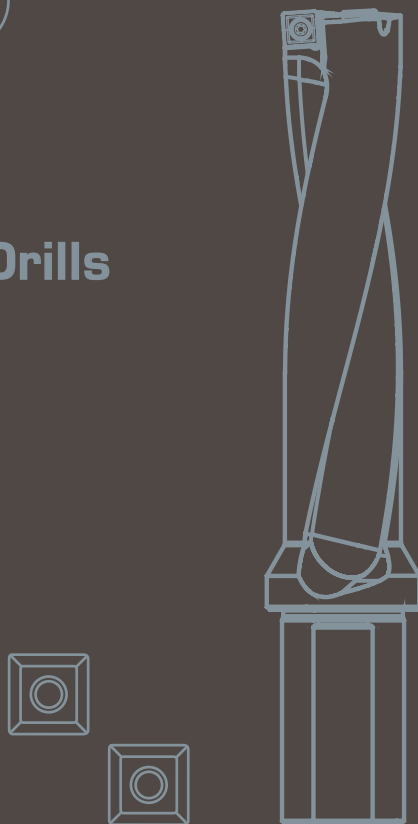


EVO[®] EDH. __ QPR



| Indexable Inserts Drills
| Punte a Inerti

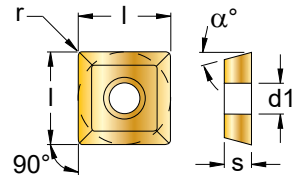


... THE WAY TO THE FUTURE!



EVO	DIN ISO 513		Material Materiale	Toughness Tenacità	Application Applicazione
D4130	<i>Coated carbide</i> Metallo duro rivestito	P20-40 M25-40	P M K N		- carbide grade with excellent toughness and stress resistance characteristics - qualità di metallo duro con ottime caratteristiche di tenacità e resistenza alle sollecitazioni
D4120	<i>Coated carbide</i> Metallo duro rivestito	P15-30 M20-30	P M K N		- carbide grade with excellent abrasion resistance suitable for medium-high cutting speeds on steel and stainless steel - qualità di metallo duro con ottima resistenza all'abrasione adatta a velocità di taglio medio-alte su acciai e acciai inossidabili
D6120	<i>Coated carbide</i> Metallo duro rivestito	P10-25 K10-30	P K N		- carbide grade with excellent abrasion resistance suitable for high cutting speeds on hard steels and cast iron - qualità di metallo duro con eccellente resistenza all'abrasione adatta a velocità di taglio alte su acciai duri e ghisa

EVO	Material Materiale	Machining Lavorazione	Tool application Applicazione utensile	Application Applicazione
PM4C	P M K N		Drilling Foratura	Central cutting insert geometry Geometria di taglio per inserto centrale
PM4P	P M K N		Drilling Foratura	Peripheral cutting insert geometry for steel and stainless steel Geometria di taglio per inserto Periferico per acciai e acciai inossidabili
PK5P	P K N		Drilling Foratura	Peripheral cutting insert geometry for hard steel and cast iron Geometria di taglio per inserto Periferico per acciai duri e ghisa



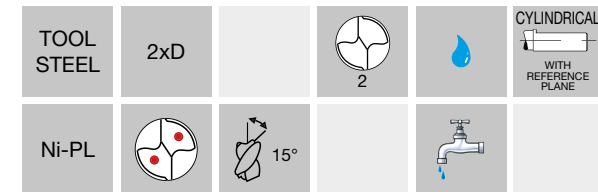
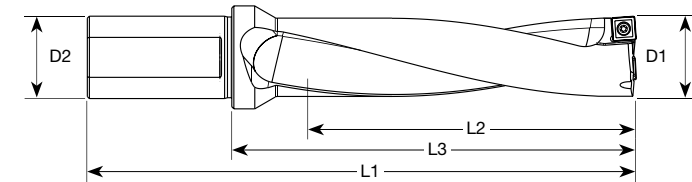
Insert / Inserto	l	s	d1	r	α°
QPGX 050204	5,00	2,38	3,00	0,4	11,0
QPGX 060204	6,00	2,38	3,60	0,4	11,0
QPGX 07T308	7,94	3,97	4,10	0,8	11,0
QPGX 090408	9,80	4,76	5,85	0,8	11,0
QPGX 110408	11,50	4,76	6,30	0,8	11,0

art.			
EDK . QPGX 050204 . BKPM4C . D4130			
EDK . QPGX 060204 . BKPM4C . D4130			
EDK . QPGX 07T308 . BKPM4C . D4130			
EDK . QPGX 090408 . BKPM4C . D4130			
EDK . QPGX 110408 . BKPM4C . D4130			

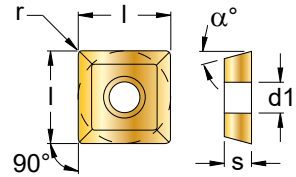
art.	geometry	toughness	Vt (m/min)	P	M	K	N
EDK . QPGX 050204 . BKPM4P . D4120	P		P1.1		M2.1	K1.1	
EDK . QPGX 060204 . BKPM4P . D4120	M		100-200		80-100	80-100	
EDK . QPGX 07T308 . BKPM4P . D4120	K		P2.2		M1.2	N1.4	
EDK . QPGX 090408 . BKPM4P . D4120	N		80-180		60-90	100-150	
EDK . QPGX 110408 . BKPM4P . D4120			P2.3			N2.2	
			70-160			120-200	

art.	geometry	toughness	Vt (m/min)	P	K	N
EDK . QPGX 050204 . BKPK5P . D6120	P		K1.1		P2.2	N1.4
EDK . QPGX 060204 . BKPK5P . D6120			100-150		100-220	120-160
EDK . QPGX 07T308 . BKPK5P . D6120	K		K1.2		P2.3	N2.2
EDK . QPGX 090408 . BKPK5P . D6120	N		60-90		80-180	140-250
EDK . QPGX 110408 . BKPK5P . D6120						

mat.	ø mm	f mm/giro	EDK.QPGX PM4P.D4120			EDK.QPGX PK5P.D6120		
			Vt mm/min	n rpm	Vf mm/min	Vt mm/min	n rpm	Vf mm/min
P 1.1	13,0	0,060	120	2940	176	150	3675	220
Construction steel	15,0	0,080	120	2548	204	150	3185	255
Acciaio da costruzione	20,0	0,120	120	1911	229	150	2389	287
	25,0	0,160	120	1529	245	150	1911	306
	30,0	0,190	120	1274	242	150	1592	303
	35,0	0,220	120	1092	240	150	1365	300
≤ 850 N/mm²	40,0	0,250	120	955	239	150	1194	299
P 2.3	13,0	0,050	80	1960	98	100	2450	122
Heat treatable steel	15,0	0,060	80	1699	102	100	2123	127
Acciaio da bonifica	20,0	0,080	80	1274	102	100	1592	127
	25,0	0,100	80	1019	102	100	1274	127
	30,0	0,120	80	849	102	100	1062	127
	35,0	0,130	80	728	95	100	910	118
≤ 1300 N/mm²	40,0	0,150	80	637	96	100	796	119
M 2.1	13,0	0,050	80	1960	98			
Stainless steel	15,0	0,060	80	1699	102			
Acciaio inossidabile	20,0	0,080	80	1274	102			
	25,0	0,100	80	1019	102			
	30,0	0,120	80	849	102			
	35,0	0,130	80	728	95			
Aust.	40,0	0,150	80	637	96			
K 1.2	13,0	0,060	100	2450	147	120	2940	176
Cast Iron	15,0	0,080	100	2123	170	120	2548	204
Ghisa	20,0	0,120	100	1592	191	120	1911	229
	25,0	0,160	100	1274	204	120	1529	245
	30,0	0,190	100	1062	202	120	1274	242
	35,0	0,210	100	910	191	120	1092	229
	40,0	0,230	100	796	183	120	955	220
N1.3	13,0	0,060	120	2940	176	150	3675	220
Aluminium cast alloys	15,0	0,080	120	2548	176	150	3185	255
Leghe fuse di Alluminio	20,0	0,120	120	1911	176	150	2389	287
	25,0	0,160	120	1529	176	150	1911	306
	30,0	0,190	120	1274	176	150	1592	303
	35,0	0,220	120	1092	176	150	1365	300
≤6% Si	40,0	0,250	120	955	176	150	1194	299



art.	D1 ±0,1	D2	L1	L2	L3			Z				
EDH . 02QPR . BKS1605 . 200 . 130	13,0	20	98	26	48							
EDH . 02QPR . BKS1605 . 200 . 135	13,5	20	98	26	48							
EDH . 02QPR . BKS1605 . 200 . 140	14,0	20	100	28	50							
EDH . 02QPR . BKS1605 . 200 . 145	14,5	20	100	28	50							
EDH . 02QPR . BKS1605 . 200 . 150	15,0	20	105	30	52							
								0,4 ÷ 0,6	2	EDK.QPGX 050204	SP-IV.BKQPGX0502.TX06	A-W.SD.TX06
EDH . 02QPR . BKS1606 . 200 . 155	15,5	20	102	30	52							
EDH . 02QPR . BKS1606 . 250 . 160	16,0	25	110	32	54							
EDH . 02QPR . BKS1606 . 250 . 165	16,5	25	110	32	54							
EDH . 02QPR . BKS1606 . 250 . 170	17,0	25	112	34	56							
EDH . 02QPR . BKS1606 . 250 . 175	17,5	25	112	34	56							
EDH . 02QPR . BKS1606 . 250 . 180	18,0	25	114	36	58							
EDH . 02QPR . BKS1606 . 250 . 185	18,5	25	114	36	58							
EDH . 02QPR . BKS1606 . 250 . 190	19,0	25	116	38	60							
EDH . 02QPR . BKS1606 . 250 . 195	19,5	25	116	38	60							
EDH . 02QPR . BKS1606 . 250 . 200	20,0	25	118	40	62							
EDH . 02QPR . BKS1606 . 250 . 205	20,5	25	118	40	62							
EDH . 02QPR . BKS1606 . 250 . 210	21,0	25	120	42	64							
								0,9 ÷ 1,2	2	EDK.QPGX 060204	SP-IV.BKQPGX0602.TX07	A-W.SD.TX07
EDH . 02QPR . BKS1607 . 250 . 220	22,0	25	122	44	66							
EDH . 02QPR . BKS1607 . 250 . 230	23,0	25	124	46	68							
EDH . 02QPR . BKS1607 . 250 . 235	23,5	25	124	47	68							
EDH . 02QPR . BKS1607 . 250 . 240	24,0	25	126	48	70							
EDH . 02QPR . BKS1607 . 250 . 245	24,5	25	126	49	70							
EDH . 02QPR . BKS1607 . 250 . 250	25,0	25	128	50	72							
EDH . 02QPR . BKS1607 . 250 . 260	26,0	25	130	52	74							
EDH . 02QPR . BKS1607 . 250 . 265	26,5	25	130	53	74							
EDH . 02QPR . BKS1607 . 250 . 270	27,0	25	132	54	76							
								1,1 ÷ 1,3	2	EDK.QPGX 07T308	SP-IV.BKQPGX07T3.TX08	A-W.SD.TX08
EDH . 02QPR . BKS1609 . 250 . 280	28,0	25	134	56	78							
EDH . 02QPR . BKS1609 . 250 . 285	28,5	25	135	57	79							
EDH . 02QPR . BKS1609 . 250 . 290	29,0	25	136	58	80							
EDH . 02QPR . BKS1609 . 320 . 300	30,0	32	147	60	87							
EDH . 02QPR . BKS1609 . 320 . 310	31,0	32	149	62	89							
EDH . 02QPR . BKS1609 . 320 . 320	32,0	32	151	64	91							
EDH . 02QPR . BKS1609 . 320 . 330	33,0	32	153	66	93							
								3,0 ÷ 4,0	2	EDK.QPGX 090408	SP-IV.BKQPGX0904.TX15	A-W.SD.TX15
EDH . 02QPR . BKS1611 . 320 . 340	34,0	32	155	68	95							
EDH . 02QPR . BKS1611 . 320 . 350	35,0	32	157	70	97							
EDH . 02QPR . BKS1611 . 320 . 360	36,0	32	159	72	99							
EDH . 02QPR . BKS1611 . 320 . 370	37,0	32	161	74	101							
EDH . 02QPR . BKS1611 . 320 . 380	38,0	32	163	76	103							
EDH . 02QPR . BKS1611 . 320 . 390	39,0	32	165	78	105							
EDH . 02QPR . BKS1611 . 320 . 395	39,5	32	166	79	105							
EDH . 02QPR . BKS1611 . 320 . 400	40,0	32	167	80	107							
								3,0 ÷ 4,0	2	EDK.QPGX 110408	SP-IV.BKQPGX1104.TX15	A-W.SD.TX15



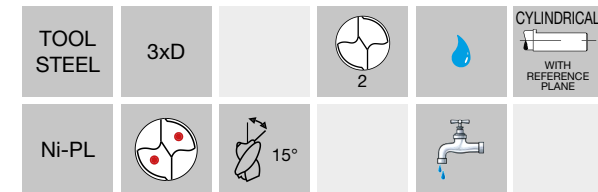
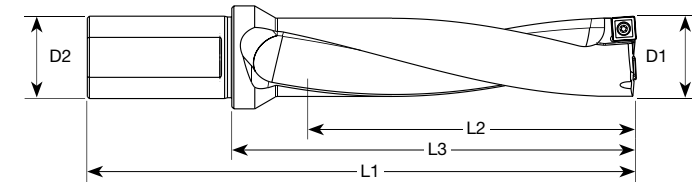
Insert / Inserto	l	s	d1	r	α°
QPGX 050204	5,00	2,38	3,00	0,4	11,0
QPGX 060204	6,00	2,38	3,60	0,4	11,0
QPGX 07T308	7,94	3,97	4,10	0,8	11,0
QPGX 090408	9,80	4,76	5,85	0,8	11,0
QPGX 110408	11,50	4,76	6,30	0,8	11,0

art.			
EDK . QPGX 050204 . BKPM4C . D4130			
EDK . QPGX 060204 . BKPM4C . D4130			
EDK . QPGX 07T308 . BKPM4C . D4130			
EDK . QPGX 090408 . BKPM4C . D4130			
EDK . QPGX 110408 . BKPM4C . D4130			

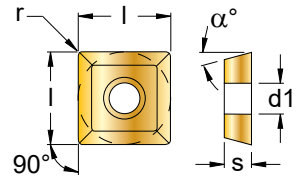
art.	geometry	toughness	Vt (m/min)	P	M	K	N
EDK . QPGX 050204 . BKPM4P . D4120	P		P1.1		M2.1	K1.1	
EDK . QPGX 060204 . BKPM4P . D4120	M		100-200		80-100	80-100	
EDK . QPGX 07T308 . BKPM4P . D4120	K		P2.2		M1.2	N1.4	
EDK . QPGX 090408 . BKPM4P . D4120	N		80-180		60-90	100-150	
EDK . QPGX 110408 . BKPM4P . D4120			P2.3			N2.2	
			70-160			120-200	

art.	geometry	toughness	Vt (m/min)	P	K	N
EDK . QPGX 050204 . BKPK5P . D6120	P		K1.1		P2.2	N1.4
EDK . QPGX 060204 . BKPK5P . D6120	M		100-150		100-220	120-160
EDK . QPGX 07T308 . BKPK5P . D6120	K		K1.2		P2.3	N2.2
EDK . QPGX 090408 . BKPK5P . D6120	N		60-90		80-180	140-250
EDK . QPGX 110408 . BKPK5P . D6120						

mat.	ø mm	f mm/giro	EDK.QPGX PM4P.D4120			EDK.QPGX PK5P.D6120		
			Vt mm/min	n rpm	Vf mm/min	Vt mm/min	n rpm	Vf mm/min
P 1.1	13,0	0,060	120	2940	176	150	3675	220
Construction steel	15,0	0,080	120	2548	204	150	3185	255
Acciaio da costruzione	20,0	0,120	120	1911	229	150	2389	287
	25,0	0,160	120	1529	245	150	1911	306
	30,0	0,190	120	1274	242	150	1592	303
	35,0	0,220	120	1092	240	150	1365	300
≤ 850 N/mm²	40,0	0,250	120	955	239	150	1194	299
P 2.3	13,0	0,050	80	1960	98	100	2450	122
Heat treatable steel	15,0	0,060	80	1699	102	100	2123	127
Acciaio da bonifica	20,0	0,080	80	1274	102	100	1592	127
	25,0	0,100	80	1019	102	100	1274	127
	30,0	0,120	80	849	102	100	1062	127
	35,0	0,130	80	728	95	100	910	118
≤ 1300 N/mm²	40,0	0,150	80	637	96	100	796	119
M 2.1	13,0	0,050	80	1960	98			
Stainless steel	15,0	0,060	80	1699	102			
Acciaio inossidabile	20,0	0,080	80	1274	102			
	25,0	0,100	80	1019	102			
	30,0	0,120	80	849	102			
	35,0	0,130	80	728	95			
Aust.	40,0	0,150	80	637	96			
K 1.2	13,0	0,060	100	2450	147	120	2940	176
Cast Iron	15,0	0,080	100	2123	170	120	2548	204
Ghisa	20,0	0,120	100	1592	191	120	1911	229
	25,0	0,160	100	1274	204	120	1529	245
	30,0	0,190	100	1062	202	120	1274	242
	35,0	0,210	100	910	191	120	1092	229
	40,0	0,230	100	796	183	120	955	220
N1.3	13,0	0,060	120	2940	176	150	3675	220
Aluminium cast alloys	15,0	0,080	120	2548	176	150	3185	255
Leghe fuse di Alluminio	20,0	0,120	120	1911	176	150	2389	287
	25,0	0,160	120	1529	176	150	1911	306
	30,0	0,190	120	1274	176	150	1592	303
	35,0	0,220	120	1092	176	150	1365	300
≤6% Si	40,0	0,250	120	955	176	150	1194	299



art.	D1 ±0,1	D2	L1	L2	L3		0,4 ÷ 0,6	Z	EDK.OPGX 050204	SP-IV.BKQPGX0502.TX06	A-W.SD.TX06
EDH . 03QPR . BKS1605 . 200 . 130	13,0	20	111	39	61			2			
EDH . 03QPR . BKS1605 . 200 . 135	13,5	20	111	39	61						
EDH . 03QPR . BKS1605 . 200 . 140	14,0	20	114	42	64						
EDH . 03QPR . BKS1605 . 200 . 145	14,5	20	114	42	64						
EDH . 03QPR . BKS1605 . 200 . 150	15,0	20	117	45	67						
EDH . 03QPR . BKS1606 . 200 . 155	15,5	20	117	45	67						
EDH . 03QPR . BKS1606 . 250 . 160	16,0	25	126	48	70						
EDH . 03QPR . BKS1606 . 250 . 165	16,5	25	126	50	70						
EDH . 03QPR . BKS1606 . 250 . 170	17,0	25	129	51	73						
EDH . 03QPR . BKS1606 . 250 . 175	17,5	25	129	51	73						
EDH . 03QPR . BKS1606 . 250 . 180	18,0	25	132	54	76						
EDH . 03QPR . BKS1606 . 250 . 185	18,5	25	132	54	76						
EDH . 03QPR . BKS1606 . 250 . 190	19,0	25	135	57	79						
EDH . 03QPR . BKS1606 . 250 . 195	19,5	25	135	57	79						
EDH . 03QPR . BKS1606 . 250 . 200	20,0	25	138	60	82						
EDH . 03QPR . BKS1606 . 250 . 205	20,5	25	138	60	82						
EDH . 03QPR . BKS1606 . 250 . 210	21,0	25	141	63	85						
EDH . 03QPR . BKS1607 . 250 . 220	22,0	25	144	66	88						
EDH . 03QPR . BKS1607 . 250 . 225	22,5	25	144	66	88						
EDH . 03QPR . BKS1607 . 250 . 230	23,0	25	147	69	91						
EDH . 03QPR . BKS1607 . 250 . 235	23,5	25	147	71	91						
EDH . 03QPR . BKS1607 . 250 . 240	24,0	25	150	72	94						
EDH . 03QPR . BKS1607 . 250 . 245	24,5	25	150	72	94						
EDH . 03QPR . BKS1607 . 250 . 250	25,0	25	153	75	97						
EDH . 03QPR . BKS1607 . 250 . 260	26,0	25	156	78	100						
EDH . 03QPR . BKS1607 . 250 . 265	26,5	25	156	78	100						
EDH . 03QPR . BKS1607 . 250 . 270	27,0	25	159	81	103						
EDH . 03QPR . BKS1609 . 250 . 280	28,0	25	162	84	106						
EDH . 03QPR . BKS1609 . 250 . 290	29,0	25	165	87	109						
EDH . 03QPR . BKS1609 . 250 . 295	29,5	25	169	87	109						
EDH . 03QPR . BKS1609 . 320 . 300	30,0	32	177	90	117						
EDH . 03QPR . BKS1609 . 320 . 310	31,0	32	180	93	120						
EDH . 03QPR . BKS1609 . 320 . 320	32,0	32	183	96	123						
EDH . 03QPR . BKS1609 . 320 . 330	33,0	32	186	99	126						
EDH . 03QPR . BKS1611 . 320 . 340	34,0	32	189	102	129						
EDH . 03QPR . BKS1611 . 320 . 350	35,0	32	192	105	132						
EDH . 03QPR . BKS1611 . 320 . 360	36,0	32	195	108	135						
EDH . 03QPR . BKS1611 . 320 . 370	37,0	32	198	111	138						
EDH . 03QPR . BKS1611 . 320 . 380	38,0	32	201	114	141						
EDH . 03QPR . BKS1611 . 320 . 390	39,0	32	204	117	144						
EDH . 03QPR . BKS1611 . 320 . 395	39,5	32	204	117	144						
EDH . 03QPR . BKS1611 . 320 . 400	40,0	32	207	120	147						



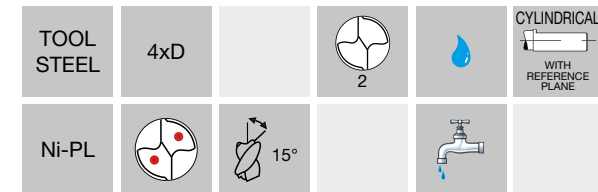
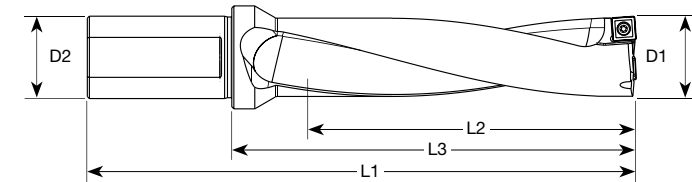
Insert / Inserto	l	s	d1	r	α°
QPGX 050204	5,00	2,38	3,00	0,4	11,0
QPGX 060204	6,00	2,38	3,60	0,4	11,0
QPGX 07T308	7,94	3,97	4,10	0,8	11,0
QPGX 090408	9,80	4,76	5,85	0,8	11,0
QPGX 110408	11,50	4,76	6,30	0,8	11,0

art.			
EDK . QPGX 050204 . BKPM4C . D4130			
EDK . QPGX 060204 . BKPM4C . D4130			
EDK . QPGX 07T308 . BKPM4C . D4130			
EDK . QPGX 090408 . BKPM4C . D4130			
EDK . QPGX 110408 . BKPM4C . D4130			

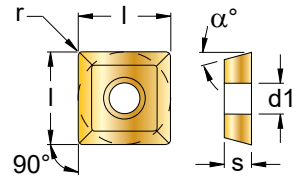
art.	geometry	toughness	Vt (m/min)	P	M	K	N
EDK . QPGX 050204 . BKPM4P . D4120	P		P1.1		M2.1	K1.1	
EDK . QPGX 060204 . BKPM4P . D4120	M		100-200		80-100	80-100	
EDK . QPGX 07T308 . BKPM4P . D4120	K		P2.2		M1.2	N1.4	
EDK . QPGX 090408 . BKPM4P . D4120	N		80-180		60-90	100-150	
EDK . QPGX 110408 . BKPM4P . D4120			P2.3			N2.2	
			70-160			120-200	

art.	geometry	toughness	Vt (m/min)	P	K	N
EDK . QPGX 050204 . BKPK5P . D6120	P		K1.1		P2.2	N1.4
EDK . QPGX 060204 . BKPK5P . D6120			100-150		100-220	120-160
EDK . QPGX 07T308 . BKPK5P . D6120	K		K1.2		P2.3	N2.2
EDK . QPGX 090408 . BKPK5P . D6120	N		60-90		80-180	140-250
EDK . QPGX 110408 . BKPK5P . D6120						

mat.	ø mm	f mm/giro	EDK.QPGX PM4P.D4120			EDK.QPGX PK5P.D6120		
			Vt mm/min	n rpm	Vf mm/min	Vt mm/min	n rpm	Vf mm/min
P 1.1	13,0	0,060	100	2450	147	130	3185	191
Construction steel	15,0	0,080	100	2123	170	130	2760	221
Acciaio da costruzione	20,0	0,120	100	1592	191	130	2070	248
	25,0	0,160	100	1274	204	130	1656	265
	30,0	0,190	100	1062	202	130	1380	262
	35,0	0,220	100	910	200	130	1183	260
≤ 850 N/mm²	40,0	0,250	100	796	199	130	1035	259
P 2.3	13,0	0,050	70	1715	86	85	2082	104
Heat treatable steel	15,0	0,060	70	1486	89	85	1805	108
Acciaio da bonifica	20,0	0,080	70	1115	89	85	1354	108
	25,0	0,100	70	892	89	85	1083	108
	30,0	0,120	70	743	89	85	902	108
	35,0	0,130	70	637	83	85	773	101
≤ 1300 N/mm²	40,0	0,150	70	557	84	85	677	102
M 2.1	13,0	0,050	70	1715	86			
Stainless steel	15,0	0,060	70	1486	89			
Acciaio inossidabile	20,0	0,080	70	1115	89			
	25,0	0,100	70	892	89			
	30,0	0,120	70	743	89			
	35,0	0,130	70	637	83			
Aust.	40,0	0,150	70	557	84			
K 1.2	13,0	0,060	85	2082	125	100	2450	147
Cast Iron Ghisa	15,0	0,080	85	1805	144	100	2123	170
	20,0	0,120	85	1354	162	100	1592	191
	25,0	0,160	85	1083	173	100	1274	204
	30,0	0,190	85	902	171	100	1062	202
	35,0	0,210	85	773	162	100	910	191
	40,0	0,230	85	677	156	100	796	183
N1.3	13,0	0,060	100	2450	176	130	3185	191
Aluminium cast alloys	15,0	0,080	100	2123	176	130	2760	221
Leghe fuse di Alluminio	20,0	0,120	100	1592	176	130	2070	248
	25,0	0,160	100	1274	176	130	1656	265
	30,0	0,190	100	1062	176	130	1380	262
	35,0	0,220	100	910	176	130	1183	260
≤6% Si	40,0	0,250	100	796	176	130	1035	259



art.	D1 ±0,1	D2	L1	L2	L3		Z				
EDH . 04QPR . BKS1605 . 200 . 130	13,0	20	124	52	74						
EDH . 04QPR . BKS1605 . 200 . 135	13,5	20	124	52	74						
EDH . 04QPR . BKS1605 . 200 . 140	14,0	20	128	56	78						
EDH . 04QPR . BKS1605 . 200 . 145	14,5	20	128	56	78						
EDH . 04QPR . BKS1605 . 200 . 150	15,0	20	132	60	82						
						0,4 ÷ 0,6	2	EDK.QPGX 050204	SP-IV.BKQPGX0502.TX06	A-W.SD.TX06	
EDH . 04QPR . BKS1606 . 200 . 155	15,5	20	132	60	82						
EDH . 04QPR . BKS1606 . 250 . 160	16,0	25	142	64	86						
EDH . 04QPR . BKS1606 . 250 . 165	16,5	25	142	64	86						
EDH . 04QPR . BKS1606 . 250 . 170	17,0	25	145	68	89						
EDH . 04QPR . BKS1606 . 250 . 175	17,5	25	145	68	89						
EDH . 04QPR . BKS1606 . 250 . 180	18,0	25	150	72	94						
EDH . 04QPR . BKS1606 . 250 . 185	18,5	25	150	72	94						
EDH . 04QPR . BKS1606 . 250 . 190	19,0	25	154	76	98						
EDH . 04QPR . BKS1606 . 250 . 195	19,5	25	154	76	98						
EDH . 04QPR . BKS1606 . 250 . 200	20,0	25	158	80	102						
EDH . 04QPR . BKS1606 . 250 . 205	20,5	25	158	80	102						
EDH . 04QPR . BKS1606 . 250 . 210	21,0	25	162	84	106						
						0,9 ÷ 1,2	2	EDK.QPGX 060204	SP-IV.BKQPGX0602.TX07	A-W.SD.TX07	
EDH . 04QPR . BKS1607 . 250 . 220	22,0	25	166	88	110						
EDH . 04QPR . BKS1607 . 250 . 225	22,5	25	166	88	110						
EDH . 04QPR . BKS1607 . 250 . 230	23,0	25	170	92	114						
EDH . 04QPR . BKS1607 . 250 . 235	23,5	25	170	92	114						
EDH . 04QPR . BKS1607 . 250 . 240	24,0	25	174	96	118						
EDH . 04QPR . BKS1607 . 250 . 245	24,5	25	174	96	118						
EDH . 04QPR . BKS1607 . 250 . 250	25,0	25	178	100	122						
EDH . 04QPR . BKS1607 . 250 . 260	26,0	25	182	104	126						
EDH . 04QPR . BKS1607 . 250 . 265	26,5	25	182	104	126						
EDH . 04QPR . BKS1607 . 250 . 270	27,0	25	188	108	130						
						1,1 ÷ 1,3	2	EDK.QPGX 07T308	SP-IV.BKQPGX07T3.TX08	A-W.SD.TX08	
EDH . 04QPR . BKS1609 . 250 . 280	28,0	25	190	112	134						
EDH . 04QPR . BKS1609 . 250 . 290	29,0	25	194	116	138						
EDH . 04QPR . BKS1609 . 250 . 295	29,5	25	194	116	138						
EDH . 04QPR . BKS1609 . 320 . 300	30,0	32	207	120	147						
EDH . 04QPR . BKS1609 . 320 . 310	31,0	32	211	124	151						
EDH . 04QPR . BKS1609 . 320 . 320	32,0	32	215	128	155						
EDH . 04QPR . BKS1609 . 320 . 330	33,0	32	219	132	159						
						3,0 ÷ 4,0	2	EDK.QPGX 090408	SP-IV.BKQPGX0904.TX15	A-W.SD.TX15	
EDH . 04QPR . BKS1611 . 320 . 340	34,0	32	223	133	163						
EDH . 04QPR . BKS1611 . 320 . 350	35,0	32	227	140	167						
EDH . 04QPR . BKS1611 . 320 . 360	36,0	32	231	144	171						
EDH . 04QPR . BKS1611 . 320 . 370	37,0	32	235	148	175						
EDH . 04QPR . BKS1611 . 320 . 380	38,0	32	239	152	179						
EDH . 04QPR . BKS1611 . 320 . 390	39,0	32	243	156	183						
EDH . 04QPR . BKS1611 . 320 . 395	39,5	32	243	156	183						
EDH . 04QPR . BKS1611 . 320 . 400	40,0	32	247	160	187						
						3,0 ÷ 4,0	2	EDK.QPGX 110408	SP-IV.BKQPGX1104.TX15	A-W.SD.TX15	



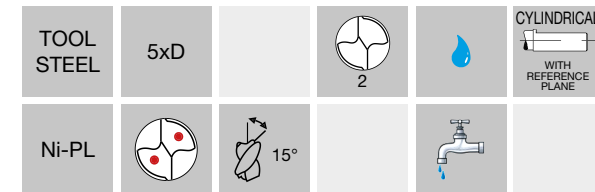
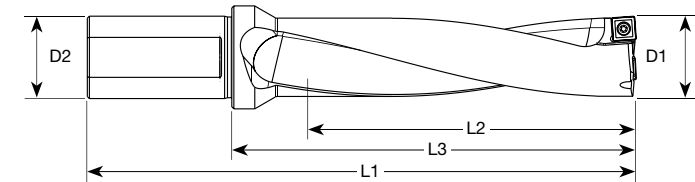
Insert / Inserto	l	s	d1	r	α°
QPGX 050204	5,00	2,38	3,00	0,4	11,0
QPGX 060204	6,00	2,38	3,60	0,4	11,0
QPGX 07T308	7,94	3,97	4,10	0,8	11,0
QPGX 090408	9,80	4,76	5,85	0,8	11,0
QPGX 110408	11,50	4,76	6,30	0,8	11,0

art.			
EDK . QPGX 050204 . BKPM4C . D4130			
EDK . QPGX 060204 . BKPM4C . D4130			
EDK . QPGX 07T308 . BKPM4C . D4130			
EDK . QPGX 090408 . BKPM4C . D4130			
EDK . QPGX 110408 . BKPM4C . D4130			

art.	geometry	toughness	Vt (m/min)	P	M	K	N
EDK . QPGX 050204 . BKPM4P . D4120	P		P1.1		M2.1	K1.1	
EDK . QPGX 060204 . BKPM4P . D4120	M		P2.2		M1.2	N1.4	
EDK . QPGX 07T308 . BKPM4P . D4120	K		P2.3			N2.2	
EDK . QPGX 090408 . BKPM4P . D4120	N						
EDK . QPGX 110408 . BKPM4P . D4120							

art.	geometry	toughness	Vt (m/min)	P	K	N
EDK . QPGX 050204 . BKPK5P . D6120	P		K1.1		P2.2	N1.4
EDK . QPGX 060204 . BKPK5P . D6120	M		K1.2		P2.3	N2.2
EDK . QPGX 07T308 . BKPK5P . D6120	K					
EDK . QPGX 090408 . BKPK5P . D6120	N					
EDK . QPGX 110408 . BKPK5P . D6120						

mat.	ø mm	f mm/giro	EDK.QPGX PM4P.D4120			EDK.QPGX PK5P.D6120		
			Vt mm/min	n rpm	Vf mm/min	Vt mm/min	n rpm	Vf mm/min
P 1.1	14,0	0,050	90	2047	102	110	2502	125
Construction steel	15,0	0,070	90	1911	134	110	2335	163
Acciaio da costruzione	20,0	0,110	90	1433	158	110	1752	193
	25,0	0,140	90	1146	161	110	1401	196
	30,0	0,170	90	955	162	110	1168	199
	35,0	0,200	90	819	164	110	1001	200
≤ 850 N/mm²	40,0	0,230	90	717	165	110	876	201
P 2.3	14,0	0,040	60	1365	55	80	1820	73
Heat treatable steel	15,0	0,050	60	1274	64	80	1699	85
Acciaio da bonifica	20,0	0,070	60	955	67	80	1274	89
	25,0	0,090	60	764	69	80	1019	92
	30,0	0,100	60	637	64	80	849	85
	35,0	0,110	60	546	60	80	728	80
≤ 1300 N/mm²	40,0	0,130	60	478	62	80	637	83
M 2.1	14,0	0,040	60	1365	55			
Stainless steel	15,0	0,050	60	1274	64			
Acciaio inossidabile	20,0	0,070	60	955	67			
	25,0	0,090	60	764	69			
	30,0	0,100	60	637	64			
	35,0	0,110	60	546	60			
Aust.	40,0	0,130	60	478	62			
K 1.2	14,0	0,050	80	1820	91	90	2047	102
Cast Iron	15,0	0,070	80	1699	119	90	1911	134
Ghisa	20,0	0,110	80	1274	140	90	1433	158
	25,0	0,140	80	1019	143	90	1146	161
	30,0	0,170	80	849	144	90	955	162
	35,0	0,190	80	728	138	90	819	156
	40,0	0,210	80	637	134	90	717	150
N1.3	14,0	0,050	90	2047	176	110	2502	125
Aluminium cast alloys	15,0	0,070	90	1911	176	110	2335	163
Leghe fuse di Alluminio	20,0	0,110	90	1433	176	110	1752	193
	25,0	0,140	90	1146	176	110	1401	196
	30,0	0,170	90	955	176	110	1168	199
	35,0	0,200	90	819	176	110	1001	200
≤6% Si	40,0	0,230	90	717	176	110	876	201



art.	D1 ±0,1	D2	L1	L2	L3		Z				
EDH . 05QPR . BKS1605 . 200 . 140	14,0	20	142	70	92						
EDH . 05QPR . BKS1605 . 200 . 145	14,5	20	142	70	92						
EDH . 05QPR . BKS1605 . 200 . 150	15,0	20	147	75	97						
						0,4 ÷ 0,6	2	EDK.OPGX 050204	SP-IV.BKQPGX0502.TX06	A-W.SD.TX06	
EDH . 05QPR . BKS1606 . 200 . 155	15,5	20	147	75	97						
EDH . 05QPR . BKS1606 . 250 . 160	16,0	25	158	80	102						
EDH . 05QPR . BKS1606 . 250 . 165	16,5	25	158	80	102						
EDH . 05QPR . BKS1606 . 250 . 170	17,0	25	163	85	107						
EDH . 05QPR . BKS1606 . 250 . 175	17,5	25	163	85	107						
EDH . 05QPR . BKS1606 . 250 . 180	18,0	25	168	90	112						
EDH . 05QPR . BKS1606 . 250 . 185	18,5	25	168	90	112						
EDH . 05QPR . BKS1606 . 250 . 190	19,0	25	173	95	117						
EDH . 05QPR . BKS1606 . 250 . 195	19,5	25	173	95	117						
EDH . 05QPR . BKS1606 . 250 . 200	20,0	25	178	100	122						
EDH . 05QPR . BKS1606 . 250 . 205	20,5	25	178	100	122						
EDH . 05QPR . BKS1606 . 250 . 210	21,0	25	183	105	127						
EDH . 05QPR . BKS1607 . 250 . 220	22,0	25	197	110	137						
EDH . 05QPR . BKS1607 . 250 . 225	22,5	25	197	110	137						
EDH . 05QPR . BKS1607 . 250 . 230	23,0	25	202	115	142						
EDH . 05QPR . BKS1607 . 250 . 235	23,5	25	202	115	142						
EDH . 05QPR . BKS1607 . 250 . 240	24,0	25	207	120	147						
EDH . 05QPR . BKS1607 . 250 . 245	24,5	25	207	120	147						
EDH . 05QPR . BKS1607 . 250 . 250	25,0	25	212	125	152						
EDH . 05QPR . BKS1607 . 250 . 260	26,0	25	217	130	157						
EDH . 05QPR . BKS1607 . 250 . 265	26,5	25	217	130	157						
EDH . 05QPR . BKS1607 . 250 . 270	27,0	25	222	135	162						
EDH . 05QPR . BKS1609 . 250 . 280	28,0	25	227	140	167						
EDH . 05QPR . BKS1609 . 250 . 290	29,0	25	232	145	172						
EDH . 05QPR . BKS1609 . 250 . 295	29,5	25	232	145	172						
EDH . 05QPR . BKS1609 . 320 . 300	30,0	32	237	150	177						
EDH . 05QPR . BKS1609 . 320 . 310	31,0	32	242	155	182						
EDH . 05QPR . BKS1609 . 320 . 320	32,0	32	247	160	187						
EDH . 05QPR . BKS1609 . 320 . 330	33,0	32	252	165	192						
EDH . 05QPR . BKS1611 . 320 . 340	34,0	32	257	170	197						
EDH . 05QPR . BKS1611 . 320 . 350	35,0	32	262	175	202						
EDH . 05QPR . BKS1611 . 320 . 360	36,0	32	267	180	207						
EDH . 05QPR . BKS1611 . 320 . 370	37,0	32	272	185	212						
EDH . 05QPR . BKS1611 . 320 . 380	38,0	32	277	190	217						
EDH . 05QPR . BKS1611 . 320 . 390	39,0	32	282	195	222						
EDH . 05QPR . BKS1611 . 320 . 395	39,5	32	282	195	222						
EDH . 05QPR . BKS1611 . 320 . 400	40,0	32	287	200	227						
						3,0 ÷ 4,0	2	EDK.OPGX 090408	SP-IV.BKQPGX0904.TX15	A-W.SD.TX15	
EDH . 05QPR . BKS1611 . 320 . 350	35,0	32	262	175	202						
EDH . 05QPR . BKS1611 . 320 . 360	36,0	32	267	180	207						
EDH . 05QPR . BKS1611 . 320 . 370	37,0	32	272	185	212						
EDH . 05QPR . BKS1611 . 320 . 380	38,0	32	277	190	217						
EDH . 05QPR . BKS1611 . 320 . 390	39,0	32	282	195	222						
EDH . 05QPR . BKS1611 . 320 . 395	39,5	32	282	195	222						
EDH . 05QPR . BKS1611 . 320 . 400	40,0	32	287	200	227						



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