CRAZYMILL™ by Mikron Tool Cool

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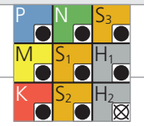
FRESARE
CRAZYMILL COOL SFERICA - Z4

NEW Tipo N - Finitura

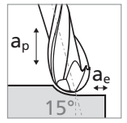
v_c [m/min]
f_z [mm]

RACCOMANDAZIONI PER L'USO
● Perfettamente consigliato | ◐ Consigliato | ○ Parzialmente consigliato | ⊠ Non consigliato



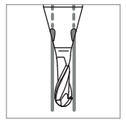
FRESARE CON RAFFREDDAMENTO INTEGRATO | VISTA D'INSIEME DEI DATI DI TAGLIO

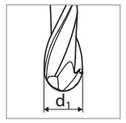
Inclinazione 15°



- $a_p = 0.1 \times d_1$
- $a_e = 0.05 – 0.1 \times d_1$

$n_{max} = 60'000$ rpm





Gruppo materiali	Materiale	Mat. no.	DIN	AISI/ASTM/UNS	1.0 mm		1.2 mm		Ød1 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	0.015	140	0.017	200	0.024	200	0.026	220	0.034	220	0.036	240	0.035	260	0.044	260	0.044	260	0.047
		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	0.014	140	0.016	200	0.022	200	0.024	220	0.032	220	0.034	240	0.033	260	0.042	260	0.042	260	0.045
		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	0.011	140	0.013	200	0.020	200	0.022	220	0.030	220	0.032	240	0.031	260	0.039	260	0.037	260	0.041
		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	0.016	140	0.018	200	0.024	200	0.026	220	0.034	220	0.036	240	0.035	260	0.042	260	0.042	260	0.045
		1.4105	X6CrMoS17	AISI 430F																				
	Acciai inossidabili martensitici	1.4034	X46Cr13	AISI 420C	140	0.015	140	0.017	200	0.022	200	0.024	220	0.032	220	0.034	240	0.032	260	0.040	260	0.040	260	0.043
		1.4112	X90CrMoV18	AISI 440B																				
	Acciai inossidabili martensitici - PH	1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH	140	0.015	140	0.017	200	0.022	200	0.024	220	0.032	220	0.034	240	0.032	260	0.040	260	0.040	260	0.043
		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH																				
	Acciai inossidabili austenitici	1.4301	X5CrNi18-10	AISI 304	140	0.012	140	0.014	200	0.016	200	0.018	220	0.030	220	0.032	240	0.030	260	0.039	260	0.039	260	0.041
		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	0.011	120	0.022	140	0.024	140	0.026	160	0.028	160	0.036	180	0.037	200	0.046	200	0.046	200	0.049
		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	0.018	140	0.020	200	0.026	200	0.028	220	0.036	220	0.040	240	0.051	260	0.048	260	0.053	260	0.051
		3.4365	AlZnMgCu1.5	ASTM 7075																				
	Leghe d'alluminio pressofuse	3.2163	GD-AlSi9Cu3	ASTM A380	140	0.018	140	0.020	200	0.026	200	0.028	220	0.036	220	0.040	240	0.051	260	0.048	260	0.053	260	0.051
		3.2381	GD-AlSi10Mg	UNS A03590																				
	Rame	2.0040	Cu-OF / CW008A	UNS C10100	140	0.020	140	0.022	200	0.026	200	0.028	220	0.036	220	0.040	240	0.051	260	0.048	260	0.053	260	0.051
		2.0065	Cu-ETP / CW004A	UNS C11000																				
	Ottoni senza piombo	2.0321	CuZn37 CW508L	UNS C27400	140	0.020	140	0.022	200	0.026	200	0.028	220	0.036	220	0.040	240	0.051	260	0.048	260	0.053	260	0.051
		2.0360	CuZn40 CW509L	UNS C28000																				
	Ottoni, Bronzi Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	140	0.020	140	0.022	200	0.026	200	0.028	220	0.036	220	0.040	240	0.051	260	0.048	260	0.053	260	0.051
		2.1020	CuSn6	UNS C51900																				
	Bronzi Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000	140	0.018	140	0.020	200	0.026	200	0.028	220	0.036	220	0.040	240	0.051	260	0.048	260	0.053	260	0.051
		2.0960	CuAl9Mn2	UNS C63200																				
S_1	Superleghe	2.4856		Inconel 625	120	0.007	120	0.008	130	0.009	130	0.010	140	0.010	140	0.012	150	0.013	170	0.018	170	0.018	170	0.019
		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	120	0.016	120	0.018	130	0.020	130	0.022	140	0.028	140	0.030	150	0.030	170	0.037	170	0.039	170	0.039
		3.7065	Gr.4	ASTM B348 / F68																				
	Leghe di titanio	3.7165	TiAl6V4	ASTM B348 / F136	120	0.016	120	0.018	130	0.020	130	0.022	140	0.028	140	0.030	150	0.030	170	0.037	170	0.039	170	0.039
		9.9367	TiAl6Nb7	ASTM F1295																				
S_3	Leghe CrCo	2.4964	CoCr20W15Ni	Haynes 25	140	0.007	140	0.008	180	0.009	180	0.010	200	0.010	200	0.012	220	0.013	240	0.018	240	0.018	240	0.019
			CrCoMo28	ASTM F1537																				
H_1	Acciai temprati < 55 HRC	1.2510	100MnCrMoW4	AISI O1	100	0.010	100	0.012	140	0.014	140	0.018	180	0.020	180	0.026	200	0.026	240	0.028	240	0.035	240	0.030
H_2	Acciai temprati ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2																				