b>	●	□	11.8	4.4	5.3	STAWLN1150S16
<b>1190TH</b>	●	□	11.9	4.4	5.3	
<b>1200TH</b>	●	□	12.0	4.6	5.5	STAWSS1200S16
<b>1210TH</b>	●	□	12.1	4.6	5.5	STAWSN1200S16
<b>1220TH</b>	●	□	12.2	4.6	5.5	STAWMN1200S16
<b>1230TH</b>	●	□	12.3	4.6	5.5	STAWLN1200S16
<b>1240TH</b>	●	□	12.4	4.6	5.5	
<b>1250TH</b>	●	□	12.5	4.8	5.8	STAWSS1250S16
<b>1260TH</b>	●	□	12.6	4.8	5.8	STAWSN1250S16
<b>1270TH</b>	●	□	12.7	4.8	5.8	STAWMN1250S16
<b>1280TH</b>	●	□	12.8	4.8	5.8	STAWLN1250S16
<b>1290TH</b>	●	□	12.9	4.8	5.8	
<b>1300TH</b>	●	□	13.0	4.9	6.0	STAWSS1300S16
<b>1310TH</b>	●	□	13.1	4.9	6.0	STAWSN1300S16
<b>1320TH</b>	●	□	13.2	4.9	6.0	STAWMN1300S16
<b>1330TH</b>	●	□	13.3	4.9	6.0	STAWLN1300S16
<b>1340TH</b>	●	□	13.4	4.9	6.0	
<b>1350TH</b>	●	□	13.5	5.1	6.2	STAWSS1350S16
<b>1360TH</b>	●	□	13.6	5.1	6.2	STAWSN1350S16
<b>1370TH</b>	●	□	13.7	5.1	6.2	STAWMN1350S16
<b>1380TH</b>	●	□	13.8	5.1	6.2	STAWLN1350S16
<b>1390TH</b>	●	□	13.9	5.1	6.2	

Referência para Pedido	Estoque		Dimensões (mm)			Suporte Correspondente
	VP15TF	VP10H	D1	L2	S1	
<b>STAWN1400TH</b>	●		14.0	5.3	6.4	STAWSS1400S16 STAWSN1400S16 STAWMN1400S16 STAWLN1400S16
<b>1410TH</b>	●		14.1	5.3	6.4	
<b>1420TH</b>	●		14.2	5.3	6.4	
<b>1430TH</b>	●		14.3	5.3	6.4	
<b>1440TH</b>	●		14.4	5.3	6.4	
<b>1450TH</b>	●		14.5	5.5	6.7	STAWSS1450S16 STAWSN1450S16 STAWMN1450S16 STAWLN1450S16
<b>1460TH</b>	●		14.6	5.5	6.7	
<b>1470TH</b>	●		14.7	5.5	6.7	
<b>1480TH</b>	●		14.8	5.5	6.7	
<b>1490TH</b>	●		14.9	5.5	6.7	
<b>1500TH</b>	●		15.0	5.7	6.9	STAWSS1500S20 STAWSN1500S20 STAWMN1500S20 STAWLN1500S20
<b>1510TH</b>	●		15.1	5.7	6.9	
<b>1520TH</b>	●		15.2	5.7	6.9	
<b>1530TH</b>	●		15.3	5.7	6.9	
<b>1540TH</b>	●		15.4	5.7	6.9	
<b>NEW 1550T</b>	●		15.5	5.9	7.1	STAWSS1600S20 STAWSN1600S20 STAWMN1600S20 STAWLN1600S20
<b>NEW 1560T</b>	●		15.6	5.9	7.1	
<b>NEW 1570T</b>	●		15.7	5.9	7.1	
<b>NEW 1580T</b>	●		15.8	5.9	7.1	
<b>NEW 1590T</b>	●		15.9	5.9	7.1	
<b>NEW 1600T</b>	●		16.0	5.9	7.1	
<b>NEW 1610T</b>	●		16.1	5.9	7.1	
<b>NEW 1620T</b>	●		16.2	5.9	7.1	
<b>NEW 1630T</b>	●		16.3	5.9	7.1	
<b>NEW 1640T</b>	●		16.4	5.9	7.1	
<b>NEW 1650T</b>	●		16.5	6.3	7.6	STAWSS1700S20 STAWSN1700S20 STAWMN1700S20 STAWLN1700S20
<b>NEW 1660T</b>	●		16.6	6.3	7.6	
<b>NEW 1670T</b>	●		16.7	6.3	7.6	
<b>NEW 1680T</b>	●		16.8	6.3	7.6	
<b>NEW 1690T</b>	●		16.9	6.3	7.6	
<b>NEW 1700T</b>	●		17.0	6.3	7.6	
<b>NEW 1710T</b>	●		17.1	6.3	7.6	
<b>NEW 1720T</b>	●		17.2	6.3	7.6	
<b>NEW 1730T</b>	●		17.3	6.3	7.6	
<b>NEW 1740T</b>	●		17.4	6.3	7.6	
<b>NEW 1750T</b>	●		17.5	6.7	8.1	STAWSS1800S20 STAWSN1800S20 STAWMN1800S20 STAWLN1800S20
<b>NEW 1760T</b>	●		17.6	6.7	8.1	
<b>NEW 1770T</b>	●		17.7	6.7	8.1	
<b>NEW 1780T</b>	●		17.8	6.7	8.1	
<b>NEW 1790T</b>	●		17.9	6.7	8.1	
<b>NEW 1800T</b>	●		18.0	6.7	8.1	
<b>NEW 1810T</b>	●		18.1	6.7	8.1	
<b>NEW 1820T</b>	●		18.2	6.7	8.1	
<b>NEW 1830T</b>	●		18.3	6.7	8.1	
<b>NEW 1840T</b>	●		18.4	6.7	8.1	

**INSERTOS****(Ferro Fundido)**

Referência para Pedido	Estoque		Dimensões (mm)			Suporte Correspondente
	DP5010		D1	L2	S1	
<b>NEW</b> STAWK1000TG	●		10.0	3.3	4.6	STAWSS1000S16 STAWSN1000S16 STAWMN1000S16 STAWLN1000S16
<b>NEW</b> 1010TG	●		10.1	3.3	4.6	
<b>NEW</b> 1020TG	●		10.2	3.3	4.6	
<b>NEW</b> 1030TG	●		10.3	3.3	4.6	
<b>NEW</b> 1040TG	●		10.4	3.3	4.6	
<b>NEW</b> 1050TG	●		10.5	3.5	4.8	STAWSS1050S16 STAWSN1050S16 STAWMN1050S16 STAWLN1050S16
<b>NEW</b> 1060TG	●		10.6	3.5	4.8	
<b>NEW</b> 1070TG	●		10.7	3.5	4.8	
<b>NEW</b> 1080TG	●		10.8	3.5	4.8	
<b>NEW</b> 1090TG	●		10.9	3.5	4.8	
<b>NEW</b> 1100TG	●		11.0	3.7	5.1	STAWSS1100S16 STAWSN1100S16 STAWMN1100S16 STAWLN1100S16
<b>NEW</b> 1110TG	●		11.1	3.7	5.1	
<b>NEW</b> 1120TG	●		11.2	3.7	5.1	
<b>NEW</b> 1130TG	●		11.3	3.7	5.1	
<b>NEW</b> 1140TG	●		11.4	3.7	5.1	
<b>NEW</b> 1150TG	●		11.5	3.9	5.3	STAWSS1150S16 STAWSN1150S16 STAWMN1150S16 STAWLN1150S16
<b>NEW</b> 1160TG	●		11.6	3.9	5.3	
<b>NEW</b> 1170TG	●		11.7	3.9	5.3	
<b>NEW</b> 1180TG	●		11.8	3.9	5.3	
<b>NEW</b> 1190TG	●		11.9	3.9	5.3	
<b>NEW</b> 1200TG	●		12.0	4.1	5.5	STAWSS1200S16 STAWSN1200S16 STAWMN1200S16 STAWLN1200S16
<b>NEW</b> 1210TG	●		12.1	4.1	5.5	
<b>NEW</b> 1220TG	●		12.2	4.1	5.5	
<b>NEW</b> 1230TG	●		12.3	4.1	5.5	
<b>NEW</b> 1240TG	●		12.4	4.1	5.5	
<b>NEW</b> 1250TG	●		12.5	4.2	5.8	STAWSS1250S16 STAWSN1250S16 STAWMN1250S16 STAWLN1250S16
<b>NEW</b> 1260TG	●		12.6	4.2	5.8	
<b>NEW</b> 1270TG	●		12.7	4.2	5.8	
<b>NEW</b> 1280TG	●		12.8	4.2	5.8	
<b>NEW</b> 1290TG	●		12.9	4.2	5.8	
<b>NEW</b> 1300TG	●		13.0	4.4	6.0	STAWSS1300S16 STAWSN1300S16 STAWMN1300S16 STAWLN1300S16
<b>NEW</b> 1310TG	●		13.1	4.4	6.0	
<b>NEW</b> 1320TG	●		13.2	4.4	6.0	
<b>NEW</b> 1330TG	●		13.3	4.4	6.0	
<b>NEW</b> 1340TG	●		13.4	4.4	6.0	
<b>NEW</b> 1350TG	●		13.5	4.6	6.2	STAWSS1350S16 STAWSN1350S16 STAWMN1350S16 STAWLN1350S16
<b>NEW</b> 1360TG	●		13.6	4.6	6.2	
<b>NEW</b> 1370TG	●		13.7	4.6	6.2	
<b>NEW</b> 1380TG	●		13.8	4.6	6.2	
<b>NEW</b> 1390TG	●		13.9	4.6	6.2	

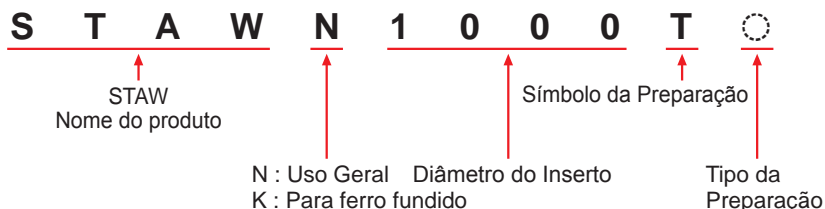


Referência para Pedido	Estoque		Dimensões (mm)			Suporte Correspondente
	DP5010		D1	L2	S1	
<b>NEW</b> STAWK1400TG	●		14.0	4.8	6.4	STAWSS1400S16 STAWSN1400S16 STAWMN1400S16 STAWLN1400S16
<b>NEW</b> 1410TG	●		14.1	4.8	6.4	
<b>NEW</b> 1420TG	●		14.2	4.8	6.4	
<b>NEW</b> 1430TG	●		14.3	4.8	6.4	
<b>NEW</b> 1440TG	●		14.4	4.8	6.4	
<b>NEW</b> 1450TG	●		14.5	5.0	6.7	STAWSS1450S16 STAWSN1450S16 STAWMN1450S16 STAWLN1450S16
<b>NEW</b> 1460TG	●		14.6	5.0	6.7	
<b>NEW</b> 1470TG	●		14.7	5.0	6.7	
<b>NEW</b> 1480TG	●		14.8	5.0	6.7	
<b>NEW</b> 1490TG	●		14.9	5.0	6.7	
<b>NEW</b> 1500TG	●		15.0	5.2	6.9	STAWSS1500S20 STAWSN1500S20 STAWMN1500S20 STAWLN1500S20
<b>NEW</b> 1510TG	●		15.1	5.2	6.9	
<b>NEW</b> 1520TG	●		15.2	5.2	6.9	
<b>NEW</b> 1530TG	●		15.3	5.2	6.9	
<b>NEW</b> 1540TG	●		15.4	5.2	6.9	
<b>NEW</b> 1550TG	●		15.5	5.3	7.1	STAWSS1600S20 STAWSN1600S20 STAWMN1600S20 STAWLN1600S20
<b>NEW</b> 1560TG	●		15.6	5.3	7.1	
<b>NEW</b> 1570TG	●		15.7	5.3	7.1	
<b>NEW</b> 1580TG	●		15.8	5.3	7.1	
<b>NEW</b> 1590TG	●		15.9	5.3	7.1	
<b>NEW</b> 1600TG	●		16.0	5.3	7.1	
<b>NEW</b> 1610TG	●		16.1	5.3	7.1	
<b>NEW</b> 1620TG	●		16.2	5.3	7.1	
<b>NEW</b> 1630TG	●		16.3	5.3	7.1	
<b>NEW</b> 1640TG	●		16.4	5.3	7.1	
<b>NEW</b> 1650TG	●		16.5	5.7	7.6	STAWSS1700S20 STAWSN1700S20 STAWMN1700S20 STAWLN1700S20
<b>NEW</b> 1660TG	●		16.6	5.7	7.6	
<b>NEW</b> 1670TG	●		16.7	5.7	7.6	
<b>NEW</b> 1680TG	●		16.8	5.7	7.6	
<b>NEW</b> 1690TG	●		16.9	5.7	7.6	
<b>NEW</b> 1700TG	●		17.0	5.7	7.6	
<b>NEW</b> 1710TG	●		17.1	5.7	7.6	
<b>NEW</b> 1720TG	●		17.2	5.7	7.6	
<b>NEW</b> 1730TG	●		17.3	5.7	7.6	
<b>NEW</b> 1740TG	●		17.4	5.7	7.6	
<b>NEW</b> 1750TG	●		17.5	6.0	8.1	STAWSS1800S20 STAWSN1800S20 STAWMN1800S20 STAWLN1800S20
<b>NEW</b> 1760TG	●		17.6	6.0	8.1	
<b>NEW</b> 1770TG	●		17.7	6.0	8.1	
<b>NEW</b> 1780TG	●		17.8	6.0	8.1	
<b>NEW</b> 1790TG	●		17.9	6.0	8.1	
<b>NEW</b> 1800TG	●		18.0	6.0	8.1	
<b>NEW</b> 1810TG	●		18.1	6.0	8.1	
<b>NEW</b> 1820TG	●		18.2	6.0	8.1	
<b>NEW</b> 1830TG	●		18.3	6.0	8.1	
<b>NEW</b> 1840TG	●		18.4	6.0	8.1	

## PREPARAÇÃO DE ARESTA

Se um inserto com preparação de aresta for necessário, solicite utilizando o símbolo abaixo, o que melhor lhe atender.

(Referência para Pedido do Inserto)



(Preparação Standard)

Tipo da Preparação	Espessura da Preparação (mm)
F	0
G	0.02—0.05
H	0.05—0.10
-	0.10—0.15
K	0.15—0.20
S	0.20—0.25
M	0.25—0.30

## CONDIÇÕES DE CORTE RECOMENDADAS

Material	Diâm. da Broca	φ10.0—φ12.9		φ13.0—φ13.9		φ14.0—φ15.4		φ15.5—φ18.4	
		Condições Dureza	Vel. de Corte (m/min)	Avanço (mm/rot)	Vel. de Corte (m/min)	Avanço (mm/rot)	Vel. de Corte (m/min)	Avanço (mm/rot)	Vel. de Corte (m/min)
<b>P</b> Aço Médio	≤180HB	80 (60—100)	0.20 (0.15—0.25)	90 (70—110)	0.25 (0.20—0.30)	100 (80—120)	0.30 (0.25—0.35)	100 (80—120)	0.35 (0.25—0.40)
	180—280HB	80 (60—100)	0.20 (0.15—0.25)	90 (70—110)	0.25 (0.20—0.30)	100 (80—120)	0.30 (0.25—0.35)	100 (80—120)	0.35 (0.25—0.40)
	Aço Carbono Aço Liga 280—350HB	70 (60—90)	0.20 (0.15—0.25)	80 (60—100)	0.25 (0.20—0.30)	90 (70—110)	0.25 (0.20—0.30)	90 (70—110)	0.30 (0.20—0.35)
<b>M</b> Aço Inoxidável	≤200HB	40 (30—50)	0.13 (0.10—0.16)	50 (40—60)	0.15 (0.12—0.18)	60 (50—70)	0.17 (0.14—0.20)	60 (50—70)	0.17 (0.14—0.20)
<b>K</b> Ferro Fundido Cinzento	Resistência à Tração ≤350MPa	80 (60—100)	0.20 (0.15—0.25)	90 (70—110)	0.25 (0.20—0.30)	100 (80—120)	0.30 (0.25—0.35)	120 (80—140)	0.45 (0.35—0.55)
	Ferro Fundido Nodular	Resistência à Tração ≤450MPa	70 (60—90)	0.20 (0.15—0.25)	80 (60—100)	0.25 (0.20—0.30)	90 (70—110)	0.30 (0.25—0.35)	100 (80—120)

(Nota 1) Quando usar uma broca para um furo com profundidade 1.5D, é possível aumentar o avanço em aprox. 20%.

(Nota 2) Ao utilizar suportes 8D, reduza a velocidade de corte em aprox. 20%.

(Nota 3) Ao utilizar suportes 8D, recomenda-se utilizar um furo de guia.

(Nota 4) Para aço inoxidável, use refrigeração interna. (Névoa e MQL não são recomendados.)



#### UTILIZAÇÃO

##### INSTALAÇÃO DO INSERTO

1. Antes de montar o inserto no suporte, limpe o alojamento e certifique-se de que não há sujeira na fenda nem no alojamento.
2. Para abrir a ponta do suporte, use a chave fornecida para afrouxar o parafuso interno, depois coloque o inserto no alojamento como mostrado na figura 1.  
\*Certifique-se de que a chave está firmemente em contato com a base da cabeça do parafuso interno quando apertá-lo.
3. Após posicionar o inserto no alojamento, aperte o parafuso interno enquanto segura o inserto levemente como mostrado na figura 2 para localizar e fixar o inserto seguramente.  
\*Certifique-se de que a chave está firmemente em contato com a base da cabeça do parafuso interno quando apertá-lo.

Aperte o parafuso de fixação de acordo com o torque abaixo.

Drill Diameter (mm)	Torque
	N · m
10 -12.9	1
13 -15.4	2
15.5 -18.4	2.5

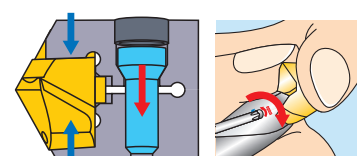
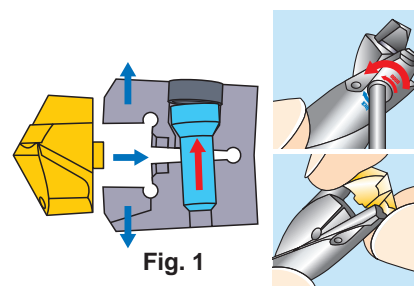
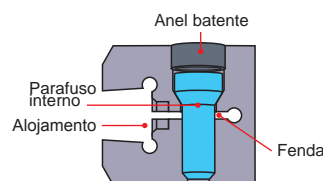
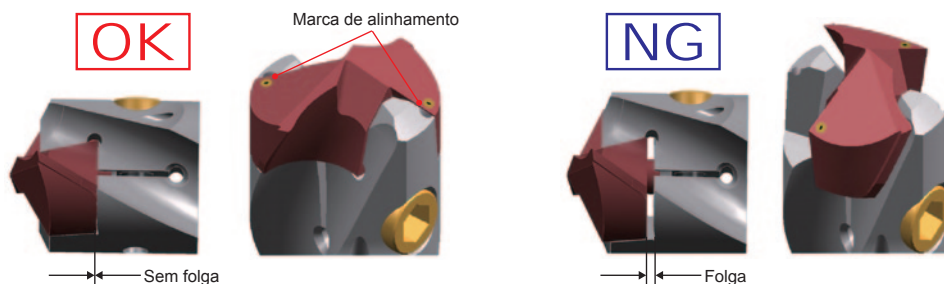


Fig. 2

4. Verifique se não há nenhuma folga entre a base do inserto com o suporte.



(Nota) A fixação insuficiente ou incorreta dos inserts podem causar baixo desempenho da furação e/ou quebra da broca.

Portanto, assegure o alinhamento das marcas do corpo e do inserto na montagem.

Durante a usinagem, use óculos de proteção e outras medidas de segurança.

#### PEÇAS DE REPOSIÇÃO

Suporte Correspondente	Referência para pedido (embalagem com parafuso interno e anel batente)		
		Parafuso interno	Anel batente
STAWSS/SN/MN/LN1000S16	WS203107TPS-35LH	WS203107TPS	WS35LH
STAWSS/SN/MN/LN1050S16	WS203107TPS-35LH	WS203107TPS	WS35LH
STAWSS/SN/MN/LN1100S16	WS203108TPS-35LH	WS203108TPS	WS35LH
STAWSS/SN/MN/LN1150S16	WS203108TPS-35LH	WS203108TPS	WS35LH
STAWSS/SN/MN/LN1200S16	WS203108TPS-35LH	WS203108TPS	WS35LH
STAWSS/SN/MN/LN1250S16	WS203108TPS-35LH	WS203108TPS	WS35LH
STAWSS/SN/MN/LN1300S16	WS253909TPS-45LH	WS253909TPS	WS45LH
STAWSS/SN/MN/LN1350S16	WS253909TPS-45LH	WS253909TPS	WS45LH
STAWSS/SN/MN/LN1400S16	WS253909TPS-45LH	WS253909TPS	WS45LH
STAWSS/SN/MN/LN1450S16	WS253909TPS-45LH	WS253909TPS	WS45LH
STAWSS/SN/MN/LN1500S20	WS253909TPS-45LH	WS253909TPS	WS45LH
STAWSS/SN/MN/LN1600S20	WS304912TPS-55LH	WS304912TPS	WS55LH
STAWSS/SN/MN/LN1700S20	WS304912TPS-55LH	WS304912TPS	WS55LH
STAWSS/SN/MN/LN1800S20	WS304912TPS-55LH	WS304912TPS	WS55LH

(Nota) As peças de reposição que compõe a embalagem são o parafuso interno, o anel batente e o manual de operação. Favor substituir as peças conforme o manual.