

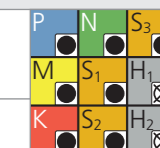
NEW

# Tipo A - Contornatura - Finitura

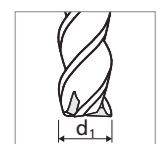
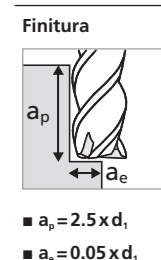
$v_c$  [m/min]  
 $f_z$  [mm]

RACCOMANDAZIONI PER L'USO

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



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



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 <sub>1</sub> 4.0 mm 5/32"		5.0 mm 3/16" - 7/32"		6.0 mm 1/4"		8.0 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																			
		1.0401	C15	AISI 1015																			
		1.1191	C45E/CK45	AISI 1045		130	0.008																
		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		130	0.007																
		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		130	0.006																	
	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	130	0.008																	
		1.4105	X6CrMoS17	AISI 430F																			
	Acciai inossidabili martensitici	1.4034	X46Cr13	AISI 420C	130	0.008																	
		1.4112	X90CrMoV18	AISI 440B																			
	Acciai inossidabili martensitici - PH	1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH	130	0.008																	
		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH																			
		1.4301	X5CrNi18-10	AISI 304																			
Acciai inossidabili austenitici	1.4435	X2CrNiMo18-14-3	AISI 316L	130	0.006																		
	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	110	0.006																	
		0.7060	GGG60	ASTM 80-60-03																			
N	Leghe d'alluminio battute	3.2315	AlMgSi1	ASTM 6351	130	0.009																	
		3.4365	AlZnMgCu1.5	ASTM 7075																			
	Leghe d'alluminio pressofuse	3.2163	GD-AlSi9Cu3	ASTM A380	130	0.009																	
		3.2381	GD-AlSi10Mg	UNS A03590																			
	Rame	2.0040	Cu-OF / CW008A	UNS C10100	130	0.010																	
		2.0065	Cu-ETP / CW004A	UNS C11000																			
	Ottoni senza piombo	2.0321	CuZn37 CW508L	UNS C27400	130	0.010																	
		2.0360	CuZn40 CW509L	UNS C28000																			
	Ottoni, Bronzi Rm < 400 N/mm <sup>2</sup>	2.0401	CuZn39Pb3 / CW614N	UNS C38500	130	0.010																	
		2.1020	CuSn6	UNS C51900																			
Bronzi Rm < 600 N/mm <sup>2</sup>	2.0966	CuAl10Ni5Fe4	UNS C63000	130	0.009																		
	2.0960	CuAl9Mn2	UNS C63200																				
S <sub>1</sub>	Superleghe	2.4856		Inconel 625																			
		2.4668		Inconel 718																			
		2.4617	NiMo28	Hastelloy B-2	110	0.004																	
		2.4665	NiCr22Fe18Mo	Hastelloy X																			
S <sub>2</sub>	Titanio puro	3.7035	Gr.2	ASTM B348 / F67	110	0.008																	
		3.7065	Gr.4	ASTM B348 / F68																			
S <sub>3</sub>	Leghe di titanio	3.7165	TiAl6V4	ASTM B348 / F136	110	0.008																	
		9.9367	TiAl6Nb7	ASTM F1295																			
H <sub>1</sub>	Acciai temprati < 55 HRC	2.4964	CoCr20W15Ni	Haynes 25	110	0.004																	
			CrCoMo28	ASTM F1537																			
H <sub>2</sub>	Acciai temprati ≥ 55 HRC	1.2510	100MnCrMoW4	AISI O1																			
		1.2379	X153CrMoV12	AISI D2																			