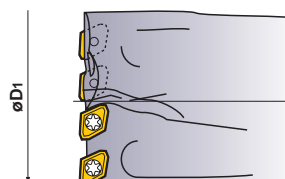
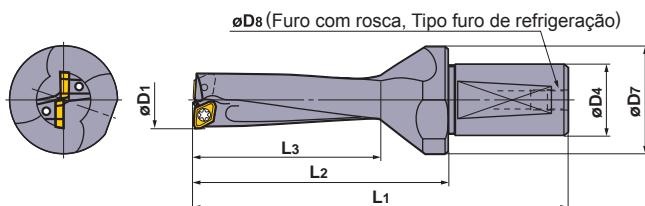
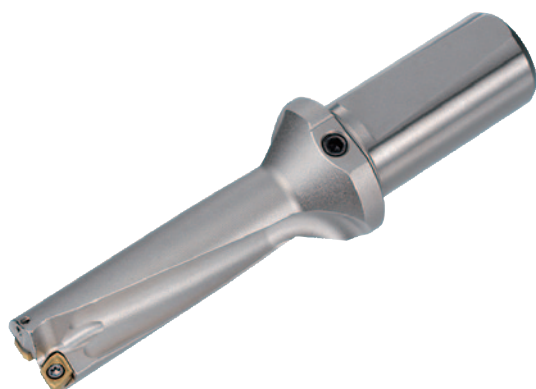


TAFS/TAFM/TAFL

- Suporte de alta rigidez.
- Insertos de 4 arestas.
- Várias classes e quebra-cavacos.

METAL DURO

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



(Nota) O furo rosqueado na lateral da flange não é para refrigeração.

Número de Dentes = 4 ($\phi D1 \geq 49$)

Diâm. da Broca D1 (mm)	Prof. do Furo (l/d)	Referência para Pedido	Estoque	Número de Dentes	Dimensões (mm)						Referência do Inserto	Parafuso de Fixação	Chave
					Compr. efetivo do canal	Compr. do Corpo	Compr. Total	Diâm. da Haste	Diâmetro do flange	Furo de refrigeração			
12.0	2	TAFS1200F20	●	2	29	39	82	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
	3	TAFM1200F20	●	2	41	51	94	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
12.5	2	TAFS1250F20	●	2	29	39	82	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
	3	TAFM1250F20	●	2	41	51	94	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
13.0	2	TAFS1300F20	●	2	31	41	84	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
	3	TAFM1300F20	●	2	44	54	97	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
13.5	2	TAFS1350F20	●	2	31	41	84	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
	3	TAFM1350F20	●	2	44	54	97	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
14.0	2	TAFS1400F20	●	2	33	43	86	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
	3	TAFM1400F20	●	2	47	57	100	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
14.5	2	TAFS1450F20	●	2	33	43	86	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
	3	TAFM1450F20	●	2	47	57	100	20	25	PT1/8	GCMT040204-U	TS2	TKY06F
15.0	2	TAFS1500F20	●	2	35	45	88	20	25	PT1/8	GPMT060204-U	TS2	TKY06F
	3	TAFM1500F20	●	2	50	60	103	20	25	PT1/8	GPMT060204-U	TS2	TKY06F
15.5	2	TAFS1550F20	●	2	35	45	88	20	25	PT1/8	GPMT060204-U	TS2	TKY06F
	3	TAFM1550F20	●	2	50	60	103	20	25	PT1/8	GPMT060204-U	TS2	TKY06F
16.0	2	TAFS1600F25	●	2	38	57	107	25	35	PT1/8	GPMT060204-U	TS2	TKY06F
	3	TAFM1600F25	●	2	54	73	123	25	35	PT1/8	GPMT060204-U	TS2	TKY06F
	4	TAFL1600F25	●	2	70	89	139	25	35	PT1/8	GPMT060204-U	TS2	TKY06F
16.5	2	TAFS1650F25	●	2	38	57	107	25	35	PT1/8	GPMT060204-U	TS2	TKY06F
	3	TAFM1650F25	●	2	54	73	123	25	35	PT1/8	GPMT060204-U	TS2	TKY06F
17.0	2	TAFS1700F25	●	2	41	59	109	25	35	PT1/8	GPMT060204-U	TS2	TKY06F
	3	TAFM1700F25	●	2	58	76	126	25	35	PT1/8	GPMT060204-U	TS2	TKY06F
	4	TAFL1700F25	●	2	75	93	143	25	35	PT1/8	GPMT060204-U	TS2	TKY06F
17.5	2	TAFS1750F25	●	2	41	59	109	25	35	PT1/8	GPMT060204-U	TS2	TKY06F
	3	TAFM1750F25	●	2	58	76	126	25	35	PT1/8	GPMT060204-U	TS2	TKY06F
18.0	2	TAFS1800F25	●	2	43	61	111	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
	3	TAFM1800F25	●	2	61	79	129	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
	4	TAFL1800F25	●	2	79	97	147	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
18.5	2	TAFS1850F25	●	2	43	61	111	25	35	PT1/8	GPMT070204-U	TS25	TKY08F
	3	TAFM1850F25	●	2	61	79	129	25	35	PT1/8	GPMT070204-U	TS25	TKY08F



● : Estoque mantido.

DESCRIÇÃO DO INSERTO > N221
CONDIÇÕES DE CORTE > N222



UTILIZAÇÃO > N225
INFORMAÇÕES TÉCNICAS > Q001



N217

FURAÇÃO

Diâm. da Broca D1 (mm)	Prof. do Furo (l/d)	Referência para Pedido	Estoque	Número de Dentes	Dimensões (mm)						Referência do Inserto	 Parafuso de Fixação	 Chave
					Compr. efetivo do canal	Compr. do Corpo	Comp. Total	Diâm. da Haste	Diâmetro do flange	Furo de refrigeração			
					L3	L2	L1	D4	D7	D8			
19.0	2	TAFS1900F25	●	2	46	63	113	25	35	PT1/8	GPMT070204-U	TS25	①TKY08F
	3	TAFM1900F25	●	2	65	82	132	25	35	PT1/8	GPMT070204-U	TS25	①TKY08F
	4	TAFL1900F25	●	2	84	101	151	25	35	PT1/8	GPMT070204-U	TS25	①TKY08F
19.5	2	TAFS1950F25	●	2	46	63	113	25	35	PT1/8	GPMT070204-U	TS25	①TKY08F
	3	TAFM1950F25	●	2	65	82	132	25	35	PT1/8	GPMT070204-U	TS25	①TKY08F
20.0	2	TAFS2000F25	●	2	48	65	115	25	35	PT1/8	GPMT070204-U	TS25	①TKY08F
	3	TAFM2000F25	●	2	68	85	135	25	35	PT1/8	GPMT070204-U	TS25	①TKY08F
	4	TAFL2000F25	●	2	88	105	155	25	35	PT1/8	GPMT070204-U	TS25	①TKY08F
20.5	2	TAFS2050F25	●	2	48	65	115	25	35	PT1/8	GPMT070204-U	TS25	①TKY08F
	3	TAFM2050F25	●	2	68	85	135	25	35	PT1/8	GPMT070204-U	TS25	①TKY08F
21.0	2	TAFS2100F25	●	2	50	67	117	25	35	PT1/8	GPMT070204-U	TS25	①TKY08F
	3	TAFM2100F25	●	2	71	88	138	25	35	PT1/8	GPMT070204-U	TS25	①TKY08F
	4	TAFL2100F25	●	2	92	109	159	25	35	PT1/8	GPMT070204-U	TS25	①TKY08F
21.5	2	TAFS2150F25	●	2	50	67	117	25	35	PT1/8	GPMT070204-U	TS25	①TKY08F
	3	TAFM2150F25	●	2	71	88	138	25	35	PT1/8	GPMT070204-U	TS25	①TKY08F
22.0	2	TAFS2200F25	●	2	53	69	119	25	35	PT1/8	GPMT070204-U	TS25	①TKY08F
	3	TAFM2200F25	●	2	75	91	141	25	35	PT1/8	GPMT070204-U	TS25	①TKY08F
	4	TAFL2200F25	●	2	97	113	163	25	35	PT1/8	GPMT070204-U	TS25	①TKY08F
22.5	2	TAFS2250F25	●	2	53	69	119	25	35	PT1/8	GPMT070204-U	TS25	①TKY08F
	3	TAFM2250F25	●	2	75	91	141	25	35	PT1/8	GPMT070204-U	TS25	①TKY08F
23.0	2	TAFS2300F25	●	2	55	71	121	25	35	PT1/8	GPMT090304-U	TS3	①TKY08F
	3	TAFM2300F25	●	2	78	94	144	25	35	PT1/8	GPMT090304-U	TS3	①TKY08F
	4	TAFL2300F25	●	2	101	117	167	25	35	PT1/8	GPMT090304-U	TS3	①TKY08F
23.5	2	TAFS2350F25	●	2	55	71	121	25	35	PT1/8	GPMT090304-U	TS3	①TKY08F
	3	TAFM2350F25	●	2	78	94	144	25	35	PT1/8	GPMT090304-U	TS3	①TKY08F
24.0	2	TAFS2400F25	●	2	58	73	123	25	35	PT1/8	GPMT090304-U	TS3	①TKY08F
	3	TAFM2400F25	●	2	82	97	147	25	35	PT1/8	GPMT090304-U	TS3	①TKY08F
	4	TAFL2400F25	●	2	106	121	171	25	35	PT1/8	GPMT090304-U	TS3	①TKY08F
24.5	2	TAFS2450F25	●	2	58	73	123	25	35	PT1/8	GPMT090304-U	TS3	①TKY08F
	3	TAFM2450F25	●	2	82	97	147	25	35	PT1/8	GPMT090304-U	TS3	①TKY08F
25.0	2	TAFS2500F32	●	2	60	75	130	32	42	PT1/8	GPMT090304-U	TS3	①TKY08F
	3	TAFM2500F32	●	2	85	100	155	32	42	PT1/8	GPMT090304-U	TS3	①TKY08F
	4	TAFL2500F32	●	2	110	125	180	32	42	PT1/8	GPMT090304-U	TS3	①TKY08F
25.5	2	TAFS2550F32	●	2	60	75	130	32	42	PT1/8	GPMT090304-U	TS3	①TKY08F
	3	TAFM2550F32	●	2	85	100	155	32	42	PT1/8	GPMT090304-U	TS3	①TKY08F
26.0	2	TAFS2600F32	●	2	62	77	132	32	42	PT1/8	GPMT090304-U	TS3	①TKY08F
	3	TAFM2600F32	●	2	88	103	158	32	42	PT1/8	GPMT090304-U	TS3	①TKY08F
	4	TAFL2600F32	●	2	114	129	184	32	42	PT1/8	GPMT090304-U	TS3	①TKY08F
26.5	2	TAFS2650F32	●	2	62	77	132	32	42	PT1/8	GPMT090304-U	TS3	①TKY08F
	3	TAFM2650F32	●	2	88	103	158	32	42	PT1/8	GPMT090304-U	TS3	①TKY08F
27.0	2	TAFS2700F32	●	2	65	79	134	32	42	PT1/8	GPMT090304-U	TS3	①TKY08F
	3	TAFM2700F32	●	2	92	106	161	32	42	PT1/8	GPMT090304-U	TS3	①TKY08F
	4	TAFL2700F32	●	2	119	133	188	32	42	PT1/8	GPMT090304-U	TS3	①TKY08F
27.5	2	TAFS2750F32	●	2	65	79	134	32	42	PT1/8	GPMT090304-U	TS3	①TKY08F
	3	TAFM2750F32	●	2	92	106	161	32	42	PT1/8	GPMT090304-U	TS3	①TKY08F
28.0	2	TAFS2800F32	●	2	67	81	136	32	42	PT1/8	GPMT11T308-U	TS4	②TKY15D
	3	TAFM2800F32	●	2	95	109	164	32	42	PT1/8	GPMT11T308-U	TS4	②TKY15D
	4	TAFL2800F32	●	2	123	137	192	32	42	PT1/8	GPMT11T308-U	TS4	②TKY15D

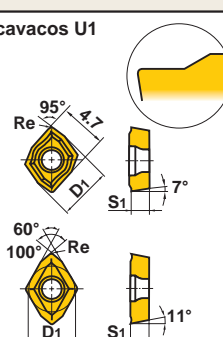
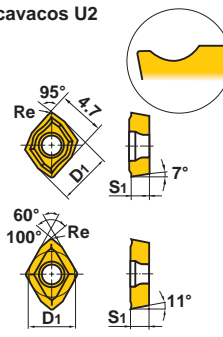
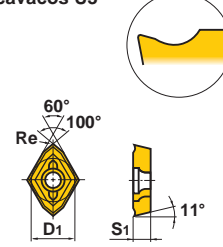
● : Estoque mantido.

Diâm. da Broca D1 (mm)	Prof. do Furo (l/d)	Referência para Pedido	Estoque	Número de Dentes	Dimensões (mm)						Referência do Inserto		
					Compr. efetivo do canal	Compr. do Corpo	Comp. Total	Diâm. da Haste	Diâmetro do flange	Furo de refrigeração			
					L3	L2	L1	D4	D7	D8			
28.5	2	TAFS2850F32	●	2	67	81	136	32	42	PT1/8	GPMT11T308-U	TS4	TKY15D
	3	TAFM2850F32	●	2	95	109	164	32	42	PT1/8	GPMT11T308-U	TS4	TKY15D
29.0	2	TAFS2900F32	●	2	70	83	138	32	42	PT1/8	GPMT11T308-U	TS4	TKY15D
	3	TAFM2900F32	●	2	99	112	167	32	42	PT1/8	GPMT11T308-U	TS4	TKY15D
	4	TAFM2900F32	●	2	128	141	196	32	42	PT1/8	GPMT11T308-U	TS4	TKY15D
29.5	2	TAFS2950F32	●	2	70	83	138	32	42	PT1/8	GPMT11T308-U	TS4	TKY15D
	3	TAFM2950F32	●	2	99	112	167	32	42	PT1/8	GPMT11T308-U	TS4	TKY15D
30.0	2	TAFS3000F40	●	2	72	90	155	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
	3	TAFM3000F40	●	2	102	120	185	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
	4	TAFM3000F40	●	2	132	150	215	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
31.0	2	TAFS3100F40	●	2	74	92	157	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
	3	TAFM3100F40	●	2	105	123	188	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
	4	TAFM3100F40	●	2	136	154	219	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
32.0	2	TAFS3200F40	●	2	77	94	159	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
	3	TAFM3200F40	●	2	109	126	191	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
	4	TAFM3200F40	●	2	141	158	223	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
33.0	2	TAFS3300F40	●	2	79	96	161	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
	3	TAFM3300F40	●	2	112	129	194	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
	4	TAFM3300F40	●	2	145	162	227	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
34.0	2	TAFS3400F40	●	2	82	98	163	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
	3	TAFM3400F40	●	2	116	132	197	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
	4	TAFM3400F40	●	2	150	166	231	40	50	PT1/4	GPMT11T308-U	TS4	TKY15D
35.0	2	TAFS3500F40	●	2	84	100	165	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
	3	TAFM3500F40	●	2	119	135	200	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
36.0	2	TAFS3600F40	●	2	86	102	167	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
	3	TAFM3600F40	●	2	122	138	203	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
37.0	2	TAFS3700F40	●	2	89	104	169	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
	3	TAFM3700F40	●	2	126	141	206	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
38.0	2	TAFS3800F40	●	2	91	106	171	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
	3	TAFM3800F40	●	2	129	144	209	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
39.0	2	TAFS3900F40	●	2	94	108	173	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
	3	TAFM3900F40	●	2	133	147	212	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
40.0	2	TAFS4000F40	●	2	96	110	175	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
	3	TAFM4000F40	●	2	136	150	215	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
41.0	2	TAFS4100F40	●	2	98	112	177	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
	3	TAFM4100F40	●	2	139	153	218	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
42.0	2	TAFS4200F40	●	2	101	114	179	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
	3	TAFM4200F40	●	2	143	156	221	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
43.0	2	TAFS4300F40	●	2	103	116	181	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
	3	TAFM4300F40	●	2	146	159	224	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
44.0	2	TAFS4400F40	●	2	106	118	183	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
	3	TAFM4400F40	●	2	150	162	227	40	50	PT1/4	GPMT140408-U	TS55	TKY25D
45.0	2	TAFS4500F40	●	2	108	120	185	40	54	PT1/4	GPMT140408-U	TS55	TKY25D
	3	TAFM4500F40	●	2	153	165	230	40	54	PT1/4	GPMT140408-U	TS55	TKY25D
46.0	2	TAFS4600F40	●	2	110	122	187	40	54	PT1/4	GPMT140408-U	TS55	TKY25D
	3	TAFM4600F40	●	2	156	168	233	40	54	PT1/4	GPMT140408-U	TS55	TKY25D
47.0	2	TAFS4700F40	●	2	113	124	189	40	54	PT1/4	GPMT140408-U	TS55	TKY25D
	3	TAFM4700F40	●	2	160	171	236	40	54	PT1/4	GPMT140408-U	TS55	TKY25D
48.0	2	TAFS4800F40	●	2	115	126	191	40	54	PT1/4	GPMT140408-U	TS55	TKY25D
	3	TAFM4800F40	●	2	163	174	239	40	54	PT1/4	GPMT140408-U	TS55	TKY25D

Diâm. da Broca D1 (mm)	Prof. do Furo (l/d)	Referência para Pedido	Estoque	Número de Dentes	Dimensões (mm)						Referência do Inserto		
					Compr. efetivo do canal	Compr. do Corpo	Comp. Total	Diâm. da Haste	Diâmetro do flange	Furo de refrigeração			
					L3	L2	L1	D4	D7	D8			
49.0	2	TAFS4900F40	●	4	118	133	198	40	58	PT1/4	GPMT090304-U	TS3	TKY08F
	3	TAFM4900F40	●	4	167	182	247	40	58	PT1/4	GPMT090304-U	TS3	TKY08F
50.0	2	TAFS5000F40	●	4	120	135	200	40	58	PT1/4	GPMT090304-U	TS3	TKY08F
	3	TAFM5000F40	●	4	170	185	250	40	58	PT1/4	GPMT090304-U	TS3	TKY08F
51.0	2	TAFS5100F40	●	4	122	137	202	40	58	PT1/4	GPMT090304-U	TS3	TKY08F
	3	TAFM5100F40	●	4	173	188	253	40	58	PT1/4	GPMT090304-U	TS3	TKY08F
52.0	2	TAFS5200F40	●	4	125	139	204	40	58	PT1/4	GPMT090304-U	TS3	TKY08F
	3	TAFM5200F40	●	4	177	191	256	40	58	PT1/4	GPMT090304-U	TS3	TKY08F
53.0	2	TAFS5300F40	●	4	127	141	206	40	63	PT1/4	GPMT090304-U	TS3	TKY08F
	3	TAFM5300F40	●	4	180	194	259	40	63	PT1/4	GPMT090304-U	TS3	TKY08F
54.0	2	TAFS5400F40	●	4	128	143	208	40	63	PT1/4	GPMT090304-U	TS3	TKY08F
	3	TAFM5400F40	●	4	182	197	262	40	63	PT1/4	GPMT090304-U	TS3	TKY08F
55.0	2	TAFS5500F40	●	4	130	145	210	40	63	PT1/4	GPMT090304-U	TS3	TKY08F
	3	TAFM5500F40	●	4	185	200	265	40	63	PT1/4	GPMT090304-U	TS3	TKY08F
56.0	2	TAFS5600F40	●	4	132	147	212	40	63	PT1/4	GPMT090304-U	TS3	TKY08F
	3	TAFM5600F40	●	4	188	203	268	40	63	PT1/4	GPMT090304-U	TS3	TKY08F

● : Estoque mantido. (Nota: 10 insertos por embalagem)

INSERTOS

Geometria	Diâm. da Broca	Referência do Inserto	Dimensões (mm)			Estoque				
			D ₁	S ₁	Re	VP15TF	UP20M	GP20M	UE6020	US735
Quebra-cavacos U1 	ø12-ø14.5	GCMT040204-U1	5.0	2.38	0.4		●			
	ø15-ø17.5	GPMT060204-U1	5.56	2.38	0.4		●		●	
	ø18-ø22.5	GPMT070204-U1	6.35	2.38	0.4		●		●	
	ø23-ø27.5 ø49-ø56	GPMT090304-U1	7.94	3.18	0.4		●		●	
	ø28-ø34	GPMT11T308-U1	9.525	3.97	0.8		●		●	
	ø35-ø48	GPMT140408-U1	12.70	4.76	0.8		●		●	
Quebra-cavacos U2 	ø12-ø14.5	GCMT040204-U2	5.0	2.38	0.4	●		●		
	ø15-ø17.5	GPMT060204-U2	5.56	2.38	0.4	●	●		●	●
	ø18-ø22.5	GPMT070204-U2	6.35	2.38	0.4	●	●		●	●
	ø23-ø27.5 ø49-ø56	GPMT090304-U2	7.94	3.18	0.4	●	●		●	●
	ø28-ø34	GPMT11T308-U2	9.525	3.97	0.8	●	●		●	●
	ø35-ø48	GPMT140408-U2	12.70	4.76	0.8	●	●		●	●
Quebra-cavacos U3 	ø15-ø17.5	GPMT060204-U3	5.56	2.38	0.4		●		●	●
	ø18-ø22.5	GPMT070204-U3	6.35	2.38	0.4		●		●	●
	ø23-ø27.5 ø49-ø56	GPMT090304-U3	7.94	3.18	0.4		●		●	●
	ø28-ø34	GPMT11T308-U3	9.525	3.97	0.8		●		●	●
	ø35-ø48	GPMT140408-U3	12.70	4.76	0.8		●		●	●

RECOMENDAÇÃO DE INSERTO

RECOMENDAÇÃO DE QUEBRA-CAVACOS

◎ : 1ª Recomendação ○ : 2ª Recomendação

Material	P						M		K			
	Aço Baixo Carbono		Aço Carbono		Aço Liga		Aço Inoxidável		Ferro Fundido Cinzento		Ferro Fundido Nodular	
	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT
U1	◎	◎	○	○	○	○	○	○	○	○	○	○
U2	○	○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
U3		○			○	○				○		○

RECOMENDAÇÃO DE CLASSE

◎ : 1ª Recomendação ○ : 2ª Recomendação

Work Material	P						M		K			
	Aço Baixo Carbono		Aço Carbono		Aço Liga		Aço Inoxidável		Ferro Fundido Cinzento		Ferro Fundido Nodular	
	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT	GCMT	GPMT
VP15TF		○	◎	◎	◎	◎	◎	◎	◎	◎	◎	◎
UP20M	◎	◎	○	○	○	○	○	○	○	○	○	○
GP20M	○		○		○		○		○		○	
UE6020		○		○		○			○		○	
US735		○		○		○			○		○	

CONDIÇÕES DE CORTE > N222
 UTILIZAÇÃO > N225
 INFORMAÇÕES TÉCNICAS > Q001

N221

CONDIÇÕES DE CORTE RECOMENDADAS

Material	Dureza	Vel. de Corte (m/min)			Quebra-cavacos	Avanço (mm/rot)					
		Para l/d=2,3		Para l/d=4		Diâm. da Broca (mm)					
		($\phi 12-\phi 14.5$)	($\phi 15-$)	($\phi 16-$)		$\phi 12-\phi 14.5$	$\phi 15-\phi 22.5$	$\phi 23-\phi 34$	$\phi 35-\phi 48$	$\phi 49-\phi 56$	
P	Aço Médio	$\leq 180\text{HB}$	150 (100-200)	200 (150-300)	140 (100-200)	U1	0.06 (0.04-0.10)	0.07 (0.04-0.10)	0.08 (0.04-0.10)	0.10 (0.04-0.12)	0.08 (0.04-0.10)
						U2	0.06 (0.04-0.10)	0.08 (0.04-0.12)	0.10 (0.04-0.12)	0.12 (0.04-0.14)	0.10 (0.04-0.12)
						U3	-	0.08 (0.04-0.12)	0.10 (0.04-0.12)	0.12 (0.04-0.14)	0.10 (0.04-0.12)
	Aço Carbono	180-280HB	120 (80-160)	150 (120-180)	100 (80-120)	U1	0.06 (0.04-0.10)	0.09 (0.06-0.12)	0.12 (0.08-0.14)	0.15 (0.08-0.18)	0.12 (0.08-0.14)
						U2	0.06 (0.04-0.10)	0.12 (0.06-0.14)	0.14 (0.08-0.18)	0.17 (0.08-0.20)	0.14 (0.08-0.18)
						U3	-	0.12 (0.06-0.14)	0.14 (0.08-0.18)	0.17 (0.08-0.20)	0.14 (0.08-0.18)
	Aço Liga	180-280HB	120 (80-160)	150 (120-180)	100 (80-120)	U1	0.06 (0.04-0.10)	0.08 (0.06-0.10)	0.09 (0.06-0.12)	0.11 (0.06-0.14)	0.09 (0.06-0.12)
						U2	0.06 (0.04-0.10)	0.10 (0.06-0.12)	0.12 (0.08-0.16)	0.14 (0.08-0.18)	0.12 (0.08-0.16)
						U3	-	0.10 (0.06-0.12)	0.12 (0.08-0.16)	0.14 (0.08-0.18)	0.12 (0.08-0.16)
M	Aço Inoxidável	$\leq 200\text{HB}$	100 (80-120)	150 (120-200)	110 (80-140)	U1	0.07 (0.04-0.10)	0.07 (0.04-0.10)	0.08 (0.04-0.10)	0.10 (0.04-0.12)	0.08 (0.04-0.10)
						U2	0.07 (0.04-0.10)	0.08 (0.04-0.12)	0.10 (0.04-0.14)	0.12 (0.04-0.16)	0.10 (0.04-0.14)
						U3	-	0.08 (0.04-0.12)	0.10 (0.04-0.14)	0.12 (0.04-0.16)	0.10 (0.04-0.14)
K	Ferro Fundido Cinzento	Resistência à Tração $\leq 350\text{MPa}$	120 (80-160)	150 (120-180)	140 (110-160)	U1	0.07 (0.06-0.10)	0.07 (0.06-0.10)	0.10 (0.04-0.14)	0.10 (0.06-0.14)	0.10 (0.06-0.14)
						U2	0.07 (0.06-0.10)	0.15 (0.10-0.18)	0.20 (0.10-0.25)	0.20 (0.10-0.25)	0.20 (0.10-0.25)
						U3	-	0.15 (0.10-0.18)	0.20 (0.10-0.25)	0.20 (0.10-0.25)	0.20 (0.10-0.25)
	Ferro Fundido Nodular	Resistência à Tração $\leq 450\text{MPa}$	120 (80-150)	150 (120-180)	100 (80-120)	U1	0.06 (0.04-0.10)	0.07 (0.06-0.10)	0.10 (0.06-0.14)	0.10 (0.06-0.14)	0.10 (0.06-0.14)
						U2	0.06 (0.04-0.10)	0.12 (0.08-0.14)	0.15 (0.08-0.20)	0.18 (0.08-0.20)	0.15 (0.08-0.20)
						U3	-	0.12 (0.08-0.14)	0.15 (0.08-0.20)	0.18 (0.08-0.20)	0.15 (0.08-0.20)

(Nota) Quando utilizar brocas para l/d = 4, o avanço deve ser reduzido para 80% das recomendações acima.

RESISTÊNCIA DE CORTE

Material : SCM440(220HB) Velocidade de Corte : 150m/min Inserto : Quebra-cavacos U2

