

Plaquitas

Inserts

Las plaquitas de ranurado se fabrican con una aleación que, tras el tratamiento térmico, alcanza una dureza de 70-71 HRC. Este material confiere a las plaquitas una gran resistencia y, por lo tanto, puede soportar fuertes presiones. Las plaquitas también están sujetas a tratamiento de superficie, recubrimiento de TiN, con propiedades antidesgaste y antiagarrotamiento.

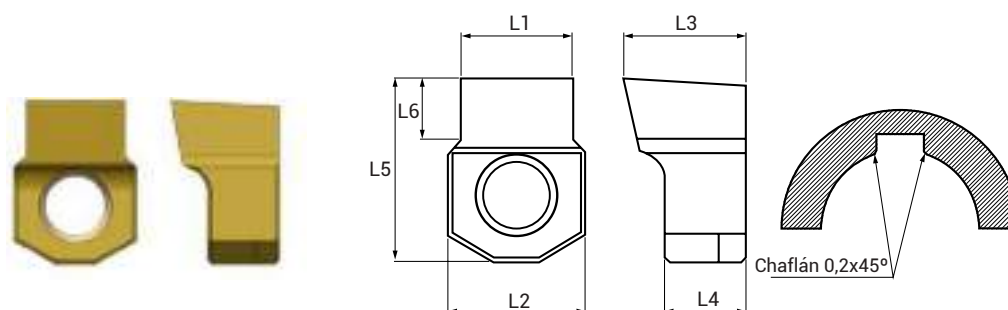
Las plaquitas se afilan de nuevo afilando sus lados. Este proceso elimina cualquier gubia que pudiera impedir que la plaquita corte perpendicular al eje de referencia de la pieza durante la fase de ranurado. La forma sobresaliente de las plaquitas permite afilarlos varias veces. Todas estas características hacen que las plaquitas sean extraordinariamente duraderas.

Las plaquitas identificadas por su código con "SM" ejecutan un chaflán de $0,2 \times 45^\circ$ en el punto de intersección entre el agujero y las paredes de la ranura, dejando el agujero libre de rebabas. Este tipo de biselado sólo se puede realizar en llaves UNI.

The slotting inserts are made with alloy which, following heat treatment, reaches a hardness of 70-71 HRC. This material gives the inserts high toughness, and can accordingly withstand strong pressures. The inserts are also subject to surface treatment, TiN coating, with anti wear and seize properties.

The inserts are re-sharpened by tapering their sides. This process eliminates any gouges that would prevent the insert from cutting perpendicular to the reference axis of the workpiece during the broaching phase. The protruding shape of the inserts makes it possible to re-sharpen them numerous times. All of these characteristics make inserts extraordinarily long-lasting.

The inserts identified by their code ending with "SM" execute a $0.2 \times 45^\circ$ chamfering on the intersection point between the hole and the walls of the broached slot, leaving the hole burr-free. This type of chamfering can only be carried out on UNI keys.



Ref.	L1	L2	L3	L4	L5	L6	
IN-02 P9	1,994	5,00	6,5	5	6,0	1,30	
IN-02 P9-SM	1,994	5,00	6,5	5	6,0	1,09	
IN-02 H7	2,010	5,00	6,5	5	6,0	1,30	
IN-02 H7-SM	2,010	5,00	6,5	5	6,0	1,09	
IN-02 D10	2,060	5,00	6,5	5	6,0	1,30	
IN-02 C11	2,120	5,00	6,5	5	6,0	1,30	
IN-03 P9	2,994	6,08	6,5	5	7,5	2,00	
IN-03 P9-SM	2,994	6,08	6,5	5	7,5	1,42	
IN-03 H7	3,010	6,08	6,5	5	7,5	2,00	
IN-03 H7-SM	3,010	6,08	6,5	5	7,5	1,42	
IN-03 D10	3,060	6,08	6,5	5	7,5	2,00	
IN-03 C11	3,120	6,08	6,5	5	7,5	2,00	
IN-04 P9	3,988	6,08	7,0	5	8,0	2,60	
IN-04 P9-SM	3,988	6,08	7,0	5	8,0	2,07	
IN-04 H7	4,012	6,08	7,0	5	8,0	2,60	
IN-04 H7-SM	4,012	6,08	7,0	5	8,0	2,07	
IN-04 D10	4,078	6,08	7,0	5	8,0	2,60	
IN-04 C11	4,145	6,08	7,0	5	8,0	2,60	
IN-05 P9	4,988	6,08	7,0	5	8,0	3,00	
IN-05 P9-SM	4,988	6,08	7	5	8,0	2,74	
IN-05 H7	5,012	6,08	7	5	8,0	3,00	
IN-05 H7-SM	5,012	6,08	7	5	8,0	2,74	
IN-05 D10	5,078	6,08	7	5	8,0	3,00	

Ref.	L1	L2	L3	L4	L5	L6
IN-05 C11	5,145	6,08	7	5	8,0	3,00
IN-06 P9	5,988	10,08	9	6	13,5	4,00
IN-06 P9-SM	5,988	10,08	9	6	13,5	3,00
IN-06 H7	6,012	10,08	9	6	13,5	4,00
IN-06 H7-SM	6,012	10,08	9	6	13,5	3,00
IN-06 D10	6,078	10,08	9	6	13,5	4,00
IN-06 C11	6,145	10,08	9	6	13,5	4,00
IN-08 P9	7,985	10,08	9	6	13,5	4,50
IN-08 P9-SM	7,985	10,08	9	6	13,5	3,78
IN-08 H7	8,015	10,08	9	6	13,5	4,50
IN-08 H7-SM	8,015	10,08	9	6	13,5	3,78
IN-08 D10	8,098	10,08	9	6	13,5	4,50
IN-08 C11	8,170,00	10,08	9	6	13,5	4,50
IN-10 P9	9,985	13,10	14	10	18,5	6,00
IN-10 P9-SM	9,985	13,10	14	10	18,5	3,88
IN-10 H7	10,015	13,10	14	10	18,5	6,00
IN-10 H7-SM	10,015	13,10	14	10	18,5	3,88
IN-10 D10	10,098	13,10	14	10	18,5	6,00
IN-10 C11	10,170,00	13,10	14	10	18,5	6,00
IN-12 P9	11,982	13,10	14	10	18,5	6,50
IN-12 P9-SM	11,982	13,10	14	10	18,5	3,89
IN-12 H7	12,018	13,10	14	10	18,5	6,50
IN-12 H7-SM	12,018	13,10	14	10	18,5	3,89
IN-12 D10	12,120	13,10	14	10	18,5	6,50
IN-12 C11	12,205	13,10	14	10	18,5	6,50
IN-14 P9	13,982	18,00	14	10	22,0	7,00
IN-14 P9-SM	13,982	18,00	14	10	22,0	4,71
IN-14 H7	14,018	18,00	14	10	22,0	7,00
IN-14 H7-SM	14,018	18,00	14	10	22,0	4,71
IN-14 D10	14,120	18,00	14	10	22,0	7,00
IN-14 C11	14,205	18,00	14	10	22,0	7,00
IN-16 P9	15,982	18,00	14	10	22,0	8,00
IN-16 P9-SM	15,982	18,00	14	10	22,0	5,53
IN-16 H7	16,018	18,00	14	10	22,0	8,00
IN-16 H7-SM	16,018	18,00	14	10	22,0	5,53
IN-16 D10	16,120	18,00	14	10	22,0	8,00
IN-16 C11	16,205	18,00	14	10	22,0	8,00
IN-18 P9**	17,982	26,00	18	10	30,0	9,00
IN-18 P9-SM**	17,982	26,00	18	10	30,0	5,67
IN-18 H7**	18,018	26,00	18	10	30,0	9,00
IN-18 H7-SM**	18,018	26,00	18	10	30,0	5,67
IN-18 D10**	18,120	26,00	18	10	30,0	9,00
IN-18 C11**	18,205	26,00	18	10	30,0	9,00
IN-20 P9**	19,978	26,00	18	10	30,0	10,00
IN-20 P9-SM**	19,978	26,00	18	10	30,0	6,29
IN-20 H7**	20,021	26,00	18	10	30,0	10,00
IN-20 H7-SM**	20,021	26,00	18	10	30,0	6,29
IN-20 D10**	20,149	26,00	18	10	30,0	10,00
IN-20 C11**	20,240	26,00	18	10	30,0	10,00
IN-22 P9**	21,978	26,00	18	10	30,0	11,00
IN-22 P9-SM**	21,978	26,00	18	10	30,0	6,79
IN-22 H7**	22,021	26,00	18	10	30,0	11,00
IN-22 H7-SM**	22,021	26,00	18	10	30,0	6,79
IN-22 D10**	22,149	26,00	18	10	30,0	11,00
IN-22 C11**	22,240	26,00	18	10	30,0	11,00
IN-25 P9**	24,978	26,00	18	10	30,0	12,00
IN-25 P9-SM**	24,978	26,00	18	10	30,0	7,02
IN-25 H7**	25,021	26,00	18	10	30,0	12,00
IN-25 H7-SM**	25,021	26,00	18	10	30,0	7,02
IN-25 D10**	25,149	26,00	18	10	30,0	12,00
IN-25 C11**	25,240	26,00	18	10	30,0	12,00

** Para estas medidas recomendamos el mecanizado en dos pasos: desbaste y acabado

** For these sizes we recommend machining in two steps: roughing and finishing