

NEW

Tipo A - Finitura

v_c [m/min]
 f_z [mm]

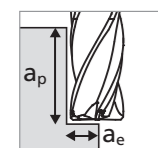
RACCOMANDAZIONI PER L'USO

● Perfettamente consigliato | ● Consigliato | ○ Parzialmente consigliato | ⊗ Non consigliato



FRESARE CON RAFFREDDAMENTO INTEGRATO | VISTA D'INSIEME DEI DATI DI TAGLIO

Finitura

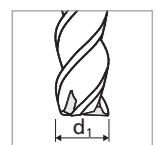


①

■ $a_p = 2 \times d_1$
■ $a_e = 0.04 \times d_1$

②

■ $a_p = 2 \times d_1$
■ $a_e = 0.02 \times d_1$



Gruppo materiali	Materiale	Mat. no.	DIN	AISI/ASTM/UNS	1.0 mm		1.5 mm 1/16"		2.0 mm 3/32"		3.0 mm 1/8"		4.0 mm 5/32"		5.0 mm 3/16" - 7/32"		6.0 mm 1/4"		8.0 mm																																		
					v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z																																	
P	Acciai non legati Rm < 800 N/mm ²	1.0301	C10	AISI 1010	130	0.008	0.009	180	0.012	0.014	200	0.017	0.020	210	0.023	0.026	220	0.025	0.029	220	0.028	0.032	220	0.033	0.038	220	0.038	0.044																									
		1.0401	C15	AISI 1015																																																	
		1.1191	C45E/CK45	AISI 1045																																																	
		1.0044	S275JR	AISI 1020																																																	
		1.0715	11SMn30	AISI 1215																																																	
	Acciai debolmente legati Rm > 900 N/mm ²	1.5752	15NiCr13	ASTM 3415 / AISI 3310	130	0.007	0.008	180	0.011	0.013	200	0.016	0.018	210	0.022	0.025	220	0.024	0.028	220	0.026	0.030	220	0.029	0.033	220	0.034	0.040																									
		1.7131	16MnCr5	AISI 5115																																																	
		1.3505	100Cr6	AISI 52100																																																	
		1.7225	42CrMo4	AISI 4140																																																	
		1.2842	90MnCrV8	AISI O2																																																	
Acciai da utensili forte-mente legati Rm < 1200 N/mm ²	1.2379	X153CrMoV12	AISI D2	130	0.006	0.007	180	0.010	0.012	200	0.015	0.017	210	0.020	0.023	220	0.021	0.024	220	0.023	0.026	220	0.025	0.029	220	0.030	0.035																										
	1.2436	X210CrW12	AISI D4/D6																																																		
	1.3343	HS6-5-2C	AISI M2 / UNS T11302																																																		
	1.3355	HS18-0-1	AISI T1 / UNS T12001																																																		
	M	Acciai inossidabili ferritici	1.4016																									X6Cr17	AISI 430 / UNS S43000	130	0.008	0.009	180	0.012	0.014	200	0.017	0.020	210	0.022	0.025	220	0.024	0.028	220	0.026	0.030	220	0.029	0.033	260	0.034	0.040
1.4105			X6CrMoS17	AISI 430F																																																	
1.4034			X46Cr13	AISI 420C																																																	
1.4112			X90CrMoV18	AISI 440B																																																	
Acciai inossidabili mar-tensitici - PH		1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH	130	0.008	0.009	180	0.011	0.013	200	0.016	0.018	210	0.022	0.025	220	0.023	0.027	220	0.025	0.029	220	0.028	0.032	260	0.033	0.038																									
		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH																																																	
		1.4301	X5CrNi18-10	AISI 304																																																	
		1.4435	X2CrNiMo18-14-3	AISI 316L																																																	
Acciai inossidabili austenitici	1.4441	X2CrNiMo18-15-3	AISI 316LM	130	0.006	0.007	180	0.008	0.009	200	0.015	0.017	210	0.020	0.023	220	0.022	0.025	220	0.024	0.028	220	0.026	0.030	260	0.032	0.037																										
	1.4539	X1NiCrMoCu25-20-5	AISI 904L																																																		
	K	Ghise	0.6020																									GG20	ASTM 30	110	0.006	0.007	130	0.012	0.014	150	0.014	0.016	160	0.022	0.025	170	0.025	0.029	170	0.029	0.033	170	0.031	0.036	200	0.036	0.042
			0.6030																									GG30	ASTM 40B																								
0.7040			GGG40	ASTM 60-40-18																																																	
0.7060			GGG60	ASTM 80-60-03																																																	
N			Leghe d'alluminio battute	3.2315	AlMgSi1	ASTM 6351	130	0.009	0.010	180	0.013	0.015	200	0.018	0.021	210	0.029	0.033	220	0.030	0.035	220	0.033	0.038	220	0.036	0.041	270	0.041																								
	3.4365	AlZnMgCu1.5		ASTM 7075																																																	
	3.2163	GD-AlSi9Cu3		ASTM A380																																																	
	Leghe d'alluminio pressofuse	3.2381	GD-AlSi10Mg	UNS A03590	130	0.009	0.010	180	0.013	0.015	200	0.018	0.021	210	0.029	0.033	220	0.030	0.035	220	0.033	0.038	220	0.036	0.041	270	0.041	0.047																									
		2.0040	Cu-OF / CW008A	UNS C10100																																																	
	Rame	2.0065	Cu-ETP / CW004A	UNS C11000	130	0.010	0.012	180	0.013	0.015	200	0.018	0.021	210	0.029	0.033	220	0.030	0.035	220	0.033	0.038	220	0.036	0.041	270	0.041	0.047																									
		2.0321	CuZn37 CW508L	UNS C27400																																																	
	Ottoni senza piombo	2.0360	CuZn40 CW509L	UNS C28000	130	0.010	0.012	180	0.013	0.015	200	0.018	0.021	210	0.029	0.033	220	0.030	0.035	220	0.033	0.038	220	0.036	0.041	270	0.041	0.047																									
		2.0401	CuZn39Pb3 / CW614N	UNS C38500																																																	
	Ottoni, Bronzi Rm < 400 N/mm ²	2.1020	CuSn6	UNS C51900	130	0.010	0.012	180	0.013	0.015	200	0.018	0.021	210	0.029	0.033	220	0.030	0.035	220	0.033	0.038	220	0.036	0.041	270	0.041	0.047																									
2.0966		CuAl10Ni5Fe4	UNS C63000																																																		
Bronzi Rm < 600 N/mm ²	2.0960	CuAl9Mn2	UNS C63200	130	0.009	0.010	180	0.013	0.015	200	0.018	0.021	210	0.029	0.033	220	0.030	0.035	220	0.033	0.038	220	0.036	0.041	270	0.041	0.047																										
	2.4856		Inconel 625																																																		
S ₁	Superleghe	2.4668		Inconel 718	110	0.004	0.005	120	0.005	0.006	130	0.005	0.006	130	0.008	0.009	140	0.010	0.012	140	0.011	0.013	150	0.012	0.014	160	0.017	0.020																									
		2.4617	NiMo28	Hastelloy B-2																																																	
		2.4665	NiCr22Fe18Mo	Hastelloy X																																																	
		3.7035	Gr.2	ASTM B348 / F67																																																	
S ₂	Titanio puro	3.7065	Gr.4	ASTM B348 / F68	110	0.008	0.009	120	0.010	0.012	130	0.014	0.016	130	0.020	0.023	140	0.022	0.025	140	0.024	0.028	150	0.026	0.030	160	0.031	0.036																									
		3.7165	TiAl6V4	ASTM B348 / F136																																																	
S ₃	Leghe di titanio	9.9367	TiAl6Nb7	ASTM F1295	110	0.008	0.009	120	0.010	0.012	130	0.014	0.016	130	0.020	0.023	140	0.022	0.025	140	0.024	0.028	150	0.026	0.030	160	0.031	0.036																									
		2.4964	CoCr20W15NiCrCoMo28	Haynes 25 ASTM F1537																																																	
H ₁ H ₂	Acciai temprati < 55 HRC	1.2510	100MnCrMoW4	AISI O1																																																	
		1.2379	X153CrMoV12	AISI D2																																																	