

NEW

Tipo C - Finitura

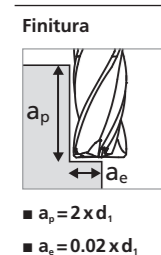
v_c [m/min]
 f_z [mm]

RACCOMANDAZIONI PER L'USO

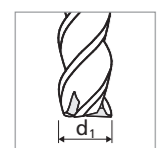
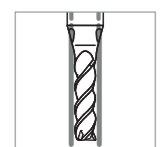
● Perfettamente consigliato | ● Consigliato | ○ Parzialmente consigliato | ☒ Non consigliato



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



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



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"		Ød. 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/mm²	1.0301	C10	AISI 1010	130	0.008	180	0.012	200	0.017	210	0.023	220	0.025	220	0.028	220	0.033	220	0.042	
		1.0401	C15	AISI 1015																	
		1.1191	C45E/CK45	AISI 1045																	
		1.0044	S275JR	AISI 1020																	
		1.0715	11Mn30	AISI 1215																	
	Acciai debolmente legati Rm > 900 N/mm²	1.5752	15NiCr13	ASTM 3415 / AISI 3310	130	0.007	180	0.011	200	0.016	210	0.022	220	0.024	220	0.026	220	0.029	220	0.038	
		1.7131	16MnCr5	AISI 5115																	
		1.3505	100Cr6	AISI 52100																	
		1.7225	42CrMo4	AISI 4140																	
		1.2842	90MnCrV8	AISI O2																	
	Acciai da utensili fortemente legati Rm < 1200 N/mm²	1.2379	X153CrMoV12	AISI D2	130	0.006	180	0.010	200	0.015	210	0.020	220	0.021	220	0.023	220	0.025	220	0.034	
		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	180	0.012	200	0.017	210	0.022	220	0.024	220	0.026	220	0.029	260	0.036	
		1.4105	X6CrMoS17	AISI 430F																	
		1.4034	X46Cr13	AISI 420C																	
	Acciai inossidabili martensitici	1.4112	X90CrMoV18	AISI 440B	130	0.008	180	0.011	200	0.016	210	0.022	220	0.023	220	0.025	220	0.028	260	0.037	
		1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH																	
		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH																	
	Acciai inossidabili martensitici - PH	1.4301	X5CrNi18-10	AISI 304	130	0.008	180	0.011	200	0.016	210	0.022	220	0.023	220	0.025	220	0.028	260	0.037	
		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH																	
Acciai inossidabili austenitici	1.4435	X2CrNiMo18-14-3	AISI 316L	130	0.006	180	0.008	200	0.015	210	0.020	220	0.022	220	0.024	220	0.026	220	0.026	260	0.035
	1.4441	X2CrNiMo18-15-3	AISI 316LM																		
	1.4539	X1NiCrMoCu25-20-5	AISI 904L																		
	1.4539	X1NiCrMoCu25-20-5	AISI 904L																		
K	Ghise	0.6020	GG20	ASTM 30	110	0.006	130	0.012	150	0.014	160	0.022	170	0.025	170	0.029	170	0.031	200	0.040	
		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	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	270	0.045	
		3.4365	AlZnMgCu1.5	ASTM 7075																	
	Leghe d'alluminio pressofuse	3.2163	GD-AlSi9Cu3	ASTM A380	130	0.009	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	270	0.045	
		3.2381	GD-AlSi10Mg	UNS A03590																	
	Rame	2.0040	Cu-OF / CW008A	UNS C10100	130	0.010	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	270	0.045	
		2.0065	Cu-ETP / CW004A	UNS C11000																	
	Ottoni senza piombo	2.0321	CuZn37 CW508L	UNS C27400	130	0.010	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	270	0.045	
		2.0360	CuZn40 CW509L	UNS C28000																	
	Ottoni, Bronzi Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	130	0.010	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	270	0.045	
		2.1020	CuSn6	UNS C51900																	
Bronzi Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000	130	0.009	180	0.013	200	0.018	210	0.029	220	0.030	220	0.033	220	0.036	270	0.045		
	2.0960	CuAl9Mn2	UNS C63200																		
S1	Superleghe	2.4856		Inconel 625	110	0.004	120	0.005	130	0.005	130	0.008	140	0.010	140	0.011	150	0.012	160	0.021	
		2.4668		Inconel 718																	
		2.4617	NiMo28	Hastelloy B-2																	
		2.4665	NiCr22Fe18Mo	Hastelloy X																	
S2	Titanio puro	3.7035	Gr.2	ASTM B348 / F67	110	0.008	120	0.010	130	0.014	130	0.020	140	0.022	140	0.024	150	0.026	160	0.035	
		3.7065	Gr.4	ASTM B348 / F68																	
S2	Leghe di titanio	3.7165	TiAl6V4	ASTM B348 / F136	110	0.008	120	0.010	130	0.014	130	0.020	140	0.022	140	0.024	150	0.026	160	0.035	
		9.9367	TiAl6Nb7	ASTM F1295																	
S3	Leghe CrCo	2.4964	CoCr20W15Ni CrCoMo28	Haynes 25 ASTM F1537	110	0.004	120	0.005	130	0.005	130	0.008	140	0.010	140	0.011	150	0.012	160	0.021	
H1	Acciai temprati < 55 HRC	1.2510	100MnCrMoW4	AISI O1																	
		1.2379	X153CrMoV12	AISI D2																	