

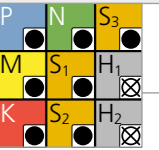
**NEW**

# Tipo B - Z3 - Contornatura - Sgrossatura

$v_c$  [m/min]  
 $f_z$  [mm]

RACCOMANDAZIONI PER L'USO

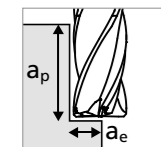
● Perfettamente consigliato | ● Consigliato | ○ Parzialmente consigliato | ⊗ Non consigliato



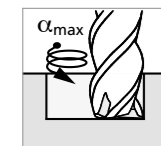
## FRESARE CON RAFFREDDAMENTO INTEGRATO | VISTA D'INSIEME DEI DATI DI TAGLIO

**Contornatura**

**Sgrossatura**

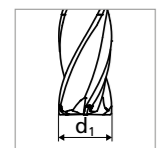
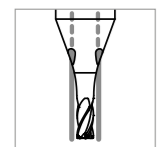


■  $a_p = 1 \times d_1$   
■  $a_e = 0.2 \times d_1$



**Nota:**

In caso di fresatura con interpolazione elicoidale vedere  $\alpha_{max}$  alla pagina 35



Gruppo materiali	Materiale	Mat. no.	DIN	AISI/ASTM/UNS	Geometria di taglio	0.2 mm		0.3 mm		0.4 mm 1/64"		0.5 mm		$\phi d_1$ 0.6 mm		0.7 mm		0.8 mm 1/32"		0.9 - 1.0 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 <sup>2</sup>	1.0301	C10	AISI 1010	GEOMETRIA S	15 - 25	0.003	20 - 40	0.005	25 - 50	0.007	30 - 65	0.010	40 - 75	0.012	45 - 90	0.014	50 - 100	0.016	55 - 115	0.018
		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 <sup>2</sup>	1.5752	15NiCr13	ASTM 3415 / AISI 3310																	
		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/mm <sup>2</sup>	1.2379	X153CrMoV12	AISI D2																		
	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	GEOMETRIA S	15 - 25	0.003	20 - 40	0.005	25 - 50	0.007	30 - 65	0.010	40 - 75	0.012	45 - 90	0.014	50 - 100	0.016	55 - 115	0.018
		1.4105	X6CrMoS17	AISI 430F																	
	Acciai inossidabili martensitici	1.4034	X46Cr13	AISI 420C																	
		1.4112	X90CrMoV18	AISI 440B																	
	Acciai inossidabili martensitici - PH	1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH																	
		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH																	
	Acciai inossidabili austenitici	1.4301	X5CrNi18-10	AISI 304																	
		1.4435	X2CrNiMo18-14-3	AISI 316L																	
1.4441		X2CrNiMo18-15-3	AISI 316LM																		
K	Ghise	0.6020	GG20	ASTM 30	GEOMETRIA S	15 - 25	0.002	20 - 40	0.004	25 - 50	0.006	30 - 65	0.008	40 - 75	0.009	45 - 90	0.011	50 - 100	0.013	55 - 115	0.015
		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	GEOMETRIA S	15 - 25	0.004	20 - 40	0.007	25 - 50	0.009	30 - 65	0.012	40 - 75	0.013	45 - 90	0.015	50 - 100	0.016	55 - 115	0.017
		3.4365	AlZnMgCu1.5	ASTM 7075																	
	Leghe d'alluminio pressofuse	3.2163	GD-AlSi9Cu3	ASTM A380																	
		3.2381	GD-AlSi10Mg	UNS A03590																	
	Rame	2.0040	Cu-OF / CW008A	UNS C10100																	
		2.0065	Cu-ETP / CW004A	UNS C11000																	
	Ottoni senza piombo	2.0321	CuZn37 CW508L	UNS C27400																	
		2.0360	CuZn40 CW509L	UNS C28000																	
	Ottoni, Bronzi Rm < 400 N/mm <sup>2</sup>	2.0401	CuZn39Pb3 / CW614N	UNS C38500																	
		2.1020	CuSn6	UNS C51900																	
Bronzi Rm < 600 N/mm <sup>2</sup>	2.0966	CuAl10Ni5Fe4	UNS C63000																		
	2.0960	CuAl9Mn2	UNS C63200																		
S <sub>1</sub>	Superleghe	2.4856		Inconel 625	GEOMETRIA SX	15 - 25	0.002	20 - 40	0.003	25 - 50	0.004	30 - 65	0.005	40 - 75	0.007	45 - 90	0.008	50 - 100	0.009	55 - 115	0.010
		2.4668		Inconel 718																	
		2.4617	NiMo28	Hastelloy B-2																	
		2.4665	NiCr22Fe18Mo	Hastelloy X																	
S <sub>2</sub>	Titanio puro	3.7035	Gr.2	ASTM B348 / F67	GEOMETRIA S	15 - 25	0.002	20 - 40	0.004	25 - 50	0.006	30 - 65	0.008	40 - 75	0.009	45 - 90	0.011	50 - 100	0.013	55 - 115	0.015
		3.7065	Gr.4	ASTM B348 / F68																	
S <sub>2</sub>	Leghe di titanio	3.7165	TiAl6V4	ASTM B348 / F136	GEOMETRIA S	15 - 25	0.003	20 - 40	0.005	25 - 50	0.007	30 - 65	0.010	40 - 75	0.012	45 - 90	0.014	50 - 100	0.016	55 - 115	0.018
		9.9367	TiAl6Nb7	ASTM F1295																	
S <sub>3</sub>	Leghe CoCr	2.4964	CoCr20W15Ni CrCoMo28	Haynes 25 ASTM F1537	GEOMETRIA SX	15 - 25	0.002	20 - 40	0.003	25 - 50	0.004	30 - 65	0.005	40 - 75	0.007	45 - 90	0.008	50 - 100	0.009	55 - 115	0.010
H <sub>1</sub> H <sub>2</sub>	Acciai temprati < 55 HRC	1.2510	100MnCrMoW4	AISI O1																	
		1.2379	X153CrMoV12	AISI D2																	