

THREADS

| CODE | d | L | I2 | n ° fil. threads | I1 | Z | Ø Preforo Prehole | Tipo filetto Thread type |
|---------------|------|-----|-------|------------------|-------|---|-------------------|--------------------------|
| Y243110600270 | 6,0 | 75 | 15,39 | 16 | 14,10 | 3 | 8,10 | 1/8x27" |
| Y243110800180 | 8,0 | 80 | 20,27 | 14 | 18,34 | 4 | 10,70 | 1/4x18" |
| Y243111000180 | 10,0 | 80 | 24,5 | 17 | 22,57 | 4 | 14,25 | 3/8x18" |
| Y243111400140 | 14,0 | 100 | 27,87 | 15 | 25,39 | 5 | 17,70 | 1/2x14" |
| Y243111600140 | 16,0 | 100 | 29,69 | 16 | 27,21 | 5 | 23 | 3/4x14" |
| Y243112000115 | 20,0 | 105 | 33,93 | 15 | 30,91 | 5 | 29 | 1x11,5" |

TAPS

REAMERS

Y1200

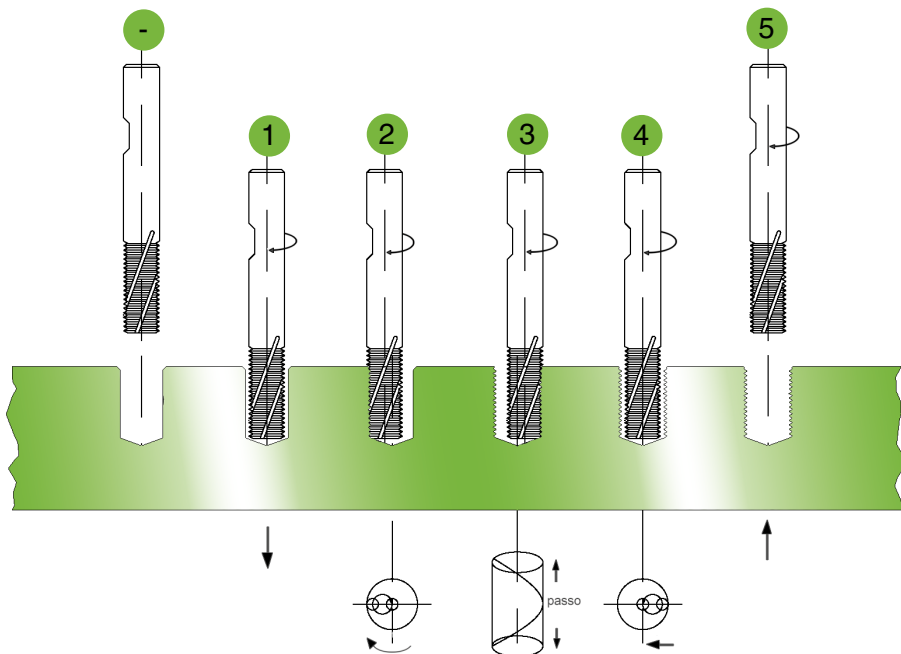
I2FN

| | | | | | | | | | | | | |
|--|--|--------------------------------------|-----------------|--|-----------------------------------|------------------------------|--------------------------|--------------------|---------------|-----------------------|------------------|----------------------------|
| Acciai non legati a basso tenore di carbonio | Acciai non legati bonificati | Acciai per utensili altamente legati | Acciai temprati | Acciai inossidabili ferritici e martensitici | Acciai inossidabili austenitici | Ghisa, Ghisa duttile | Ghisa sferoidale | Leghe di alluminio | Leghe di rame | Materiali non ferrosi | Leghe di titanio | Leghe resistenti al calore |
| Steel non-alloyed, low carbon steel | Steel non-alloyed, hardening & quenching steel | Tools steel high alloyed | Hardened Steels | Stainless steel, ferritic steel, martensitic steel | Stainless steel, austenitic steel | Cast iron, Ductile cast iron | Spheroidal graphite iron | Aluminium alloys | Copper alloys | Non-ferrous material | Titanium alloys | Heat-resisting alloy |
| ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | | ○ | ○ |

Operazioni per fresatura in discordanza del filetto Example for thread alternate milling work

Qui sotto esponiamo la sequenza delle operazioni con fresatura in discordanza.

Here under we expose the sequence of the milling operations in discordanza.



1 - Posizionamento rapido.

1 - Fast positioning.

2 - Scostamento radiale al diametro nominale del filetto - entrata ad arco tangente.

2 - Radial removal to the nominal diameter of the thread - entered to tangent arc.

3 - Avanzamento del passo con simultanea rotazione dell'utensile attorno all'asse mediano filetto.

3 - Advancement of the footstep with simultaneous rotation of the tool around the axle median thread.

4 - Scostamento radiale al centro del foro - uscita arco tangente.

4 - Radial removal in the middle of the hole - exit by tangent arc.

5 - Fuoriuscita dal foro filettato (rapido).

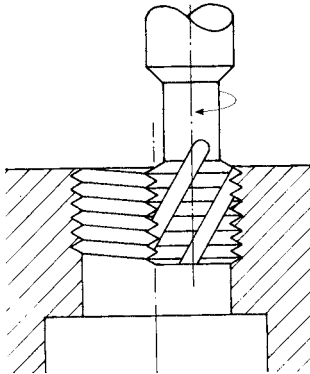
5 - Escaped by the threaded hole (fast).

Sono possibili tutte le combinazioni All the combinations are possible

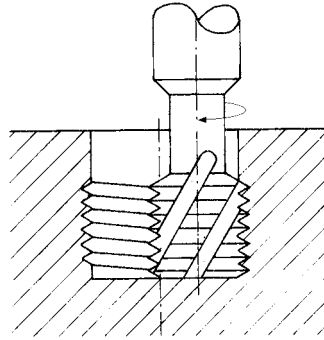
Poichè il taglio di questi utensili è destro, la direzione della rotazione è destra. Modificando l'avanzamento assiale sono possibili tutte le filettature sia in concordanza che in discordanza.

Since the cut of these tools is right, the direction of the rotation is right. Modifying the axial advancement they are possible all the threadings both in agreement and in discordance.

■ Filettatura destra interna Internal right threading

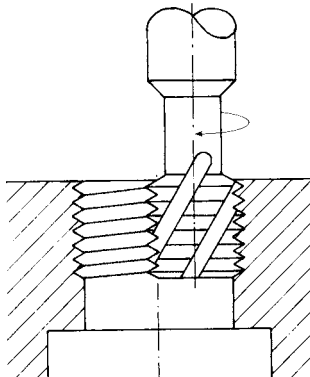


Foro passante Through hole
Discordanza Discordanza

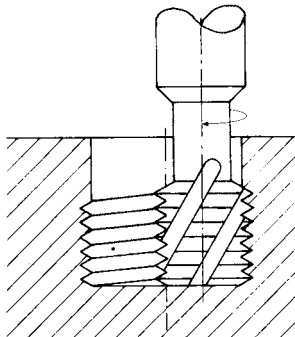


Foro cieco Dead hole
Concordanza Agreement

■ Filettatura sinistra interna Internal left threading



Foro passante Through hole
Concordanza Agreement



Foro cieco Dead hole
Discordanza Discordanza

DRILLING
 THREADS
 TAPS
 REAMERS
 YONNEX
 DRILLING

VALORI INDICATIVI PER FILETTATURA
CON FRESE A FILETTARE IN METALLO DURO
INDICATIVE VALUES FOR MILLING WITH CARBIDE THREADING MILLS

| MATERIALI MATERIAL | Vc m/min. | Fz Ø6 | Fz Ø8 | Fz Ø10 | Fz Ø12 | Fz Ø14 | Fz Ø16 | Fz Ø18 | Fz Ø20 |
|--|--------------|--------------|--------------|--------------|--------------|--------------|--------------|--------------|--------------|
| Acciai fino a 700N/mm ² - Steel < 700 N/mm ² | 90/200 | 0.035 / 0.1 | 0.04 / 0.12 | 0.045 / 0.15 | 0.05 / 0.18 | 0.06 / 0.21 | 0.07 / 0.25 | 0.08 / 0.28 | 0.09 / 0.35 |
| Acciai da 700 a 900N/mm ² - Steel 700- 900N/mm ² | 80/160 | 0.03 / 0.09 | 0.035 / 0.1 | 0.04 / 0.13 | 0.045 / 0.15 | 0.05 / 0.18 | 0.06 / 0.21 | 0.07 / 0.25 | 0.08 / 0.30 |
| Acciai da 900 a 1200N/mm ² - Steel 900-1200N/mm ² | 60/120 | 0.025 / 0.08 | 0.03 / 0.09 | 0.035 / 0.11 | 0.04 / 0.13 | 0.045 / 0.16 | 0.05 / 0.19 | 0.055 / 0.22 | 0.06 / 0.25 |
| Acciai superiori a 1200 N/mm ² - Steel >1200N/mm ² | 40/100 | 0.02 / 0.07 | 0.025 / 0.08 | 0.03 / 0.1 | 0.035 / 0.12 | 0.04 / 0.15 | 0.045 / 0.18 | 0.05 / 0.21 | 0.055 / 0.23 |
| Acciai Inox buona lavorabilità - Stainless steel good working | 25/80 | 0.025 / 0.08 | 0.03 / 0.09 | 0.035 / 0.11 | 0.04 / 0.13 | 0.045 / 0.16 | 0.05 / 0.19 | 0.055 / 0.22 | 0.06 / 0.25 |
| Acciai Inox difficile lavorabilità - Stainless steel hard working | 20/65 | 0.02 / 0.07 | 0.025 / 0.08 | 0.03 / 0.1 | 0.035 / 0.12 | 0.04 / 0.15 | 0.045 / 0.18 | 0.05 / 0.21 | 0.055 / 0.23 |
| Ghisa Grigia bassa durezza - Gray Iron low hardness | 80/180 | 0.035 / 0.1 | 0.04 / 0.12 | 0.045 / 0.15 | 0.05 / 0.18 | 0.06 / 0.21 | 0.07 / 0.25 | 0.08 / 0.28 | 0.09 / 0.35 |
| Ghisa malleabile media durezza - Malleable Cast Iron | 65/150 | 0.03 / 0.09 | 0.035 / 0.1 | 0.04 / 0.13 | 0.045 / 0.15 | 0.05 / 0.18 | 0.06 / 0.21 | 0.07 / 0.25 | 0.08 / 0.30 |
| Ghisa nodulare alta durezza - Nodular Cast Iron | 50/120 | 0.025 / 0.08 | 0.03 / 0.09 | 0.035 / 0.11 | 0.04 / 0.13 | 0.045 / 0.16 | 0.05 / 0.19 | 0.055 / 0.22 | 0.06 / 0.25 |
| Ghisa di difficile lavorabilità - Cast Iron hard working | 40/100 | 0.02 / 0.07 | 0.025 / 0.08 | 0.03 / 0.1 | 0.035 / 0.12 | 0.04 / 0.15 | 0.045 / 0.18 | 0.05 / 0.21 | 0.055 / 0.23 |
| Alluminio con Si <15% - Aluminium Si < 15% | 100/350 | 0.05 / 0.2 | 0.07 / 0.24 | 0.09 / 0.28 | 0.11 / 0.3 | 0.13 / 0.35 | 0.14 / 0.4 | 0.15 / 0.45 | 0.16 / 0.5 |
| Alluminio con Si >15% - Aluminium Si > 15% | 80/250 | 0.04 / 0.1 | 0.06 / 0.14 | 0.08 / 0.18 | 0.1 / 0.2 | 0.12 / 0.25 | 0.13 / 0.3 | 0.14 / 0.35 | 0.15 / 0.4 |
| Ottone / Zinco - Brass / Zinc | 80/180 | 0.03 / 0.09 | 0.035 / 0.1 | 0.04 / 0.13 | 0.045 / 0.15 | 0.05 / 0.18 | 0.06 / 0.21 | 0.07 / 0.25 | 0.08 / 0.30 |
| Bronzo Cupro/Nickel - Bronze/Nickel | 70/200 | 0.03 / 0.09 | 0.035 / 0.1 | 0.04 / 0.13 | 0.045 / 0.15 | 0.05 / 0.18 | 0.06 / 0.21 | 0.07 / 0.25 | 0.08 / 0.30 |
| Titanio Ti/6Al/4V - Titanium | 20/60 | 0.02 / 0.07 | 0.025 / 0.08 | 0.03 / 0.1 | 0.035 / 0.12 | 0.04 / 0.15 | 0.045 / 0.18 | 0.05 / 0.21 | 0.055 / 0.23 |