

TAFS, TAFM, TAFL

DEĞİŞTİRİLEBİLİR KESİCİ UÇLU MATKAP
DÜŞÜK DELME GÜRÜLTÜSÜ VE GÜÇLÜ GÖVDE



*M*plus...

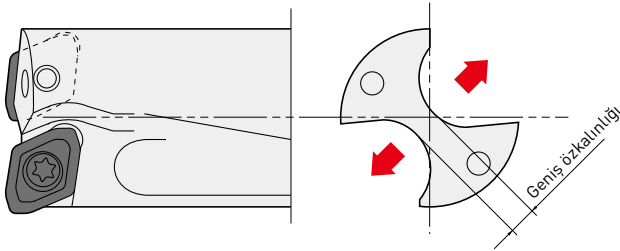
TAFS, TAFM, TAFL

DEĞİŞTİRİLEBİLİR KESİCİ UÇLU MATKAP

ÖZELLİKLER

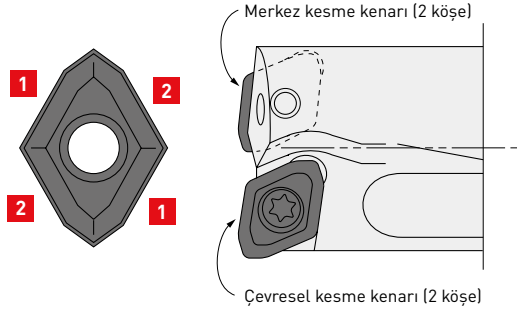
Güçlü Gövde

- Kapsamlı web tasarımı gürültüyü azaltır.
- Daha düşük kesme sesi.
- Sağlıklı uç yerleştirme için yüksek uç yuvası dayanıklılığı.



Ekonomik Kesici uç

- Ekonomik dört köşe kullanımı.



1 Merkez kenar

2 Çevresel kenar



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KESME PERFORMANSI

TALAŞ GEOMETRİSİ

U1 Kırıcı

Malzeme	Yumuşak Çelik
Matkap Çapı (mm)	Ø 25
Vc (m/dk)	200
f (mm/dev)	0.10



U2 Kırıcı

Malzeme	DIN X5CrNi189
Matkap Çapı (mm)	Ø 25
Vc (m/dk)	150
f (mm/dev)	0.10



U3 Kırıcı

Malzeme	DIN Ck45
Matkap Çapı (mm)	Ø 25
Vc (m/dk)	150
f (mm/dev)	0.14



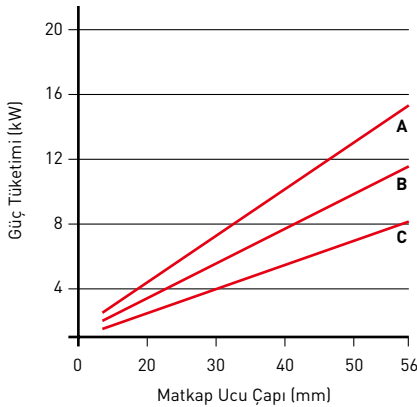
U3 Kırıcı

Malzeme	DIN 42CrMo4
Matkap Çapı (mm)	Ø 25
Vc (m/dk)	150
f (mm/dev)	0.12

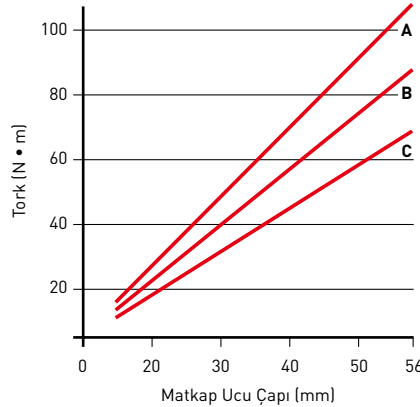


KESME DİRENCİ

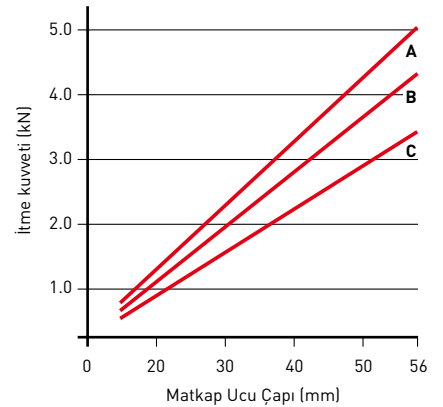
GÜÇ TÜKETİMİ



TORK



İTME KUVVETİ

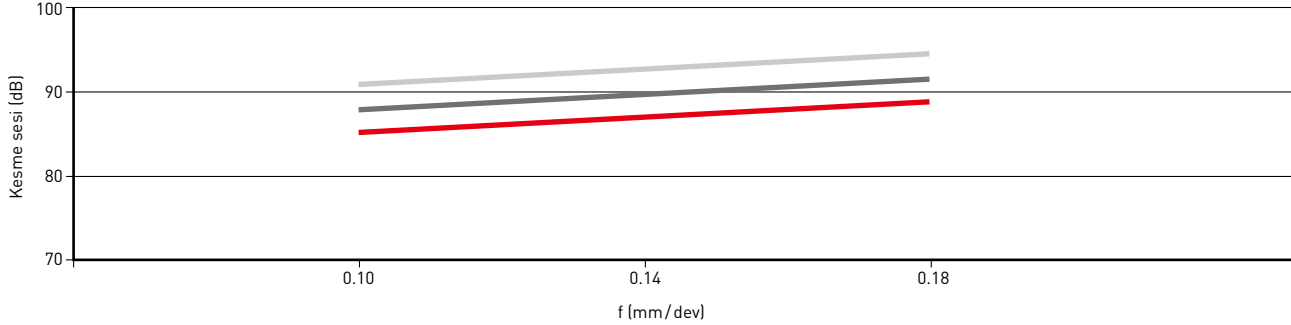


1. İş parçası: DIN X5CrNi189 (220HB) Kesme Hızı: 150 m/dk Kesici Uç: U2 Kırıcı

A: f = 0.15 mm/dev B: f = 0.1 mm/dev C: f = 0.06 mm/dev

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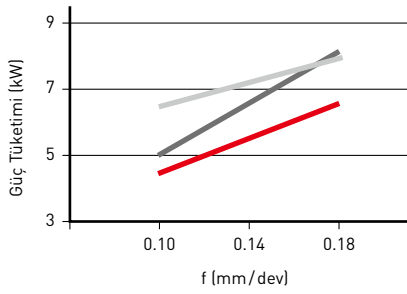
KESME SESİ



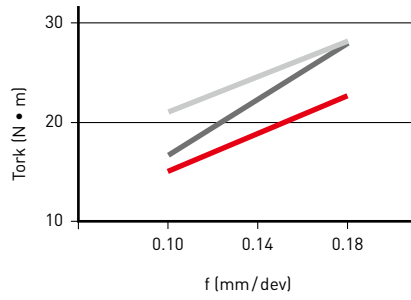
1. İş parçası: DIN 42CrMo4 (200 – 220 HB) Matkap Ucu Çapı (mm): Ø 25 Kesme Hızı: 150 m/dk Kesici Uç: U2 Kırıcı

KESME DİRENCİ

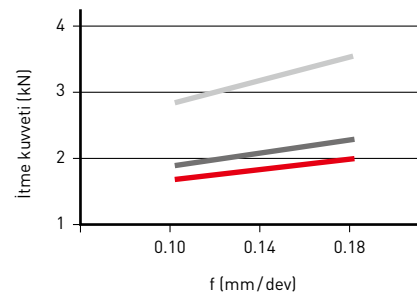
GÜÇ TÜKETİMİ



TORK



İTME KUVVETİ



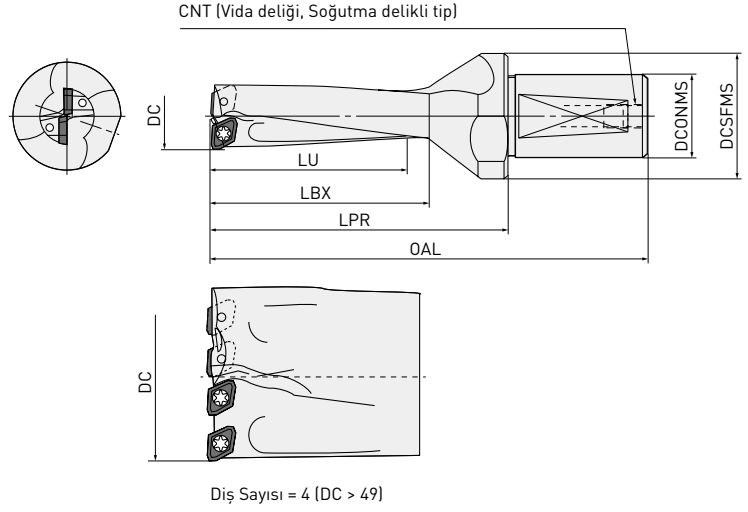
1. İş parçası: DIN 42CrMo4 (200 – 220 HB) Matkap Ucu Çapı (mm): Ø 25 Kesme Hızı: 150 m/dk Kesici Uç: U3 Kırıcı

GW > TANIMLAMA

	TA	F	S	3200	F	40
Değiştirilebilir uçlu matkap simli	TAF matkap simbolü	L x D simbolü: S = 2D, M = 3D, L = 4D	Matkap çapı: Ø 32.00	Şaft tipi simbolü F = Flanş tipi	Şaft çapı: Ø 40	

TAFS, TAFM, TAFL

P M K



Sipariş No.	Stok	DC	L/D	ZNF	LU	LBX	LPR	OAL	DCONMS	DCSFMS	CNT	Kesici uç
TAFS1200F20	●	12.0	2	2	24	29	39	82	20	25	PT1/8	GCMT040204-U○
TAFM1200F20	●		3		36	41	51	94	20	25	PT1/8	
TAFL1200F20	●		4		48	53	63	106	20	25	PT1/8	
TAFS1250F20	●	12.5	2	2	25	29	39	82	20	25	PT1/8	GCMT040204-U○
TAFM1250F20	●		3		37.5	41	51	94	20	25	PT1/8	
TAFL1250F20	●		4		50	53	63	106	20	25	PT1/8	
TAFS1300F20	●	13.0	2	2	26	31	41	84	20	25	PT1/8	GCMT040204-U○
TAFM1300F20	●		3		39	44	54	97	20	25	PT1/8	
TAFL1300F20	●		4		52	57	67	110	20	25	PT1/8	
TAFS1350F20	●	13.5	2	2	27	31	41	84	20	25	PT1/8	GCMT040204-U○
TAFM1350F20	●		3		40.5	44	54	97	20	25	PT1/8	
TAFL1350F20	●		4		54	57	67	110	20	25	PT1/8	
TAFS1400F20	●	14.0	2	2	28	33	43	86	20	25	PT1/8	GCMT040204-U○
TAFM1400F20	●		3		42	47	57	100	20	25	PT1/8	
TAFL1400F20	●		4		56	61	71	114	20	25	PT1/8	
TAFS1450F20	●	14.5	2	2	29	33	43	86	20	25	PT1/8	GCMT040204-U○
TAFM1450F20	●		3		43.5	47	57	100	20	25	PT1/8	
TAFL1450F20	●		4		58	61	71	114	20	25	PT1/8	
TAFS1500F20	●	15.0	2	2	30	35	45	88	20	25	PT1/8	GPMT060204-U○
TAFM1500F20	●		3		45	50	60	103	20	25	PT1/8	
TAFL1500F20	●		4		60	65	75	118	20	25	PT1/8	
TAFS1550F20	●	15.5	2	2	31	35	45	88	20	25	PT1/8	GPMT060204-U○
TAFM1550F20	●		3		46.5	50	60	103	20	25	PT1/8	
TAFL1550F20	●		4		62	65	75	118	20	25	PT1/8	
TAFS1600F25	●	16.0	2	2	32	38	57	107	25	35	PT1/8	GPMT060204-U○
TAFM1600F25	●		3		48	54	73	123	25	35	PT1/8	
TAFL1600F25	●		4		64	70	89	139	25	35	PT1/8	
TAFS1650F25	●	16.5	2	2	33	38	57	107	25	35	PT1/8	GPMT060204-U○
TAFM1650F25	●		3		49.5	54	73	123	25	35	PT1/8	

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TAFS,TAFM,TAFL

Sipariş No.	Stok	DC	L/D	ZNF	LU	LBX	LPR	OAL	DCONMS	DCSFMX	CNT	Kesici uç
TAFS1700F25	●		2		34	41	59	109	25	35	PT1/8	
TAFM1700F25	●	17.0	3	2	51	58	76	126	25	35	PT1/8	GPMT060204-U○
TAFL1700F25	●		4		68	75	93	143	25	35	PT1/8	
TAFS1750F25	●		2		35	41	59	109	25	35	PT1/8	
TAFM1750F25	●	17.5	3	2	52.5	58	76	126	25	35	PT1/8	GPMT060204-U○
TAFL1750F25	●		4		70	75	93	143	25	35	PT1/8	
TAFS1800F25	●		2		36	43	61	111	25	35	PT1/8	
TAFM1800F25	●	18.0	3	2	54	61	79	129	25	35	PT1/8	GPMT070204-U○
TAFL1800F25	●		4		72	79	97	147	25	35	PT1/8	
TAFS1850F25	●		2		37	43	61	111	25	35	PT1/8	
TAFM1850F25	●	18.5	3	2	55.5	61	79	129	25	35	PT1/8	GPMT070204-U○
TAFS1900F25	●		2		38	46	63	113	25	35	PT1/8	
TAFM1900F25	●	19.0	3	2	57	65	82	132	25	35	PT1/8	GPMT070204-U○
TAFL1900F25	●		4		76	84	101	151	25	35	PT1/8	
TAFS1950F25	●		2		39	46	63	113	25	35	PT1/8	
TAFM1950F25	●	19.5	3	2	58.5	65	82	132	25	35	PT1/8	GPMT070204-U○
TAFS2000F25	●		2		40	48	65	115	25	35	PT1/8	
TAFM2000F25	●	20.0	3	2	60	68	85	135	25	35	PT1/8	GPMT070204-U○
TAFL2000F25	●		4		80	88	105	155	25	35	PT1/8	
TAFS2050F25	●		2		41	48	65	115	25	35	PT1/8	
TAFM2050F25	●	20.5	3	2	61.5	68	85	135	25	35	PT1/8	GPMT070204-U○
TAFS2100F25	●		2		42	50	67	117	25	35	PT1/8	
TAFM2100F25	●	21.0	3	2	63	71	88	138	25	35	PT1/8	GPMT070204-U○
TAFL2100F25	●		4		84	92	109	159	25	35	PT1/8	
TAFS2150F25	●		2		43	50	67	117	25	35	PT1/8	
TAFM2150F25	●	21.5	3	2	64.5	71	88	138	25	35	PT1/8	GPMT070204-U○
TAFS2200F25	●		2		44	53	69	119	25	35	PT1/8	
TAFM2200F25	●	22.0	3	2	66	75	91	141	25	35	PT1/8	GPMT070204-U○
TAFL2200F25	●		4		88	97	113	163	25	35	PT1/8	
TAFS2250F25	●		2		45	53	69	119	25	35	PT1/8	
TAFM2250F25	●	22.5	3	2	67.5	75	91	141	25	35	PT1/8	GPMT070204-U○
TAFS2300F25	●		2		46	55	71	121	25	35	PT1/8	
TAFM2300F25	●	23.0	3	2	69	78	94	144	25	35	PT1/8	GPMT090304-U○
TAFL2300F25	●		4		92	101	117	167	25	35	PT1/8	
TAFS2350F25	●		2		47	55	71	121	25	35	PT1/8	
TAFM2350F25	●	23.5	3	2	70.5	78	94	144	25	35	PT1/8	GPMT090304-U○
TAFL2350F25	●		4		94	101	117	167	25	35	PT1/8	
TAFS2400F25	●		2		48	58	73	123	25	35	PT1/8	
TAFM2400F25	●	24.0	3	2	72	82	97	147	25	35	PT1/8	GPMT090304-U○
TAFL2400F25	●		4		96	106	121	171	25	35	PT1/8	
TAFS2450F25	●		2		49	58	73	123	25	35	PT1/8	
TAFM2450F25	●	24.5	3	2	73.5	82	97	147	25	35	PT1/8	GPMT090304-U○
TAFS2500F32	●		2		50	60	75	130	32	42	PT1/8	
TAFM2500F32	●		3		75	85	100	155	32	42	PT1/8	
TAFL2500F25	●	25.0	4	2	100	110	125	180	25	35	PT1/8	GPMT090304-U○
TAFL2500F32	●		4		100	110	125	180	32	42	PT1/8	
TAFS2550F32	●		2		51	60	75	130	32	42	PT1/8	
TAFM2550F32	●	25.5	3	2	76.5	85	100	155	32	42	PT1/8	GPMT090304-U○
TAFS2600F32	●		2		52	62	77	132	32	42	PT1/8	
TAFM2600F32	●	26.0	3	2	78	88	103	158	32	42	PT1/8	GPMT090304-U○
TAFL2600F32	●		4		104	114	129	184	32	42	PT1/8	

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TAFS,TAFM,TAFL

Sipariş No.	Stok	DC	L/D	ZNF	LU	LBX	LPR	OAL	DCONMS	DCSFMX	CNT	Kesici uç
TAFS2650F32	●	26.5	2	2	53	62	77	132	32	42	PT1/8	GPMT090304-U○
TAFM2650F32	●		3		79.5	88	103	158	32	42	PT1/8	
TAFL2650F32	●		4		106	114	129	184	32	42	PT1/8	
TAFS2700F32	●	27.0	2	2	54	65	79	134	32	42	PT1/8	GPMT090304-U○
TAFM2700F32	●		3		81	92	106	161	32	42	PT1/8	
TAFL2700F32	●		4		108	119	133	188	32	42	PT1/8	
TAFS2750F32	●	27.5	2	2	55	65	79	134	32	42	PT1/8	GPMT090304-U○
TAFM2750F32	●		3		82.5	92	106	161	32	42	PT1/8	
TAFS2800F32	●		2		56	67	81	136	32	42	PT1/8	
TAFM2800F32	●	28.0	3	2	84	95	109	164	32	42	PT1/8	GPMT11T308-U○
TAFL2800F32	●		4		112	123	137	192	32	42	PT1/8	
TAFS2850F32	●		2		57	67	81	136	32	42	PT1/8	
TAFM2850F32	●	28.5	3	2	85.5	95	109	164	32	42	PT1/8	GPMT11T308-U○
TAFL2850F40	●		4		114	123	137	202	40	50	PT1/8	
TAFS2900F32	●		2		58	70	83	138	32	42	PT1/8	
TAFM2900F32	●	29.0	3	2	87	99	112	167	32	42	PT1/8	GPMT11T308-U○
TAFL2900F32	●		4		116	128	141	196	32	42	PT1/8	
TAFS2950F32	●		2		59	70	83	138	32	42	PT1/8	
TAFM2950F32	●	29.5	3	2	88.5	99	112	167	32	42	PT1/8	GPMT11T308-U○
TAFS3000F32	●		2		60	72	90	145	32	50	PT1/8	
TAFS3000F40	●		2		60	72	90	155	40	50	PT1/4	
TAFM3000F32	●	30.0	3	2	90	102	120	175	32	50	PT1/8	GPMT11T308-U○
TAFM3000F40	●		3		90	102	120	185	40	50	PT1/4	
TAFL3000F32	●		4		120	132	150	205	32	42	PT1/8	
TAFL3000F40	●	30.5	4		120	132	150	215	40	50	PT1/4	
TAFS3050F40	●		2	2	61	72	90	155	40	50	PT1/4	GPMT11T308-U○
TAFM3050F40	●		3		91.5	102	120	185	40	50	PT1/4	
TAFS3100F32	●	31.0	2		62	74	92	147	32	50	PT1/8	
TAFS3100F40	●		2		62	74	92	157	40	50	PT1/4	
TAFM3100F32	●		3	2	93	105	123	178	32	50	PT1/8	GPMT11T308-U○
TAFM3100F40	●	31.0	3		93	105	123	188	40	50	PT1/4	
TAFL3100F32	●		4		124	135	154	209	32	42	PT1/8	
TAFL3100F40	●	32.0	4		124	136	154	219	40	50	PT1/4	
TAFS3200F32	●		2	2	64	77	94	149	32	50	PT1/8	GPMT11T308-U○
TAFS3200F40	●		2		64	77	94	159	40	50	PT1/4	
TAFM3200F32	●	32.0	3		96	109	126	181	32	50	PT1/8	
TAFM3200F40	●		3		96	109	126	191	40	50	PT1/4	
TAFL3200F32	●		4	2	128	141	158	213	32	42	PT1/8	GPMT11T308-U○
TAFL3200F40	●	33.0	4		128	141	158	223	40	50	PT1/4	
TAFS3300F32	●		2		66	79	96	151	32	50	PT1/8	
TAFS3300F40	●	33.0	2	2	66	79	96	161	40	50	PT1/4	GPMT11T308-U○
TAFM3300F32	●		3		99	112	129	184	32	50	PT1/8	
TAFM3300F40	●		3		99	112	129	194	40	50	PT1/4	
TAFL3300F32	●	34.0	4	2	132	145	162	217	32	42	PT1/8	GPMT11T308-U○
TAFL3300F40	●		4		132	145	162	227	40	50	PT1/4	
TAFS3400F32	●		2		68	82	98	153	32	50	PT1/8	
TAFS3400F40	●	34.0	2	2	68	82	98	163	40	50	PT1/4	GPMT11T308-U○
TAFM3400F32	●		3		102	116	132	187	32	50	PT1/8	
TAFM3400F40	●		3		102	116	132	197	40	50	PT1/4	
TAFL3400F32	●	34.0	4	2	136	150	166	231	32	42	PT1/8	GPMT11T308-U○
TAFL3400F40	●		4		136	150	166	231	40	50	PT1/4	

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TAFS, TAFM, TAFL

Sipariş No.	Stok	DC	L/D	ZNF	LU	LBX	LPR	OAL	DCONMS	DCSFMX	CNT	Kesici uç
TAFS3500F32	●	35.0	2	2	70	84	100	155	32	50	PT1/8	GPMT140408-U○
TAFS3500F40	●		2		70	84	100	165	40	50	PT1/4	
TAFM3500F32	●		3		105	119	135	190	32	50	PT1/8	
TAFM3500F40	●		3		105	119	135	200	40	50	PT1/4	
TAFL3500F32	●		4		140	154	170	235	32	42	PT1/8	
TAFL3500F40	●		4		140	154	170	235	40	50	PT1/4	
TAFS3600F32	□	36.0	2	2	72	86	102	157	32	50	PT1/8	GPMT140408-U○
TAFS3600F40	□		2		72	86	102	167	40	50	PT1/4	
TAFM3600F32	□		3		108	122	138	193	32	50	PT1/8	
TAFM3600F40	□		3		108	122	138	203	40	50	PT1/4	
TAFL3600F32	□		4		144	158	174	229	32	42	PT1/8	
TAFL3600F40	□		4		144	158	174	239	40	50	PT1/4	
TAFS3700F32	□	37.0	2	2	74	89	104	159	32	50	PT1/8	GPMT140408-U○
TAFS3700F40	□		2		74	89	104	169	40	50	PT1/4	
TAFM3700F32	□		3		111	126	141	196	32	50	PT1/8	
TAFM3700F40	□		3		111	126	141	206	40	50	PT1/4	
TAFL3700F32	□		4		148	163	178	233	32	42	PT1/8	
TAFL3700F40	□		4		148	163	178	243	40	50	PT1/4	
TAFS3750F32	□	37.5	2	2	75	89	104	159	32	50	PT1/8	GPMT140408-U○
TAFS3750F40	□		2		75	89	104	169	40	50	PT1/4	
TAFM3750F32	□		3		112.5	126	141	196	32	50	PT1/8	
TAFM3750F40	□		3		112.5	126	141	206	40	50	PT1/4	
TAFL3750F32	□		4		150	163	178	233	32	42	PT1/8	
TAFL3750F40	□		4		150	163	178	243	40	50	PT1/4	
TAFS3800F32	□	38.0	2	2	76	91	106	161	32	50	PT1/8	GPMT140408-U○
TAFS3800F40	□		2		76	91	106	171	40	50	PT1/4	
TAFM3800F32	□		3		114	129	144	199	32	50	PT1/8	
TAFM3800F40	□		3		114	129	144	209	40	50	PT1/4	
TAFL3800F32	□		4		152	167	182	247	32	42	PT1/8	
TAFL3800F40	□		4		152	167	182	247	40	50	PT1/4	
TAFS3900F32	□	39.0	2	2	78	94	108	163	32	50	PT1/8	GPMT140408-U○
TAFS3900F40	□		2		78	94	108	173	40	50	PT1/4	
TAFM3900F32	□		3		117	133	147	202	32	50	PT1/8	
TAFM3900F40	□		3		117	133	147	212	40	50	PT1/4	
TAFL3900F32	□		4		156	172	186	251	32	42	PT1/8	
TAFL3900F40	□		4		156	172	186	251	40	50	PT1/4	
TAFS4000F32	□	40.0	2	2	80	96	110	165	32	50	PT1/8	GPMT140408-U○
TAFS4000F40	□		2		80	96	110	175	40	50	PT1/4	
TAFM4000F32	□		3		120	136	150	205	32	50	PT1/8	
TAFM4000F40	□		3		120	136	150	215	40	50	PT1/4	
TAFL4000F32	□		4		160	176	190	245	32	42	PT1/8	
TAFL4000F40	□		4		160	176	190	255	40	50	PT1/4	
TAFS4100F40	□	41.0	2	2	82	98	112	177	40	50	PT1/4	GPMT140408-U○
TAFM4100F40	□		3		123	139	153	218	40	50	PT1/4	
TAFL4100F40	□		4		164	180	194	259	40	50	PT1/4	
TAFS4200F40	□	42.0	2	2	84	101	114	179	40	50	PT1/4	GPMT140408-U○
TAFM4200F40	□		3		126	143	156	221	40	50	PT1/4	
TAFL4200F40	□		4		168	185	198	263	40	50	PT1/4	
TAFS4300F40	□	43.0	2	2	86	103	116	181	40	50	PT1/4	GPMT140408-U○
TAFM4300F40	□		3		129	146	159	224	40	50	PT1/4	
TAFL4300F40	□		4		172	189	202	267	40	50	PT1/4	

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TAFS, TAFM, TAFL

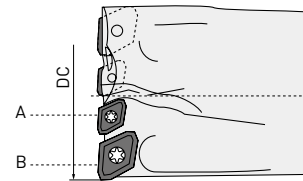
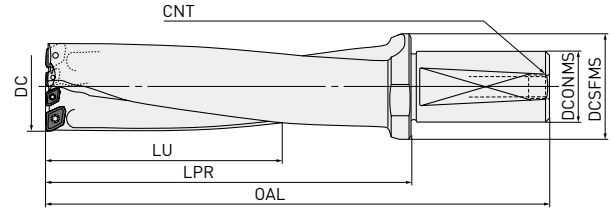
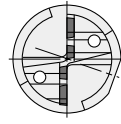
Sipariş No.	Stok	DC	L/D	ZNF	LU	LBX	LPR	OAL	DCONMS	DCSFMX	CNT	Kesici uç
TAFS4400F40	☐		2		88	106	118	183	40	50	PT1/4	GPMT140408-U
TAFM4400F40	☐	44.0	3	2	132	150	162	227	40	50	PT1/4	
TAFL4400F40	☐		4		176	194	206	271	40	50	PT1/4	
TAFS4500F40	☐		2		90	108	120	185	40	54	PT1/4	GPMT140408-U
TAFM4500F40	☐	45.0	3	2	135	153	165	230	40	54	PT1/4	
TAFL4500F40	☐		4		180	198	210	275	40	54	PT1/4	
TAFS4600F40	☐		2		92	110	122	187	40	54	PT1/4	GPMT140408-U
TAFM4600F40	☐	46.0	3	2	138	156	168	233	40	54	PT1/4	
TAFL4600F40	☐		4		184	202	214	279	40	54	PT1/4	
TAFS4700F40	☐		2		94	113	124	189	40	54	PT1/4	GPMT140408-U
TAFM4700F40	☐	47.0	3	2	141	160	171	236	40	54	PT1/4	
TAFL4700F40	☐		4		188	207	218	283	40	54	PT1/4	
TAFS4800F40	☐		2		96	115	126	191	40	54	PT1/4	GPMT140408-U
TAFM4800F40	☐	48.0	3	2	144	163	174	239	40	54	PT1/4	
TAFL4800F40	☐		4		192	211	222	287	40	54	PT1/4	
TAFS4900F40	☐		2		98	118	133	198	40	58	PT1/4	GPMT090304-U
TAFM4900F40	☐	49.0	3	4	147	167	182	247	40	58	PT1/4	
TAFL4900F40	☐		4		196	216	231	296	40	58	PT1/4	
TAFS5000F40	☐		2		100	120	135	200	40	58	PT1/4	GPMT090304-U
TAFM5000F40	☐	50.0	3	4	150	170	185	250	40	58	PT1/4	
TAFL5000F40	☐		4		200	220	235	300	40	58	PT1/4	
TAFS5100F40	☐		2		102	122	137	202	40	58	PT1/4	GPMT090304-U
TAFM5100F40	☐	51.0	3	4	153	173	188	253	40	58	PT1/4	
TAFL5100F40	☐		4		204	224	239	304	40	58	PT1/4	
TAFS5200F40	☐		2		104	125	139	204	40	58	PT1/4	GPMT090304-U
TAFM5200F40	☐	52.0	3	4	156	177	191	256	40	58	PT1/4	
TAFL5200F40	☐		4		208	229	243	308	40	58	PT1/4	
TAFS5300F40	☐		2		106	127	141	206	40	63	PT1/4	GPMT090304-U
TAFM5300F40	☐	53.0	3	4	159	180	194	259	40	63	PT1/4	
TAFL5300F40	☐		4		212	233	247	312	40	63	PT1/4	
TAFS5400F40	☐		2		108	128	143	208	40	63	PT1/4	GPMT090304-U
TAFM5400F40	☐	54.0	3	4	162	182	197	262	40	63	PT1/4	
TAFL5400F40	☐		4		216	236	251	316	40	63	PT1/4	
TAFS5500F40	☐		2		110	130	145	210	40	63	PT1/4	GPMT090304-U
TAFM5500F40	☐	55.0	3	4	165	185	200	265	40	63	PT1/4	
TAFL5500F40	☐		4		220	240	255	320	40	63	PT1/4	
TAFS5600F40	☐		2		112	132	147	212	40	63	PT1/4	GPMT090304-U
TAFM5600F40	☐	56.0	3	4	168	188	203	268	40	63	PT1/4	
TAFL5600F40	☐		4		224	244	259	324	40	63	PT1/4	

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TAFS, TAFM, TAFL

RİJİTLİĞİ ARTIRILMIŞ TİP

P M K



Sipariş No.	Stok	DC	L/D	ZNF	DCONMS	DCSFMS	CNT	OAL	LPR	LU	İç / Dış tip	Kesici uç
TAFS5000F40-E	☐	50.0	2	4	40	58	PT1/4	200	135	120	A	GPMT090304-U
											B	GPMT11T308-U
TAFM5000F40-E	☐		3	4	40	58	PT1/4	250	185	170	A	GPMT090304-U
											B	GPMT11T308-U
TAFL5000F40-E	☐	51.0	4	4	40	58	PT1/4	300	235	220	A	GPMT090304-U
											B	GPMT11T308-U
TAFS5100F40-E	☐		2	4	40	58	PT1/4	202	137	122	A	GPMT090304-U
											B	GPMT11T308-U
TAFM5100F40-E	☐	52.0	3	4	40	58	PT1/4	253	188	173	A	GPMT090304-U
											B	GPMT11T308-U
TAFL5100F40-E	☐		4	4	40	58	PT1/4	304	239	224	A	GPMT090304-U
											B	GPMT11T308-U
TAFS5200F40-E	☐	53.0	2	4	40	58	PT1/4	204	139	125	A	GPMT090304-U
											B	GPMT11T308-U
TAFM5200F40-E	☐		3	4	40	58	PT1/4	256	191	177	A	GPMT090304-U
											B	GPMT11T308-U
TAFL5200F40-E	☐	54.0	4	4	40	58	PT1/4	308	243	229	A	GPMT090304-U
											B	GPMT11T308-U
TAFS5300F40-E	☐		2	4	40	63	PT1/4	206	141	127	A	GPMT11T308-U
TAFM5300F40-E	☐	55.0	3	4	40	63	PT1/4	259	194	180		
TAFL5300F40-E	☐		4	4	40	63	PT1/4	312	247	233		
TAFS5400F40-E	☐	56.0	2	4	40	63	PT1/4	208	134	128	A	GPMT11T308-U
TAFM5400F40-E	☐		3	4	40	63	PT1/4	262	197	182		
TAFL5400F40-E	☐		4	4	40	63	PT1/4	316	251	236		
TAFS5500F40-E	☐	57.0	2	4	40	63	PT1/4	210	145	130	A	GPMT11T308-U
TAFM5500F40-E	☐		3	4	40	63	PT1/4	265	200	185		
TAFL5500F40-E	☐		4	4	40	63	PT1/4	320	255	240		
TAFS5600F40-E	☐	58.0	2	4	40	63	PT1/4	212	147	132	A	GPMT11T308-U
TAFM5600F40-E	☐		3	4	40	63	PT1/4	268	203	188		
TAFL5600F40-E	☐		4	4	40	63	PT1/4	324	259	244		

TAFS, TAFM, TAFL

YEDEK PARÇALAR

Takım Tutucu Tipi	Uç Vidası	Anahtar
GCMT040204-U○	TS2	1 TKY06F
GPMT060204-U○	TS2	1 TKY06F
GPMT070204-U○	TS25	1 TKY08F
GPMT090304-U○	TS3	1 TKY08F
GPMT11T308-U○	TS4	2 TKY15D
GPMT140408-U○	TS5	2 TKY25D
GPMT090304-U○	TS3	1 TKY08F

KESİCİ UÇLAR

Sipariş No.	VP15TF	UP20M	GP20M	UE6020	US735	L	W1	IC	S	RE	Matkap Çapı	Şekil
U1												
GCMT040204-U1	●					5.0	4.7	—	2.38	0.4	Ø 12 – 14.5	
GPMT060204-U1	●	●		●	●	—	—	5.56	2.38	0.4	Ø 15 – 17.5	
GPMT070204-U1	●			●	●	—	—	6.35	2.38	0.4	Ø 18 – 22.5	
GPMT090304-U1	●			●	●	—	—	7.94	3.18	0.4	Ø 23 – 27.5	
GPMT090304-U1	●			●	●	—	—	7.94	3.18	0.4	Ø 49 – 56	
GPMT11T308-U1	●			●	●	—	—	9.525	3.97	0.8	Ø 28 – 34	
GPMT140408-U1	●			●	●	—	—	12.70	4.76	0.8	Ø 35 – 48	
U2												
GCMT040204-U2	●		●			5.0	4.7	—	2.38	0.4	Ø 12 – 14.5	
GPMT060204-U2	●	●		●	●	—	—	5.56	2.38	0.4	Ø 15 – 17.5	
GPMT070204-U2	●	●		●	●	—	—	6.35	2.38	0.4	Ø 18 – 22.5	
GPMT090304-U2	●	●		●	●	—	—	7.94	3.18	0.4	Ø 23 – 27.5	
GPMT090304-U2	●	●		●	●	—	—	7.94	3.18	0.4	Ø 49 – 56	
GPMT11T308-U2	●	●		●	●	—	—	9.525	3.97	0.8	Ø 28 – 34	
GPMT140408-U2	●	●		●	●	—	—	12.70	4.76	0.8	Ø 35 – 48	
U3												
GPMT060204-U3		●		●	●	—	—	5.56	2.38	0.4	Ø 15 – 17.5	
GPMT070204-U3		●		●	●	—	—	6.35	2.38	0.4	Ø 18 – 22.5	
GPMT090304-U3		●		●	●	—	—	7.94	3.18	0.4	Ø 23 – 27.5	
GPMT090304-U3		●		●	●	—	—	7.94	3.18	0.4	Ø 49 – 56	
GPMT11T308-U3		●		●	●	—	—	9.525	3.97	0.8	Ø 28 – 34	
GPMT140408-U3		●		●	●	—	—	12.70	4.76	0.8	Ø 35 – 48	

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TAFS, TAFM, TAFL

TALAŞ KIRICI ÖNERİSİ

Malzeme	1. Önerimiz		2. Önerimiz	
	GCMT	GPMT	GCMT	GPMT
	U1	U1	U2	U2
P Yumuşak Çelik				U3
			U1	U1
	U2	U2		U2
				U3
M Paslanmaz Çelik			U1	U1
	U2	U2		
				U3
K Gri Dökme Demir Duktil Dökme Demir			U1	U1
	U2	U3		U2

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KESİCİ UÇ KALİTE ÖNERİSİ

Malzeme	Kalite			
	1. Önerimiz		2. Önerimiz	
	GCMT	GPMT	GCMT	GPMT
P Yumuşak Çelik			VP15TF	VP15TF
	UP20M	UP20M		
			GP20M	
				UE6020
Karbon Çeliği Alaşımlı Çelik Alaşımlı Takım Çelik				US735
	VP15TF	VP15TF		
			UP20M	UP20M
	GP20M	UE6020	GP20M	VP15TF
M Paslanmaz Çelik				US735
	VP15TF	VP15TF		
			UP20M	UP20M
	GP20M	US735	GP20M	
K Gri Dökme Demir Duktil Dökme Demir				UE6020
	VP15TF			
			UP20M	UP20M
	GP20M			UE6020
				US735
				VP15TF

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TAFS, TAFM, TAFL

ÖNERİLEN KESME KOŞULLARI

Malzeme	Sertlik	Vc				Vc													
		L/D = 2, 3		L/D = 4		Matkap Çapı													
		Ø 12 – Ø 14.5	Ø 15 –	Ø 16 –		Ø 12 – Ø 14.5	Ø 15 – Ø 22.5	Ø 23 – Ø 34	Ø 35 – Ø 48	Ø 49 – Ø 56									
P	Yumuşak Çelik	≤180HB	150	200	140	U1	0.06	0.07	0.08	0.10	0.08								
			(100 – 200)	(150 – 300)	(100 – 200)		(0.04 – 0.10)	(0.04 – 0.10)	(0.04 – 0.10)	(0.04 – 0.12)	(0.04 – 0.10)								
						U2	0.06	0.08	0.10	0.12	0.10								
	Karbon Çelik	180 – 280 HB	120	150	100		(0.04 – 0.10)	(0.04 – 0.12)	(0.04 – 0.12)	(0.04 – 0.14)	(0.04 – 0.12)								
			(80 – 160)	(120 – 180)	(80 – 120)	U3	—	0.08	0.10	0.12	0.10								
							(0.04 – 0.12)	(0.04 – 0.12)	(0.04 – 0.14)	(0.04 – 0.12)									
	Alaşımlı Çelik	180 – 280 HB	120	150	100	U1	0.06	0.09	0.12	0.15	0.12								
			(80 – 160)	(120 – 180)	(80 – 120)		(0.04 – 0.10)	(0.06 – 0.12)	(0.08 – 0.14)	(0.08 – 0.18)	(0.08 – 0.14)								
						U2	0.06	0.12	0.14	0.17	0.14								

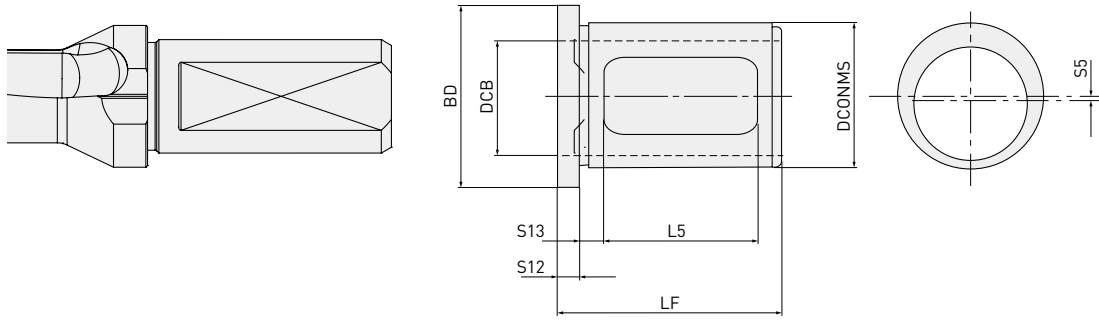
1/1

1. l/d= 4 için matkap kullanıldığında, ilerleme yukarıdaki önerilerin %80'ine düşürülmelidir.

TAFS, TAFM, TAFL

TAM UYUMLU AYAR BURCU [JFS]

Matkap şaftı için kesme çapının artırılmasında kullanılan çap ayar burcu.



Sipariş No.	Set Sipariş No.	Stok	DCB	DCONMS	BD	LF	L5	* Artış (S5x2)	TAF Tip Matkaplara Uygun
JFS2520-10	JFS-1	●	20	25	33	43	30	0.1	TAFS/M/L1200F20 - TAFS/M/L1550F20
JFS2520-20		●	20	25	33	43	30	0.2	
JFS2520-30		●	20	25	33	43	30	0.3	
JFS2520-40		●	20	25	33	43	30	0.4	
JFS2520-50		●	20	25	33	43	30	0.5	
JFS3225-10	JFS-2	●	25	32	40	50	34	0.1	TAFS/M/L1600F25 - TAFS/M/L2450F25
JFS3225-20		●	25	32	40	50	34	0.2	
JFS3225-30		●	25	32	40	50	34	0.3	
JFS3225-40		●	25	32	40	50	34	0.4	
JFS3225-50		●	25	32	40	50	34	0.5	
JFS4032-10	JFS-3	●	32	40	48	55	40	0.1	TAFS/M/L2500F32 - TAFS/M/L2950F32
JFS4032-20		●	32	40	48	55	40	0.2	
JFS4032-30		●	32	40	48	55	40	0.3	
JFS4032-40		●	32	40	48	55	40	0.4	
JFS4032-50		●	32	40	48	55	40	0.5	
JFS5040-10	JFS-4	●	40	50	68	65	50	0.1	AFS/M/L2850F40 - TAFS/M/L5600F40 TAFS/M/L5000F40-E
JFS5040-20		●	40	50	68	65	50	0.2	
JFS5040-30		●	40	50	68	65	50	0.3	
JFS5040-40		●	40	50	68	65	50	0.4	
JFS5040-50		●	40	50	68	65	50	0.5	

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* Artış: Kesme çapındaki artışın büyüklüğü.

TAFS, TAFM, TAFL

TAM UYUMLU AYAR BURCUNU SEÇME KILAVUZU

İstenilen = (Matkap Ø + JFS Artışı) + 0.1 mm

(Ör.) İstenen çap 20.3 mm (Standart ölçüden büyüklük 0.1 mm olarak alınır).

$$\text{Ø } 20.3 = (\text{TAFS/M/L2000F25} + \text{JFS3225-20}) + 0.1$$

20 mm Matkap

JFS'yi kullanarak,
0.2 mm bir artış olur

Standart
ölçüden
büyüklük

Seçilen Takım

Matkap: TAFM2000F25

Tam Uyumlu Burç [JFS]: JFS3225-20

1. Ölçü dışılık kullanılan kesme koşulları nedeniyle değişebilir, lütfen kılavuz olarak yukarıyı kullanın.

TAM UYUMLU BURCU SİPARİŞ ETME

SATIN ALMA YÖNTEMİ 1

Aşırı boyut kullanılan kesme koşulları nedeniyle değişebilir. Bu nedenle set olarak satın alınması önerilir. Bir sipariş verirken, lütfen Set sipariş numarasını kullanın. (5 manşon/set)

SATIN ALMA YÖNTEMİ 2

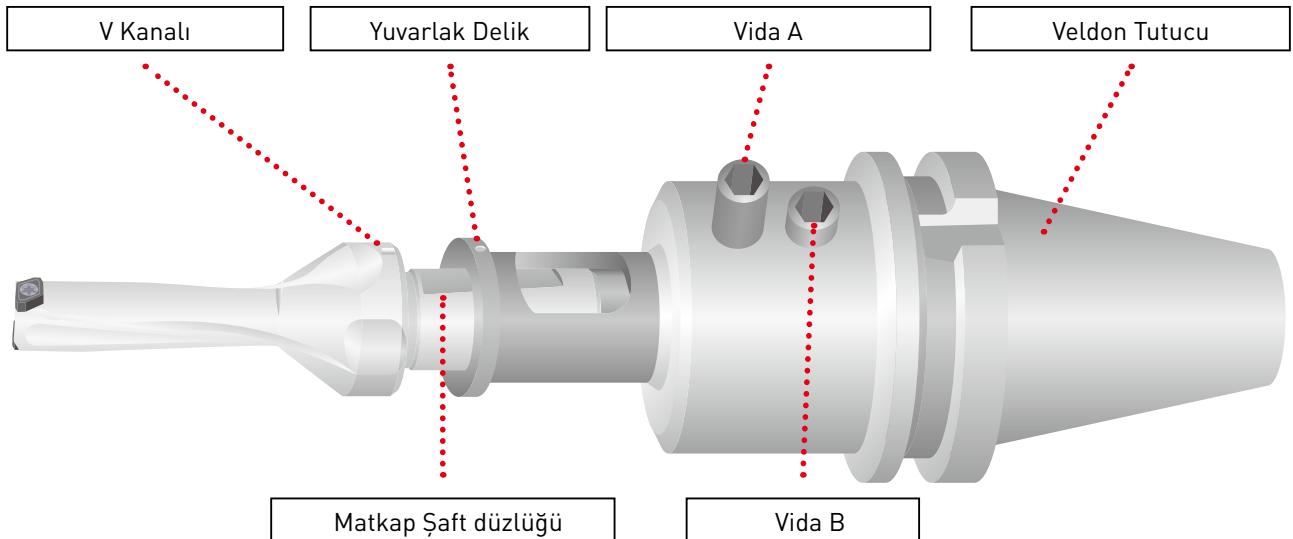
Ayrı ayrı sipariş etmek mümkündür. Bir sipariş verirken, lütfen bireysel sipariş numarasını kullanın.

TAM UYUMLU MANŞONU UYGULAMA

Matkabı takarken yandan kilitli tutucuya yerleştirin, matkap flanşının dış çevresel kenarındaki V şekilli çentiğini burç flanşı dış çevresel kenarındaki yuvarlak delik ile hizalayın ve yandan vidalı takım tutucuya matkabı bağlayın. (eğer matkabin V çentiği yoksa burcun yuvarlak deliği ile matkap gövdesi üzerindeki düzlüğü aynı hizaya getirin.)

Matkabı bağlamak için yandan kilitli tutucunun A vidasını burcun açık penceresine doğrudan takın. B vidasını sıkarken manşona zarar vermeyecek bir radde de sıkın.

- Burç çapı ile ince ayarlamalar yapılamaz.
- Pensli takım tutucular ile kullanılamaz.

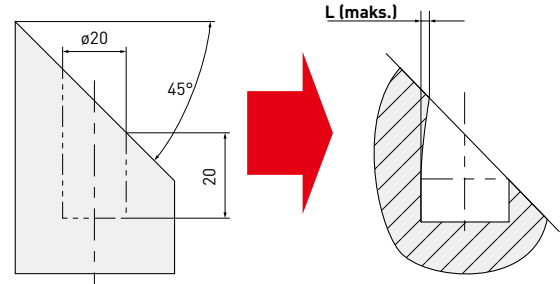


TAFS, TAFM, TAFL

UYGULAMA ÖRNEKLERİ

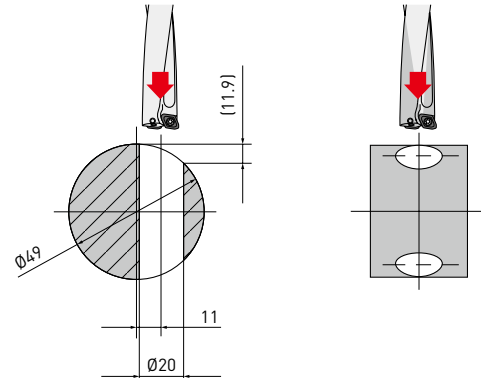
EĞİMLİ YÜZEYDE DELME

Malzeme	DIN 42CrMo4 (180 – 280 HB)	
Takım	Ø 20 (3 x D)	
Vc (m/dk)	80	
f (mm/dev)	0.08	
Takım	L (mm)	L (maks.)
TAF	0.11	İyi
Geleneksel A	0.17	İyi
Geleneksel B	0.13	Merkez ve çevresel kesici kenarlarda kırılmalar



YUVARLAK İŞ PARÇASINI DELME

Malzeme	DIN Ck50 (120 HB – 180 HB)	
Takım	Ø 20 (3 x D)	
Vc (m/dk)	50, 80, 100	
f (mm/dev)	Başlangıç da kesme 0.05	

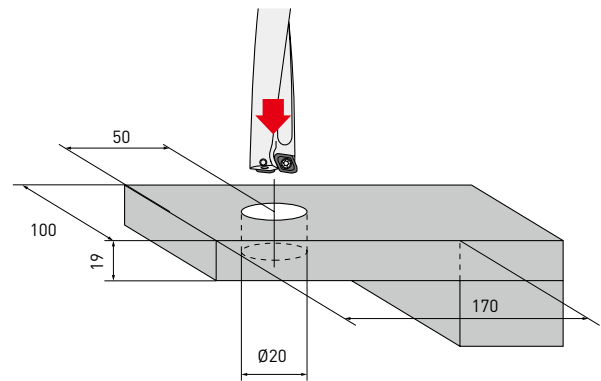
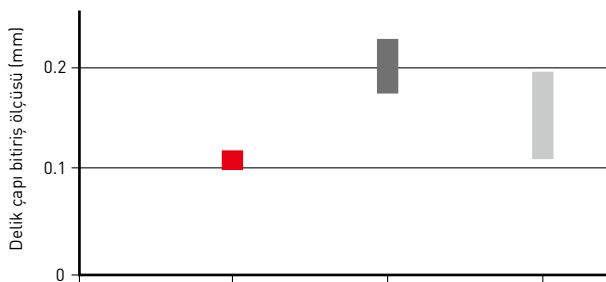


1. Geleneksel bir matkapla iç kesici kenar kırılır.

AÇIK DELİK DELME

Malzeme	DIN Ck50 (120 – 180 HB)	
Takım	Ø 20 (3 x D)	
Vc (m/dk)	80	
f (mm/dev)	0.08	

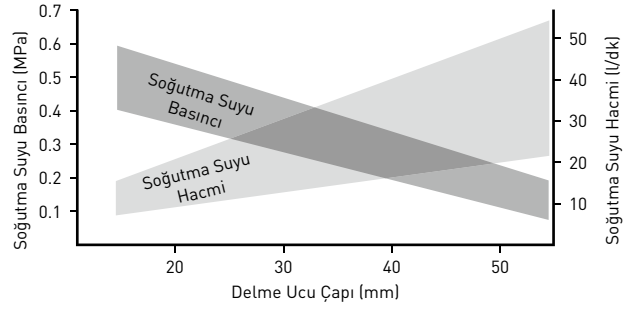
Matkap bitiriş ölçüsü (matkap çapına göre ölçülen)



TAFS, TAFM, TAFL

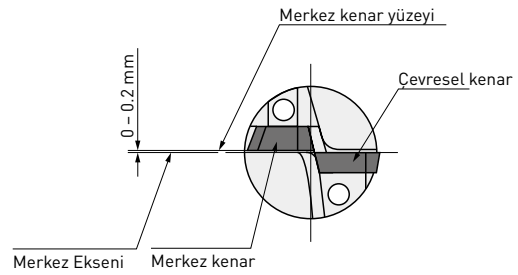
UYGULAMA

- Lütfen hem tezgah ayarlarında hem de iş parçasının bağlanmasında mevcut olası en yüksek rijidliği sağlayın.
- Soğutma sıvısı basıncı ve hacmi için aşağıdaki grafiği kullanın. Soğutma sıvısı bu matkabın verimli kullanımı için önemli bir faktördür.
- İstifli delme için kullanılamaz.
Pek çok değiştirilebilen uçlu matkaplarda ortak olmakla birlikte; bu matkaplar çıkışta yuvarlak disk üretir, ancak tahliye edilmedikçe matkabın kırılmasına neden olabilir.

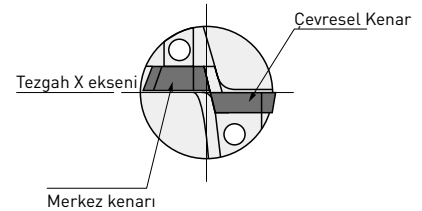


TORNADA KULLANILMASI

Merkez kesme kenarı 0 – 0.2 mm arasında merkezin üstünde konumlandırılmalıdır.

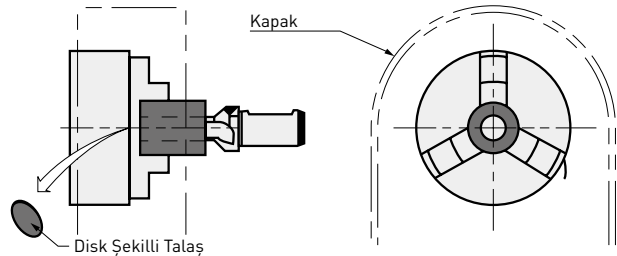


Matkap ofset ayarları ile delik çapı ayarlanır, dış kesme kenarı ve tezgah eksenine paralel ayarlanmalıdır.



Çaptan daha büyük bir delik üretirken.
Matkap ofseti çapın %2'sinden büyük olmamalıdır.
Düşük çaplı bir delik üretmek mümkün değildir.

Tornada delik delme sırasında, iş parçasından çıkan matkap tarafından üretilen disk yüksek hızda fırlayabilir.
Yaralanma veya hasar tehlikesini azaltmak için bir koruyucu kullanımı şiddetle önerilir.



NOTLAR

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