AMS **ARNO®-Mini-System**	*AMS* *ARNO®-Mini-System*	AMS ARNO®-Mini-System	
Innenbearbeitungssystem	*Internal machining system*	Sistema di lavorazione interna	
• **Systemvorstellung**	• *Introduction*	• Caratteristiche del sistema	446 – 447
• **Klemmhalter**	• *Holders*	• Adattatori	448 – 467
– **Werkzeugauswahl**	– *Tool shank options*	– Tipologie di corpo utensile	448 – 453
– **Bezeichnungssystem**	– *Designation system*	– Sistema di identificazione	454
– **Klemmhalter**	– *Holders*	– Adattatori	455 – 467
• **Schneideinsätze**	• *Inserts*	• Inserti	470 – 522
– **Sortenbeschreibung**	– *Grade description*	– Descrizione delle Qualità	470 – 472
– **Schneideinsätze**	– *Inserts*	– Inserti	473 – 512
• **Ersatzteile und Zubehör**	• *Spare parts and accessories*	• Ricambi e accessori	516
• **Schnittwerte**	• *Cutting data*	• Parametri di taglio	517 – 520
• **Anwendungshinweise**	• *Application reference*	• Suggerimenti tecnici	521 – 522

ARNO®-Mini-System
Durchmesser ab 0,7 mm, Bohrtiefe bis 50 mm

ARNO® Mini-System
Diameter from 0.7 mm, depth up to 50 mm

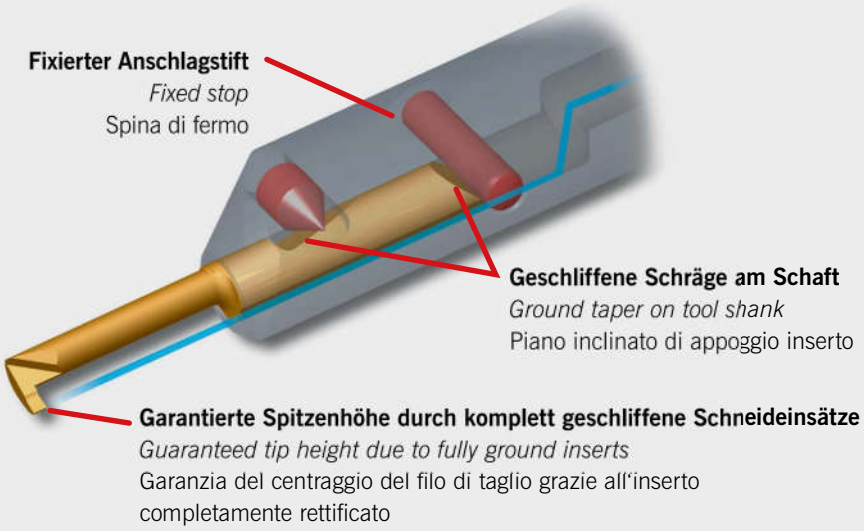
ARNO® Mini-System
Diametri da 0,7 mm, profondità
del foro massima fino a 50 mm

Systemvorstellung

AMS ist ein modulares System zur flexiblen Bohrungsbearbeitung ab Durchmesser 0,7 mm mit maximaler Bohrungstiefe bis zu 50 mm (abhängig von der Bearbeitung). Durch die geschliffene Schräge am Schaft des Schneideinsatzes und den fixierten Anschlagstift im Halter wird eine exakte Bestimmung der Länge sowie eine garantierte Wiederholgenauigkeit der Spitzenhöhe erreicht. Der Kegel des Gewindestiftes ermöglicht eine sichere Spannung und reduziert somit die auftretenden Schwingungen im Schneidenbereich. Das Ergebnis ist maximale Stabilität für prozesssichere Bohrungsbearbeitung.

Fakten

- **Bohrungen Ausdrehen ab Durchmesser 0,7 mm**
- **Einstechen ab Breite 0,8 mm**
- **Radieneinstich ab R 0,5 mm**
- **Rückwärtsdrehen und Fasen**
- **Vorstechen und Fasen**
- **Zentrum Fasen**
- **Kopieren**
- **Gewindedrehen ab M3**
- **Axial-Stechen ab Durchmesser 5 mm**
- **Seegering DIN 471/472**



Introduction

AMS is a modular boring system starting at D_{min} 0.7 mm with a maximum reach of 50 mm (depending on application). With the ground taper on the tool shank and the fixed stop in the sleeve the length remains accurately constant and guaranteed cutting edge repeatability is achieved. The cone of the threaded pin ensures secure tool locking and reduces cutting edge vibrations.

Features

- *Boring from diameter 0.7 mm*
- *Groove width starting at 0.8 mm*
- *Full radius grooving starting at R 0.5 mm*
- *Back turning and chamfering*
- *Pre-grooving and chamfering*
- *Centre chamfering*
- *Copying*
- *Threading from M3*
- *Face grooving starting at Ø 5 mm*
- *Cir-clip DIN 471/472*

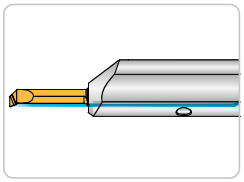
Descrizione

AMS è un sistema modulare per una lavorazione flessibile da diametri di 0,7 mm con profondità del foro massima fino a 50 mm (in base alla lavorazione). Il gambo rettificato ed il piano di fermo garantiscono perfetta ripetibilità di posizione ed altezza del filo di taglio. Il metodo di bloccaggio garantisce un bloccaggio sicuro e privo di vibrazioni.

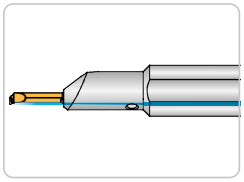
Caratteristiche

- Lavorazione fori da diametro 0,7 mm
- Gole da larghezza 0,8 mm
- Raggio da R 0,5 mm
- Pre-scanalatura e smusso
- Lavorazione in tirata
- Smussatura centrale
- Copiatura
- Filettatura da M3
- Gole assiali da diametro 5 mm
- Sedi Seeger DIN 471/472

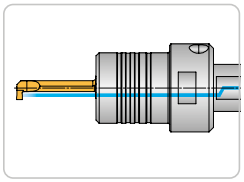
Übersicht Klemmhalter und Schneideinsätze / *Program overview holders and inserts* / Gamma prodotti adattatori e inserti



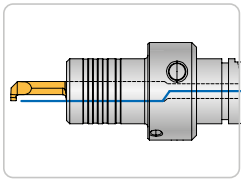
Klemmhalter – Standard
Holder – Standard
Stelo – Standard
Seite/page/pagina **455** / Schneideinsätze Seite/Inserts page/Inserti pagina **473 – 501**



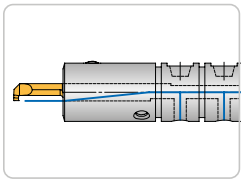
Klemmhalter – Abgesetzt
Holder – Off-set
Stelo – Off-Set
Seite/page/pagina **456** / Schneideinsätze Seite/Inserts page/Inserti pagina **473 – 501**



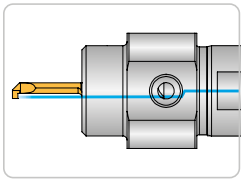
Hydro-Dehn Klemmhalter
Hydraulic Holder
Adattatore idraulici
Seite/page/pagina **457** / Schneideinsätze Seite/Inserts page/Inserti pagina **473 – 501**



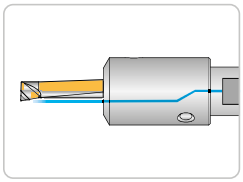
Hydro-Dehn Klemmhalter für Index/Traub - Drehmaschinen /
Hydraulic Holder for Index/traub - Holders for lathes / Adattatore idraulici per Index/Traub - Adattatori per torni
Seite/page/pagina **458** / Schneideinsätze Seite/Inserts page/Inserti pagina **473 – 501**



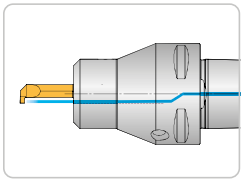
Klemmhalter für Index/Traub – Drehmaschinen
Holder for Index/Traub - Holders for lathes
Steli per Index/Traub - Adattatori per torni
Seite/page/pagina **459** / Schneideinsätze Seite/Inserts page/Inserti pagina **473 – 501**



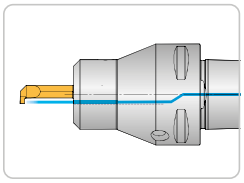
Klemmhalter für STAR-Drehmaschinen
Holders for STAR – lathes
Utensile di finitura per torni STAR
Seite/page/pagina **460 – 461** / Schneideinsätze Seite/Inserts page/Inserti pagina **473 – 501**



Klemmhalter zum Ausspindeln
Holders for finishing
Adattatori corti per contromandrino
Seite/page/pagina **464** / Schneideinsätze Seite/Inserts page/Inserti pagina **473 – 501**

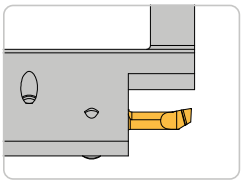


Klemmhalter mit Polygonschaft
Holders with Polygon-Shank
Adattatori con attacco poligonale
Seite/page/pagina **465** / Schneideinsätze Seite/Inserts page/Inserti pagina **473 – 501**

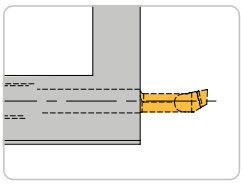


Klemmhalter mit Polygonschaft
Holders with Polygon-Shank
Adattatori con attacco poligonale
Seite/page/pagina **465** / Schneideinsätze Seite/Inserts page/Inserti pagina **473 – 501**

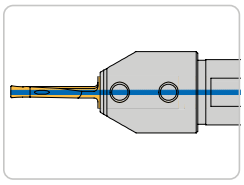
Übersicht Klemmhalter und Schneideinsätze / *Program overview holders and inserts* / Gamma prodotti adattatori e inserti



Klemmhalter für Langdrehmaschinen und Mehrspindler
Adattatori per fantina mobile e plurimandrino
Holders for sliding head auto lathes and multi spindle machines
Seite/page/pagina **466** / Schneideinsätze Seite/Inserts page/Inserti pagina **473 – 501**

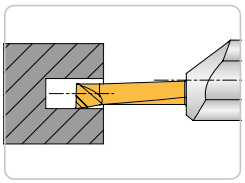


Klemmhalter für Langdrehmaschinen an Gegenspindel
Holder for sliding head lathes on counter spindle
Adattori per torni a fantina mobile su contromandrino
Seite/page/pagina **467** / Schneideinsätze Seite/Inserts page/Inserti pagina **473 – 501**

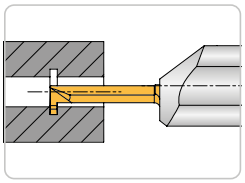


Klemmhalter SAV - Axial Stechen
Holder SAV – Axial grooving
Adattatori SAV – Scanalatura assiale
Seite/page/pagina **468** / Schneideinsätze Seite/Inserts page/Inserti pagina **511 – 512**

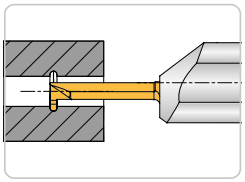
Schneideinsätze / *Inserts* / Inserti



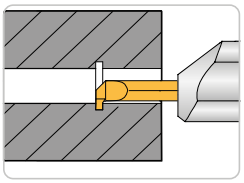
Drehen
Turning
Barenatura
Seite/page/pagina **473 – 474** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**



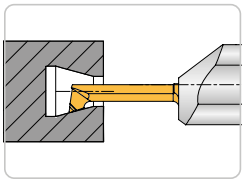
Stechen
Grooving
Scanalatura
Seite/page/pagina **475** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**



Radius-Einstich
Radius grooving
Profilo a raggio pieno
Seite/page/pagina **476** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**

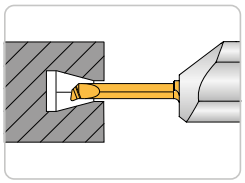


Seegering DIN 471/472
Cir-clip DIN 471/472
Sedi seeger DIN 471/472
Seite/page/pagina **477** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**

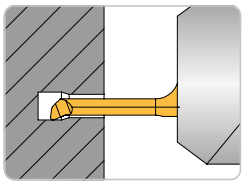


Kopieren
Copying
Copiatura
Seite/page/pagina **479** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**

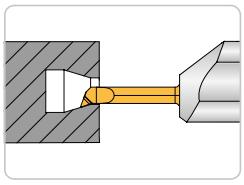
Übersicht Schneideinsätze / *Program overview inserts* / Gamma prodottiinserti



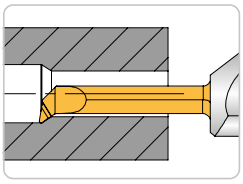
Kopieren – verstärkte Ausführung
Copying – Re-inforced execution
Copiatura – Versione rinforzata
Seite/page/pagina **482** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**



Kopieren - versetzte und verstärkte Ausführung
Copying - offset and reinforced version
Copiatura - versione disassata e rinforzata
Seite/page/pagina **483** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**



Kopieren 20/20° / *Copying 20/20°* / Copiatura 20/20°
Copying 32°
Copiatura 32°
Seite/page/pagina **484** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**



Kopieren 32°
Copying 32°
Copiatura 32°
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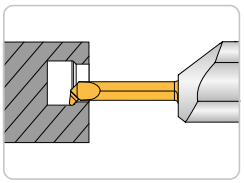
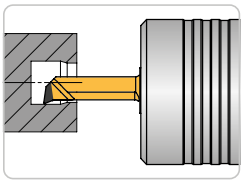
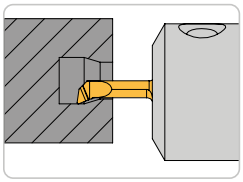


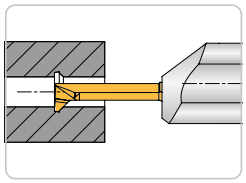
Kopieren 45°
Copying 45°
Copiatura 45°
Seite/page/pagina **486** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**



Kopieren – CBN bestückt
Copy turning – CBN brazed
Copiatura – riporto CBN
Seite/page/pagina **487** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**

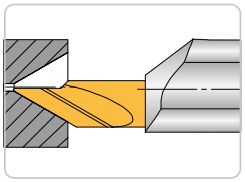


Kopieren -US
Pre-grooving and chamfering
Pre-scanalatura e smusso
Seite/page/pagina **488** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**

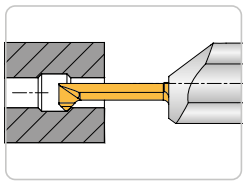


Vorstechen und Fasen
Pre-grooving and chamfering
Pre-scanalatura e smusso
Seite/page/pagina **489** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**

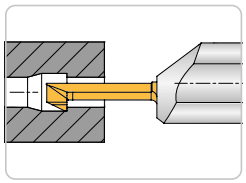
Übersicht Schneideinsätze / *Program overview inserts* / Gamma prodottiinserti



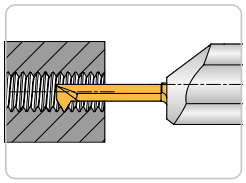
Zentrum Fasen 45°/60°
Centre chamfering 45°/60°
Smussatura centrale 45°/60°
Seite/page/pagina **490** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**



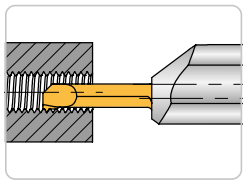
Fasen 45°
Chamfering 45°
Smusso 45°
Seite/page/pagina **491** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**



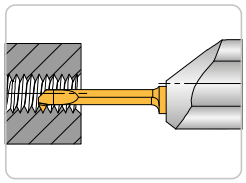
Rückwärtsdrehen
Back turning
Lavorazione in tirata
Seite/page/pagina **492** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**



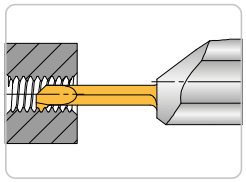
Gewinde 60° – Metrisch-Teilprofil
Threading 60° – Metric partial profile
Filettatura 60° – Metrica profilo parziale
Seite/page/pagina **493** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**



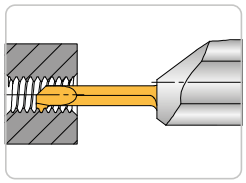
Gewinde 60° – Metrisch-Vollprofil
Threading 60° – Metric full profile
Filettatura 60° – Metrica profilo completo
Seite/page/pagina **494** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**



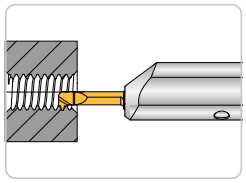
Whitworth Gewinde 55° – Teilprofil
Whitworth thread 55° – Partial profile
Filettatura Whitworth 55° – Profilo parziale
Seite/page/pagina **495** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**



Whitworth Rohrgewinde 55° DIN-ISO 228 – Vollprofil
Whitworth pipe thread 55° DIN ISO 228 – Full profile
Filettatura Whitworth 55° DIN ISO 228 – Profilo completo
Seite/page/pagina **496** / Klemmhalter Seite/Inserts page/Inserti pagina **455 – 467**

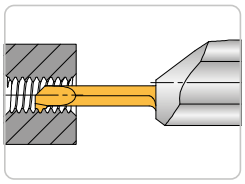


Whitworth Rohrgewinde 55° BSW – Vollprofil
Whitworth pipe thread 55° BSW – Full profile
Filettatura Whitworth 55° BSW – Profilo completo
Seite/page/pagina **497** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**

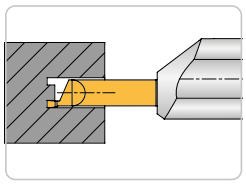


Trapezgewinde 30° DIN-ISO 103 – Teilprofil
Trapezoidal 30° DIN ISO 103 – Partial profile
Filettatura Trapezoidale 30° DIN ISO 103 – Profilo parziale
Seite/page/pagina **498** / Klemmhalter Seite/Inserts page/Inserti pagina **455 – 467**

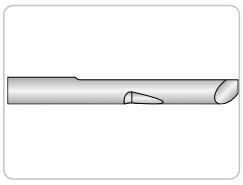
Übersicht Schneideinsätze / *Program overview inserts* / Gamma prodottiinserti



Amerikanisches ISO-Zollgewinde 60° UN – Vollprofil
American standard thread 60° UN – full profile
Filettatura Americana standard 60° UN – Profilo completo
Seite/page/pagina **499** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**

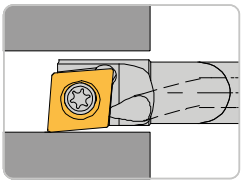


Axial-Stechen
Axial grooving
Scanalatura assiale
Seite/page/pagina **500** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**

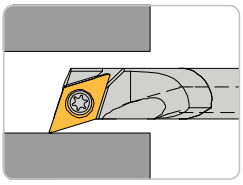


Halbzeuge zur Eigenprofilierung
Blanks for special profiles
Semilavorato per la realizzazione di speciali
Seite/page/pagina **501** / Klemmhalter Seite/Holders page/Adattatori pagina **455 – 467**

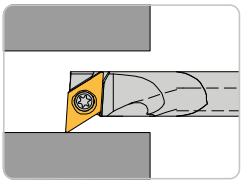
AMS-Bohrstangen - mit innerer Kühlmittelzufuhr / *AMS boring bar - with through tool coolant* / Bareno AMS - con adduzione interna del refrigerante



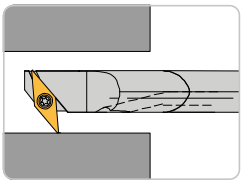
SCLD L/R
Anstellwinkel 95° / Approach angle 95° / Angolo di attacco 95°
Seite/page/pagina **502**



SDQC L/R
Anstellwinkel 107,5° / Approach angle 107,5° / Angolo di attacco *107,5°*
Seite/page/pagina **503**

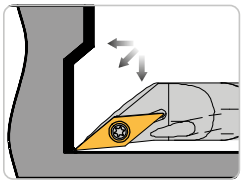


SDUC L/R
Anstellwinkel 93° / Approach angle 93° / Angolo di attacco 93°
Seite/page/pagina **504**

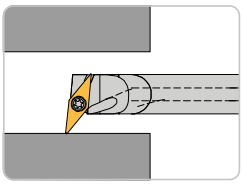


SV95C L/R
Anstellwinkel 95° / Approach angle 95° / Angolo di attacco 95°
Seite/page/pagina **505**

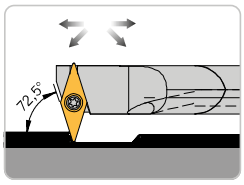
Übersicht Klemmhalter und Schneideinsätze / *Program overview holders and inserts* / Gamma prodotti adattatori e inserti



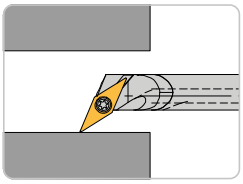
SVJC L/R
Anstellwinkel 52° / Approach angle 52° / Angolo di attacco 52°
Seite/page/pagina **506**



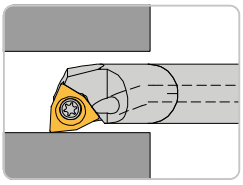
SVLC L/R
Anstellwinkel 95° / Approach angle 95° / Angolo di attacco 95°
Seite/page/pagina **507**



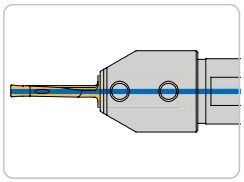
SVVC L/R
Anstellwinkel 72,5° / Approach angle 72,5° /
Angolo di attacco 72,5°
Seite/page/pagina **508**



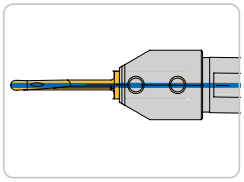
SVXC L/R
Anstellwinkel 113° / Approach angle 113° / Angolo di attacco 113°
Seite/page/pagina **509**



SWUC L/R
Anstellwinkel 93° / Approach angle 93° / Angolo di attacco 93°
Seite/page/pagina **510**



SAV – Axial-Stechen
SAV – Axial grooving
SAV – Scanalatura assiale
Seite/page/pagina **511** / Klemmhalter Seite/Holders page/Adattatori pagina **468**



SAV – Axial Stechen - Vollradiusausführung
SAV – Axial grooving - Full radius execution
SAV – Scanalatura assiale - Esecuzione a raggio completo
Seite/page/pagina **512** / Klemmhalter Seite/Holders page/Adattatori pagina **468**

ARNO® SpecialDesign

Anfrage Sonderwerkzeuge Seite/Request Special products page/Richiesta utensili speciali pagina **513 – 515**

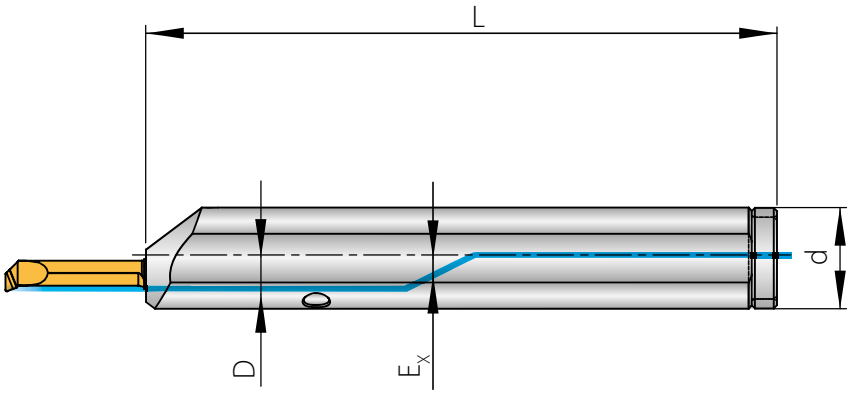
Klemmhalter / *Holders* / Adattatori

HAMS	16	06	R/L
H = Halter *Sleeve* Stelo	**Schaftdurchmesser 16 mm**	**Schneideinsatzdurchmesser 6 mm**	**Ausführung** **R = Rechts** **L = Links**
A = ARNO®	*Shank diameter 16 mm*	*Inserts shank diameter 6 mm*	*Version* *R = Right-hand* *L = Left-hand*
M = Mini	Diametro gambo 16 mm	Diametro foro inserto 6 mm	Versione R = Destro L = Sinistro
S = Stechen *Grooving* Scanalatura			

Schneideinsätze / *Inserts* / Inserti

AMS	D	25	08	06	01	100	40R
A = ARNO®	**D = Drehen** / *Turning* / Tornitura	**D_{min} = 2,5 mm**	**Einstechbreite EB = 0,8 mm**	**Einstechtiefe ET = 0,6 mm**	**Radius R = 0,1 mm**	**Auskraglänge AKL = 10 mm**	**Schaftdurchmesser 4 mm**
M = Mini			*Groove width EB = 0.8 mm*	*Groove depth ET = 0.6 mm*	*Radius R = 0.1 mm*	*Maximum work length AKL = 10 mm*	*Shank diameter 4 mm*
S = Stechen *Grooving* Scanalatura			Larghezza gola EB = 0,8 mm	Profondità gola ET = 0,6 mm	Raggio di punta R = 0,1 mm	*Utile di lavoro AKL = 10 mm*	Diametro gambo 4 mm
							Ausführung **R = Rechts** **L = Links**
							Version *R = Right-hand* *L = Left-hand*
							Versione R = Destro L = Sinistro

Klemmhalter - Standard / *Holder - Standard* / Stelo - Standard



516 – 522

Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

Trägerwerkzeuge / *Holders* / Utensili

Bezeichnung *Designation* Articolo	**D**	**d**	**L**	**E_x**	**Schneideinsatz** *Insert* Inserto
HAMS 1204L/R	4	12	100	2,35	AMS...40L/R
HAMS 1206L/R	6	12	100	2,35	AMS...60L/R
HAMS 1606L/R	6	16	120	2,80	AMS...60L/R
HAMS 1608L/R	8	16	120	2,80	AMS...80L/R
HAMS 2010R	10	20	120	2,80	AMS...100R

Hinweis: Auf diese Halter passen alle Schneideinsätze von den Seiten 473 bis 501. Maß „D“ beachten!
Remark: The inserts for these holders you will find on pages 473 to 501. Note measurement “D”!
Nota: Inserti per questi adattatori a pagg da 473 a 501. Fare attenzione alla misura “D”!

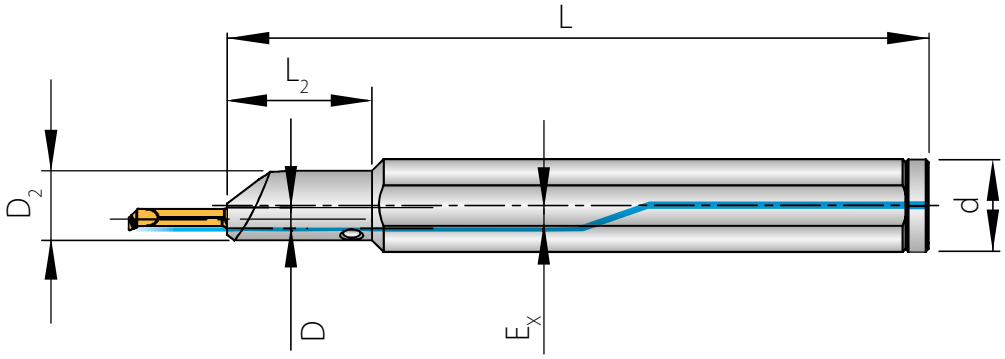
Ersatzteile / *Spare Parts* / Ricambi

Trägerwerkzeug *Holder* Utensile	**Schraube** *Screw* Vite	**Schlüssel** *Key* Chiave	**Kühlmittelverschlussring** *Coolant seal ring* Anello tenuta refrigerante
HAMS 1204 ..-HAMS 1206 ..	AS 0043	KP3111	KVR 12
HAMS 1606 ..-HAMS 1608 ..	AS 0044	KP1111	KVR 16
HAMS 2010 ..	AS 0044	KP1111	KVR 20

Klemmhalter - Abgesetzt / *Holder - Off-set* / Selo - Scaricato

516 – 522

Abbildung ähnlich
Similar to illustration
Simile all'illustrazione
Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura



Trägerwerkzeuge / *Holders* / Utensili

Bezeichnung *Designation* Articolo	D	D_2	d	L	L_2	E_x	Schneideinsatz *Insert* Inserto
HAMS 1604L/R	4	12	16	120	25	2,35	AMS...40L/R

Hinweis: Auf diese Halter passen alle Schneideinsätze von den Seiten 473 bis 501. Maß „D“ beachten!
Remark: The inserts for these holders you will find on pages 473 to 501. Note measurement “D”!
Nota: Inserti per questi adattatori a pagg da 473 a 501. Fare attenzione alla misura “D”!

Ersatzteile / *Spare Parts* / Ricambi

Trägerwerkzeug *Holder* Utensile	Schraube *Screw* Vite	Schlüssel *Key* Chiave	Kühlmittelverschlussring *Coolant seal ring* Anello tenuta refrigerante
HAMS 1604 ..	AS 0043	KP3111	KVR 16

Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

Hydro-Dehn Klemmhalter / *Hydraulic Holder* / Adattatore idraulici

516 – 522

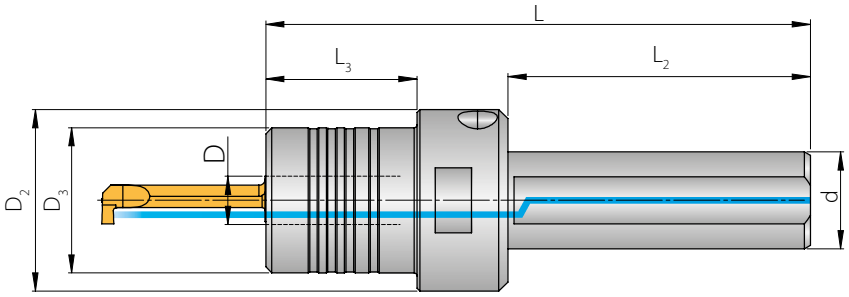


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

d = Schaftdurchmesser [mm]
d = Shank diameter [mm]
d = Diametro accoppiamento [mm]

Trägerwerkzeuge / *Holders* / Utensili

Bezeichnung *Designation* Articolo	**D**	**D_2**	**D_3**	**d**	**L**	**L_2**	**L_3**	**Schneideinsatz** *Insert* Inserto
HAMS 1604R-HYD.	4	30	18	16	82,5	50	18	AMS...40R
HAMS 1606R-HYD.	6	30	20	16	90,0	50	25	AMS...60R
HAMS 1608R-HYD.	8	30	24	16	90,0	50	25	AMS...80R

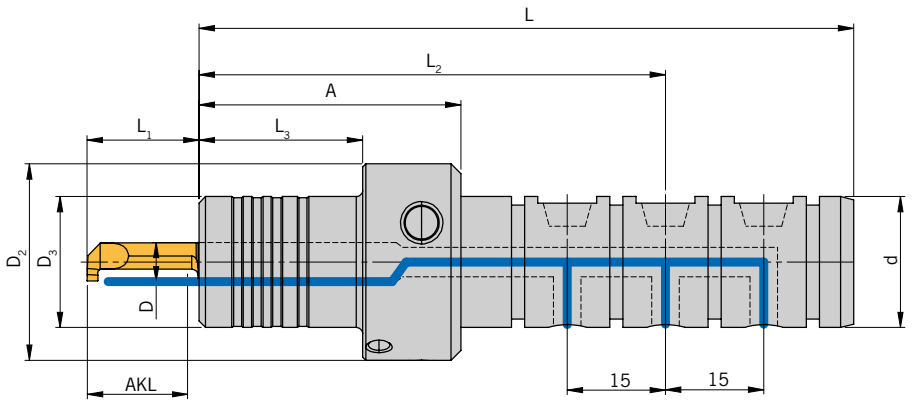
Hinweis: Auf diese Halter passen alle Schneideinsätze von den Seiten 473 bis 501. Maß „D" beachten!
Remark: The inserts for these holders you will find on pages 473 to 501. Note measurement "D"!
Nota: Inserti per questi adattatori a pagg da 473 a 501. Fare attenzione alla misura "D"!

Hydro-Dehn Klemmhalter für INDEX/TRAUB - Drehmaschinen /
Hydraulic Holder for INDEX/TRAUB - Holders for lathes /
Adattatore idraulici per INDEX/TRAUB - Adattatori per torni

516 – 522

AKL = Auskraglänge (mm)
d = Schaftdurchmesser (mm)
AKL = Overhang length (mm)
d = Shank diameter (mm)
AKL = Lunghezza totale (mm)
d = Diametro accoppiamento (mm)

Abbildung ähnlich
Similar to illustration
Simile all'illustrazione



Trägerwerkzeuge / *Holders* / Utensili

Bezeichnung *Designation* Articolo	D	D_2	D_3	d	L	L_2	L_3	A
HAMS 2004-HYD-TNL-TR	4	30	20	20	92,5	63,8	17,5	32,5
HAMS 2006-HYD-TNL-TR	6	30	20	20	100,0	71,3	25,0	40,0
HAMS 2008-HYD-TNL-TR	8	30	20	20	100,0	71,3	25,0	40,0

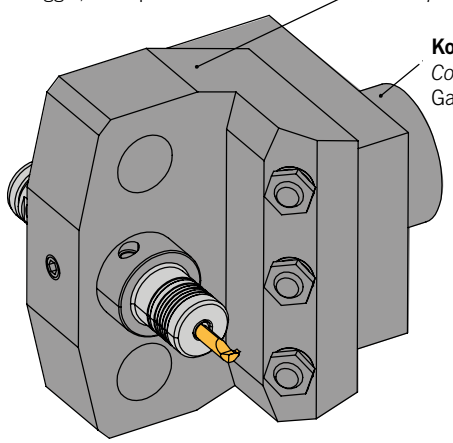
Auskraglänge /
Maximum work length / Utile di lavoro

D	AKL	L_1
4	2,0	4,0
4	5,0	6,5
4	6,0	8,0
4	7,5	10,0
4	10,0	12,0
4	15,0	17,0
4	20,0	22,0
6	10,0	12,0
6	18,0	20,0
6	20,0	22,0
6	30,0	32,0
6	40,0	42,0
6	50,0	52,0
8	10,0	12,0
8	25,0	17,0
8	30,0	32,0
8	42,0	44,0
8	45,0	47,0
8	50,0	52,0

Einbaulage, Beispiel
Assembly options, example
Montaggio, esempio

Beispielaufnahme W7040111
Example basic holder W7040111
Esempio W7040111

Kompaktschaft 45
Compact shank 45
Gambo compatto 45



Ersatzteile / *Spare Parts* / Ricambi

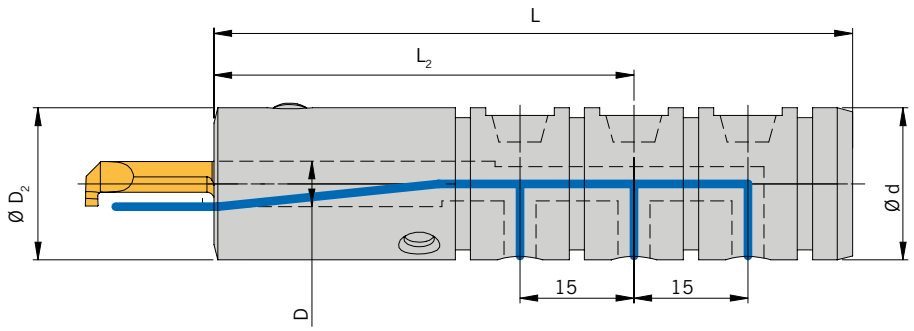
Trägerwerkzeug *Holder* Utensile	Schraube *Screw* Vite	O-Ring *O-ring* O-Ring
HAMS ..-HYD-TNL-TR	1x AS0043, 1x AS0074	4x17x1,5 NBR70

Klemmhalter für INDEX/TRAUB - Drehmaschinen /
Holder for INDEX/TRAUB - Holders for lathes /
Adattatore per INDEX/TRAUB - Adattatori per torni

516 – 522

AKL = Auskraglänge (mm)
d = Schaftdurchmesser (mm)
AKL = Overhang length (mm)
d = Shank diameter (mm)
AKL = Lunghezza totale (mm)
d = Diametro accoppiamento (mm)

Abbildung ähnlich
Similar to illustration
Simile all'illustrazione



Trägerwerkzeuge / *Holders* / Utensili

Bezeichnung *Designation* Articolo	**D**	**D_2**	**d**	**L**	**L_2**
HAMS 2004-TNL-TR	4	20	20	84	55,3
HAMS 2006-TNL-TR	6	20	20	84	55,3
HAMS 2008-TNL-TR	8	20	20	84	55,3

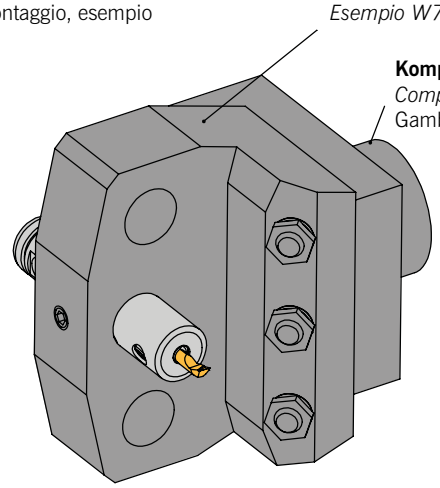
Auskraglänge /
Maximum work length / Utile di lavoro

D	**AKL**	**L_1**
4	2,0	4,0
4	5,0	6,5
4	6,0	8,0
4	7,5	10,0
4	10,0	12,0
4	15,0	17,0
4	20,0	22,0
6	10,0	12,0
6	18,0	20,0
6	20,0	22,0
6	30,0	32,0
6	40,0	42,0
6	50,0	52,0
8	10,0	12,0
8	25,0	17,0
8	30,0	32,0
8	42,0	44,0
8	45,0	47,0
8	50,0	52,0

Einbaulage, Beispiel
Assembly options, example
Montaggio, esempio

Beispielaufnahme W7040111
Example basic holder W7040111
Esempio W7040111

Kompaktschaft 45
Compact shank 45
Gambo compatto 45

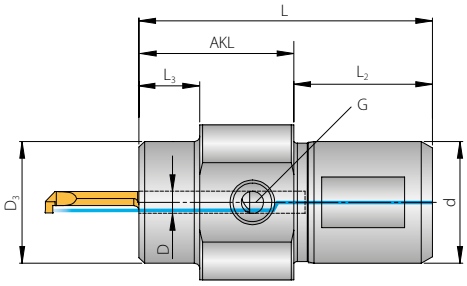


Ersatzteile / *Spare Parts* / Ricambi

Trägerwerkzeug *Holder* Utensile	**Schraube** *Screw* Vite	**Schlüssel** *Key* Chiave
HAMS...-TNL-TR	AS 0044	KP 1111

Klemmhalter für STAR-Drehmaschinen / *Holder for STAR-lathes* / Adattatore per STAR-torni

516 – 522



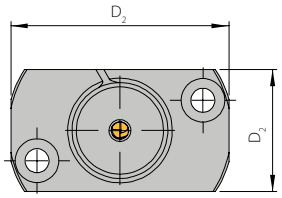


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

AKL = Auskraglänge [mm]
d = Schaftdurchmesser [mm]
AKL = Maximum work length [mm]
d = Shank diameter [mm]
AKL = Utile di lavoro [mm]
d = Diametro accoppiamento [mm]

Trägerwerkzeuge / *Holders* / Utensili

Bezeichnung *Designation* Articolo	**D**	**D_2**	**D_3**	**d**	**AKL**	**L**	**L_2**	**L_3**	**G**	**Schneideinsatz** *Insert* Inserto
HAMS 2204-A28-SR	4	28 x 50	22	22	28	53	25	11	M8x1	AMS...40R
HAMS 2204-A50-S2-SR	4	28 x 50	22	22	50	75	25	33	G 1/8	AMS...40R
HAMS 2204-A50A-S2-SR	4	32,5 x 37,5	22	22	75	50	35	33	G 1/8	AMS...40R
HAMS 2206-A33-SR	6	28 x 50	22	22	28	53	25	16	M8x1	AMS...60R
HAMS 2206-A50-S2-SR	6	28 x 50	22	22	50	75	25	33	G 1/8	AMS...60R
HAMS 2206-A50A-S2-SR	6	32,5 x 37,5	22	22	75	50	25	33	G 1/8	AMS...60R
HAMS 3004-A28-SR	4	28 X 50	22	30	28	53	25	11	M8x1	AMS...40R
HAMS 3204-A28-SR	4	28 x 50	22	32	28	53	25	11	M8x1	AMS...40R

Hinweis: Auf diese Halter passen alle Schneideinsätze von den Seiten 473 bis 501. Maß „D“ beachten!
Remark: The inserts for these holders you will find on pages 473 to 501. Note measurement “D”!
Nota: Inserti per questi adattatori a pagg da 473 a 501. Fare attenzione alla misura “D”!

Ersatzteile / *Spare Parts* / Ricambi

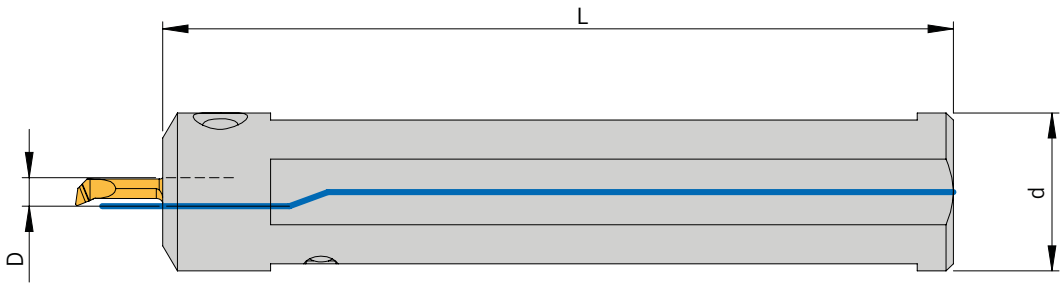
Trägerwerkzeug *Holder* Utensile	**Schraube** *Screw* Vite	**Schlüssel** *Key* Chiave
HAMS 2204..-HAMS 3204..	AS 0044	KP1111

Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

Klemmhalter für STAR-Drehmaschinen / *Holder for STAR-lathes* / Adattatore per STAR-torni

516 – 522

Abbildung ähnlich
Similar to illustration
Simile all'illustrazione



Trägerwerkzeuge / *Holders* / Utensili

Bezeichnung *Designation* Articolo	**D**	**d**	**L**	**Schneideinsatz** *Insert* Inserto
HAMS-US-2204-SR	4	22	110	AMS-US-...40R

Diese Halter können sowohl für die Zustellung in X-Achse sowie für die Zustellung in Y-Achse verwendet werden.
These holders can be used for X-axis and Y-axis feed.
Questi adattatori possono essere utilizzati per l'incremento sull'asse X e sull'asse Y.

Hinweis: Kompletter Halter muss um 90° gedreht werden, um eine andere Zustellachse nutzen zu können! Dabei ist die Spannschraube immer von unten bzw. seitlich zugänglich. Bei Überkopfeinsatz des Halters erfolgt der Zugang zur Spannschraube von oben bzw. seitlich.
Note: The complete holder must be rotated 90° to use another infeed axis! In doing so, the clamping screw can always be accessed from below or from the side. If you use the holder upside down, access can be gained from above or from the side.
Nota: l'adattatore completo deve essere ruotato di 90° per poter utilizzare un altro asse di incremento! La vite di bloccaggio è sempre accessibile dal basso o lateralmente. Se si utilizza l'inserto invertito dell'adattatore, si può accedere alla vite di bloccaggio dall'alto o lateralmente.

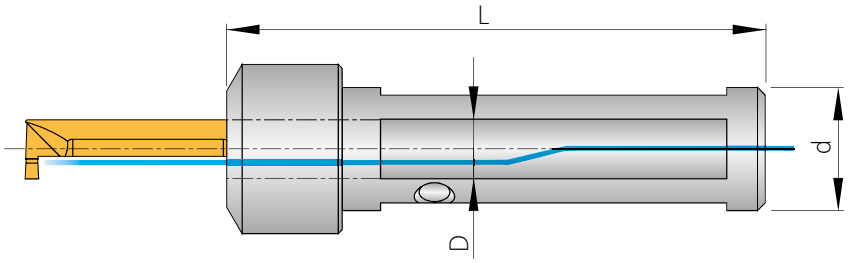
Ersatzteile / *Spare Parts* / Ricambi

Trägerwerkzeug *Holder* Utensile	**Schraube** *Screw* Vite	**Schlüssel** *Key* Chiave
HAMS-US-...	AS 0044	KP 1111

Klemmhalter für Drehmaschinen / *Holders for lathes* / Adattatori per torni

516 – 522

Abbildung ähnlich
Similar to illustration
Simile all'illustrazione
d = Schaftdurchmesser [mm]
d = Shank diameter [mm]
d = Diametro accoppiamento [mm]



Trägerwerkzeuge / *Holders* / Utensili

CITIZEN

Bezeichnung *Designation* Articolo	**D**	**d**	**L**	**Anschluss** *Connection* Filetto	**Schneideinsatz** *Insert* Inserto
HAMS 1"04-CR	4	1"	100	G 1/4"	AMS...40R
HAMS 1"06-CR	6	1"	100	G 1/4"	AMS...60R
HAMS 1"08-CR	8	1"	100	G 1/4"	AMS...80R
HAMS 3/4"04-CR	4	3/4"	100	G 1/8"	AMS...40R
HAMS 3/4"06-CR	6	3/4"	100	G 1/8"	AMS...60R
HAMS 3/4"08-CR	8	3/4"	100	G 1/8"	AMS...80R

STAR

Bezeichnung *Designation* Articolo	**D**	**d**	**L**	**Anschluss** *Connection* Filetto	**Schneideinsatz** *Insert* Inserto
HAMS 1604-SR	4	16	70	G 1/8"	AMS...40R
HAMS 1606-SR	6	16	70	G 1/8"	AMS...60R
HAMS 1608-SR	8	16	70	G 1/8"	AMS...80R
HAMS 2204-SR	4	22	110	G 1/8"	AMS...40R
HAMS 2204-SR G1/4"	4	22	110	G 1/4"	AMS...40R
HAMS 2206-SR	6	22	110	G 1/8"	AMS...60R
HAMS 2206-SR G1/4"	6	22	110	G 1/4"	AMS...60R
HAMS 2208-SR	8	22	110	G 1/8"	AMS...80R

TORNOS, TSUGAMI, HANWA

Bezeichnung *Designation* Articolo	**D**	**d**	**L**	**Anschluss** *Connection* Filetto	**Schneideinsatz** *Insert* Inserto
HAMS 2004-TOR	4	20	90	G 1/8"	AMS...40R
HAMS 2006-TOR	6	20	90	G 1/8"	AMS...60R
HAMS 2008-TOR	8	20	90	G 1/8"	AMS...80R
HAMS 2504-TOR	4	25	100	G 1/8"	AMS...40R
HAMS 2504-170-TOR	4	25	170	G 1/8"	AMS...40R
HAMS 2506-TOR	6	25	100	G 1/8"	AMS...60R
HAMS 2506-170-TOR	6	25	170	G 1/8"	AMS...60R
HAMS 2508-TOR	8	25	100	G 1/8"	AMS...80R

Ersatzteile / *Spare Parts* / Ricambi

Trägerwerkzeug *Holder* Utensile	**Schraube** *Screw* Vite	**Schlüssel** *Key* Chiave
HAMS 1"..-HAMS 3/4"..	AS 0044	KP1111
HAMS 1604..	AS 0044	KP1111
HAMS 1606 - HAMS 1608..	AS 0044	KP1111
HAMS 2004..-HAMS 2508..	AS 0044	KP1111

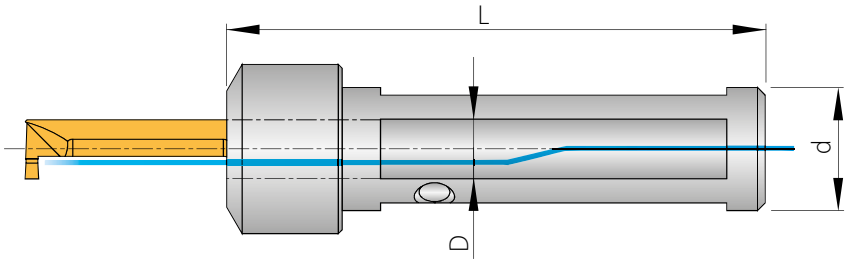
Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

Klemmhalter für Drehmaschinen / *Holders for lathes* / Adattatori per torni

516 – 522

Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

d = Schaftdurchmesser [mm]
d = Shank diameter [mm]
d = Diametro accoppiamento [mm]



TRAUB

Bezeichnung *Designation* Articolo	**D**	**d**	**L**	**Anschluss** *Connection* Filetto	**Schneideinsatz** *Insert* Inserto
HAMS 2804-TR	4	28	120	G 1/4“	AMS...40R
HAMS 2806-TR	6	28	120	G 1/4“	AMS...60R

Halter mit 2 Spannflächen = CITIZEN, TORNOS, TRAUB, TSUGAMI und HANWA.
Halter mit 4 Spannflächen = STAR.
Holders with 2 flats = CITIZEN, TORNOS, TRAUB, TSUGAMI and HANWA.
Holders with 4 flats = STAR.
Adattatore con 2 piani di bloccaggio = CITIZEN, TORNOS, TRAUB, TSUGAMI und HANWA.
Adattatore con 4 piani di bloccaggio = STAR.

Hinweis: Auf diese Halter passen alle Schneideinsätze von den Seiten 473 bis 501. Maß „D“ beachten!
Remark: The inserts for these holders you will find on pages 473 to 501. Note measurement “D”!
Nota: Inserti per questi adattatori a pagg da 473 a 501. Fare attenzione alla misura “D”!

Ersatzteile / *Spare Parts* / Ricambi

Trägerwerkzeug *Holder* Utensile	**Schraube** *Screw* Vite	**Schlüssel** *Key* Chiave
HAMS 2804..-HAMS 2806..	AS 0044	KP1111

Klemmhalter zum Ausspindeln / *Holders for finishing* / Adattatori corti per contromandrino

516 – 522

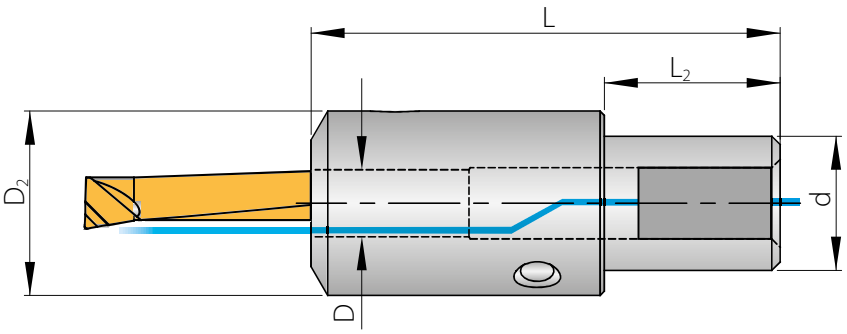


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

d = Schaftdurchmesser [mm]
d = Shank diameter [mm]
d = Diametro accoppiamento [mm]

Trägerwerkzeuge / *Holders* / Utensili

Bezeichnung *Designation* Articolo	**D**	**D_2**	**d**	**L**	**L_2**	**Schneideinsatz** *Insert* Inserto
HAMS 1604-AR	4	22	16	56	21	AMS...40R
HAMS 1606-AR	6	22	16	56	21	AMS...60R
HAMS 1608-AR	8	22	16	56	21	AMS...80R

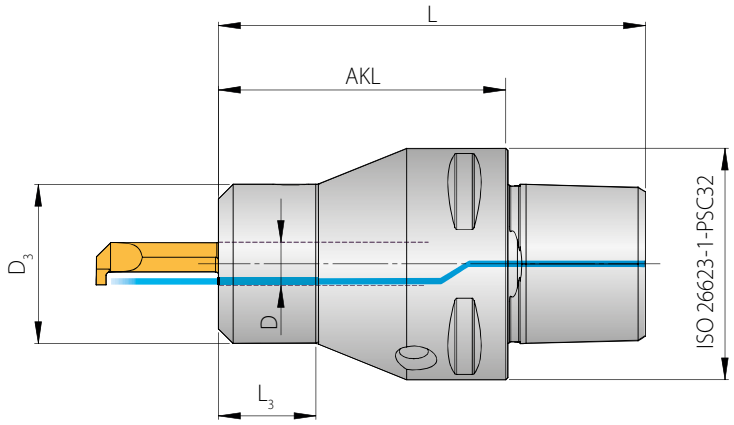
Hinweis: Auf diese Halter passen alle Schneideinsätze von den Seiten 473 bis 501. Maß „D" beachten!
Remark: The inserts for these holders you will find on pages 473 to 501. Note measurement "D"!
Nota: Inserti per questi adattatori a pagg da 473 a 501. Fare attenzione alla misura "D"!

Ersatzteile / *Spare Parts* / Ricambi

Trägerwerkzeug *Holder* Utensile	**Schraube** *Screw* Vite	**Schlüssel** *Key* Chiave
HAMS 1604..-HAMS 1608..	AS 0044	KP1111

Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

Klemmhalter mit Polygonschaft / *Holders with Polygon-Shank* / Adattatori con attacco poligonale



516 – 522

Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

AKL = Auskraglänge [mm]
AKL = Maximum work length [mm]
AKL = Utile di lavoro [mm]

Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

Trägerwerkzeuge / *Holders* / Utensili

Bezeichnung *Designation* Articolo	**PSC**	**D**	**D_3**	**L**	**AKL**	**L_3**	**Schneideinsatz** *Insert* Inserto
HAMS PSC3204R	PSC32	4	22	59	40	13	AMS...40R
HAMS PSC3206R	PSC32	6	22	59	40	13	AMS...60R

Hinweis: Auf diese Halter passen alle Schneideinsätze von den Seiten 473 bis 501. Maß „D“ beachten!
Remark: The inserts for these holders you will find on pages 473 to 501. Note measurement “D”!
Nota: Inserti per questi adattatori a pagg da 473 a 501. Fare attenzione alla misura “D”!

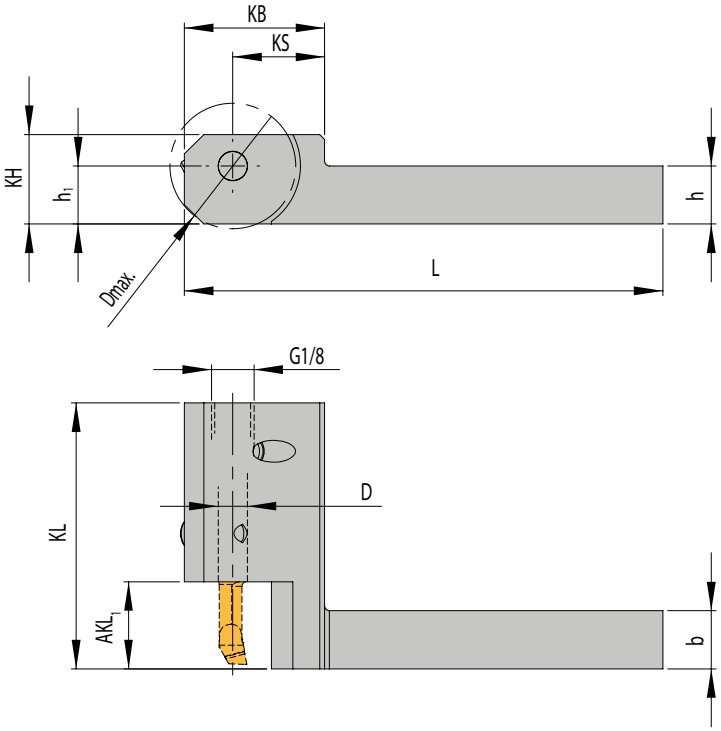
Ersatzteile / *Spare Parts* / Ricambi

Trägerwerkzeug *Holder* Utensile	**Schraube** *Screw* Vite	**Schlüssel** *Key* Chiave
HAMS PSC32..	AS 0044	KP1111

Klemmhalter für Langdrehmaschinen und Mehrspindler
Holders for sliding head auto lathes and multi spindle machines
Adattori per torni a fantina mobile e plurimandrino

516 – 522

Abbildung ähnlich
Similar to illustration
Simile all'illustrazione



Trägerwerkzeuge / *Holders* / Utensili

Bezeichnung *Designation* Articolo	D	h	b	L	KB	KS	KL	AKL_1	KH	h_1	D_{max}	Anschluss *Connection* Filetto	Schneideinsatz *Insert* Inserto
HAMS 121204-R	4	12	12	98	28	19	52,5	18	18,5	12	26	G 1/8“	AMS...40R
HAMS 121206-R	6	12	12	99	29	19	55,0	18	18,5	12	26	G 1/8“	AMS...60R

Dmax= Maximaler Durchmesser bei Vollmaterial
Dmax = Maximum diameter in solid
Dmax = Diametro massimo lavorazione dal pieno

Hinweis: Auf diese Halter passen alle Schneideinsätze von den Seiten 473 bis 501. Maß „D“ beachten!
Remark: The inserts for these holders you will find on pages 473 to 501. Note measurement “D”!
Nota: Inserti per questi adattatori a pagg da 473 a 501. Fare attenzione alla misura “D”!

8

Ersatzteile / *Spare Parts* / Ricambi

Trägerwerkzeug *Holder* Utensile	Schraube *Screw* Vite	Schlüssel *Key* Chiave
HAMS 12..04..	AS 0043	KP3111
HAMS 12..06..	AS 0044	KP1111

Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

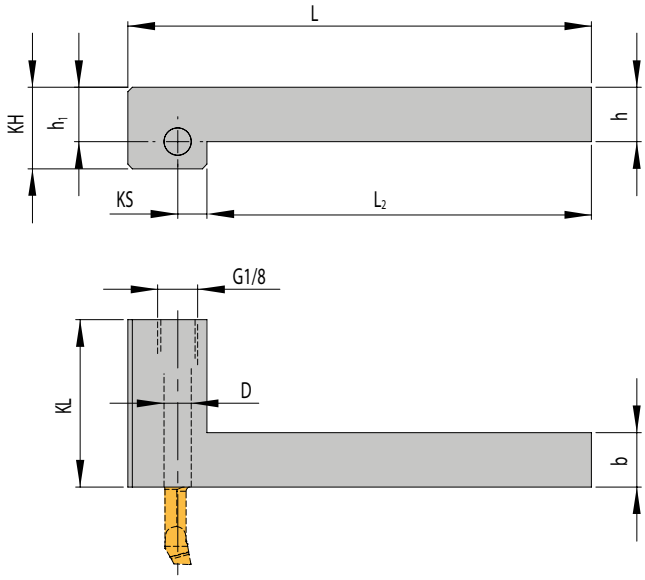
Klemmhalter für Langdrehmaschinen an Gegenspindel

Holder for sliding head lathes on counter spindle

Adattori per torni a fantina mobile su contromandrino

516 – 522

Abbildung ähnlich
Similar to illustration
Simile all'illustrazione



Trägerwerkzeuge / *Holders* / Utensili

Bezeichnung *Designation* Articolo	**D**	**h**	**b**	**L**	**L_2**	**KS**	**KL**	**KH**	**h_1**	**Anschluss** *Connection* Filetto	**Schneideinsatz** *Insert* Inserto
HAMS 121206-R-GS	6	12	12	102,5	85	6,5	37	18	12	G 1/8“	AMS...60R

Hinweis: Auf diese Halter passen alle Schneideinsätze AMS-... .60R.
Information: please use AMS-... .60R for these holders.
Nota: uilizzare inserti AMS-...60R. con questi adattatori.

Ersatzteile / *Spare Parts* / Ricambi

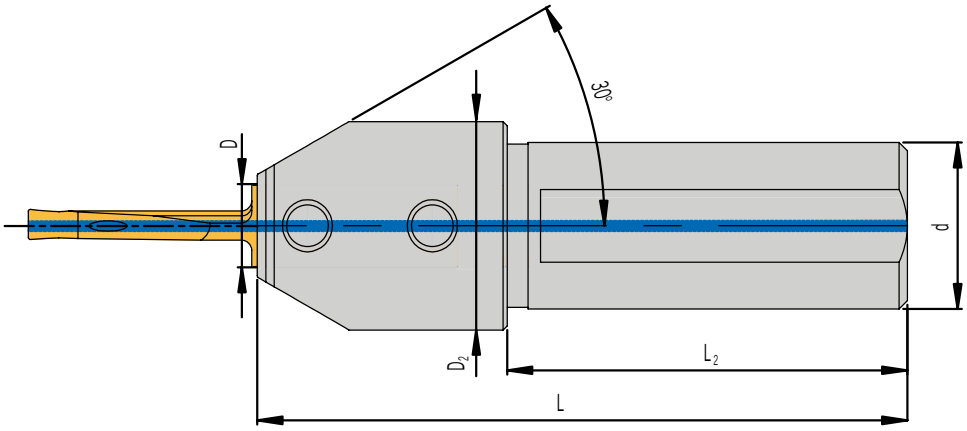
Trägerwerkzeug *Holder* Utensile	**Schraube** *Screw* Vite	**Schlüssel** *Key* Chiave
HAMS 1206..	AS 0044	KP1111

Axial Stechen / *Axial grooving* / Scanalatura assiale

516 – 522

Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Mit innerer Kühlmittelzufuhr
With internal coolant
Con adduzione interna



Trägerwerkzeuge / *Holders* / Utensili

Bezeichnung *Designation* Articolo	**D**	**D_2**	**d**	**L**	**L_2**	**Schneideinsatz** *Insert* Inserto
HSAV 2006	6	25	20	78	48	SAV15...|SAV20...
HSAV 2008	8	25	20	78	48	SAV25...|SAV30...
HSAV 2010	10	25	20	78	48	SAV40...
HSAV 2508	8	30	25	78	48	SAV25...|SAV30...
HSAV 2510	10	30	25	78	48	SAV40...

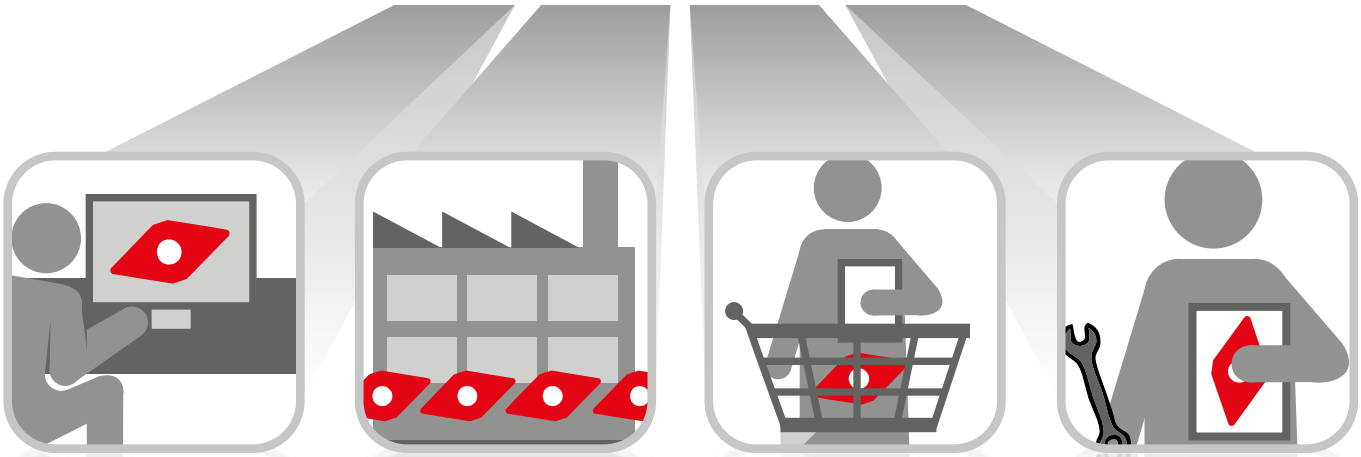
Beim Axialstechen ins Volle ist die komplette Stechtiefe nur im Durchmesserbereich bis 50mm erreichbar.
When face grooving into solid the overall groove depth can only be obtained in diameter range up to 50mm.
Con la scanalatura assiale dal pieno la profondità completa di scanalatura si ottiene solamente per una gamma di diametri fino a 50mm.

Hinweis: Auf diese Halter passen alle Schneideinsätze von den Seiten 511 bis 512.
Remark: The inserts for these holders you will find on pages 511 to 512.
Nota: Inserti per questi adattatori a pagg da 511 a 512.

Ersatzteile / *Spare Parts* / Ricambi

Trägerwerkzeug *Holder* Utensile	**Gewindestift** *Threaded pin* Spina filettata
HSAV 2006	2 x DIN913-M5x10
HSAV 2008 - 2510	2 x DIN913-M6x8

ARNO®
WERKZEUGE



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HC – HARTMETALL BESCHICHTET
HC - SOLID CARBIDE COATED
HC – METALLO DURO RIVESTITO

AL40

- **Universell einsetzbare Sorte**
- **Gute Zähigkeit**
- **Gute Verschleißfestigkeit**
- *Universally applicable type*
- *Good degree of toughness*
- *Good wear resistance*
- Qualità utilizzabile universalmente
- Buona tenacità
- Buona resistenza all'usura

PVD

Abbildung ähnlich
Similar picture
Foto simile

Verschleißfestigkeit
Wear resistance
Resistenza all'usura

Zähigkeit
Toughness
Tenacità

P	M	K	N	S	H
●	●	●		●	

AP5015

- **Universell einsetzbare Sorte**
- **Hohe Hitzebeständigkeit**
- **Hohe Oxidationsbeständigkeit**
- *Universally applicable type*
- *High thermal resistance*
- *High oxidation resistance*
- Qualità utilizzabile universalmente
- Elevata resistenza al calore
- Elevata resistenza all'ossidazione

PVD

Abbildung ähnlich
Similar picture
Foto simile

Verschleißfestigkeit
Wear resistance
Resistenza all'usura

Zähigkeit
Toughness
Tenacità

P	M	K	N	S	H
●	●	●	○	○	

HU – HARTMETALL UNBESCHICHTET
HU - SOLID CARBIDE UNCOATED
HU – METALLO DURO NON RIVESTITO

AK40

- **Gute Kantenstabilität**
- **Hohe Zuverlässigkeit**
- **Feinstkorn-Hartmetallsubstrat**
- *Good edge stability*
- *High reliability*
- *Fine grain solid carbide substrate*
- Buona stabilità del profilo
- Elevata affidabilità
- Substrato in metallo duro a grana fine

Abbildung ähnlich
Similar picture
Foto simile

Verschleißfestigkeit
Wear resistance
Resistenza all'usura

Zähigkeit
Toughness
Tenacità

P	M	K	N	S	H
		●	●		

8

BU – CBN UNBESCHICHTET
BU – CBN UNCOATED
BU – CBN NON RIVESTITO

AH7525

- **Für glatten sowie unterbrochenen Schnitt**
- **Zähe CBN-Sorte**
- **Bearbeitung von gehärteten Stählen (48-65 HRC)**
- *For smooth and interrupted cuts*
- *Tough CBN grade*
- *For machining hardened steels (48-65 HRC)*
- Adatto per tagli costanti e tagli interrotti
- Qualità CBN tenace
- Lavorazione di acciai temprati (48-65 HRC)

Abbildung ähnlich
Similar picture
Foto simile

Verschleißfestigkeit
Wear resistance
Resistenza all'usura

Zähigkeit
Toughness
Tenacità

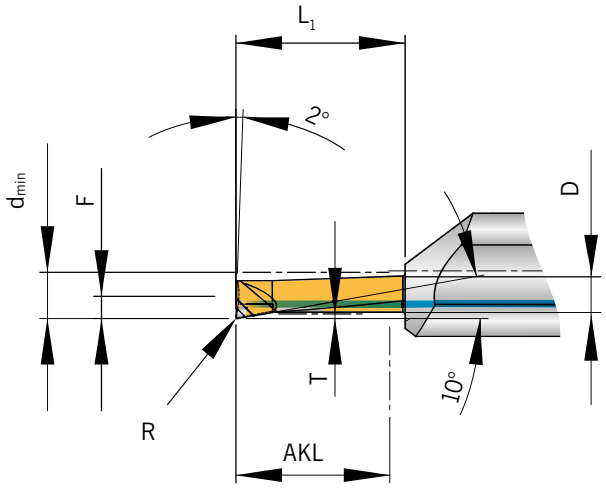
10 20 30 40

P	M	K	N	S	H
					●

8

Drehen / *Turning* / Inserti di tornitura

516 – 522



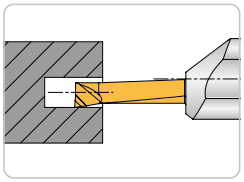


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

NEU/NEW/ NUOVO

Bezeichnung *Designation* Articolo	d_{min}	AKL	T	R	F	L_1	D	HC AP5015
AMS-D-07005005-020.40R	0,7	2	0,05	0,05	0,30	4	4	◆
AMS-D-20015002-060.40R	2,0	6	0,15	0,02	0,90	8	4	◆
AMS-D-20015002-100.40R	2,0	10	0,15	0,02	0,90	12	4	◆
AMS-D-220401-060.40R	2,2	6	0,40	0,10	1,05	8	4	◆
AMS-D-250401-100.40R	2,5	10	0,40	0,10	1,15	12	4	◆
AMS-D-250401-150.40R	2,5	15	0,40	0,10	1,15	17	4	◆
AMS-D-250401-200.40R	2,5	20	0,40	0,10	1,15	22	4	◆
AMS-D-300401-100.40R	3,0	10	0,40	0,10	1,40	12	4	◆
AMS-D-300401-150.40R	3,0	15	0,40	0,10	1,40	17	4	◆
AMS-D-300401-200.40R	3,0	20	0,40	0,10	1,40	22	4	◆
AMS-D-300402-100.40R	3,0	10	0,40	0,20	1,40	12	4	◆
AMS-D-300402-150.40R	3,0	15	0,40	0,20	1,40	17	4	◆
AMS-D-300402-200.40R	3,0	20	0,40	0,20	1,40	22	4	◆
AMS-D-390602-100.40R	3,9	10	0,60	0,20	1,90	12	4	◆
AMS-D-390602-150.40L/R	3,9	15	0,60	0,20	1,90	17	4	◆
AMS-D-390602-200.40L/R	3,9	20	0,60	0,20	1,90	22	4	◆
AMS-D-40015005-250.40L/R	4,0	25	0,15	0,05	1,90	27	4	◆
AMS-D-400301-250.40R	4,0	25	0,30	0,10	1,90	27	4	◆
AMS-D-590801-150.60R	5,9	15	0,80	0,10	2,90	17	6	◆
AMS-D-590802-100.60R	5,9	10	0,80	0,20	2,90	12	6	◆
AMS-D-590802-200.60L/R	5,9	20	0,80	0,20	2,90	22	6	◆
AMS-D-590802-300.60L/R	5,9	30	0,80	0,20	2,90	32	6	◆
AMS-D-590804-200.60R	5,9	20	0,80	0,40	2,90	22	6	◆
AMS-D-6005015-420.60R	6,0	42	0,50	0,15	2,90	44	6	◆
AMS-D-791002-100.80R	7,9	10	1,00	0,20	3,90	12	8	◆
AMS-D-791002-250.80L/R	7,9	25	1,00	0,20	3,90	27	8	◆
AMS-D-820402-300.80R	8,2	30	0,40	0,20	3,90	32	8	◆
AMS-D-1021002-200.100R	10,2	20	1,00	0,20	4,90	22	10	◆
AMS-D-1021002-300.100R	10,2	30	1,00	0,20	4,90	32	10	◆

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

P	●
M	●
K	●
N	●
S	●
H	

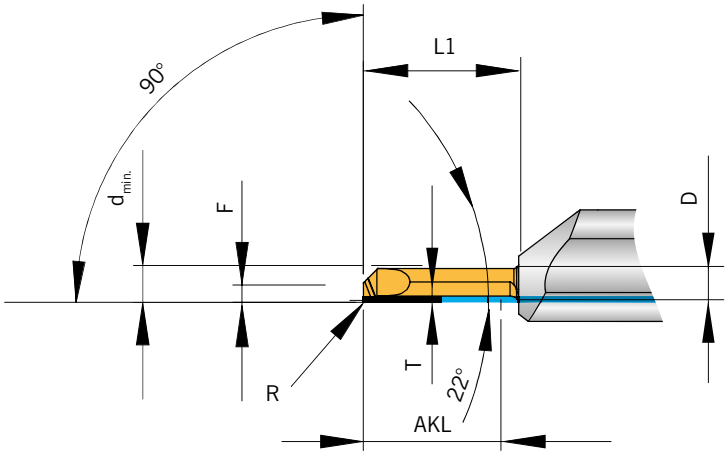
● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

8

Drehen / *Turning* / Inserti di tornitura

516 – 522



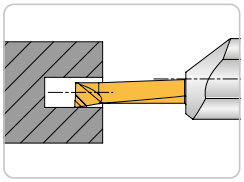


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	d_{min}	AKL	T	R	F	L_1	D	HC AP5015
AMS-D20-3001502-150.40R	3	15	0,15	0,2	1,3	17	4	◆
AMS-D20-400302-150.40R	4	15	0,30	0,2	1,9	17	4	◆
AMS-D20-500502-100.60R	5	10	0,50	0,2	2,3	12	6	◆
AMS-D20-500502-150.60R	5	15	0,50	0,2	2,3	17	6	◆

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

P	●
M	●
K	●
N	●
S	●
H	

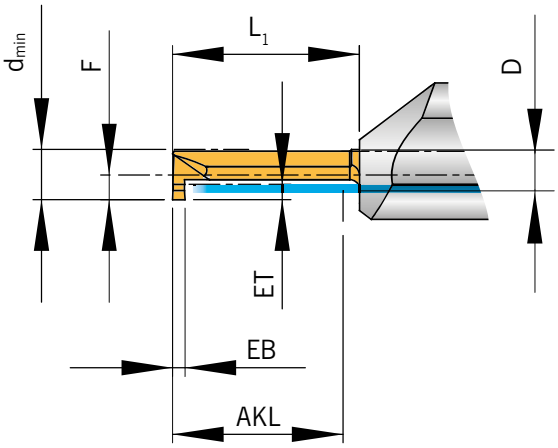
● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

8

Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

Stechen / *Grooving* / Scanalatura



516 – 522

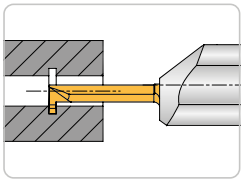


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	d_{min}	AKL	EB + 0,03	ET	F	L_1	D	HC AP5015
AMS-S-25080600-100.40R	2,5	10	0,8	0,6	1,15	12	4	◆
AMS-S-25080600-150.40R	2,5	15	0,8	0,6	1,15	17	4	◆
AMS-S-25080600-200.40R	2,5	20	0,8	0,6	1,15	22	4	◆
AMS-S-30080600-100.40R	3,0	10	0,8	0,6	1,40	12	4	◆
AMS-S-30080600-150.40R	3,0	15	0,8	0,6	1,40	17	4	◆
AMS-S-30080600-200.40R	3,0	20	0,8	0,6	1,40	22	4	◆
AMS-S-39100800-100.40R	3,9	10	1,0	0,8	1,90	12	4	◆
AMS-S-39100800-150.40L/R	3,9	15	1,0	0,8	1,90	17	4	◆
AMS-S-39100800-200.40R	3,9	20	1,0	0,8	1,90	22	4	◆
AMS-S-59101800-200.60L/R	5,9	20	1,0	1,8	2,90	22	6	◆
AMS-S-59151800-100.60R	5,9	10	1,5	1,8	2,90	12	6	◆
AMS-S-59151800-200.60L/R	5,9	20	1,5	1,8	2,90	22	6	◆
AMS-S-59151800-300.60R	5,9	30	1,5	1,8	2,90	32	6	◆
AMS-S-69202500-150.80L/R	6,9	15	2,0	2,5	3,90	17	8	◆
AMS-S-79182500-100.80R	7,9	10	1,8	2,5	3,90	12	8	◆
AMS-S-79182500-250.80R	7,9	25	1,8	2,5	3,90	27	8	◆

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

P	●
M	●
K	●
N	●
S	●
H	

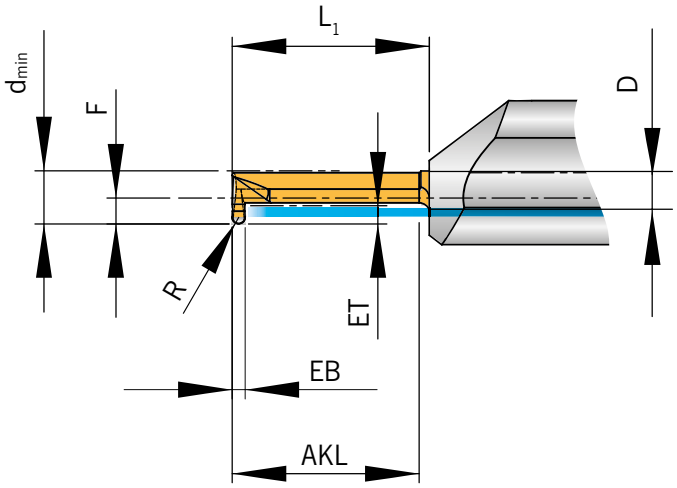
● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

8

Radius-Einstich / *Radius grooving* / Profilo a raggio pieno

516 – 522



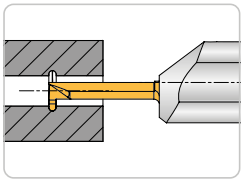


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	d_{min}	AKL	EB + 0,03	ET	R	F	L_1	D	HC AP5015
AMS-S-39100805-100.40R	3,9	10	1,0	0,8	0,50	1,9	12	4	◆
AMS-S-39100805-150.40L/R	3,9	15	1,0	0,8	0,50	1,9	17	4	◆
AMS-S-39100805-200.40R	3,9	20	1,0	0,8	0,50	1,9	22	4	◆
AMS-S-59151875-100.60R	5,9	10	1,5	1,8	0,75	2,9	12	6	◆
AMS-S-59151875-200.60R	5,9	20	1,5	1,8	0,75	2,9	22	6	◆
AMS-S-59151875-300.60R	5,9	30	1,5	1,8	0,75	2,9	32	6	◆
AMS-S-82202010-200.80R	8,2	20	2,0	2,0	1,00	3,9	22	8	◆

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

P	●
M	●
K	●
N	●
S	●
H	

● **Hauptanwendung**
Main application
Applicazione principale

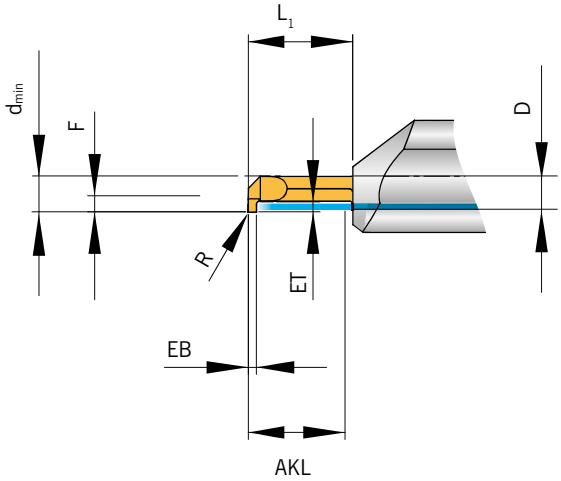
○ **Nebenanwendung**
Secondary application
Applicazione secondaria

8

Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

Seegering DIN 471/472 / *Cir-clip grooving DIN 471/472* / Sedi Seeger DIN 471/472

516 – 522



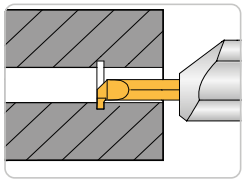


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	d_{min}	AKL	EB ± 0,025	ET	R	F	L_1	D	HC AP5015
AMS-472-41099110-150.40R	4,1	15	0,99	1,1	0,05	1,9	17	4	◆
AMS-472-41119110-150.40R	4,1	15	1,19	1,1	0,05	1,9	17	4	◆
AMS-472-41139110-150.40R	4,1	15	1,39	1,1	0,05	1,9	17	4	◆
AMS-472-41169110-150.40R	4,1	15	1,69	1,1	0,05	1,9	17	4	◆
AMS-472-61099150-150.60R	6,1	15	0,99	1,5	0,05	2,9	17	6	◆
AMS-472-61119150-150.60R	6,1	15	1,19	1,5	0,05	2,9	17	6	◆
AMS-472-61139150-150.60R	6,1	15	1,39	1,5	0,05	2,9	17	6	◆
AMS-472-61169150-150.60R	6,1	15	1,69	1,5	0,05	2,9	17	6	◆
AMS-472-61194150-150.60R	6,1	15	1,94	1,5	0,05	2,9	17	6	◆
AMS-472-84119200-200.80R	8,4	20	1,19	2,0	0,05	3,9	22	8	◆
AMS-472-84139200-200.80R	8,4	20	1,39	2,0	0,05	3,9	22	8	◆
AMS-472-84169250-200.80R	8,4	20	1,69	2,5	0,05	3,9	22	8	◆
AMS-472-84194250-200.80R	8,4	20	1,94	2,5	0,05	3,9	22	8	◆
AMS-472-84224300-200.80R	8,4	20	2,24	3,0	0,05	3,9	22	8	◆
AMS-472-84274350-200.80R	8,4	20	2,74	3,5	0,05	3,9	22	8	◆
AMS-472-84328350-200.80R	8,4	20	3,28	3,5	0,05	3,9	22	8	◆
AMS-472-104139350-250.100R	10,4	25	1,39	3,5	0,05	4,9	27	10	◆
AMS-472-104169350-250.100R	10,4	25	1,69	3,5	0,05	4,9	27	10	◆
AMS-472-104194350-250.100R	10,4	25	1,94	3,5	0,05	4,9	27	10	◆
AMS-472-104224350-250.100R	10,4	25	2,24	3,5	0,05	4,9	27	10	◆
AMS-472-104274350-250.100R	10,4	25	2,74	3,5	0,05	4,9	27	10	◆
AMS-472-104328350-250.100R	10,4	25	3,28	3,5	0,05	4,9	27	10	◆

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

P	●
M	●
K	●
N	●
S	●
H	

● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

8

Sonderlösungen – genau auf Sie zugeschnitten.

Special solutions especially for your application!

Soluzioni speciali – su misura per voi.

Sie haben eine Aufgabe – wir haben die Lösung.

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You have an application – we have a solution.

Take advantage of our many years' experience in special solutions and in future benefit from more efficient and cost effective ARNO tooling.

Whether it is special inserts or complex combination tools – we are able to offer nearly any solutions.

Hai un problema – chiedici la nostra soluzione.

La nostra pluriennale esperienza nell'ambito delle lavorazioni meccaniche ci rende capaci di offrire qualsiasi soluzione di lavorazione nell'ambito delle nostre competenze specifiche.

Sia per singoli inserti o utensili e sia per complete combinazioni di utensili.

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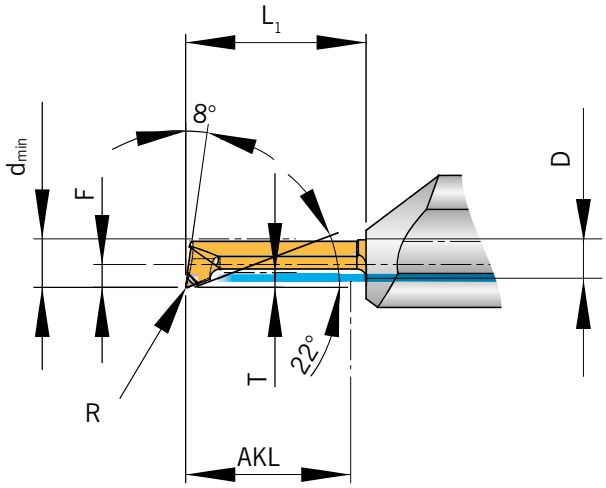


516 – 522

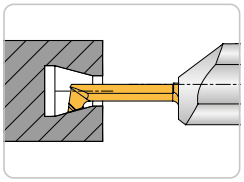


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

NEU/NEW/ NUOVO

Artikel *Article* Articolo	d_{min}	AKL	T	R	F	L_1	D	HC AP5015
AMS-K-1501501-060.40R	1,5	6	0,15	0,10	1,30	7	4	◆
AMS-K-1501005-110.40R	1,5	11	0,10	0,05	1,30	12	4	◆
AMS-K-2003005-060.40R	2,0	6	0,30	0,05	0,90	7	4	◆
AMS-K-2003005-100.40R	2,0	10	0,30	0,05	0,90	11	4	◆
AMS-K-20015005-100.40L	2,0	10	0,15	0,05	0,90	11	4	◆
AMS-K-20015005-100.40R	2,0	10	0,15	0,05	0,90	11	4	◆
AMS-K-2001005-150.40R	2,0	15	0,15	0,05	0,90	17	4	◆
AMS-K-220201-150.40R	2,2	15	0,20	0,10	0,95	16	4	◆
AMS-K-250401-100.40R	2,5	10	0,40	0,10	1,15	12	4	◆
AMS-K-250401-150.40R	2,5	15	0,40	0,10	1,15	17	4	◆
AMS-K-250401-200.40R	2,5	20	0,40	0,10	1,15	22	4	◆
AMS-K-300401-100.40R	3,0	10	0,40	0,10	1,40	12	4	◆
AMS-K-300401-150.40R	3,0	15	0,40	0,10	1,40	17	4	◆
AMS-K-300401-200.40L	3,0	20	0,40	0,10	1,40	22	4	◆
AMS-K-300401-200.40R	3,0	20	0,40	0,10	1,40	22	4	◆
AMS-K-390802-100.40R	3,9	10	0,80	0,20	1,90	12	4	◆
AMS-K-390802-150.40L	3,9	15	0,80	0,20	1,90	17	4	◆
AMS-K-390802-150.40R	3,9	15	0,80	0,20	1,90	17	4	◆
AMS-K-390802-200.40L	3,9	20	0,80	0,20	1,90	22	4	◆
AMS-K-390802-200.40R	3,9	20	0,80	0,20	1,90	22	4	◆
AMS-K-391304-200.40R	3,9	20	1,30	0,40	1,90	22	4	◆
AMS-K-400604-120.40R	4,0	12	0,60	0,40	1,90	14	4	◆
AMS-K-400604-150.40R	4,0	15	0,60	0,40	1,90	17	4	◆
AMS-K-400602-200.40R	4,0	20	0,60	0,20	1,90	22	4	◆
AMS-K-400301-300.40R	4,0	30	0,30	0,10	1,50	32	4	◆
AMS-K-500502-100.60L	5,0	10	0,50	0,20	2,30	12	6	◆
AMS-K-500502-100.60R	5,0	10	0,50	0,20	2,30	12	6	◆
AMS-K-500502-150.60L	5,0	15	0,50	1,20	2,30	17	6	◆
AMS-K-500502-150.60R	5,0	15	0,50	0,20	2,30	17	6	◆
AMS-K-500502-200.60R	5,0	20	0,50	0,20	2,30	22	6	◆
AMS-K-500502-250.60L	5,0	25	0,50	0,20	2,30	26	6	◆
AMS-K-500502-250.60R	5,0	25	0,50	0,20	2,30	26	6	◆
AMS-K-500502-300.60R	5,0	30	0,50	0,20	2,30	31	6	◆
AMS-K-591802-100.60R	5,9	10	1,80	0,20	2,90	12	6	◆
AMS-K-591802-200.60L	5,9	20	1,80	0,20	2,90	22	6	◆
AMS-K-591802-200.60R	5,9	20	1,80	0,20	2,90	22	6	◆
AMS-K-591802-300.60L	5,9	30	1,80	0,20	2,90	32	6	◆
AMS-K-591802-300.60R	5,9	30	1,80	0,20	2,90	32	6	◆

Artikel *Article* Articolo	d_{min}	AKL	T	R	F	L_1	D	HC AP5015
AMS-K-590502-350.60R	5,9	35	0,50	0,20	2,90	37	6	◆
AMS-K-590502-400.60R	5,9	40	0,50	0,20	2,90	42	6	◆
AMS-K-590502-500.60R	5,9	50	0,50	0,20	2,90	52	6	◆
AMS-K-6005015-420.60R	6,0	42	0,50	0,15	2,30	44	6	◆
AMS-K-680502-200.80L	6,8	20	0,50	0,20	3,90	22	8	◆
AMS-K-6805005-250.80R	6,8	25	0,50	0,05	3,90	27	8	◆
AMS-K-680502-250.80L	6,8	25	0,50	0,20	3,90	27	8	◆
AMS-K-680502-250.80R	6,8	25	0,50	0,20	3,90	27	8	◆
AMS-K-720502-450.80R	7,2	45	0,50	0,20	3,45	47	8	◆
AMS-K-791002-200.80R	7,9	20	1,00	0,20	3,90	22	8	◆
AMS-K-791002-300.80R	7,9	30	1,00	0,20	3,90	32	8	◆
AMS-K-791002-400.80R	7,9	40	1,00	0,20	3,90	42	8	◆
AMS-K-800502-500.80R	8,0	50	0,50	0,20	3,90	52	8	◆
AMS-K-893902-200.80R	8,9	20	3,90	0,20	3,90	22	8	◆
AMS-K-893902-300.80R	8,9	30	3,90	0,20	3,90	32	8	◆
AMS-K-1084902-250.100R	10,8	25	4,90	0,20	4,90	27	10	◆
AMS-K-1084902-350.100R	10,8	35	4,90	0,20	4,90	37	10	◆

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

P	●
M	●
K	●
N	●
S	●
H	

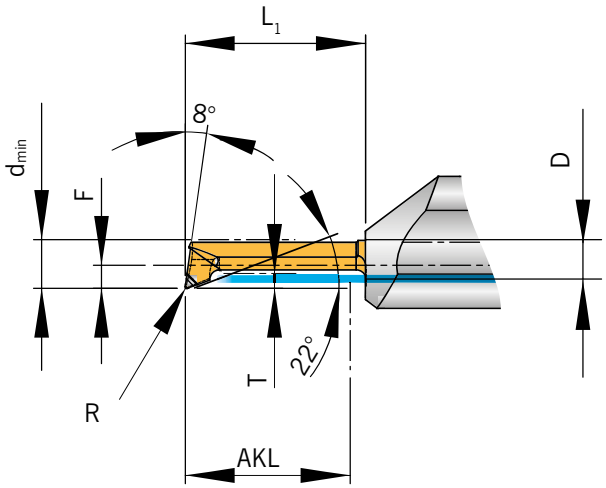
● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

8

Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

Kopieren / *Copying* / Copiatura



516 – 522

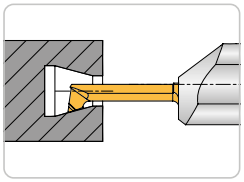


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

NEU/NEW/ NUOVO

Bezeichnung *Designation* Articolo	d_{min}	AKL	T	R	F	L_1	D	HC AP5015
AMS-K-2001005-150.40R	2,0	15	0,1	0,05	0,9	17	4	◆
AMS-K-400301-300.40R	4,0	30	0,3	0,10	1,5	32	4	◆
AMS-K-500502-150.60 L/R	5,0	15	0,5	0,20	2,3	17	6	◆
AMS-K-6805005-250.80R	6,8	25	0,5	0,05	3,9	27	8	◆
AMS-K-680502-200.80L	6,8	20	0,5	0,20	3,9	22	8	◆
AMS-K-680502-250.80 L/R	6,8	25	0,5	0,20	3,9	27	8	◆
AMS-K-791002-200.80R	7,9	20	1,0	0,20	3,9	22	8	◆
AMS-K-791002-300.80R	7,9	30	1,0	0,20	3,9	32	8	◆
AMS-K-791002-400.80R	7,9	40	1,0	0,20	3,9	42	8	◆

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

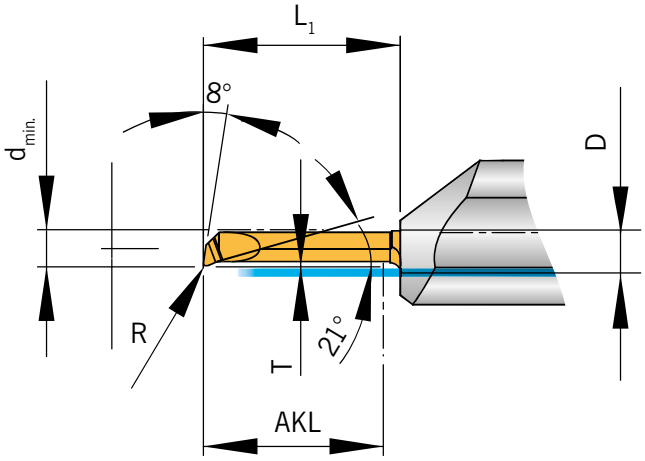
P	●
M	●
K	●
N	●
S	●
H	

● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

Kopieren - verstärkte Ausführung / *Copying – reinforced version /* Copiatura - versione rinforzata

516 – 522



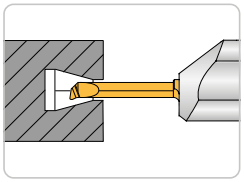


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	d_{min}	AKL	T	R	F	L_1	D	HC AP5015
AMS-K-300202-100.40L/R	3,0	10	0,2	0,20	1,30	12	4	◆
AMS-K-300202-150.40R	3,0	15	0,2	0,20	1,30	17	4	◆
AMS-K-3202015-100.40R	3,2	10	0,2	0,15	1,45	12	4	◆
AMS-K-400301-250.40R	4,0	25	0,3	0,10	1,50	27	4	◆
AMS-K-400302-100.40L/R	4,0	10	0,3	0,20	1,90	12	4	◆

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

P	●
M	●
K	●
N	●
S	●
H	

● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

8

Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

Kopieren - versetzte und verstärkte Ausführung / *Copying - offset and reinforced version* / Copiatura - versione disassata e rinforzata

516 – 522

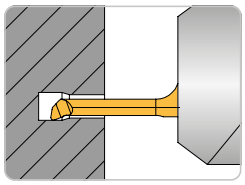
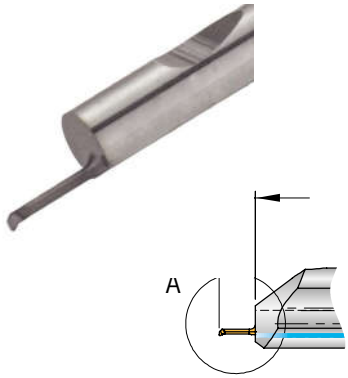
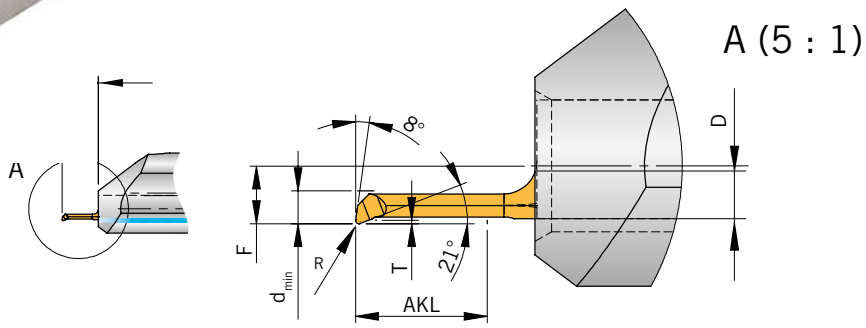


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione





								HC
Bezeichnung *Designation* Articolo	d_{min}	**AKL**	**T**	**R**	**F**	L_1	**D**	**AP5015**
AMS-K-100101-040.40R	1	4	0,1	0,1	1,75	5,5	4	◆

HC = Hartmetall beschichtet / *Solid carbide coated* / Metallo duro rivestito

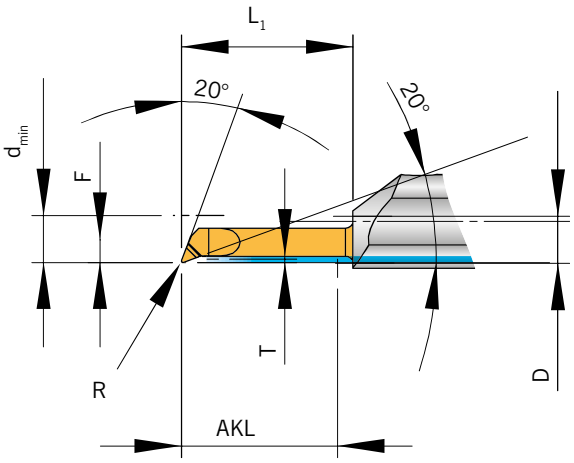
P	●
M	●
K	●
N	●
S	●
H	

● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

8

Kopieren 20/20° / *Copying 20/20°* / Copiatura 20/20°



516 – 522

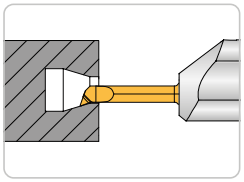


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	d_{min}	AKL	T	R	F	L_1	D	HC AP5015
AMS-K2020-5005015-200.60L	6	20	0,5	0,2	2,9	22	6	◆
AMS-K2020-5005015-200.60R	6	20	0,5	0,2	2,9	22	6	◆

HC = Hartmetall beschichtet / *Solid carbide coated* / Metallo duro rivestito

P	●
M	●
K	●
N	●
S	●
H	

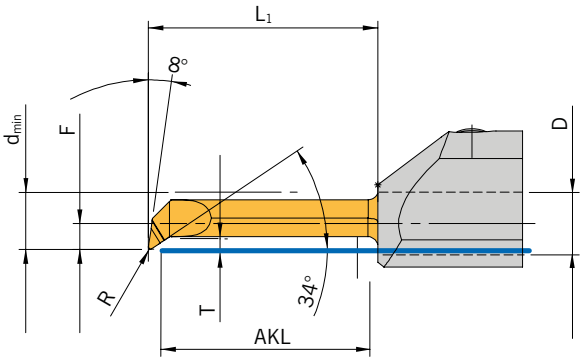
● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

8

Kopieren 32° / *Copying 32* / Copiatura 32

516 – 522



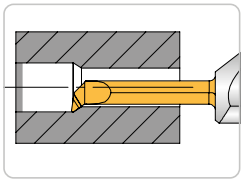


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	d_{min}	AKL	T	R	F	L_1	D	HC AP5015
AMS-K32-290701-100.40R	2,9	10	0,7	0,1	1,90	12	4	◆
AMS-K32-290701-200.40R	2,9	20	0,7	0,1	1,90	22	4	◆
AMS-K32-390801-100.40R	3,9	10	0,8	0,1	1,90	12	4	◆
AMS-K32-390801-160.40R	3,9	16	0,8	0,1	1,90	18	4	◆
AMS-K32-390801-200.40R	3,9	20	0,8	0,1	1,90	22	4	◆
AMS-K32-501002-150.60R	5,0	15	1,0	0,2	2,45	17	6	◆
AMS-K32-501002-200.60R	5,0	15	1,0	0,2	2,45	22	6	◆
AMS-K32-501002-300.60R	5,0	30	1,0	0,2	2,45	32	6	◆
AMS-K32-792002-250.80R	7,9	25	2,0	0,2	3,90	27	8	◆
AMS-K32-792002-300.80R	7,9	30	2,0	0,2	3,90	32	8	◆
AMS-K32-792002-400.80R	7,9	40	2,0	0,2	3,90	42	8	◆
AMS-K32-792002-500.80R	7,9	50	2,0	0,2	3,90	52	8	◆
AMS-K32-802502-200.80R	8,0	20	2,5	0,2	3,90	22	8	◆

HC = Hartmetall beschichtet / *Solid carbide coated* / Metallo duro rivestito

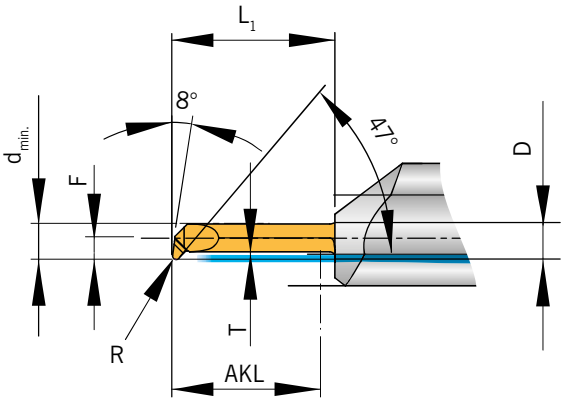
P	●
M	●
K	●
N	●
S	●
H	

● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

Kopieren 45° / *Copying 45°* / Copiatura 45°

516 – 522



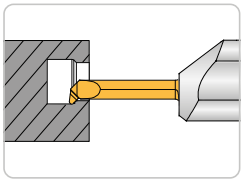


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	d_{min}	AKL	T	R	F	L_1	D	HC AP5015
AMS-K45-16015005-070.40L/R	1,6	7	0,15	0,05	0,9	9	4	◆
AMS-K45-2102005-090.40R	2,1	9	0,2	0,05	1,3	11	4	◆
AMS-K45-2602005-120.40R	2,6	12	0,2	0,05	1,3	14	4	◆
AMS-K45-3906015-200.40R	3,9	20	0,6	0,15	1,90	22	4	◆
AMS-K45-391304-200.40R	3,9	20	1,3	0,40	1,90	22	4	◆
AMS-K45-400604-120.40R	4,0	12	0,6	0,40	1,90	14	4	◆
AMS-K45-400604-150.40R	4,0	15	0,6	0,40	1,90	17	4	◆
AMS-K45-4008015-200.40R	4,0	20	0,8	0,15	1,90	22	4	◆
AMS-K45-5010015-250.60R	5,0	25	1,0	0,15	2,45	27	6	◆
AMS-K45-5918015-150.60L/R	5,9	15	1,8	0,15	2,90	17	6	◆
AMS-K45-5918015-300.60R	5,9	30	1,8	0,15	2,90	32	6	◆
AMS-K45-692902-100.60R	6,9	10	2,9	0,20	2,90	12	6	◆
AMS-K45-692902-150.60L/R	6,9	15	2,9	0,20	2,90	17	6	◆
AMS-K45-692902-200.60R	6,9	20	2,9	0,20	2,90	22	6	◆
AMS-K45-692902-300.60R	6,9	30	2,9	0,20	2,90	32	6	◆
AMS-K45-893902-150.80R	8,9	15	3,9	0,20	3,90	17	8	◆
AMS-K45-893902-200.80R	8,9	20	3,9	0,20	3,90	22	8	◆
AMS-K45-893902-300.80R	8,9	30	3,9	0,20	3,90	32	8	◆

HC = Hartmetall beschichtet / *Solid carbide coated* / Metallo duro rivestito

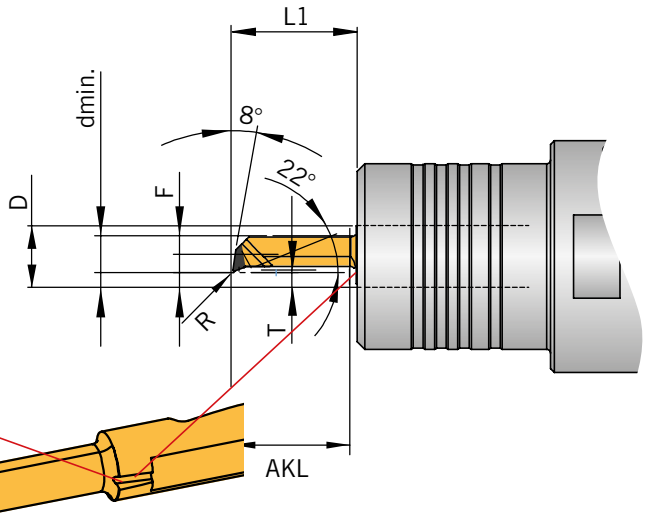
P	●
M	●
K	●
N	●
S	●
H	

● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

Kopieren - CBN bestückt / *Copy turning - CBN brazed* / Copiatura - riporto CBN

516 – 522



Zusätzliche Nut zur effektiven Kühlmittelzuführung bei dmin 3,0 mm / 4,0 mm und 5,0 mm
Additional groove for effective coolant supply for minimum diameter 3.0 mm / 4.0 mm and 5.0 mm
Scanalatura supplementare per un efficace adduzione del refrigerante per Dia 3,0 millimetri / 4,0 mm e 5,0 mm

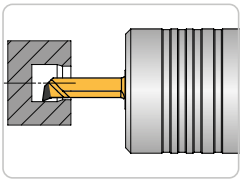


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	d_{min}	AKL	T	R	F	L_1	D	BC AH7525
AMS-K-300201-100.60R	3	10	0,2	0,1	1,5	12	6	◆
AMS-K-400302-130.60R	4	13	0,3	0,2	2,0	15	6	◆
AMS-K-500402-150.60R	5	15	0,4	0,2	2,5	17	6	◆
AMS-K-600402-180.60R	6	18	0,4	0,2	3,0	20	6	◆

BC = Hochharte-Schneidstoffe beschichtet / *CBN super hard cutting materials uncoated* / Materiali da taglio extra duri CBN rivestiti

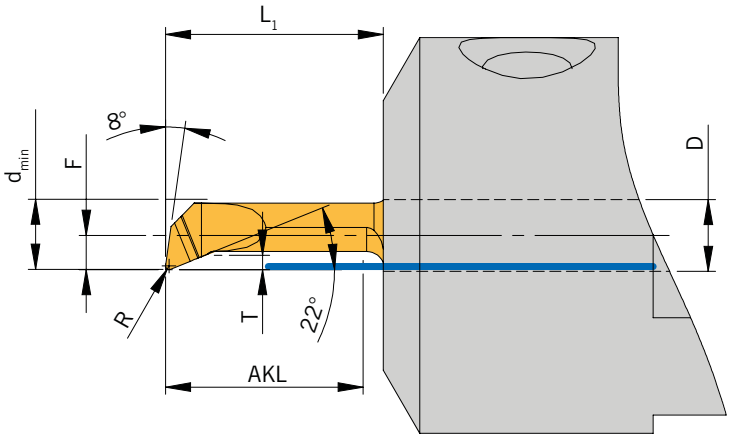
P	
M	
K	
N	
S	
H	●

● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

8

Kopieren / *Copying* / Copiatura



516 – 522

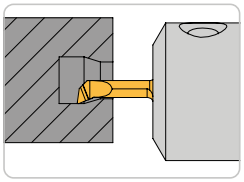


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	d_{min}	AKL	T	R	F	L_1	D	HC AP5015
AMS-US-K-390802-100.40R	3,9	10	0,8	0,2	1,9	12	4	◆

Diese Schneideinsätze passen nur auf folgenden Halter: HAMS-US-...
These tool holders fit on the following basic holder: HAMS-US-...
Questi adattatori si adattano ai seguenti adattatore base: HAMS-US-...

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

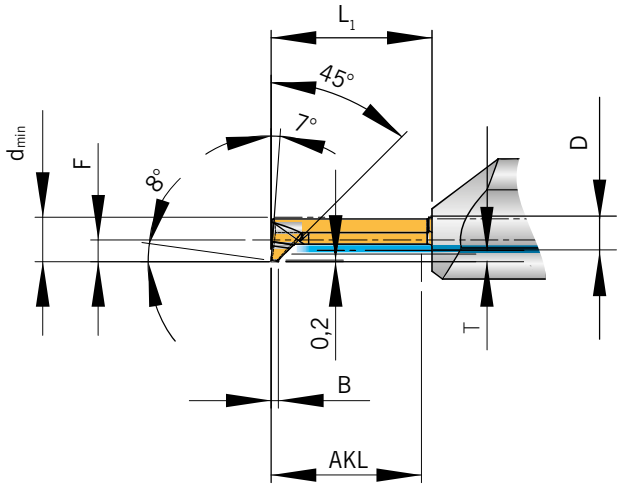
P	●
M	●
K	●
N	●
S	●
H	

● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

Vorstechen und Fasen / *Pre-grooving and chamfering* / Pre-scanalatura e smusso

516 – 522



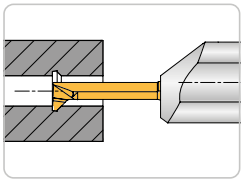


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	d_{min}	AKL	T	B + 0,03	F	L_1	D	HC AP5015
AMS-V-50100800-200.60R	5,0	20	0,8	1	2,4	22	6	◆
AMS-V-59100800-200.60R	5,9	20	0,8	1	2,9	22	6	◆

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

P	●
M	●
K	●
N	●
S	●
H	

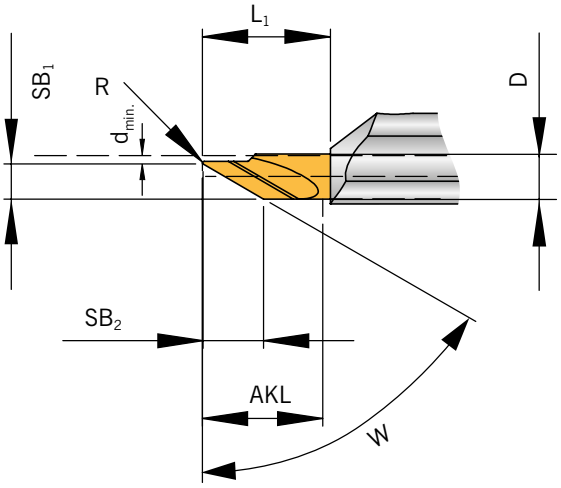
● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

8

Zentrum Fasen 45° / 60° / *Centre Chamfering 45° / 60° /* Smussatura centrale 45° / 60°

516 – 522



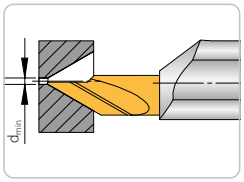


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	d_{min}	SB_1	SB_2	W	AKL	R	F	L_1	D	HC AP5015
AMS-ZF45-104502-150.60L/R	1	4,5	4,5	45°	15	0,2	2	17	6	◆
AMS-ZF60-108002-150.60L/R	1	4,5	7,9	60°	15	0,2	2	17	6	◆

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

P	●
M	●
K	●
N	●
S	●
H	

● **Hauptanwendung**
Main application
Applicazione principale

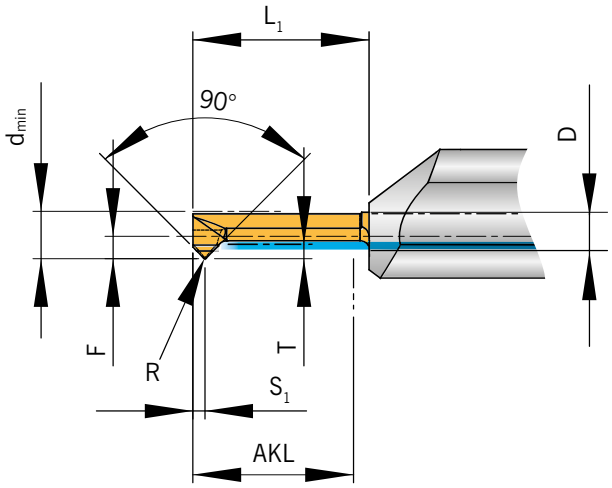
○ **Nebenanwendung**
Secondary application
Applicazione secondaria

8

Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

Fasen 45° / *Chamfering 45°* / Smusso 45°

516 – 522



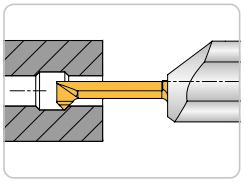


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	d_{min}	AKL	T	S_1	R	F	L_1	D	HC AP5015
AMS-F-250401-150.40R	2,5	15	0,4	1,0	0,1	1,15	17	4	◆
AMS-F-300401-150.40R	3,0	15	0,4	1,0	0,1	1,40	17	4	◆
AMS-F-390802-150.40R	3,9	15	0,8	1,2	0,2	1,90	17	4	◆
AMS-F-591802-200.60R	5,9	20	1,8	2,0	0,2	2,90	22	6	◆

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

P	●
M	●
K	●
N	●
S	●
H	

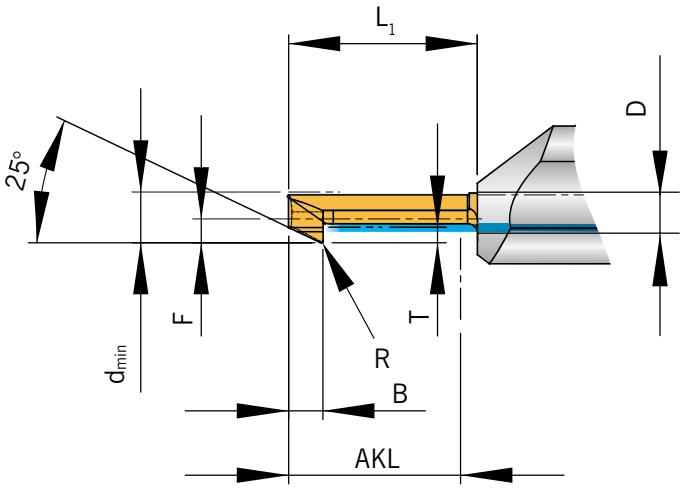
● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

8

Rückwärtsdrehen / *Back turning* / Lavorazione in tirata

516 – 522



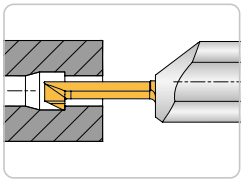


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	d_{min}	AKL	T	B	R	F	L_1	D	HC AP5015
AMS-R-39401002-150.40R	3,9	15	1	4	0,2	1,9	17	4	◆
AMS-R-59402002-200.60R	5,9	20	2	4	0,2	2,9	22	6	◆

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

P	●
M	●
K	●
N	●
S	●
H	

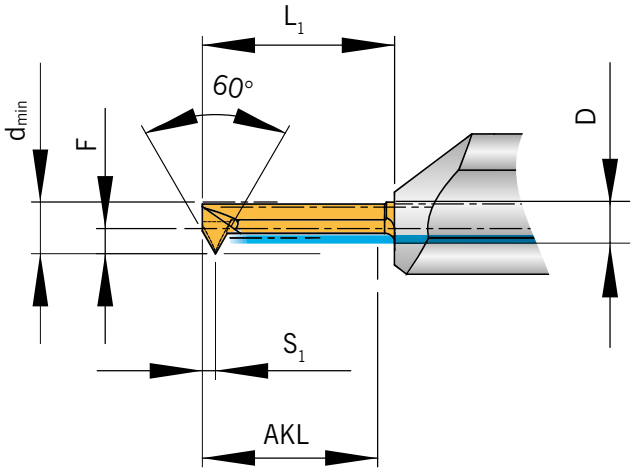
● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

Gewinde 60° - Metrisch-Teilprofil
Threading 60° - Metric partial profile
Filettatura 60° - Metrica profilo parziale

516 – 522



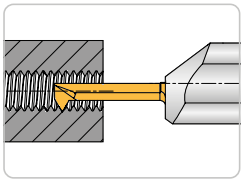


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

									HC
Bezeichnung *Designation* Articolo	d_{min}	**AKL**	**Gewinde** *Threading* Filettatura	**P Steigung** *P Pitch* P Passo	S_1	**F**	L_1	**D**	**AP5015**
AMS-G-MF020050-050.40R	2,3	5	>M2,5	0,2 - 0,5	0,45	1,1	6,5	4	◆
AMS-G-MF050070-150.40R	3,0	15	M4	0,5 - 0,7	0,70	1,4	17,0	4	◆
AMS-G-MF050100-150.40R	4,0	15	M5	0,5 - 1,0	0,70	1,9	17,0	4	◆
AMS-G-MF050150-200.60R	6,0	20	M8	0,5 - 1,5	0,80	2,9	22,0	6	◆

MF = ISO-Innengewinde Metrisch Fein
MF – ISO-Metric – Fine
MF – Filettatura Metrica ISO – Passo Fine

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

P	●
M	●
K	●
N	●
S	●
H	

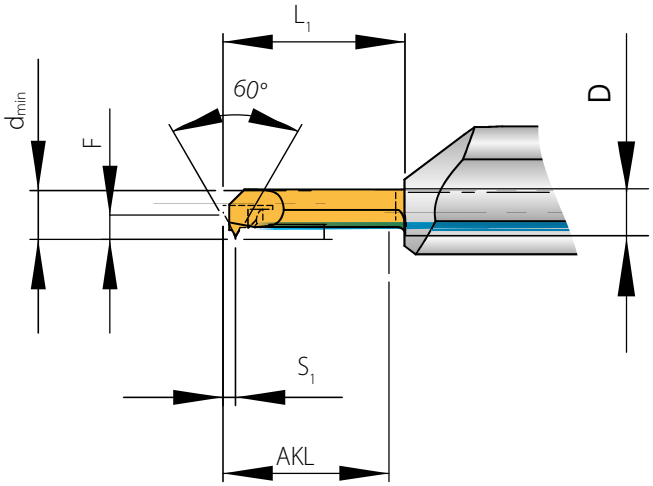
● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

8

Gewinde 60° - Metrisch-Vollprofil
Threading 60° - Metric full profile
Filettatura 60° - Metrica profilo completo

516 – 522



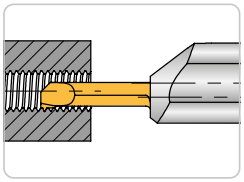


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	d_{min}	AKL	Gewinde *Threading* Filettatura	P Steigung *P Pitch* P Passo	S_1	F	L_1	D	HC AP5015
AMS-GV-MF025-150.40R	3,7	16	M4,5	0,25	0,4	1,9	18	4	◆
AMS-GV-MF035-150.40R	3,7	16	M4,5	0,35	0,4	1,9	18	4	◆
AMS-GV-MF050-150.40R	4,0	15	MF	0,50	0,4	1,9	17	4	◆
AMS-GV-MF060-150.40R	4,0	15	MF	0,60	0,4	1,9	17	4	◆
AMS-GV-MF070-150.40R	4,1	15	MF	0,70	0,5	1,9	17	4	◆
AMS-GV-MF075-150.40R	4,2	15	MF	0,75	0,5	1,9	17	4	◆
AMS-GV-M100-200.60R	4,8	20	M6	1,00	0,7	2,9	22	6	◆
AMS-GV-M100-150.40R	5,0	15	M6	1,00	0,7	1,9	17	4	◆
AMS-GV-MF025-150.60R	5,1	16	M4	0,25	0,4	2,5	18	6	◆
AMS-GV-MF080-150.60R	5,3	16	M6	0,80	0,5	2,6	18	6	◆
AMS-GV-MF050-150.60R	5,4	15	MF	0,50	0,4	2,5	17	6	◆
AMS-GV-MF075-150.60R	5,6	15	MF	0,75	0,5	2,6	17	6	◆
AMS-GV-M100-150.60R	5,7	15	M10	1,00	0,7	2,6	17	6	◆
AMS-GV-M125-200.60R	6,0	20	M8	1,25	0,8	2,9	22	6	◆
AMS-GV-M150-200.60R	6,0	20	M12	1,50	1,0	2,9	22	6	◆

M = ISO-Innengewinde Metrisch
M = ISO-Metric
M = Filettatura Metrica ISO
MF = ISO-Innengewinde Metrisch Fein
MF – ISO-Metric – Fine
MF – Filettatura Metrica ISO – Passo Fine

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

P	●
M	●
K	●
N	●
S	●
H	

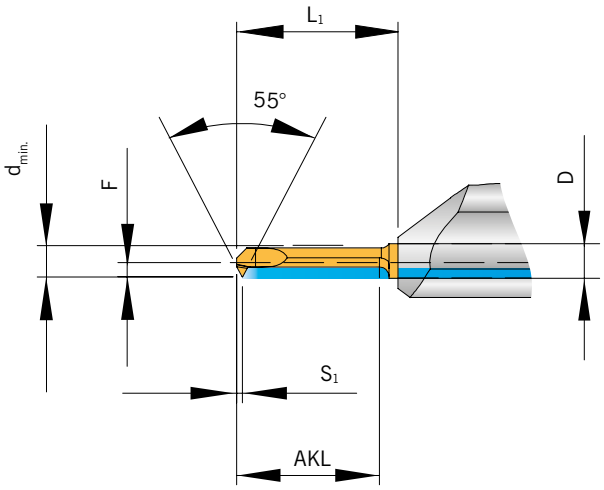
● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

Whithworth Gewinde 55° - Teilprofil
Whitworth thread 55° - Partial profile
Filettatura Whithworth 55° - Profilo parziale

516 – 522



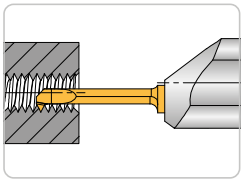


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	d_{min}	AKL	Gewinde *Threading* Filettatura	P Steigung *P Pitch* P Passo	S_1	F	L_1	D	HC AP5015
AMS-G-WF33025100-150.40R	3,3	15	WF	0,25 - 1,0	0,6	1,5	17	4	◆
AMS-G-WF43025100-150.40R	4,3	15	WF	0,25 - 1,0	0,6	1,9	17	4	◆
AMS-G-WF60050150-150.60R	6,0	15	WF	0,5 - 1,5	0,8	2,9	17	6	◆

WF = Whitworth – Feingewinde
WF = Whitworth – Fine
WF = Filettatura Whitworth – Passo fine

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

P	●
M	●
K	●
N	●
S	●
H	

● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

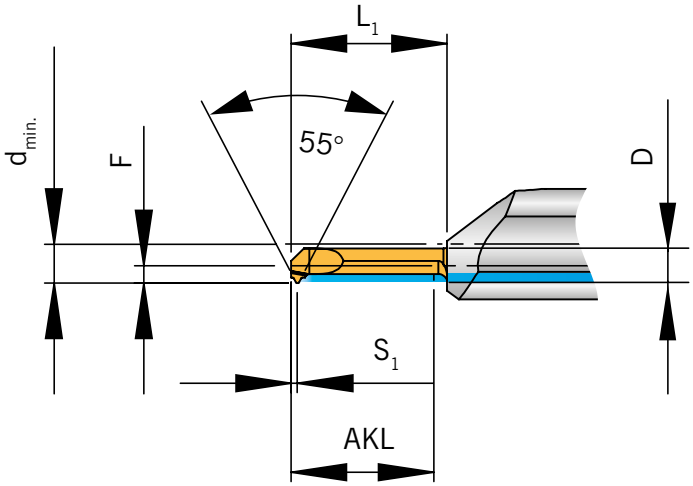
8

Whithworth Rohrgewinde 55° - DIN ISO 228-Vollprofil

Whitworth pipe thread 55° - DIN ISO 228-Full profil

Filettatura Whithworth 55° - DIN ISO 228-Profilo completo

516 – 522



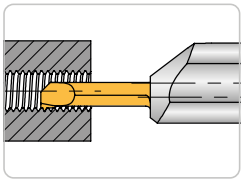


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	d_{min}	AKL	Gewinde *Threading* Filettatura	P Steigung *P Pitch* P Passo	G/Inch *TPI* G/Inch	S_1	F	L_1	D	HC AP5015
AMS-GV-W228/20-150.40R	4	15	W228	1,27	20	0,70	1,9	17	4	◆
AMS-GV-W228/19-150.60R	11	15	1/4"-19 BSP	1,33	19	0,95	2,9	17	6	◆

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

P	●
M	●
K	●
N	●
S	●
H	

● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

8

Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

Whithworth Rohrgewinde 55° BSW-Vollprofil
Whitworth pipe thread 55° BSW-Full profil
Filettatura Whithworth 55° BSW-Profilo completo

516 – 522

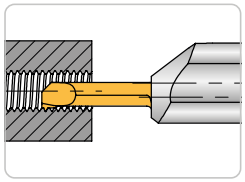
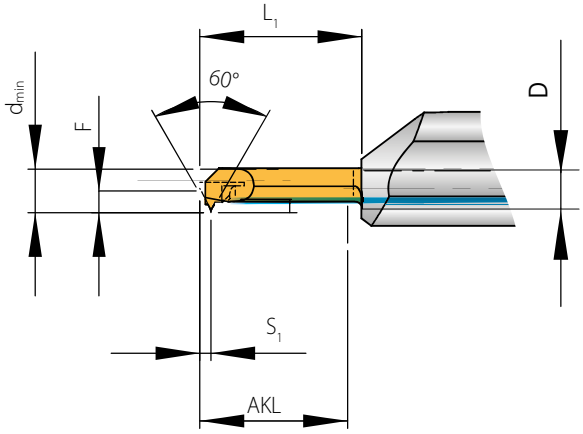


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione



									HC
Bezeichnung *Designation* Articolo	d_{min}	**AKL**	**Gewinde** *Threading* Filettatura	**G/Inch** *TPI* G/Inch	S_1	**F**	L_1	**D**	**AP5015**
AMS-GV-BSW24-150.40R	3,4	15	3/16"-24BSW	24	0,75	1,3	17	4	◆
AMS-GV-BSW24-150.60R	3,4	15	3/16"-24BSW	24	0,75	0,3	17	6	◆
AMS-GV-BSW28-150.60R	4,4	15	7/32"-28BSW	28	0,65	1,2	17	6	◆
AMS-GV-BSW22-150.60R	6,5	15	5/16"-22BSW	22	0,90	2,9	17	6	◆

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

P	●
M	●
K	●
N	●
S	●
H	

● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

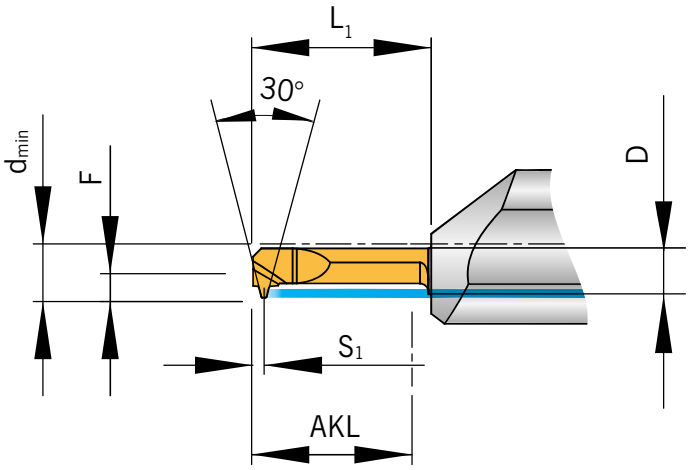
8

Trapezgewinde 30° DIN-ISO 103 – Teilprofil

Trapezoidal 30° DIN ISO 103 – Partial profile

Filettatura Trapezoidale 30° DIN ISO 103 – Profilo parziale

516 – 522



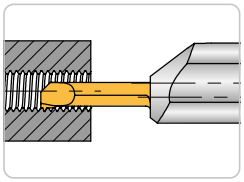


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	d_{min}	AKL	Gewinde *Threading* Filettatura	P Steigung *P Pitch* P Passo	S_1	F	L_1	D	HC AP5015
AMS-G-TR103/1.5R-200.60R	6,5	20	TR 8x1.5	1,5	0,85	2,9	22	6	◆
AMS-G-TR103/2.0R-200.60R	7,0	20	TR 9x2.0	2,0	1,30	2,9	22	6	◆
AMS-G-TR103/2.0R-200.80R	7,0	20	TR 9x2.0	2,0	1,30	2,6	22	8	◆
AMS-G-TR103/3.0R-200.80R	8,0	20	TR 11x3.0	3,0	1,40	3,6	22	8	◆

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

P	●
M	●
K	●
N	●
S	●
H	

● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

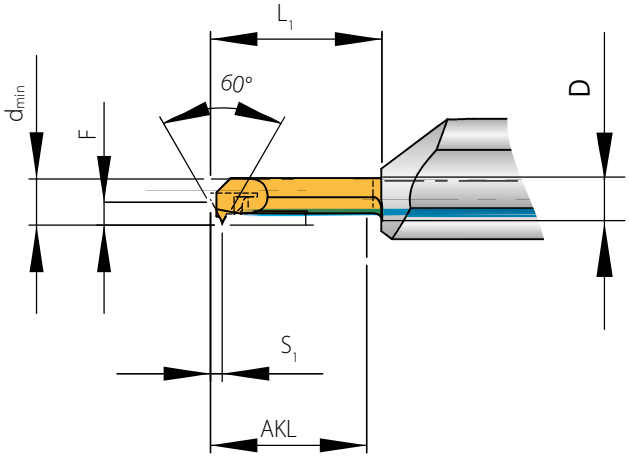
Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

Amerikanische ISO-Zollgewinde 60° - UN - Vollprofil

American thread 60° - UN - Full profile

Filettatura norme americane 60° - UN - Profilo completo

516 – 522



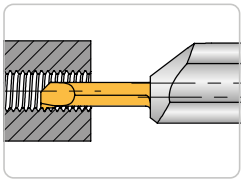


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	d_{min}	AKL	Gewinde *Threading* Filettatura	G/Inch *TPI*	S_1	F	L_1	D	HC AP5015
AMS-GV-UN32-110.40R	2,35	12	No.6-32 UNC	32	0,60	0,45	17	4	◆
AMS-GV-UN32-150.40R	2,60	16	No.6-32 UNC	32	0,60	0,45	17	4	◆
AMS-GV-UN32-150.60R	2,60	16	No.6-32 UNC	32	0,60	-0,55	17	6	◆
AMS-GV-UN24-150.40R	3,60	16	No.10-24 UNC	24	0,75	1,40	17	4	◆
AMS-GV-UN24-150.60R	3,60	16	No.10-24 UNC	24	0,75	0,40	17	6	◆
AMS-GV-UN28-150.40R	4,40	16	No.12-28 UNF	28	0,65	1,90	17	4	◆
AMS-GV-UN20-150.60R	4,80	16	1/4"-20 UNC	20	0,90	1,50	17	6	◆
AMS-GV-UN27-150.60R	5,30	16	1/4"-27 UNS	27	0,75	1,90	17	6	◆
AMS-GV-UN18-150.60R	6,20	16	5/16"-18 UNC	18	1,00	2,90	17	6	◆
AMS-GV-UN16-150.60R	7,60	16	3/8"-16 UNC	16	1,05	2,90	17	6	◆

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

P	●
M	●
K	●
N	●
S	●
H	

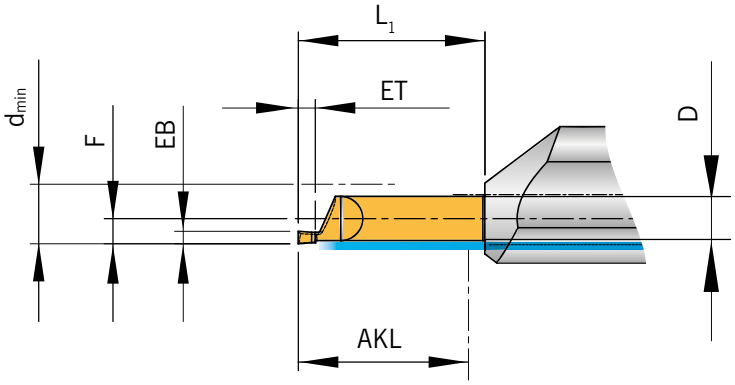
● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

8

Axial Stechen / *Axial grooving* / Scanalatura assiale

516 – 522



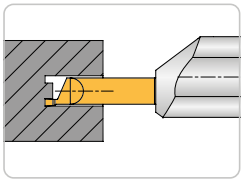


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	d_{min}	AKL	EB + 0,03	ET	R	F	L_1	D	HC AP5015
AMS-A-50071100-075.40R	5	7,5	0,70	1,1	0,00	1,9	9,7	4	◆
AMS-A-5007711005-075.40R	5	7,5	0,77	1,1	0,05	1,9	9,7	4	◆
AMS-A-50081200-075.40R	5	7,5	0,80	1,2	0,00	1,9	9,7	4	◆
AMS-A-50091300-075.40R	5	7,5	0,90	1,3	0,00	1,9	9,7	4	◆
AMS-A-50101500-075.40R	5	7,5	1,00	1,5	0,00	1,9	10,0	4	◆
AMS-A-501015005-075.40R	5	7,5	1,00	1,5	0,05	1,9	10,0	4	◆
AMS-A-50121500-075.40R	5	7,5	1,20	1,5	0,00	1,9	10,0	4	◆
AMS-A-50121500-150.40R	5	15,0	1,20	1,5	0,00	1,9	17,0	4	◆
AMS-A-502050005-100.40L/R	5	10,0	2,00	5,0	0,05	1,9	12,0	4	◆
AMS-A-600971500-100.60R	6	10,0	0,97	1,5	0,00	2,4	12,0	6	◆
AMS-A-60121500-100.60R	6	10,0	1,20	1,5	0,00	2,4	12,0	6	◆
AMS-A-60121500-180.60R	6	18,0	1,20	1,5	0,00	2,4	20,0	6	◆
AMS-A-70152000-100.60R	7	10,0	1,50	2,0	0,00	2,9	12,0	6	◆
AMS-A-70152000-200.60R	7	20,0	1,50	2,0	0,00	2,9	22,0	6	◆
AMS-A-801530015-100.80R	8	10,0	1,50	3,0	0,15	2,0	12,0	8	◆
AMS-A-90152000-100.80R	9	10,0	1,50	2,0	0,00	3,8	12,0	8	◆
AMS-A-90152000-250.80R	9	25,0	1,50	2,0	0,00	3,8	27,0	8	◆

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito

P	●
M	●
K	●
N	●
S	●
H	

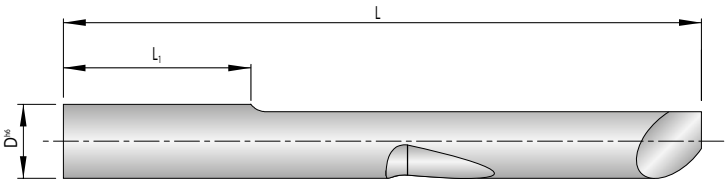
● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

Halbzeuge zur Eigenprofilierung / *Blanks fo special profiles* / Semilavorato per la realizzazione di speciali

516 – 522



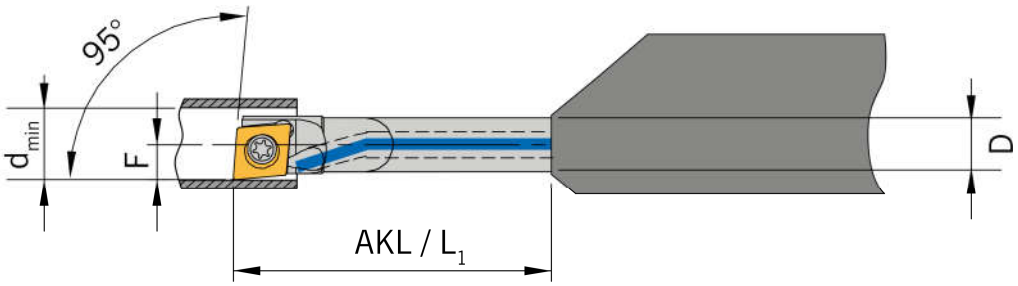
D = ø Profilseite [mm]
L1 = Auskraglänge [mm]
Linke Ausführung abgebildet.
D = ø Profile side [mm]
L1 = Maximum work length [mm]
Left hand execution shown
D = ø lato profilo [mm]
L1 = Massima lunghezza di lavoro [mm]
Esecuzione sinistra in figura

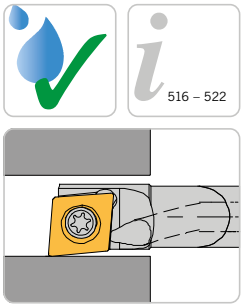
Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

Bezeichnung *Designation* Articolo	D_{h6}	L	L_1	
H-AMS-100-40L/R	4	34,4	10	◆
H-AMS-150-40L/R	4	39,4	15	◆
H-AMS-200-40L/R	4	44,4	20	◆
H-AMS-250-40L/R	4	49,4	25	◆
H-AMS-100-60L/R	6	40,6	10	◆
H-AMS-150-60L/R	6	45,6	15	◆
H-AMS-200-60L/R	6	50,6	20	◆
H-AMS-250-60L/R	6	55,6	25	◆
H-AMS-300-60L/R	6	60,6	30	◆
H-AMS-350-60R	6	65,6	35	◆
H-AMS-400-60R	6	70,6	40	◆
H-AMS-450-60R	6	75,6	45	◆
H-AMS-500-60R	6	80,6	50	◆
H-AMS-100-80R	8	40,4	10	◆
H-AMS-150-80L/R	8	45,4	15	◆
H-AMS-200-80R	8	50,4	20	◆
H-AMS-250-80L/R	8	55,4	25	◆
H-AMS-300-80R	8	60,4	30	◆
H-AMS-450-80R	8	75,4	45	◆
H-AMS-500-80R	8	80,4	50	◆
H-AMS-200-100R	10	50,4	20	◆
H-AMS-250-100R	10	55,4	25	◆
H-AMS-300-100R	10	60,4	30	◆
H-AMS-350-100R	10	65,4	35	◆

Hinweis: Sonderformen nach Kundenzeichung auf Anfrage.
Information: Special form inserts to customer's drawing on request.
Indicazione: Esecuzione di profili speciali su richiesta.

SCLD L/R Anstellwinkel / *Approach angle* / Angolo di attacco: 95°





516 – 522

Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

AMS-Bohrstangen - mit innerer Kühlmittelzufuhr / *AMS boring bar - with through tool coolant* / Bareno AMS - con adduzione interna del refrigerante

Bezeichnung *Designation* Articolo	D_{min}	AKL	F	L_1	D	**Wendeschneidplatte** *Insert* Inserto
E04-SCLDL/R04-AMS	4,8	24,0	2,4	24,0	4	CD.. 040102...
E06-SCLDL/R04-AMS	6,8	37,7	3,4	37,7	6	CD.. 040102...

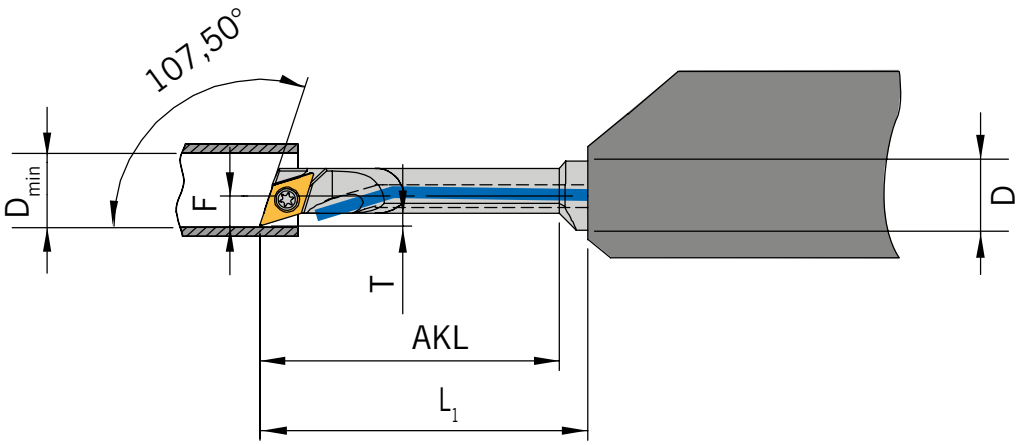
Ersatzteile / *Spare Parts* / Ricambi

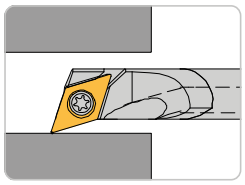
Trägerwerkzeug *Holder* Utensile	**Schraube** *Screw* Vite	**Schlüssel** *Key* Chiave
E...-SCLDL/R04-AMS	T1,8.03	KS 1886

Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

SDQC L/R Anstellwinkel / *Approach angle* / Angolo di attacco: **107,5°**

516 – 522





Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

AMS-Bohrstangen - mit innerer Kühlmittelzufuhr / *AMS boring bar - with through tool coolant* / Bareno AMS - con adduzione interna del refrigerante

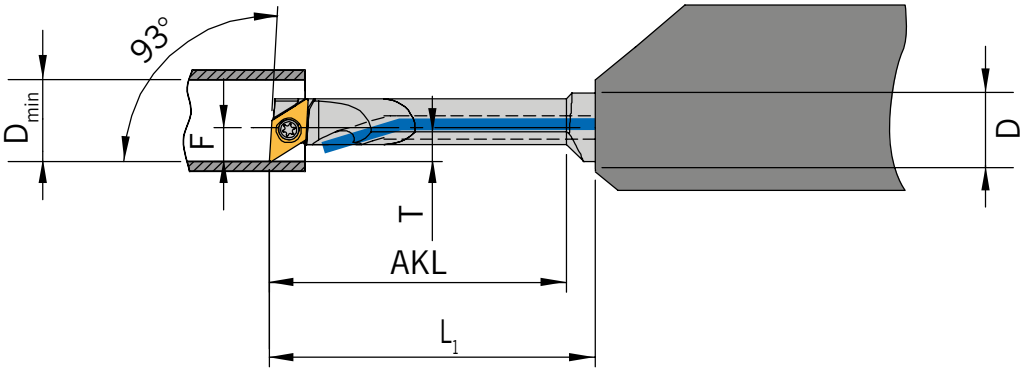
Bezeichnung *Designation* Articolo	**D_{min}**	**AKL**	**T**	**F**	**L_1**	**D**	**Wendeschneid-platte** *Insert* Inserto
E0406-SDQCL/R04-AMS	5,2	26	1,1	2,6	28,5	6	DC.. 04T0...
E0408-SDQCL/R04-AMS	5,2	26	1,1	2,6	29,5	8	DC.. 04T0...

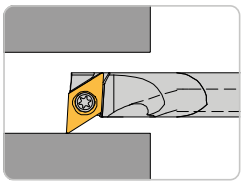
Ersatzteile / *Spare Parts* / Ricambi

Trägerwerkzeug *Holder* Utensile	**Schraube** *Screw* Vite	**Schlüssel** *Key* Chiave
E...-SDQCL/R04-AMS	AS 0112	KS 2505

SDUC L/R Anstellwinkel / *Approach angle* / Angolo di attacco: 93°

516 – 522





Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

AMS-Bohrstangen - mit innerer Kühlmittelzufuhr / *AMS boring bar - with through tool coolant* / Bareno AMS - con adduzione interna del refrigerante

Bezeichnung *Designation* Articolo	D_{min}	AKL	T	F	L_1	D	**Wendeschneidplatte** *Insert* Inserto
E0406-SDUCL/R04-AMS	5,6	26	1,5	3	28,5	6	DC.. 04T0...
E0408-SDUCL/R04-AMS	5,6	26	1,5	3	29,5	8	DC.. 04T0...

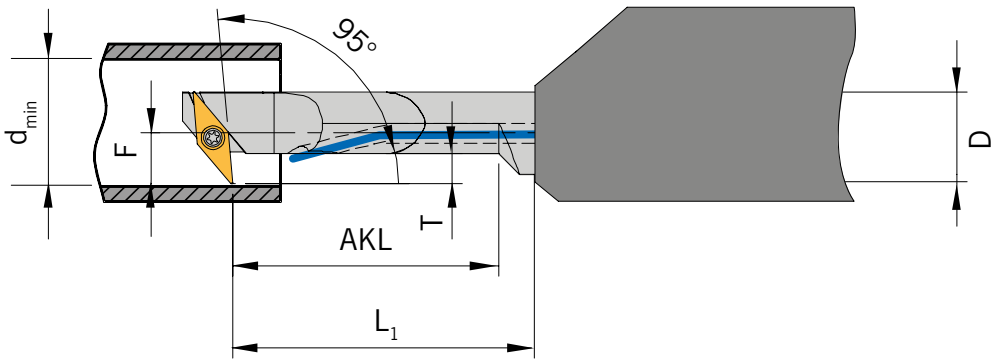
Ersatzteile / *Spare Parts* / Ricambi

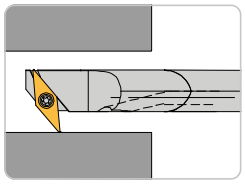
Trägerwerkzeug *Holder* Utensile	**Schraube** *Screw* Vite	**Schlüssel** *Key* Chiave
E...-SDUCL/R04-AMS	AS0112	KS 2505

Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

SV95C L/R Anstellwinkel / *Approach angle* / Angolo di attacco: 95°

516 – 522





Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

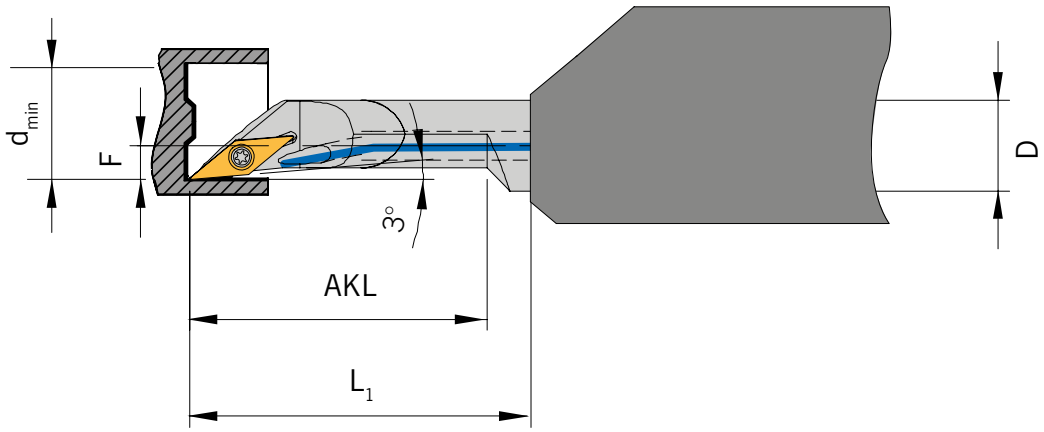
AMS-Bohrstangen - mit innerer Kühlmittelzufuhr / *AMS boring bar - with through tool coolant* / Bareno AMS - con adduzione interna del refrigerante

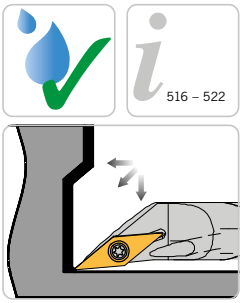
Bezeichnung *Designation* Articolo	d_{min}	**AKL**	**T**	**F**	L_1	**D**	**Wendeschneidplatte** *Insert* Inserto
E0406-SV95CL/R05-AMS	9,5	26	4,5	6	28	6	VC.. 0501...
E0408-SV95CL/R05-AMS	9,5	26	3,0	5	29	8	VC.. 0501...

Ersatzteile / *Spare Parts* / Ricambi

Trägerwerkzeug *Holder* Utensile	**Schraube** *Screw* Vite	**Schlüssel** *Key* Chiave
E04..-SV95CL/R05-AMS	AS 0112	KS 2505

SVJC L/R Anstellwinkel / *Approach angle* / Angolo di attacco: 52°





Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

AMS-Bohrstangen - mit innerer Kühlmittelzufuhr / *AMS boring bar - with through tool coolant* / Bareno AMS - con adduzione interna del refrigerante

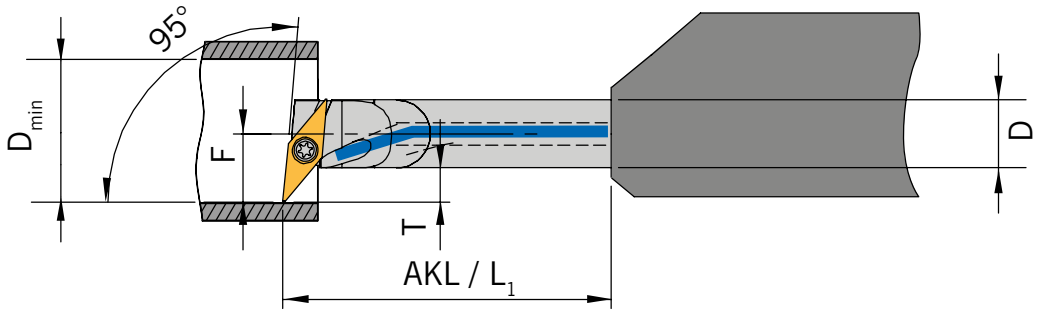
Bezeichnung *Designation* Articolo	d_{min}	**AKL**	**F**	L_1	**D**	**Wendeschneidplatte** *Insert* Inserto
E0406-SVJCL/R05-AMS	5,5	26	2	28	6	VC.. 0501...
E0408-SVJCL/R05-AMS	5,5	26	2	29	8	VC.. 0501...

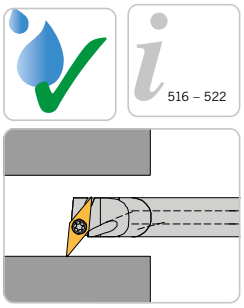
Ersatzteile / *Spare Parts* / Ricambi

Trägerwerkzeug *Holder* Utensile	**Schraube** *Screw* Vite	**Schlüssel** *Key* Chiave
04E...-SVLCL/R05-AMS	AS 0112	KS 2505

Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

SVLC L/R Anstellwinkel / *Approach angle* / Angolo di attacco: 95°





Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

AMS-Bohrstangen - mit innerer Kühlmittelzufuhr / *AMS boring bar - with through tool coolant* / Bareno AMS - con adduzione interna del refrigerante

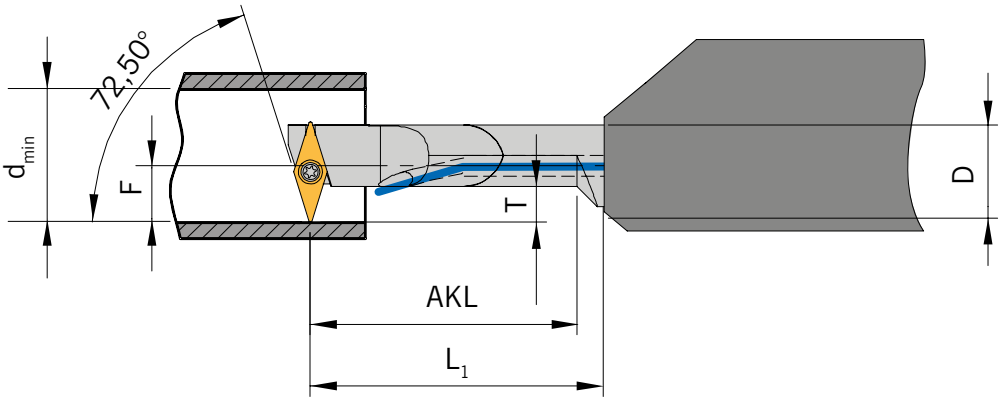
Bezeichnung *Designation* Articolo	D_{min}	**AKL**	**T**	**F**	L_1	**D**	**Wendeschneidplatte** *Insert* Inserto
E0406-SVLCL/R05-AMS	9,2	29	3	6	29	6	VC.. 0501...
E0408-SVLCL/R05-AMS	9,2	26	3	5	29	8	VC.. 0501...

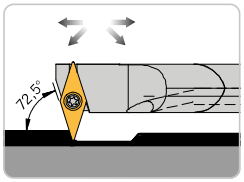
Ersatzteile / *Spare Parts* / Ricambi

Trägerwerkzeug *Holder* Utensile	**Schraube** *Screw* Vite	**Schlüssel** *Key* Chiave
E...-SVLCL/R05-AMS	AS 0113	KS 2505

SVVC L/R Anstellwinkel / *Approach angle* / Angolo di attacco: 72,5°

516 – 522





Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

AMS-Bohrstangen - mit innerer Kühlmittelzufuhr / *AMS boring bar - with through tool coolant* / Bareno AMS - con adduzione interna del refrigerante

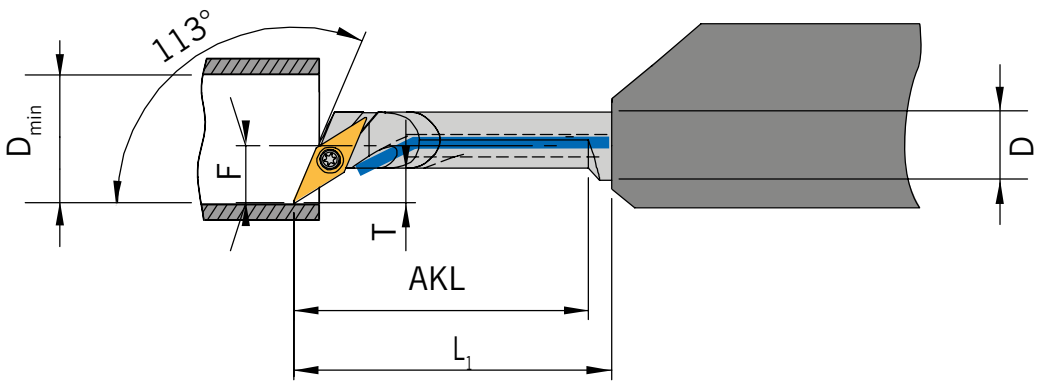
Bezeichnung *Designation* Articolo	d_{min}	AKL	T	F	L_1	D	**Wendeschneidplatte** *Insert* Inserto
E0406-SVVCL/R05-AMS	10,3	26	4,5	6,5	28	6	VC.. 0501...
E0408-SVVCL/R05-AMS	10,5	26	3,5	5,5	29	8	VC.. 0501...

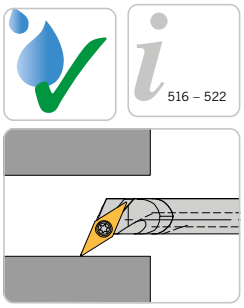
Ersatzteile / *Spare Parts* / Ricambi

Trägerwerkzeug *Holder* Utensile	**Schraube** *Screw* Vite	**Schlüssel** *Key* Chiave
E04..-SVVCL/R05-AMS	AS 0112	KS 2505

Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

SVXC L/R Anstellwinkel / *Approach angle* / Angolo di attacco: 113°





Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

AMS-Bohrstangen - mit innerer Kühlmittelzufuhr / *AMS boring bar - with through tool coolant* / Bareno AMS - con adduzione interna del refrigerante

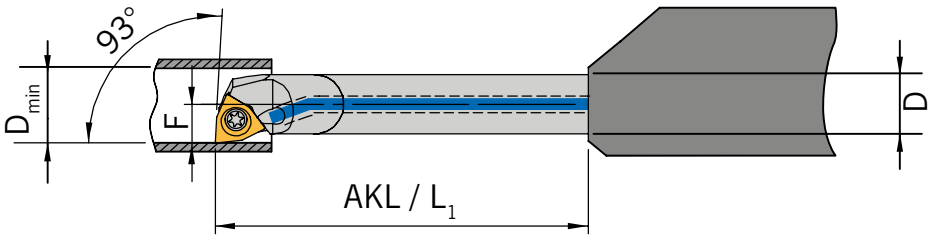
Bezeichnung *Designation* Articolo	D_{min}	**AKL**	**T**	**F**	L_1	**D**	**Wendeschneidplatte** *Insert* Inserto
E0406-SVXCL/R05-AMS	8,2	26	3	5	28	6	VC.. 0501...
E0408-SVXCL/R05-AMS	9,2	26	3	5	29	8	VC.. 0501...

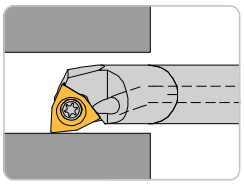
Ersatzteile / *Spare Parts* / Ricambi

Trägerwerkzeug *Holder* Utensile	**Schraube** *Screw* Vite	**Schlüssel** *Key* Chiave
E...-SVXCL/R05-AMS	AS 0113	KS 2505

SWUC L/R Anstellwinkel / *Approach angle* / Angolo di attacco: 93°

516 – 522





Rechte Ausführung abgebildet
Right-hand execution shown
Versione destra in figura

Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

AMS-Bohrstangen - mit innerer Kühlmittelzufuhr / *AMS boring bar - with through tool coolant* / Bareno AMS - con adduzione interna del refrigerante

Bezeichnung *Designation* Articolo	**D_{min}**	**AKL**	**F**	**L_1**	**D**	**Wendeschneid-platte** *Insert* Inserto
E06-SWUCL/R02-AMS	7,8	37,5	3,9	37,5	6	WC.. 0201...

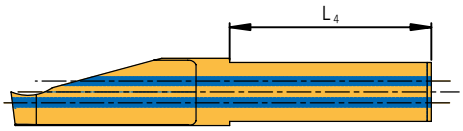
Ersatzteile / *Spare Parts* / Ricambi

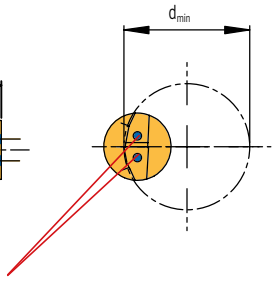
Trägerwerkzeug *Holder* Utensile	**Schraube** *Screw* Vite	**Schlüssel** *Key* Chiave
E06...-SWUCL/R02-AMS	T2.03	KS 1886

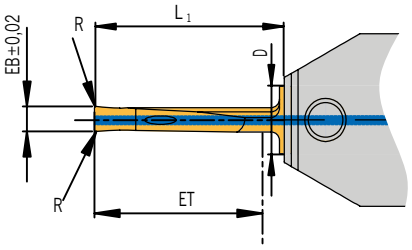
8

Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

Axial Stechen / *Axial grooving* / Scanalatura assiale







Linke Ausführung abgebildet
Left-hand execution shown
Esecuzione sinistra

Innere Kühlmittelzuführung für garantiert optimale Kühlung an der Schneide und prozess-sicheren Spänetransport.
Through tool coolant for both maximum coolant direct at the cutting edge and swarf evacuation.
Il circuito di raffreddamento interno garantisce una refrigerazione ottimale sul tagliente insieme ad una buona evacuazione del truciolo.

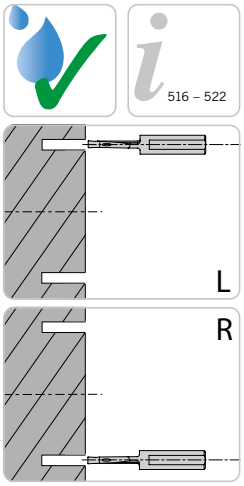


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

516 – 522

Bezeichnung *Designation* Articolo	d_{min}	EB	ET	R	L_1	L_4	D	HC AL40	HU AK40
SAV151006-IK-L/R	10	1,5	10	0,1	13	16	6	◆	◆
SAV151506-IK-L/R	10	1,5	15	0,1	18	16	6	◆	◆
SAV201206-IK-L/R	12	2,0	12	0,2	16	16	6	◆	◆
SAV202006-IK-L/R	12	2,0	20	0,2	23	16	6	◆	◆
SAV252008-IK-L/R	15	2,5	20	0,2	22	24	8	◆	◆
SAV302008-IK-L/R	15	3,0	20	0,2	22	24	8	◆	◆
SAV303008-IK-L/R	15	3,0	30	0,2	34	24	8	◆	◆
SAV403010-IK-L/R	30	4,0	30	0,2	34	24	10	◆	◆
SAV404010-IK-L/R	30	4,0	40	0,2	44	24	10	◆	◆

Beim Axialstechen ins Volle ist die komplette Stechtiefe nur im Durchmesserbereich bis 50mm erreichbar.
When face grooving into solid the overall groove depth can only be obtained in diameter range up to 50mm.
Con la scanalatura assiale dal pieno la profondità completa di scanalatura si ottiene solamente per una gamma di diametri fino a 50mm.
L_4 = Spannfläche
L_4 = Clamping flat
L_4 = Piano bloccaggio

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito
HU = Hartmetall unbeschichtet / *Carbide uncoated* / Metallo duro non rivestito

	HC	HU
P	●	●
M	●	
K	●	●
N		●
S	●	
H		

● **Hauptanwendung**
Main application
Applicazione principale

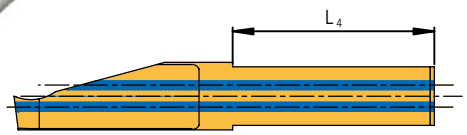
○ **Nebenanwendung**
Secondary application
Applicazione secondaria

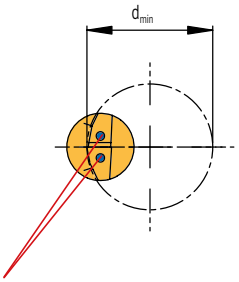
8

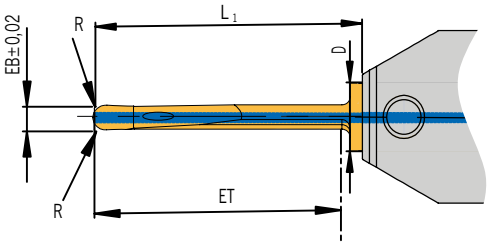
Axial Stechen - Vollradiusausführung

Axial grooving - Full radius execution

Scanalatura assiale - Esecuzione a raggio completo







Linke Ausführung abgebildet
Left-hand execution shown
Esecuzione sinistra

Innere Kühlmittelzuführung für garantiert optimale Kühlung an der Schneide und prozess-sicheren Spänetransport.
Through tool coolant for both maximum coolant direct at the cutting edge and swarf evacuation.
Il circuito di raffreddamento interno garantisce una refrigerazione ottimale sul tagliente insieme ad una buona evacuazione del truciolo.

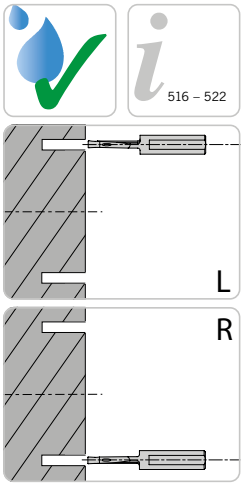


Abbildung ähnlich
Similar to illustration
Simile all'illustrazione

516 – 522

Bezeichnung *Designation* Articolo	d_{min}	EB	ET	R	L_1	L_4	D	HC AL40	HU AK40
SAV202006-V-IK-L/R	12	2	20	1,0	23	16	6	◆	◆
SAV303008-V-IK-L/R	15	3	30	1,5	34	24	8	◆	◆

	HC	HU
P	●	●
M	●	
K	●	●
N		●
S	●	
H		

Beim Axialstechen ins Volle ist die komplette Stechtiefe nur im Durchmesserbereich bis 50mm erreichbar.
When face grooving into solid the overall groove depth can only be obtained in diameter range up to 50mm.
Con la scanalatura assiale dal pieno la profondità completa di scanalatura si ottiene solamente per una gamma di diametri fino a 50mm.
V = Vollradiusausführung
V = Full radius execution
V = Esecuzione a raggio completo
L = Spannfläche
L= Clamping flat
L = Piano bloccaggio

HC = Hartmetall beschichtet / *Carbide coated* / Metallo duro rivestito
HU = Hartmetall unbeschichtet / *Carbide uncoated* / Metallo duro non rivestito

● **Hauptanwendung**
Main application
Applicazione principale

○ **Nebenanwendung**
Secondary application
Applicazione secondaria

Alle Angaben in mm / *Dimensions in mm* / Tutte le dimensioni in mm

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Wenn besondere Aufgaben individuelle Lösungen erfordern, sind Sie bei uns genau richtig.
Als Hersteller können wir AMS-Schneideinsätze schnell und zuverlässig nach Ihren Vorgaben fertigen.
Nennen Sie uns dazu einfach den Standard-Schneideinsatz und die Maße, die Sie gerne geändert hätten:

Standard-Schneideinsatz AMS- _____

Diese Maße bitte ändern: _____

_____

_____

_____

Skizze:

Adresse:

Firma: _____

Anschrift: _____

Ansprechpartner: _____

E-Mail: _____

Telefon: _____

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Should your application require a purpose made tool, we can quote that too.
As the manufacturer we can offer special AMS inserts, accurately and quickly.
Please tell us the standard inserts and the dimensions you would like to have changed:

Standard insert AMS- _____

Please change this dimensions: _____

_____

_____

_____

Draft drawing:

Address:

Company: _____

Address: _____

Contact: _____

E-Mail: _____

Phone: _____

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Dateci tutte le misure richieste o le modifiche da apportare ad utensili standard:

Inserto standard **AMS-** _____

Dimensioni di riferimento _____

_____

_____

_____

Disegno:

Indirizzo:

Azienda: _____

Indirizzo: _____

Persona di contatto: _____

E-Mail: _____

Telefono: _____

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Artikel / *Item* / Articolo
Schraube / *Screw* / Vite
AS 0043
AS 0044

Kühlmittelverschlussring / *Coolant seal ring* / Anello tenuta refrigerante
KVR 12
KVR 16
KVR 20

Schlüssel / *Key* / Chiave
KP 1111
KP 3111

Werkstoffgruppe	Gliederung der Werkstoffhauptgruppen und Kennbuchstaben			Brinell-Härte	Zugfestigkeit (N/mm²)	Zerspanungsgruppe	Schnittgeschwindigkeit Vc (m/min) HC AL40	HC AP5015	HU AK40	BC AH7525
P	Unlegierter Stahl	C ≤ 0,25 %	geglüht	125	428	P1	80 - 90 - 100	20 - 100 - 180	-	-
		C > = 0,25 ... > = 0,55 %	geglüht	190	639	P2	80 - 90 - 100	20 - 100 - 180	-	-
		C > = 0,25 ... > = 0,55 %	vergütet	210	708	P3	80 - 90 - 100	20 - 100 - 180	-	-
		C ≤ 0,55 %	geglüht	190	639	P4	80 - 90 - 100	20 - 100 - 180	-	-
		C ≤ 0,55 %	vergütet	300	1013	P5	70 - 80 - 90	20 - 100 - 180	-	-
		Automatenstahl (kurzspanend)	geglüht	220	745	P6	80 - 90 - 100	20 - 100 - 180	-	-
	Niedrig legierter Stahl	geglüht		175	591	P7	80 - 90 - 100	15 - 90 - 160	-	-
		vergütet		300	1013	P8	70 - 80 - 90	15 - 90 - 160	-	-
		vergütet		380	1282	P9	50 - 60 - 70	15 - 90 - 160	-	-
		vergütet		430	1477	P10	50 - 60 - 70	15 - 90 - 160	-	-
	Hochlegierter Stahl und hochlegierter Werkzeugstahl	geglüht		200	675	P11	80 - 90 - 100	20 - 70 - 120	-	-
		gehärtet und angelassen		300	1013	P12	50 - 60 - 70	20 - 70 - 120	-	-
		gehärtet und angelassen		400	1361	P13	50 - 60 - 70	20 - 70 - 120	-	-
	Nichtrostender Stahl	ferretisch / martensitisch, geglüht		200	675	P14	40 - 65 - 90	20 - 55 - 90	-	-
		martensitisch, vergütet		330	1114	P15	40 - 65 - 90	20 - 100 - 180	-	-
M	Nichtrostender Stahl	austenitisch, abgeschreckt		200	675	M1	40 - 65 - 90	20 - 55 - 90	-	-
		ausenitisch, ausscheidungsgehärtet (PH)		300	1013	M2	40 - 65 - 90	15 - 50 - 80	-	-
		austentisch-ferritisch, Duplex		230	778	M3	40 - 65 - 90	10 - 35 - 60	-	-
K	Temperguss	ferritisch		200	675	K1	50 - 60 - 70	20 - 70 - 120	40 - 50 - 60	-
		perlitisch		260	867	K2	50 - 60 - 70	20 - 70 - 120	40 - 50 - 60	-
	Grauguss	niedrige Festigkeit		180	602	K3	50 - 60 - 70	20 - 80 - 140	40 - 50 - 60	-
		hohe Festigkeit / austenitisch		245	825	K4	50 - 60 - 70	20 - 80 - 140	40 - 50 - 60	-
	Gusseisen mit Kugelgraphit	ferritisch		155	518	K5	50 - 60 - 70	20 - 75 - 130	40 - 50 - 60	-
		perlitisch		265	885	K6	50 - 60 - 70	20 - 75 - 130	40 - 50 - 60	-
	GGV (CGI)			200	675	K7	50 - 60 - 70	20 - 70 - 120	40 - 50 - 60	-
N	Aluminium-Knetlegierung	nicht aushärtbar		30	-	N1	-	20 - 260 - 500	100 - 125 - 150	-
		aushärtbar, ausgehärtet		100	343	N2	-	20 - 260 - 500	100 - 125 - 150	-
	Aluminium-Gusslegierung	≤ 12 % Si, nicht aushärtbar		75	260	N3	-	20 - 260 - 500	100 - 125 - 150	-
		≤ 12 % Si, aushärtbar, ausgehärtet		90	314	N4	-	20 - 260 - 500	100 - 125 - 150	-
		> 12 % Si, nicht aushärtbar		130	447	N5	-	20 - 260 - 500	100 - 125 - 150	-
	Magnesiumlegierung			70	250	N6	-	-	-	-
	Kupfer und Kupferlegierung (Bronze / Messing)	unlegiert, Elektolykupfer		100	343	N7	120 - 150 - 180	20 - 310 - 600	100 - 125 - 150	-
		Messing, Bronze, Rotguss		90	314	N8	120 - 150 - 180	20 - 310 - 600	100 - 125 - 150	-
		Cu-Legierung, kurzspanend		110	382	N9	120 - 150 - 180	20 - 310 - 600	100 - 125 - 150	-
		hochfest, Ampco		300	1013	N10	-	-	-	-
	Nichtmetallische Werkstoffe	Thermoplaste (ohne abrasive Füllstoffe)		-	-	N11	-	-	-	-
		Duroplaste (ohne abrasive Füllstoffe)		-	-	N12	-	-	-	-
		Kunststoff glasfaserverstärkt GFRP		-	-	N13	-	-	-	-
		Kunststoff kohlefaserverstärkt CFRP		-	-	N14	-	-	-	-
		Kunststoff aramidfaserverstärkt AFRP		-	-	N15	-	-	-	-
		Graphit (technisch)		80 Shore	-	N16	-	-	-	-
S	Warmfeste Legierungen	Fe-Basis	geglüht	200	675	S1	40 - 65 - 90	15 - 45 - 75	-	-
		Fe-Basis	ausgehärtet	280	943	S2	40 - 65 - 90	15 - 45 - 75	-	-
		Ni- oder Co-Basis	geglüht	250	839	S3	40 - 65 - 90	15 - 30 - 40	-	-
		Ni- oder Co-Basis	ausgehärtet	350	1177	S4	40 - 65 - 90	15 - 30 - 40	-	-
		Ni- oder Co-Basis	gegossen	320	1076	S5	40 - 65 - 90	15 - 30 - 40	-	-
	Titanlegierung	Reintitan		200	675	S6	-	-	-	-
		a- und ß-Legierungen, ausgehärtet		375	1262	S7	-	-	-	-
		ß-Legierungen		410	1396	S8	-	-	-	-
	Wolframlegierungen			300	1013	S9	-	-	-	-
	Molybdänlegierungen			300	1013	S10	-	-	-	-
H	Gehärteter Stahl	gehärtet und angelassen		50 HRC	-	H1	-	-	-	60 - 105 - 150
		gehärtet und angelassen		55 HRC	-	H2	-	-	-	60 - 105 - 150
		gehärtet und angelassen		60 HRC	-	H3	-	-	-	60 - 105 - 150
	Gehärtetes Gusseisen	gehärtet und angelassen		55 HRC	-	H4	-	-	-	60 - 105 - 150

Die Tabellenwerte sind Richtwerte.
Es kann notwendig sein, die Werte den jeweiligen Bearbeitungsumständen anzupassen.

HC = Hartmetall beschichtet
HU = Hartmetall unbeschichtet
BC = Hochharte-Schneidstoffe beschichtet

	HC		HU	BC
P	●	●	●	
M	●	●		
K	●	●		
N		●	●	
S	●	●	●	
H				●

● **Hauptanwendung**
○ **Nebenanwendung**

8

Material group	Structure of the material groups and identification letters			Brinell hardness HB	Tensile strength Rm (N/mm²)	Chipping group	Cutting speed V_c (m/min) HC AL40	HC AP5015	HU AK40	BC AH7525
P	Unalloyed steel	C ≤ 0.25 %	annealed	125	428	P1	80 - 90 - 100	20 - 100 - 180	-	-
		C > = 0,25 ... > = 0,55 %	annealed	190	639	P2	80 - 90 - 100	20 - 100 - 180	-	-
		C > = 0,25 ... > = 0,55 %	hardened and tempered	210	708	P3	80 - 90 - 100	20 - 100 - 180	-	-
		C ≤ 0.55 %	annealed	190	639	P4	80 - 90 - 100	20 - 100 - 180	-	-
		C ≤ 0.55 %	hardened and tempered	300	1013	P5	70 - 80 - 90	20 - 100 - 180	-	-
		Machinig steel (short-clipping)	annealed	220	745	P6	80 - 90 - 100	20 - 100 - 180	-	-
	Low alloyed steel	annealed		175	591	P7	80 - 90 - 100	15 - 90 - 160	-	-
		hardened and tempered		300	1013	P8	70 - 80 - 90	15 - 90 - 160	-	-
		hardened and tempered		380	1282	P9	50 - 60 - 70	15 - 90 - 160	-	-
		hardened and tempered		430	1477	P10	50 - 60 - 70	15 - 90 - 160	-	-
	High alloyed steel and high alloyed tool steel	annealed		200	675	P11	80 - 90 - 100	20 - 70 - 120	-	-
		hardened		300	1013	P12	50 - 60 - 70	20 - 70 - 120	-	-
		hardened		400	1361	P13	50 - 60 - 70	20 - 70 - 120	-	-
	Stainless steel	ferretic / martensitic, annealed		200	675	P14	40 - 65 - 90	20 - 55 - 90	-	-
		martensitic, hardened and tempered		330	1114	P15	40 - 65 - 90	20 - 100 - 180	-	-
M	Stainless steel	austenitic, chilled		200	675	M1	40 - 65 - 90	20 - 55 - 90	-	-
		austenitic, precipitation-hardened (PH)		300	1013	M2	40 - 65 - 90	15 - 50 - 80	-	-
		austenitic-ferritic, Duplex		230	778	M3	40 - 65 - 90	10 - 35 - 60	-	-
K	Malleable cast iron	ferritic		200	675	K1	50 - 60 - 70	20 - 70 - 120	40 - 50 - 60	-
		pearlitic		260	867	K2	50 - 60 - 70	20 - 70 - 120	40 - 50 - 60	-
	Cast iron	low tensile strength		180	602	K3	50 - 60 - 70	20 - 80 - 140	40 - 50 - 60	-
		high tensile strength / austenitic		245	825	K4	50 - 60 - 70	20 - 80 - 140	40 - 50 - 60	-
	Cast iron with nodular graphite	ferritic		155	518	K5	50 - 60 - 70	20 - 75 - 130	40 - 50 - 60	-
		pearlitic		265	885	K6	50 - 60 - 70	20 - 75 - 130	40 - 50 - 60	-
	GGV (CGI)			200	675	K7	50 - 60 - 70	20 - 70 - 120	40 - 50 - 60	-
N	Aluminium alloys long chipping	not heat treatable		30	-	N1	-	20 - 260 - 500	100 - 125 - 150	-
		heat treatable, heat treated		100	343	N2	-	20 - 260 - 500	100 - 125 - 150	-
	Casted aluminium alloys	≤ 12 % Si, not heat treatable		75	260	N3	-	20 - 260 - 500	100 - 125 - 150	-
		≤ 12 % Si, heat treatable, heat treated		90	314	N4	-	20 - 260 - 500	100 - 125 - 150	-
				130	447	N5	-	20 - 260 - 500	100 - 125 - 150	-
	Magnesium alloys			70	250	N6	-	-	-	-
	Copper and copper alloys (Brass / Bronze)	Unalloyed, elektrolyte copper		100	343	N7	120 - 150 - 180	20 - 310 - 600	100 - 125 - 150	-
		Brass, Bronze		90	314	N8	120 - 150 - 180	20 - 310 - 600	100 - 125 - 150	-
		Cu-alloys, short-chipping		110	382	N9	120 - 150 - 180	20 - 310 - 600	100 - 125 - 150	-
				300	1013	N10	-	-	-	-
	Non-ferrous materials	Lead alloys (without abrasive filling material)		-	-	N11	-	-	-	-
		Duroplastic (without abrasive filling material)		-	-	N12	-	-	-	-
		Plastic glas fibre reinforced GFRP		-	-	N13	-	-	-	-
		Plastic carbon fibre reinforced CFRP		-	-	N14	-	-	-	-
		Plastic aramid fibre reinforced AFRP		-	-	N15	-	-	-	-
		Graphite (tech.)		80 Shore	-	N16	-	-	-	-
S	High temperature resistant alloys	Fe-based	annealed	200	675	S1	40 - 65 - 90	15 - 45 - 75	-	-
		Fe-based	heat treated	280	943	S2	40 - 65 - 90	15 - 45 - 75	-	-
		Ni- or Co-alloyed	annealed	250	839	S3	40 - 65 - 90	15 - 30 - 40	-	-
		Ni- or Co-alloyed	heat treated	350	1177	S4	40 - 65 - 90	15 - 30 - 40	-	-
		Ni- or Co-alloyed	casting	320	1076	S5	40 - 65 - 90	15 - 30 - 40	-	-
	Titanium alloys	Pure titan		200	675	S6	-	-	-	-
		α- and β-alloys, heat treated		375	1262	S7	-	-	-	-
		β-alloys		410	1396	S8	-	-	-	-
	Wolfram alloys			300	1013	S9	-	-	-	-
	Molybdän alloys			300	1013	S10	-	-	-	-
H	Hardened steel	hardened		50 HRC	-	H1	-	-	-	60 - 105 - 150
		hardened		55 HRC	-	H2	-	-	-	60 - 105 - 150
		hardened		60 HRC	-	H3	-	-	-	60 - 105 - 150
	Hardened cast iron	hardened		55 HRC	-	H4	-	-	-	60 - 105 - 150

The recommended cutting data are only approximate values.
It may be necessary to adjust them to each individual machining application.

HC = Solid carbide coated
HU = Solid carbide uncoated
BC = CBN super hard cutting materials uncoated

	HC AL40	HC AP5015	HU AK40	BC AH7525
P	●	●	●	
M	●	●		
K	●	●		
N		●	●	
S	●	●	●	
H				●

● **Main application**
○ **Secondary application**

8

Gruppo materiale	Struttura dei gruppi di materiali e lettere di riferimento			Durezza Brinell	Resistenza Rm (N/mm²)	Gruppo di lavoro	Velocità di taglio V_c (m/min) HC AL40	HC AP5015	HU AK40	BC AH7525
P	Acciai non legato	C ≤ 0,25 %	ricotto	125	428	P1	80 - 90 - 100	20 - 100 - 180	-	-
		C > = 0,25 ... > = 0,55 %	ricotto	190	639	P2	80 - 90 - 100	20 - 100 - 180	-	-
		C > = 0,25 ... > = 0,55 %	bonificato	210	708	P3	80 - 90 - 100	20 - 100 - 180	-	-
		C ≤ 0,55 %	ricotto	190	639	P4	80 - 90 - 100	20 - 100 - 180	-	-
		C ≤ 0,55 %	bonificato	300	1013	P5	70 - 80 - 90	20 - 100 - 180	-	-
		Acciaio (truciolo corto)	ricotto	220	745	P6	80 - 90 - 100	20 - 100 - 180	-	-
	Acciai debolmente legati	ricotto		175	591	P7	80 - 90 - 100	15 - 90 - 160	-	-
		bonificato		300	1013	P8	70 - 80 - 90	15 - 90 - 160	-	-
		bonificato		380	1282	P9	50 - 60 - 70	15 - 90 - 160	-	-
		bonificato		430	1477	P10	50 - 60 - 70	15 - 90 - 160	-	-
	Acciai fortemente legati e acciai da utensili	ricotto		200	675	P11	80 - 90 - 100	20 - 70 - 120	-	-
		temprato e rinvenuto		300	1013	P12	50 - 60 - 70	20 - 70 - 120	-	-
		temprato e rinvenuto		400	1361	P13	50 - 60 - 70	20 - 70 - 120	-	-
	Acciai inossidabili	ferritico / martensitico, ricotto		200	675	P14	40 - 65 - 90	20 - 55 - 90	-	-
		martensitico, bonificato		330	1114	P15	40 - 65 - 90	20 - 100 - 180	-	-
M	Acciai inossidabili	austenitico, trattato o temoerato		200	675	M1	40 - 65 - 90	20 - 55 - 90	-	-
		austenitico, indurimento per precipitazione (PH)		300	1013	M2	40 - 65 - 90	15 - 50 - 80	-	-
		austenitico-ferritico, Duplex		230	778	M3	40 - 65 - 90	10 - 35 - 60	-	-
K	Ghisa temprata	ferritico		200	675	K1	50 - 60 - 70	20 - 70 - 120	40 - 50 - 60	-
		perlitica		260	867	K2	50 - 60 - 70	20 - 70 - 120	40 - 50 - 60	-
	Ghisa grigia	bassa resistenza		180	602	K3	50 - 60 - 70	20 - 80 - 140	40 - 50 - 60	-
		alta resistenza / austenitico		245	825	K4	50 - 60 - 70	20 - 80 - 140	40 - 50 - 60	-
	Ghisa sferoidale	ferritico		155	518	K5	50 - 60 - 70	20 - 75 - 130	40 - 50 - 60	-
		perlitica		265	885	K6	50 - 60 - 70	20 - 75 - 130	40 - 50 - 60	-
	GGV (CGI)			200	675	K7	50 - 60 - 70	20 - 70 - 120	40 - 50 - 60	-
N	Leghe di Alluminio stampato	non invecchiato		30	-	N1	-	20 - 260 - 500	100 - 125 - 150	-
		rinvenuto, invecchiato		100	343	N2	-	20 - 260 - 500	100 - 125 - 150	-
	Leghe di Alluminio da fusione	≤ 12 % Si, non invecchiato		75	260	N3	-	20 - 260 - 500	100 - 125 - 150	-
		≤ 12 % Si, rinvenuto, invecchiato		90	314	N4	-	20 - 260 - 500	100 - 125 - 150	-
				130	447	N5	-	20 - 260 - 500	100 - 125 - 150	-
	Leghe di magnesio			70	250	N6	-	-	-	-
	Rame e Leghe di Rame (Bronzo / Ottone)	Non legati, Rame Elettrolitico		100	343	N7	120 - 150 - 180	20 - 310 - 600	100 - 125 - 150	-
		Ottone, Bronzo		90	314	N8	120 - 150 - 180	20 - 310 - 600	100 - 125 - 150	-
		Leghe Cu, truciolo corto		110	382	N9	120 - 150 - 180	20 - 310 - 600	100 - 125 - 150	-
				300	1013	N10	-	-	-	-
	Materiali non metallici	Leghe al piombo (senza materiale di riempimento abrasivo)		-	-	N11	-	-	-	-
		Duroplastico (senza materiale di riempimento abrasivo)		-	-	N12	-	-	-	-
		Plastica rinforzata in fibra di vetro GFRP		-	-	N13	-	-	-	-
		Plastica rinforzata in fibra di carbonio CFRP		-	-	N14	-	-	-	-
		Plastica rinforzata in fibra aramidica AFRP		-	-	N15	-	-	-	-
		Grafite (tecnico)		80 Shore	-	N16	-	-	-	-
S	Leghe resistenti al calore	Base-Fe	ricotto	200	675	S1	40 - 65 - 90	15 - 45 - 75	-	-
		Base-Fe	invecchiato	280	943	S2	40 - 65 - 90	15 - 45 - 75	-	-
		Base Ni o Co	ricotto	250	839	S3	40 - 65 - 90	15 - 30 - 40	-	-
		Base Ni o Co	invecchiato	350	1177	S4	40 - 65 - 90	15 - 30 - 40	-	-
		Base Ni o Co	da fusione	320	1076	S5	40 - 65 - 90	15 - 30 - 40	-	-
	Leghe di Titanio	Titanio puro		200	675	S6	-	-	-	-
		Leghe α e β, invecchiato		375	1262	S7	-	-	-	-
		Leghe β		410	1396	S8	-	-	-	-
	Leghe di tungsteno			300	1013	S9	-	-	-	-
	Leghe di molibdeno			300	1013	S10	-	-	-	-
H	Acciaio Temprato	temprato e rinvenuto		50 HRC	-	H1	-	-	-	60 - 105 - 150
		temprato e rinvenuto		55 HRC	-	H2	-	-	-	60 - 105 - 150
		temprato e rinvenuto		60 HRC	-	H3	-	-	-	60 - 105 - 150
	Ghisa Temprata	temprato e rinvenuto		55 HRC	-	H4	-	-	-	60 - 105 - 150

I dati indicati in tabella sono valori approssimati.
Può essere necessario adattarli alle singole applicazioni di lavorazione.

HC = Metallo duro rivestito
HU = Metallo duro non rivestito
BC = Materiali da taglio extra duri CBN rivestiti

	HC		HU	BC
P	●	●	●	
M	●	●		
K	●	●		
N		●	●	
S	●	●	●	
H				●

● **Applicazione principale**
○ **Applicazione secondaria**

8

Schnittdatenrichtwerte AH7525
Recommended cutting data AH7525
Parametri di taglio suggeriti AH7525

Durchmesser *Diameter* Diametro	Vc [m/min]	f [mm/U]	ap [mm]
2,0 mm – 3,0 mm	50–150	0,01–0,03	0,01–0,05
3,5 mm – 4,5 mm	50–150	0,01–0,05	0,01–0,10
5,0 mm – 6,0 mm	50–150	0,01–0,08	0,01–0,10

Schnittdatenrichtwerte Gewindedrehen – Anzahl der Durchgänge
Recommended cutting data – Threading – Number of passes
Parametri di taglio suggeriti – Filettatura – Numero di passate

Steigung *Pitch* Passo		Anzahl der Schnitte *Number of passes* Numero di passate					
Vc [m/min]		110–140	80–110	65–80	70–90	80–110	200–250
[mm]	Gang/Zoll *Pitch/Inch* Filetti/Pollice	Stahl Festigkeit [N/mm²] *Steel strength [N/mm²]* Acciaio resistenza (N/mm²)			Rostfrei *Stainless steel* Acciaio inossidabile	Guss *Cast* Ghisa	Aluminium *Aluminium* Alluminio
		400–700	700–1.000	> 1.000			
0,5	48	6	7	7	8	7	6
0,75	32	8	9	9	10	9	8
0,8	32	8	9	10	10	9	8
1	24	10	11	12	12	12	10
1,25	20–19	12	14	15	15	14	12
1,5	16	15	17	18	18	17	15
1,75	14	17	19	21	21	18	17
2	12	19	22	25	25	20	18
2,5	10	22	26	31	31	22	20
3,0–3,5	8	28	32	38	38	24	22

Die hier aufgeführten Werte sind allgemeine Empfehlungen für die Anzahl der Durchgänge bei der Bearbeitung von normalen Stahl- und NE-Werkstoffen. Bei harten Werkstoffen ist die Schnitttiefe zu reduzieren und die Anzahl der Schnitte zu erhöhen. Bei Plattenbruch ist die Anzahl der Durchgänge zu erhöhen, bei hohem Verschleiß zu verringern.

HINWEIS: Der Spanquerschnitt sollte bei jedem Durchgang gleich groß sein, das heißt mit zunehmender Schnitttiefe ist die Zustellung zu reduzieren, um konstante Schnittkräfte zu erreichen.

The above mentioned data are general recommendations for machining steel and non-ferrous materials. With hard materials we recommend to reduce cutting speed and increase number of passes. By cutting edge breakage we suggest to increase number of passes, by edge wear reduce the number of passes.

Remark: The chip thickness should be constant at every pass, so with more cutting depth reduce the in-feed in order to obtain constant cutting forces.

I valori sopra indicati sono per materiali non trattati termicamente. Per materiali più duri ridurre le velocità di taglio e aumentare il numero di passate. In caso di scheggiature del tagliente si suggerisce di aumentare il numero delle passate, in caso di usura invece si suggerisce di ridurre il numero di passate.

NOTA: Lo spessore truciolo deve essere costante ad ogni passata. Per avere una sezione truciolo ed una forza di taglio costante durante la lavorazione adattare avanzamenti e profondità di passate.

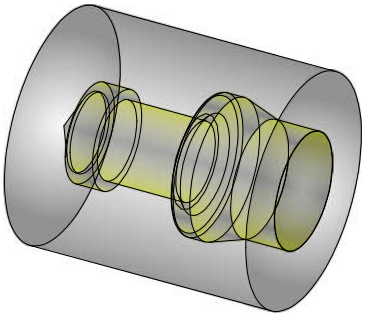
Werkstoff und Bearbeitung
Material and application
Materiale e applicazione

ISO	Werkstoff *Material* Materiale	Max. Spantiefe a_p [mm] *Max. depth of cut a_p [mm]* Max prof. di taglio a_p [mm]
P	**Stahl** *Steel* Acciaio	0,5
M	**Rostfreier Stahl** *Stainless Steel* Acciaio inossidabile	0,3
K	**Guss** *Cast* Fusioni	0,3
N	**NE-Metalle, Aluminium** *Non-ferrous, Aluminium* Alluminio e materiali non ferrosi	1,0

Bearbeitung *Application* Applicazione	Vorschubbereich *Feed rate range* Avanzamento
Stechen, Einstechen *Grooving* Scanalatura	0,01 – 0,02
Bohrung ausdrehen und kopieren *Boring, turning and copying* Foratura, tornitura e copiatura	0,02 – 0,05
Vorstechen, Fasen, Rückwärtsdrehen *Pre-grooving, chamfering and back turning* Pre-scanalatura, smusso e in tirata	0,02 – 0,05
Axial-Stechdrehen *Axial groove turning* Scanalatura assiale	0,02 – 0,05

Einsatz-Beispiel
Applicatione example
Esempio di applicazione

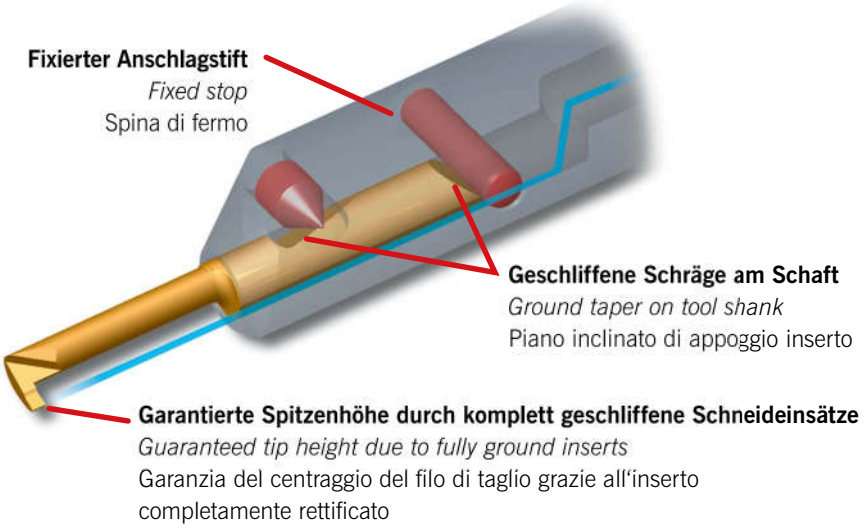
Bearbeitung **Material 1.2343 mit 800 N/mm²** *Application* *Material 1.2343 with 800 N/mm²* Applicazione Materiale 1.2343 con 800 N/mm²	Gruppe *Solution* Utensile	Empfohlene Schnittwerte *Recommended cutting data* Parametri di taglio suggeriti	
		Drehzahl n (U/min) *Revolution n (U/min)* Giri n (U/min)	**Vorschubbereich f (mm/U)** *Feed rate range f (mm/U)* Avanzamento f (mm/U)
Vorbearbeitung Bohren Ø 10 mm *Pre-machining, drilling Ø 10 mm* Prelavorazione, foratura Ø 10 mm	SC10L-0023SP-05	3800	0,03
Vorbearbeitung Bohren Ø 6 mm Pre-machining, drilling Ø 6 mm Prelavorazione, foratura Ø 6 mm	SPC0060-0300 VHM / TiAlN	4200	0,1
Drehen, Kerndurchmesser M8 *Turning to core diameter for M8* Tornitura preforo per M8	AMS-D-590802-200.60R	4200	0,04
Freistich, Gewinde *Relief groove, thread* Scanalatura, filettatura	AMS-S-59151800-200.60R	4200	0,02
Gewinde M8 *Thread M8* Filettatura M8	AMS-G-M8-200.60R	1640	1,25
Drehen, Kontur *Turning, form* Tornitura, copiatura	AMS-K-591802-200.60R	3800	0,02 – 0,04



Montage ARNO®-Mini-System

Assembling of ARNO®-Mini-System

Montaggio di ARNO®-Mini-System



Die geschliffene Schräge am Schaft kombiniert mit dem Anschlagstift garantiert eine exakte radiale Fixierung des Schneideinsatzes bezüglich der Spitzenhöhe. Eine optimale Spannung des Schneideinsatzes erreichen Sie Mittels Spannung des Gewindestiftes über die Kegelfläche.

With the ground taper on the tool shank and the fixed stop in the sleeve the length remains accurately constant and guaranteed cutting edge repeatability is achieved. The cone of the threaded pin ensures secure tool locking and reduces cutting edge vibrations.

Il piano inclinato di fermo oltre a garantire la perfetta ripetibilità dimensionale, assicura il posizionamento del tagliente in asse. Il piano di bloccaggio inclinato e la vite conica assicurano la massima tenuta e riducono la possibilità di vibrazioni.