

NEW

Tipo C - Lavorazione preliminare

v_c [m/min]
 f_z [mm]

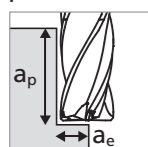
RACCOMANDAZIONI PER L'USO

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

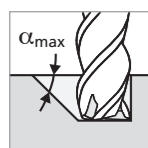


FRESARE CON RAFFREDDAMENTO INTEGRATO | VISTA D'INSIEME DEI DATI DI TAGLIO

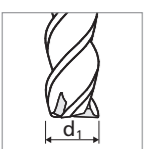
Lavorazione preliminare



■ $a_p = 2 \times d_1$
■ $a_e = 0.1 \times d_1$



Nota:
In caso di fresatura con rampa lineare o interpolazione elicoidale ridurre f_z del 35%



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/mm ²	1.0301	C10	AISI 1010	120	0.017	140	0.026	160	0.038	180	0.048	200	0.050	200	0.052	220	0.056	220	0.068
		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	120	0.016	140	0.025	160	0.036	180	0.044	200	0.048	200	0.050	220	0.054	220	0.066
		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	120	0.012	140	0.022	160	0.035	180	0.042	200	0.043	200	0.045	220	0.048	220	0.058	
	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
1.4105			X6CrMoS17	AISI 430F																
1.4034			X46Cr13	AISI 420C																
Acciai inossidabili martensitici		1.4112	X90CrMoV18	AISI 440B	120	0.017	140	0.025	160	0.036	180	0.044	200	0.046	200	0.048	220	0.052	260	0.060
		1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH																
Acciai inossidabili martensitici - PH		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH	120	0.017	140	0.025	160	0.036	180	0.044	200	0.046	200	0.048	220	0.052	260	0.060
		1.4301	X5CrNi18-10	AISI 304																
Acciai inossidabili austenitici	1.4435	X2CrNiMo18-14-3	AISI 316L	120	0.013	140	0.016	160	0.034	180	0.042	200	0.044	200	0.046	220	0.049	260	0.058	
	1.4441	X2CrNiMo18-15-3	AISI 316LM																	
K	Ghise	0.6020	GG20	ASTM 30	100	0.012	120	0.026	140	0.032	160	0.043	180	0.054	180	0.056	200	0.058	200	0.070
		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	170	0.020	190	0.029	210	0.040	230	0.060	250	0.062	250	0.064	270	0.068	270	0.084
		3.4365	AlZnMgCu1.5	ASTM 7075																
	Leghe d'alluminio pressofuse	3.2163	GD-AlSi9Cu3	ASTM A380	170	0.020	190	0.029	210	0.040	230	0.060	250	0.062	250	0.064	270	0.068	270	0.084
		3.2381	GD-AlSi10Mg	UNS A03590																
	Rame	2.0040	Cu-OF / CW008A	UNS C10100	170	0.022	190	0.029	210	0.040	230	0.060	250	0.062	250	0.064	270	0.068	270	0.084
		2.0065	Cu-ETP / CW004A	UNS C11000																
	Ottoni senza piombo	2.0321	CuZn37 CW508L	UNS C27400	170	0.022	190	0.029	210	0.040	230	0.060	250	0.062	250	0.064	270	0.068	270	0.084
		2.0360	CuZn40 CW509L	UNS C28000																
	Ottoni, Bronzi Rm < 400 N/mm ²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	170	0.022	190	0.029	210	0.040	230	0.060	250	0.062	250	0.064	270	0.068	270	0.084
		2.1020	CuSn6	UNS C51900																
Bronzi Rm < 600 N/mm ²	2.0966	CuAl10Ni5Fe4	UNS C63000	170	0.020	190	0.029	210	0.040	230	0.060	250	0.062	250	0.064	270	0.068	270	0.084	
	2.0960	CuAl9Mn2	UNS C63200																	
S ₁	Superleghe	2.4856		Inconel 625	100	0.008	100	0.010	120	0.012	120	0.016	140	0.018	140	0.020	160	0.022	160	0.024
		2.4668		Inconel 718																
		2.4617	NiMo28	Hastelloy B-2																
		2.4665	NiCr22Fe18Mo	Hastelloy X																
S ₂	Titanio puro	3.7035	Gr.2	ASTM B348 / F67	100	0.018	100	0.022	120	0.032	120	0.042	140	0.044	140	0.046	160	0.048	160	0.054
		3.7065	Gr.4	ASTM B348 / F68																
S ₃	Leghe di titanio	3.7165	TiAl6V4	ASTM B348 / F136	100	0.018	100	0.022	120	0.032	120	0.042	140	0.044	140	0.046	160	0.048	160	0.054
		9.9367	TiAl6Nb7	ASTM F1295																
H ₁	Acciai temprati < 55 HRC	2.4964	CoCr20W15Ni	Haynes 25	100	0.008	100	0.010	120	0.012	120	0.016	140	0.018	140	0.020	160	0.022	160	0.024
			CrCoMo28	ASTM F1537																
H ₂	Acciai temprati ≥ 55 HRC	1.2510	100MnCrMoW4	AISI O1																
		1.2379	X153CrMoV12	AISI D2																