

# Guida alla selezione utensile TaeguTec

## NEGATIVO



FINITURA      MEDIA      SGROSSATURA

## POSITIVO



FINITURA      MEDIA      SGROSSATURA

**P**  
Acciaio

Rompi truciolo

Grado

**WS** (0.05-0.35)  
**FA** (0.05-0.25)  
**FLP**(0.08-0.30)  
**FC** (0.08-0.35)  
**FG** (0.08-0.35)  
**MLP** (0.1-0.4)  
**MGP** (0.15-0.55)  
**PC** (0.15-0.5)  
**MT** (0.17-0.55)  
**RGP** (0.25-0.7)

**TT8105**  
**TT8115**  
**TT8125**  
**TT8135**

**FA** (0.05-0.25)  
**FG** (0.07-0.25)  
**PC** (0.08-0.25)  
**FM** (0.08-0.25)  
**MT** (0.10-0.25)

**TT8105**  
**TT8115**  
**TT8125**  
**TT5100**

**M**  
Acciaio Inox

Rompi truciolo

Grado

**EA** (0.07-0.40)  
**ML** (0.15-0.40)  
**EM** (0.13-0.50)  
**ET** (0.17-0.55)

**TT9215**  
**TT9225**  
**TT9235**  
**TT8080**

**FA** (0.05-0.25)  
**FG** (0.07-0.25)  
**PC** (0.08-0.25)

**TT9215**  
**TT9225**  
**TT9235**  
**TT8080**

**H**  
Acciaio Temprato

Rompi truciolo

Grado

**-MA / -GA**

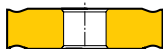
**TB610**  
**TB2015**  
**TB650**  
**AB20**  
**TB670**  
**AB2010, AB30**

**-GW / -GT**

**TB610**  
**TB2015**  
**TB650**  
**AB20**  
**TB670**

(Avanzamento: mm/giro)

## NEGATIVO



FINITURA MEDIA SGROSSATURA

## POSITIVO



FINITURA MEDIA SGROSSATURA

**K**  
Ghisa

Rompi truciolo

Grado

FG (0.08-0.35)

MT (0.17-0.55)  
-MG (0.23-0.60)

KT (0.19-0.53)  
-MA ((0.15-0.60)

RT (0.25-0.65)

KB90  
TB7015

AB30  
AS500

TT7005

TT7015

FG (0.07-0.25)

MT (0.10-0.25)

KB90  
TB7015

AS500

TT7005

TT7015

**S**  
Super leghe

Rompi truciolo

Grado

EA (0.07-0.40)

ML (0.12-0.35)

MGS (0.15-0.40)

MP (0.12-0.40)

ET (0.17-0.55)

TC430

TC3020, TC3030

TT3005

TT3010

TT3020

TT5080

TT9080

-GT FGS (0.05-0.20)

FG (0.07-0.25)

PC (0.08-0.25)

MT (0.10-0.25)

TC430

TC3020, TC3030

TT3005

TT3010

TT3020

TT5080

TT9080

**N**  
Materiali non ferrosi

Rompi truciolo

Grado

-GG ML (0.12-0.35)

KP300  
TD810

K10

-GW CB

-GT FL

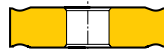
KP300  
TD810



K10

  : 1° Raccomandato

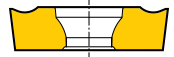
(Avanzamento: mm/giro)

Inserto Negativo



ISO	Tipo di Lavorazione								
P	Finitura con wiper	WS, WA 	WF	FW	W-MF2	NF	SW	LUW, SEW	WP
	Medio con wiper	WT	WMX, WM	MW, RW	W-M3, W-M6, W-MF5	NM	MW	GUW	WQ, WE
	Finitura	FLP, FA, FS, GG-FU 		FF, FS	FF1, FF2	FP5	FH, FP	FA	DP, GP, PP
		FX				FV5	FS, FY	FL	VF
	Semi-finitura	FLP, FG	QF	FP	MF2	NF3, NF4	LP	SU, FE	HQ
		FM 		MP-K, LF, FN					
	Media	MLP, FC, FT 	PF, XF			NS6	SA	LU	CQ, PQ
								SE, SX	CJ
	Sgrossatura	VF, DNUX 	K		UX	MV5	ES	GX, HM	
		MLP, MC		MN	MR3	MP3			GS
MGP, PC		PM, XM		MF3	MP5	MP, MV	GU	PG	
MM 		QM	P	MF5, M3	MM5 (NM4)	MA	UG	PS	
MGP, MT		HM, XMR	MP	RP, RM	MU5, NM6	MH	UX, GE	HS	
	MGP, MG-		MG-, UN	M4	MG-	MG--	UZ	MG-C	
				MR4					
				M5	NR4, RP5	RP	ME	PT, GT	
		PR	RN	MR7, M6	RP7	GH	MU, MX	PH, HT	
M	Finitura	EA, SF	MF	FP	MF1	FM5, NF4	FS, LM	SU	MQ, GU
	Media	EM, ML	MM	MP, UP, MR	MF4	MM5 (NM4)	MS, GM, MA	EX, UP, GU	MS, MU, SK
	Sgrossatura	ET	MR	RP	MR6, MF5	RM5, NR4	RM	MU, HM	HU
K	Finitura - Media		KF	FN	MF5		LK		KQ
		MT	KM		M4	NM, MK5	MA, MK	UZ	MG-
	Sgrossatura	MG-		MG-, RN	M5	NM5, RK5	MG-, GK		KG, C
		KT	KR			MV7, RK7			KH
	RT		UN	MR7		GH, RK	GZ	ZS, GC	
N	Media	ML	QM, 23	MS, MP		MJ	UP, GX, AG	A3, AH	
S	Finitura	EA, SF	SF	GG-FS	MF1	NF4	FJ, LS	EF	MQ
	Media	GG-ML	SGF, GP-	MS, GP-K	M1	GG-NFT	MJ	SU, UP	TK
		MGS, MP, MK 	QM, SM, 23	UP, P	MF4, MF5	NMS, NMT	MS	EG, EX	MS, MU, SQ
Sgrossatura	ET	SR, SMR	RP	M5, MR3, MR4	RM5, NRS, NRT	GJ, RS	MU		

Inserto Positivo



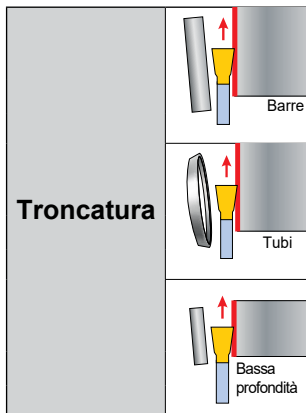
ISO	Tipo di lavorazione	TaeguTec	SANDVIK	KENNAMETAL	SECO	WALTER	MITSUBISHI	SUMITOMO	KYOCERA	
<b>P</b>	Media con wiper	WT	WM	MW	W-F2, W-M3	PM	MW			
	Finitura	FA FX	PF, UF	UF, 11, GM	FF1	PF4, FP4	FV	LU FP	XP GK, GP, DP VF	
		GT-SL GT-SA, GT-SM				FV4	SMG	FC	CF GF CK	
		FG	UM XF	FP LF	F1	PS5	SQ, SV	FK SU SC, SK	XQ GK	
	Media	PC, GT-SH FM	PM	MP		FP6, MV4			GQ HQ	
		GT-SH MT	XM PR, UR XR	MF	F2, MF2, M5	PM5 E47, MT-	MQ, MV MT- G	SF, MU	MT-	
		PMR-	PMR-	PMR-		PMR-	PMR-	UJ	G, PMR-	
	<b>N</b>	Finitura - media -Tolleranza G	GT-SA, FL	AL	HP	AL	GW-FS-1	AZ	AW, AG	AH
	<b>S</b>	Finitura - Tolleranza G	GT-FGS, SA	GT-UM	GT-HP, LF	GT-F1	GT-PF2, FM4	GT-FJ	GT-SI	
		Finitura	FG	MF, UM	FP, LF	F1, F2	PF4, PS5, MM4	FM, LM, SV	SU	MQ
Media		PC	MM	MF2		PM5, RM4	MM, MV	MU		



**Acciaio**  
(HB 200-220)

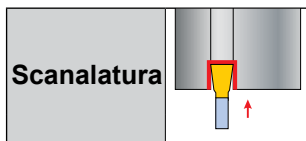


**Acciaio Inox**  
(HB 180-200)



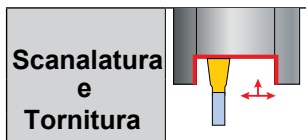
<b>SFC TT9080</b>	<b>TDC TT9080</b>
(Vc 100-150, fn 0.1-0.4)	
<b>SFC TT9080</b>	<b>TDC TT9080</b>
(Vc 100-150, fn 0.1-0.4)	
<b>TQC TT9080</b>	<b>TQS TT4430</b>
(Vc 100-150, fn 0.06-0.15)	

<b>SFC TT9080</b>	<b>TDC TT9080</b>
(Vc 80-120, fn 0.1-0.15)	
<b>SFJ TT9080</b>	<b>TDJ TT9080</b>
(Vc 80-120, fn 0.1-0.15)	
<b>TQJ TT9080</b>	<b>TQS TT4430</b>
(Vc 80-120, fn 0.05-0.13)	



<b>TDC TT9080</b>	<b>TDXU TT9080</b>
(Vc 100-150, fn 0.1-0.4)	

<b>TDJ TT9080</b>	<b>TDXU TT9080</b>
(Vc 80-120, fn 0.1-0.15)	



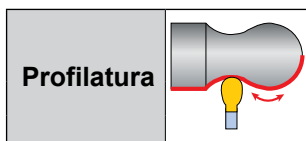
<b>TDXU TT9080</b>
(Vc 100-150, fn 0.1-0.4)

<b>TDXU TT9080</b>
(Vc 80-120, fn 0.1-0.15)



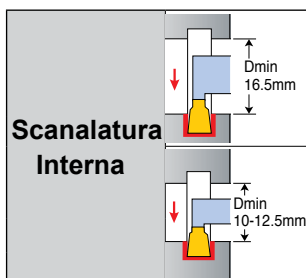
<b>TDXU TT9080</b>	<b>TDFX TT9080</b>
(Vc 100-150, fn 0.1-0.4)	

<b>TDXU TT9080</b>	<b>TDFX TT9080</b>
(Vc 80-120, fn 0.1-0.15)	



<b>TDT-RU TT9080</b>
(Vc 100-150, fn 0.1-0.4)

<b>TDT-RU TT9080</b>
(Vc 80-120, fn 0.1-0.15)



<b>TQIS TT9080</b>	<b>TDXU TT9080</b>
(Vc 100-150, fn 0.1-0.4)	
<b>TMIS TT4430</b>	<b>TDIM TT9080</b>
(Vc 100-150, fn 0.1-0.4)	

<b>TQIS TT9080</b>	<b>TDXU TT9080</b>
(Vc 80-120, fn 0.1-0.15)	
<b>TMIS TT4430</b>	<b>TDIM TT9080</b>
(Vc 80-120, fn 0.1-0.15)	

**K** Ghisa  
(HB 220-250)

**N** Materiali non ferrosi

**S** Super Leghe  
(HB 300-350)

**H** Acciai Temprati  
(HRC > 40)



**TDC TT9080**  
(Vc 120-180, fn 0.1-0.4)



**TDC TT9080**  
(Vc 120-180, fn 0.1-0.4)



**TQC TT9080**  
(Vc 120-180, fn 0.1-0.4)



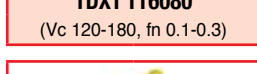
**TDXU TT6080**  
(Vc 120-180, fn 0.1-0.4)



**TDXU TT6080**  
(Vc 120-180, fn 0.1-0.4)



**TDXU TT6080**  
(Vc 120-180, fn 0.1-0.3)



**TDT-RU TT6080**  
(Vc 120-180, fn 0.1-0.4)



**TQIS TT9080 TDXU TT6080**  
(Vc 120-180, fn 0.1-0.3)



**TDIM TT9080 TDIP TT9080**  
(Vc 120-180, fn 0.1-0.3)



**TDJ K10**  
(Vc 150-330, fn 0.1-0.5)



**TDJ K10**  
(Vc 150-330, fn 0.1-0.5)



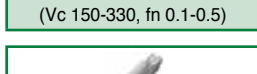
**TQS TT4430**  
(Vc 150-330, fn 0.1-0.5)



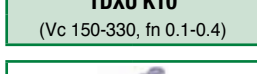
**TDJ K10 TDXU K10**  
(Vc 150-330, fn 0.1-0.5)



**TDXU K10**  
(Vc 150-330, fn 0.1-0.5)



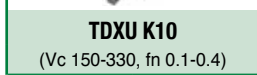
**TDXU K10**  
(Vc 150-330, fn 0.1-0.4)



**TDA K10**  
(Vc 150-330, fn 0.1-0.4)



**TDXU K10**  
(Vc 150-330, fn 0.1-0.4)



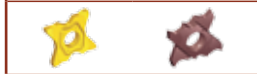
**TMIS TT4430 TDIP TT9080**  
(Vc 150-330, fn 0.1-0.4)



**SFJ TT9080 TDJ TT9080**  
(Vc 30-60, fn 0.08-0.12)



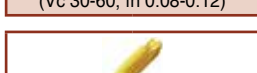
**SFJ TT9080 TDJ TT9080**  
(Vc 30-60, fn 0.08-0.12)



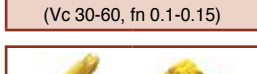
**TQJ TT9080 TQS TT4430**  
(Vc 30-60, fn 0.08-0.12)



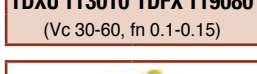
**TDXU TT3010**  
(Vc 30-60, fn 0.08-0.12)



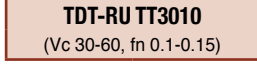
**TDXU TT3010**  
(Vc 30-60, fn 0.1-0.15)



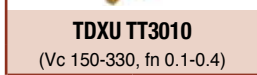
**TDXU TT3010 TDFX TT9080**  
(Vc 30-60, fn 0.1-0.15)



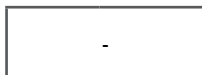
**TDT-RU TT3010**  
(Vc 30-60, fn 0.1-0.15)



**TDXU TT3010**  
(Vc 150-330, fn 0.1-0.4)



**TMIS TT4430 TDIP TT9080**  
(Vc 30-60, fn 0.1-0.15)



**TSG TB2015**  
(Vc 80-120, fn 0.1-0.15)



**TSG TB2015**  
(Vc 80-120, fn 0.1-0.15)



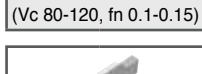
**TSG TB2015**  
(Vc 80-120, fn 0.1-0.15)



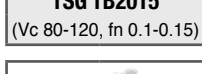
**TSG TB2015**  
(Vc 80-120, fn 0.1-0.15)



**TSG TB2015**  
(Vc 80-120, fn 0.1-0.15)



**TSG TB2015**  
(Vc 80-120, fn 0.1-0.15)



**TSG TB2015**  
(Vc 80-120, fn 0.1-0.15)



**TSG TB2015**  
(Vc 80-120, fn 0.1-0.15)

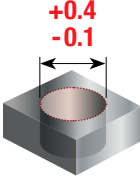
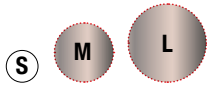


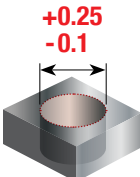
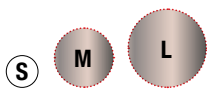


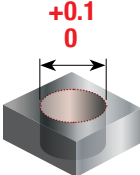
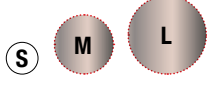


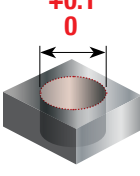
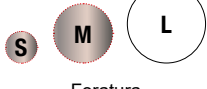


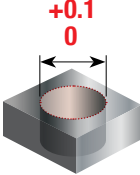
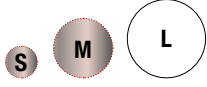


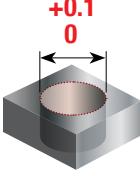
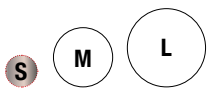




**TSG TB2015**  
(Vc 80-120, fn 0.1-0.15)

















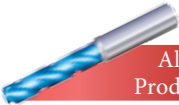
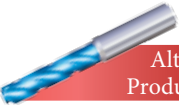


**TSG TB2015**  
(Vc 80-120, fn 0.1-0.15)

(Vc Velocità: m/min, fn Avanzamento: mm/giro)


















	Tolleranza Foro	Applicazioni	Tipo di punta consigliato	Gamma diametri (DC)
Foratura di sgrossatura	 <p><b>+0.4</b> <b>-0.1</b></p>	 <p>Foratura medio grande</p>	  <p>TOP 2 TOP 3 TOP 4 TOP 5</p>	<p>Tipo a sedi fisse Ø12.0 - Ø50.0 mm</p> <p>Tipo con cartucce Ø51.0 - Ø80.0 mm</p>
	 <p><b>+0.25</b> <b>-0.1</b></p>	 <p>Foratura medio grade</p>	  <p>MDB-3 MDB-5</p>	<p>Ø26.0 - Ø50.0 mm</p>
Foratura media	 <p><b>+0.1</b> <b>0</b></p>	 <p>Foratura medio grade</p>	  <p>LCD-3D LCD-5D LCD-8D</p>	<p>Ø20.0 - Ø41.0 mm</p>
	 <p><b>+0.1</b> <b>0</b></p>	 <p>Foratura medio piccola</p>	  <p>TCD-1.5D TCD-3D TCD-5D TCD-8D TCD-12D</p>	<p>Ø6.0 - Ø25.9 mm</p>
Foratura di Finitura	 <p><b>+0.1</b> <b>0</b></p>	 <p>Foratura medio piccola</p>	  <p>3ED-3D 3ED-5D</p>	<p>Ø16.0 - Ø20.9 mm</p>
	 <p><b>+0.1</b> <b>0</b></p>	 <p>Foratura piccola</p>	  <p>3HD-PI3 3HD-PI5</p>	<p>Ø4.0 - Ø12.0 mm</p>







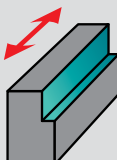








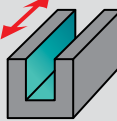

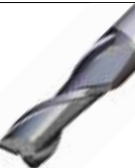






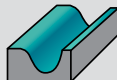

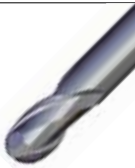



ISO Materiali			
			
<b>P M K N S</b>	Acciaio legato    Acciaio basso carbonio <b>SOMT-DP TT9080</b> <b>SOMT-DL TT9080</b> Vc 140 - 160 - 180 fn 0.08 - 0.12 - 0.14	<b>SOMT-DP TT9080</b> Vc 160 - 180 - 220 fn 0.06 - 0.08 - 0.10	<b>SOMT-DK TT9080</b> Vc 140 - 160 - 200 fn 0.10 - 0.15 - 0.20
		-	
<b>P</b> <b>K</b>	<b>TCD-P-CO+</b> <b>SPGX-DW TT9080</b> Vc 100 - 140 - 180 fn 0.20 - 0.25 - 0.35		<b>TCD-P-CO+</b> <b>SPGX-DW TT9080</b> Vc 120 - 160 - 200 fn 0.20 - 0.30 - 0.50
			
<b>P M K</b>	<b>LCD-P TT9080</b> Vc 80 - 100 - 200 fn 0.20 - 0.25 - 0.30	<b>LCD-P TT9080</b> Vc 80 - 60 - 70 fn 0.12 - 0.20 - 0.25	<b>LCD-P TT9080</b> Vc 100 - 120 - 150 fn 0.20 - 0.35 - 0.50
			
<b>P M K N</b>	<b>TCD-P TT9080</b> Vc 70 - 100 - 200 fn 0.20 - 0.25 - 0.30	<b>TCD-M TT9080</b> Vc 50 - 60 - 70 fn 0.12 - 0.18 - 0.25	<b>TCD-K TT9080</b> Vc 100 - 120 - 150 fn 0.20 - 0.27 - 0.35
	 <b>Alta Produttività</b>	-	 <b>Alta Produttività</b>
<b>P</b> <b>K</b>	<b>3ED-P+ TT5130</b> Vc 70 - 100 - 140 fn 0.30 - 0.40 - 0.55		<b>3ED-P+ TT5130</b> Vc 80 - 120 - 160 fn 0.40 - 0.50 - 0.60
	 <b>Alta Produttività</b>	-	 <b>Alta Produttività</b>
<b>P</b> <b>K</b>	<b>3HD TT5130</b> Vc 70 - 100 - 140 fn 0.20 - 0.35 - 0.55		<b>3HD TT5130</b> Vc 80 - 100 - 140 fn 0.25 - 0.45 - 0.60

(Vc Velocità: m/min, fn Avanzamento: mm/giro)







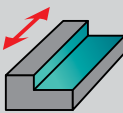




























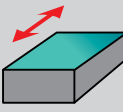


































**Selezione utensile in base al materiale**


		Usò Generale		Usò Specifico	
		Tipo tagliente	1° Consigliato	Usò specifico	1° Consigliato
 <b>TT5525</b>	Piano		<b>TSE 2/4</b>	Alto avanzamento	<b>HFM 2/4</b>
	Torico R		<b>HES 2/4</b>	Smussatura	<b>CEM 2/4</b> <b>ECEM 2/4</b>
	Sferico		<b>SBE 2/4</b>	Sgrossatura	<b>REL 2/4</b>
 <b>TT5515</b>	Piano		<b>SED 4</b>	Sgrossatura	<b>SER</b>
	Torico R				
	Sferico		<b>SBT</b>		
 <b>UF10</b>	Piano		<b>AES 2/3</b>	Tagliente ad onda	<b>AWE 3</b>
	Torico R				
	Sferico		<b>AEB 2/3</b>	Sgrossatura	<b>REA 3</b>
 <b>TT5505</b>	Piano		<b>HSF</b>	CBN sferico	<b>HSB 2CBN</b>
	Torico R		<b>HSR</b>		
	Sferico		<b>HSB</b>		
		<b>Per Trocoidale</b> 		<b>Per Inconel</b>	
 <b>S</b>	Torico R		<b>SED 7 TT5515</b>	Ceramico Torico R	<b>CRF 4/6 TC3030</b>
				Ceramico Alto avanzamento	<b>CRH 4 TC3030</b>


**Selezione utensile in base all'applicazione**

		 <b>TT5525</b>	 <b>TT5515</b>	 <b>TT5505</b>	 <b>UF10</b>
 <b>Contornatura</b>	 Piano	 <b>TSE 4</b>	 <b>SED 4/7</b>	 <b>HSF 4/6</b>	 <b>AES 3</b>
	 Torico R	 <b>HES 4</b>		 <b>HSR 4/6</b>	
 <b>Cava da pieno</b>	 Piano	 <b>TSE 2</b>	 Solo per trocoidale	 <b>HSF 2</b>	 <b>AES 2/3</b>
	 Torico R	 <b>HES 2</b>		 <b>HSR 2</b>	
 <b>Profilatura</b>	 Sferico	 <b>SBE 2/4</b>	 <b>SBT</b>	 <b>HSB</b>	 <b>AEB</b>

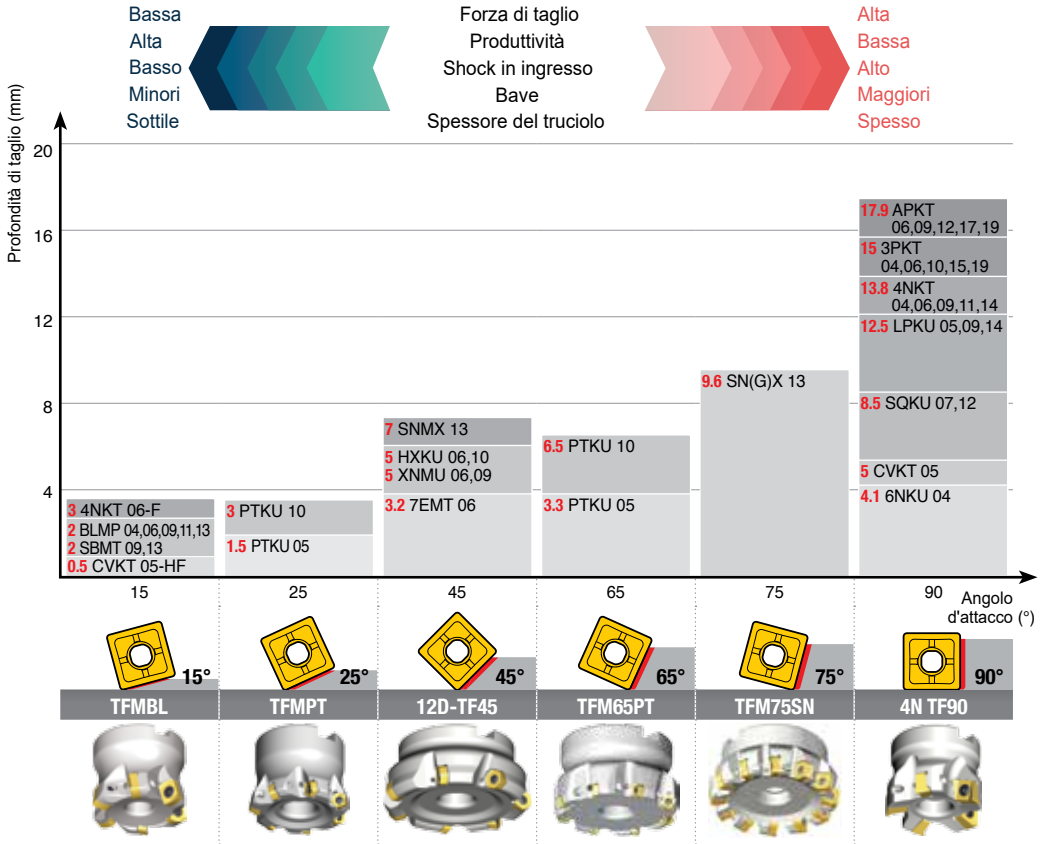
### Selezione utensile in base all'applicazione

		 TT9080 (TT8080)	 TT8080 (TT8020)	 TT6080 (TT7515)	 K10	 TT8080 (TT9540, TT3540)	 TT2510 (CBN)	
 <b>Contornatura</b>	Sgrossatura	  <b>4NKT</b>	 <b>3PKT</b>	 <b>SQKU</b>	 <b>3PHT</b>	 <b>APKT</b>	 <b>APKT</b>	
		  <b>3PKT</b>	 <b>APKT</b>	 <b>LPKU</b>	 <b>APCT</b>	 <b>3PKT</b>	 <b>6NKU</b>	
	Finitura	  <b>4NHT</b>	 <b>3PHT</b>	 <b>SQKU</b>	 <b>3PHT</b>	 <b>APCT</b>	 <b>APCT</b>	
		  <b>3PHT</b>	 <b>APCT</b>	 <b>LPHU</b>	 <b>APCT</b>	 <b>3PHT</b>	 <b>6NGU</b>	
	 <b>Spianatura</b>	Sgrossatura	  <b>HXKU</b>	 <b>7EMT</b>	 <b>HXHU</b>	 <b>APCT</b>	 <b>7EMT</b>	 <b>RYHX</b>
			  <b>XNMU</b>	 <b>SNGX</b>	 <b>XNHU</b>	-	 <b>RYMX</b>	-
Finitura		  <b>SNEX</b>	 <b>7EMT</b>	 <b>SNEX</b>	 <b>4WHU</b>	 <b>APCT</b>	 <b>4WHU-CBN</b>	
		 -	 <b>SNEX</b>	-	-	-	 <b>SNEX-CBN</b>	
Sgrossatura		  <b>BLMP</b>	 <b>SBMT</b>	 <b>BLMP</b>	-	 <b>SBMT</b>	 <b>BLMP</b>	
		  <b>CVKT-HF</b>	 <b>BLMP</b>	 <b>PTKU</b>	-	 <b>BLMP</b>	 <b>PTKU</b>	

 : Primo consigliato

 : Secondo consigliato

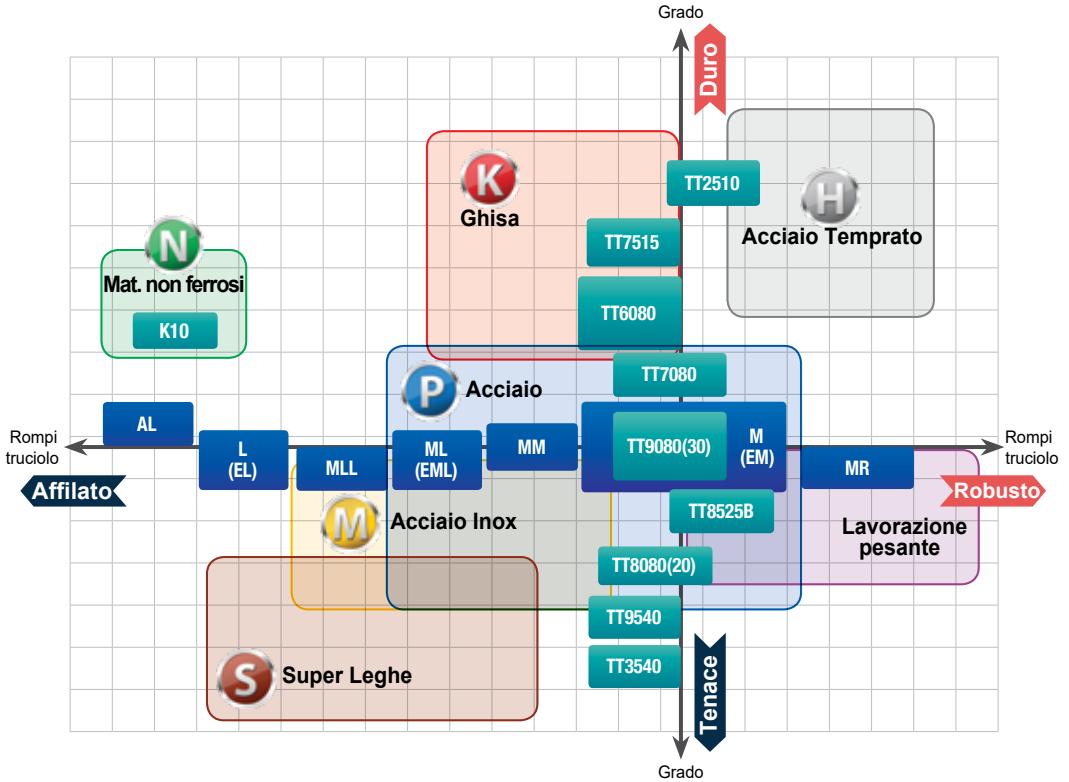
## Selezione utensile in base all'angolo d'attacco e la profondità di taglio



## Caratteristiche fresa in funzione della spaziatura tra i denti



## Mappa di selezione gradi e rompitrucioli



Alluminio e materiali non ferrosi



Super Leghe materiali HRSA



Super Leghe materiali HRSA in alto avanzamento



Taglio leggero inox serie 300



Taglio leggero Inox serie 400



Lavorazione generale



Acciai temprati e taglio interrotto



Durezza Materiale



Resistenza del tagliente



Forza di taglio



INDUSTRY 4.0



TaeguTec

**INDUSTRY 4.0**



- Cat. no.: 6226827
- Italian version: CT 01/2021
- @TaeguTec LTD.