

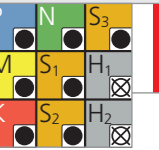
NEW

Tipo B - Z4 - Contornatura - Semi-finitura

v_c [m/min]
 f_z [mm]

RACCOMANDAZIONI PER L'USO

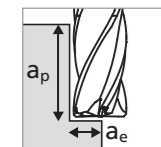
● Perfettamente consigliato | ● Consigliato | ○ Parzialmente consigliato | ⊗ Non consigliato



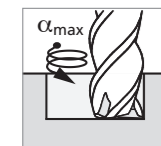
FRESARE CON RAFFREDDAMENTO INTEGRATO | VISTA D'INSIEME DEI DATI DI TAGLIO

Contornatura

Semi-finitura

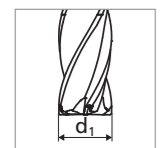
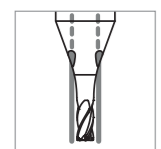


■ $a_p = 1.5 \times d_1$
■ $a_e = 0.1 \times d_1$



Nota:

In caso di fresatura con interpolazione elicoidale vedere α_{max} alla pagina 35



Gruppo materiali	Materiale	Mat. no.	DIN	AISI/ASTM/UNS	Geometria di taglio	$\varnothing d_1$											
						0.4 mm 1/64"		0.5 mm		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
P	Acciai non legati $R_m < 800 \text{ N/mm}^2$	1.0301	C10	AISI 1010	GEOMETRIA S	45 - 75	0.011	55 - 95	0.013	65 - 115	0.015	75 - 130	0.018	90 - 150	0.020	100 - 170	0.022
		1.0401	C15	AISI 1015													
		1.1191	C45E/CK45	AISI 1045													
		1.0044	S275JR	AISI 1020													
		1.0715	11SMn30	AISI 1215													
	Acciai debolmente legati $R_m > 900 \text{ N/mm}^2$	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 $R_m < 1200 \text{ N/mm}^2$	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	45 - 75	0.010	55 - 95	0.013	65 - 115	0.015	75 - 130	0.018	90 - 150	0.020	100 - 170
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	45 - 75	0.011	55 - 95	0.013	65 - 115	0.015	75 - 130	0.018	90 - 150	0.020	100 - 170	0.022
		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	45 - 75	0.012	55 - 95	0.013	65 - 115	0.015	75 - 130	0.016	90 - 150	0.017	100 - 170	0.018
		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 $R_m < 400 \text{ N/mm}^2$	2.0401	CuZn39Pb3 / CW614N	UNS C38500													
		2.1020	CuSn6	UNS C51900													
Bronzi $R_m < 600 \text{ N/mm}^2$	2.0966	CuAl10Ni5Fe4	UNS C63000														
	2.0960	CuAl9Mn2	UNS C63200														
S1	Superleghe	2.4856		Inconel 625	GEOMETRIA SX	45 - 75	0.005	55 - 95	0.007	65 - 115	0.008	75 - 130	0.009	90 - 150	0.010	100 - 170	0.011
		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	GEOMETRIA S	45 - 75	0.007	55 - 95	0.010	65 - 115	0.012	75 - 130	0.014	90 - 150	0.016	100 - 170	0.018
		3.7065	Gr.4	ASTM B348 / F68													
S2	Leghe di titanio	3.7165	TiAl6V4	ASTM B348 / F136	GEOMETRIA S	45 - 75	0.007	55 - 95	0.010	65 - 115	0.012	75 - 130	0.014	90 - 150	0.016	100 - 170	0.018
		9.9367	TiAl6Nb7	ASTM F1295													
S3	Leghe CoCr	2.4964	CoCr20W15Ni CrCoMo28	Haynes 25 ASTM F1537	GEOMETRIA SX	45 - 75	0.005	55 - 95	0.007	65 - 115	0.008	75 - 130	0.009	90 - 150	0.010	100 - 170	0.011
H1 H2	Acciai temprati < 55 HRC	1.2510	100MnCrMoW4	AISI O1													
	Acciai temprati ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2													