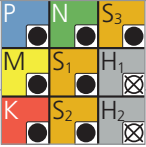


NEW Tipo A - Sedi chiavette - Fresatura a tuffo - Cave

v_c [m/min] **a_p** [mm]
f_{z,p} [mm] **f_{z,s}** [mm]

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



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

Fresatura di sedi chiavette

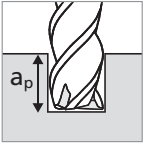
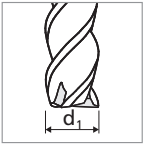
■ **f_{z,p}**: per fresatura a tuffo
■ **f_{z,s}**: per fresatura cave

Fresatura a tuffo

■ **f_{z,p}**: per fresatura a tuffo

Fresatura di cave

■ **f_{z,p}**: per fresatura a tuffo
■ **f_{z,s}**: per fresatura cave



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 ₁ 4.0 mm 5/32"				5.0 mm 3/16" - 7/32"				6.0 mm - 8.0 mm 1/4"			
					v _c	f _{z,p}	f _{z,s}	a _p	v _c	f _{z,p}	f _{z,s}	a _p	v _c	f _{z,p}	f _{z,s}	a _p	v _c	f _{z,p}	f _{z,s}	a _p	v _c	f _{z,p}	f _{z,s}	a _p	v _c	f _{z,p}	f _{z,s}	a _p	v _c	f _{z,p}	f _{z,s}	a _p
P	Acciai non legati Rm < 800 N/mm²	1.0301	C10	AISI 1010																												
		1.0401	C15	AISI 1015																												
		1.1191	C45E/CK45	AISI 1045	100	0.0013	0.0046	1xd1	120	0.0020	0.0065	1xd1	120	0.0026	0.0091	1xd1	140	0.004	0.013	1xd1	140	0.005	0.020	1xd1	150	0.005	0.026	1xd1	160	0.006	0.033	1xd1
		1.0044	S275JR	AISI 1020																												
		1.0715	11SMn30	AISI 1215																												
	Acciai debolmente legati Rm > 900 N/mm²	1.5752	15NiCr13	ASTM 3415 / AISI 3310																												
		1.7131	16MnCr5	AISI 5115																												
		1.3505	100Cr6	AISI 52100	100	0.0014	0.0049	1xd1	120	0.0021	0.0070	1xd1	120	0.0028	0.0098	1xd1	140	0.004	0.014	1xd1	140	0.005	0.021	1xd1	150	0.006	0.027	1xd1	160	0.006	0.034	1xd1
		1.7225	42CrMo4	AISI 4140																												
	Acciai da utensili forte- mente legati Rm < 1200 N/mm²	1.2842	90MnCrV8	AISI O2																												
		1.2379	X153CrMoV12	AISI D2																												
		1.2436	X210CrW12	AISI D4/D6																												
		1.3343	HS6-5-2C	AISI M2 / UNS T11302	100	0.0012	0.0042	0.5xd1	120	0.0018	0.0060	0.5xd1	120	0.0024	0.0084	0.5xd1	140	0.003	0.012	0.5xd1	140	0.004	0.017	0.5xd1	150	0.004	0.022	0.5xd1	160	0.005	0.028	0.5xd1
	1.3355	HS18-0-1	AISI T1 / UNS T12001																													
M	Acciai inossidabili ferritici	1.4016	X6Cr17	AISI 430 / UNS S43000	100	0.0010	0.0035	1xd1	120	0.0015	0.0050	1xd1	120	0.0020	0.0070	1xd1	140	0.003	0.010	1xd1	140	0.004	0.015	1xd1	150	0.004	0.020	1xd1	160	0.005	0.025	1xd1
		1.4105	X6CrMoS17	AISI 430F																												
		1.4034	X46Cr13	AISI 420C	100	0.0010	0.0035	0.5xd1	120	0.0015	0.0050	0.5xd1	120	0.0020	0.0070	0.5xd1	140	0.003	0.010	0.5xd1	140	0.004	0.015	0.5xd1	150	0.004	0.020	0.5xd1	160	0.005	0.025	0.5xd1
	Acciai inossidabili mar- tensitici - PH	1.4112	X90CrMoV18	AISI 440B																												
		1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH	100	0.0010	0.0035	0.5xd1	120	0.0015	0.0050	0.5xd1	120	0.0020	0.0070	0.5xd1	140	0.003	0.010	0.5xd1	140	0.004	0.015	0.5xd1	150	0.004	0.020	0.5xd1	160	0.005	0.025	0.5xd1
	1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH																													
	Acciai inossidabili austenitici	1.4301	X5CrNi18-10	AISI 304																												
		1.4435	X2CrNiMo18-14-3	AISI 316L	100	0.0010	0.0035	1xd1	120	0.0015	0.0050	1xd1	120	0.0020	0.0070	1xd1	140	0.003	0.010	1xd1	140	0.004	0.015	1xd1	150	0.004	0.020	1xd1	160	0.005	0.025	1xd1
		1.4441	X2CrNiMo18-15-3	AISI 316LM																												
1.4539		X1NiCrMoCu25-20-5	AISI 904L																													
K	Ghise	0.6020	GG20	ASTM 30																												
		0.6030	GG30	ASTM 40B																												
		0.7040	GGG40	ASTM 60-40-18	100	0.0013	0.0042	1xd1	120	0.0019	0.0060	1xd1	120	0.0024	0.0084	1xd1	140	0.004	0.012	1xd1	140	0.004	0.017	1xd1	150	0.005	0.022	1xd1	160	0.005	0.028	1xd1
		0.7060	GGG60	ASTM 80-60-03																												
N	Leghe d'alluminio battute	3.2315	AlMgSi1	ASTM 6351	100	0.0012	0.0100	1xd1	120	0.0018	0.0160	1xd1	120	0.0024	0.0210	1xd1	150	0.004	0.034	1xd1	160	0.004	0.035	1xd1	170	0.005	0.036	1xd1	180	0.005	0.037	1xd1
		3.4365	AlZnMgCu1.5	ASTM 7075																												
	Leghe d'alluminio pressofuse	3.2163	GD-AlSi9Cu3	ASTM A380	100	0.0012	0.0100	1xd1	120	0.0018	0.0160	1xd1	120	0.0024	0.0210	1xd1	150	0.004	0.034	1xd1	160	0.004	0.035	1xd1	170	0.005	0.036	1xd1	180	0.005	0.037	1xd1
		3.2381	GD-AlSi10Mg	UNS A03590																												
	Rame	2.0040	Cu-OF / CW008A	UNS C10100	100	0.0012	0.0100	1xd1	120	0.0018	0.0160	1xd1	120	0.0024	0.0210	1xd1	150	0.004	0.034	1xd1	160	0.004	0.035	1xd1	170	0.005	0.036	1xd1	180	0.005	0.037	1xd1
		2.0065	Cu-ETP / CW004A	UNS C11000																												
	Ottoni senza piombo	2.0321	CuZn37 CW508L	UNS C27400	100	0.0012	0.0100	1xd1	120	0.0018	0.0160	1xd1	120	0.0024	0.0210	1xd1	150	0.004	0.034	1xd1	160	0.004	0.035	1xd1	170	0.005	0.036	1xd1	180	0.005	0.037	1xd1
		2.0360	CuZn40 CW509L	UNS C28000																												
	Ottoni, Bronzi Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	100	0.0012	0.0100	1xd1	120	0.0018	0.0160	1xd1	120	0.0024	0.0210	1xd1	150	0.004	0.034	1xd1	160	0.004	0.035	1xd1	170	0.005	0.036	1xd1	180	0.005	0.037	1xd1
2.1020		CuSn6	UNS C51900																													
Bronzi Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	UNS C63000	100	0.0012	0.0100	1xd1	120	0.0018	0.0160	1xd1	120	0.0024	0.0210	1xd1	150	0.004	0.034	1xd1	160	0.004	0.035	1xd1	170	0.005	0.036	1xd1	180	0.005	0.037	1xd1	
	2.0960	CuAl9Mn2	UNS C63200																													
S ₁	Superleghe	2.4856		Inconel 625																												
		2.4668		Inconel 718																												
		2.4617	NiMo28	Hastelloy B-2	40	0.0010	0.0035	0.25xd1	40	0.0015	0.0050	0.25xd1	50	0.0020	0.0070	0.25xd1	50	0.003	0.010	0.25xd1	60	0.004	0.014	0.25xd1	80	0.004	0.018	0.25xd1	80	0.005	0.021	0.25xd1
		2.4665	NiCr22Fe18Mo	Hastelloy X																												
	Titanio puro	3.7035	Gr.2	ASTM B348 / F67	80	0.0010	0.0032	0.25xd1	90	0.0014	0.0045	0.25xd1	100	0.0018	0.0063	0.25xd1	110	0.003	0.010	0.25xd1	120	0.004	0.013	0.25xd1	120	0.004	0.016	0.25xd1	120	0.005	0.019	0.25xd1
3.7065		Gr.4	ASTM B348 / F68																													
Leghe di titanio	3.7165	TiAl6V4	ASTM B348 / F136	80	0.0010	0.0032	0.25xd1	90	0.0014	0.0045	0.25xd1	100	0.0018	0.0063	0.25xd1	110	0.003	0.010	0.25xd1	120	0.004	0.013	0.25xd1	120	0.004	0.016	0.25xd1	12				