

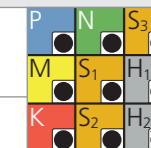
NEW

Tipo M - Semi-finitura

v_c [m/min]
 f_z [mm]

RACCOMANDAZIONI PER L'USO

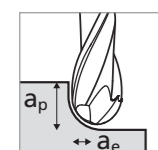
● Perfettamente consigliato | ● Consigliato | ○ Parzialmente consigliato | ☒ Non consigliato



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

Possibilità 1

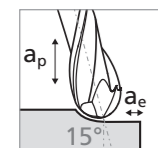
Inclinazione 0°



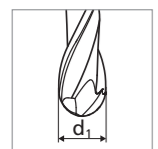
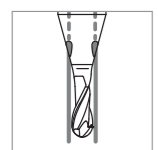
■ $a_p = 1 \times d_1$
■ $a_e = 0.2 \times d_1$

Possibilità 2

Inclinazione 15°



■ $a_p = 0.5 \times d_1$
■ $a_e = 0.2 \times d_1$



Gruppo materiali	Materiale	Mat. no.	DIN	AISI/ASTM/UNS	1.0 mm		1.2 mm		1.5 mm 1/16"		1.8 mm		2.0 mm		2.5 mm 3/32"		3.0 mm 1/8"		4.0 mm 5/32"		5.0 mm 3/16"		6.0 mm-8.0 mm 7/32-1/4"	
					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	v_c	f_z	v_c	f_z
P	Acciai non legati Rm < 800 N/mm²	1.0301	C10	AISI 1010	140	0.013	140	0.014																
		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/mm²	1.5752	15NiCr13	ASTM 3415 / AISI 3310	140	0.012	140	0.014																
		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	140	0.009	140	0.011																	
	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	140	0.014	140	0.015																
		1.4105	X6CrMoS17	AISI 430F																				
		1.4034	X46Cr13	AISI 420C																				
	Acciai inossidabili martensitici	1.4112	X90CrMoV18	AISI 440B	140	0.013	140	0.014																
		1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH																				
	Acciai inossidabili martensitici - PH	1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH	140	0.013	140	0.014																
		1.4301	X5CrNi18-10	AISI 304																				
		1.4435	X2CrNiMo18-14-3	AISI 316L																				
		1.4441	X2CrNiMo18-15-3	AISI 316LM																				
		1.4539	X1NiCrMoCu25-20-5	AISI 904L																				
K	Ghise	0.6020	GG20	ASTM 30	120	0.009	120	0.019																
		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	140	0.015	140	0.017																
		3.4365	AlZnMgCu1.5	ASTM 7075																				
	Leghe d'alluminio pressofuse	3.2163	GD-AlSi9Cu3	ASTM A380	140	0.015	140	0.017																
		3.2381	GD-AlSi10Mg	UNS A03590																				
	Rame	2.0040	Cu-OF / CW008A	UNS C10100	140	0.017	140	0.019																
		2.0065	Cu-ETP / CW004A	UNS C11000																				
	Ottoni senza piombo	2.0321	CuZn37 CW508L	UNS C27400	140	0.017	140	0.019																
		2.0360	CuZn40 CW509L	UNS C28000																				
	Ottoni, Bronzi Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	140	0.017	140	0.019																
		2.1020	CuSn6	UNS C51900																				
Bronzi Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000	140	0.015	140	0.017																	
	2.0960	CuAl9Mn2	UNS C63200																					
S1	Superleghe	2.4856		Inconel 625	120	0.006	120	0.007																
		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	120	0.014	120	0.015																
		3.7065	Gr.4	ASTM B348 / F68																				
S3	Leghe di titanio	3.7165	TiAl6V4	ASTM B348 / F136	120	0.014	120	0.015																
		9.9367	TiAl6Nb7	ASTM F1295																				
H1	Acciai temprati < 55 HRC	2.4964	CoCr20W15Ni	Haynes 25	140	0.006	140	0.007																
			CrCoMo28	ASTM F1537																				
H2	Acciai temprati ≥ 55 HRC	1.2510	100MnCrMoW4	AISI O1	100	0.009	100	0.010																
		1.2379	X153CrMoV12	AISI D2																				