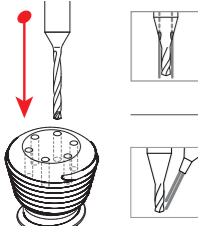
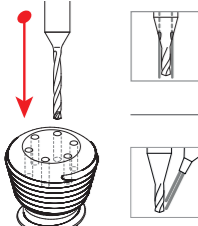
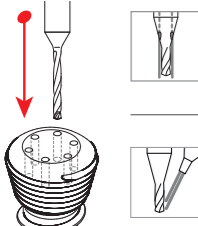
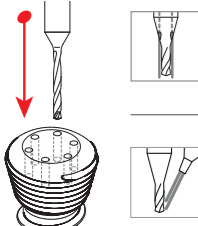
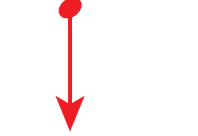
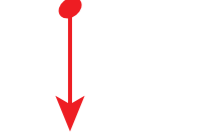
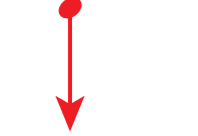


Foratura dei lobi

Gruppo materiali	Materiale	Mat. no.	DIN	AISI/ASTM/UNS	v _c [m/min]	Q ₁	Q ₂	v _c [m/min] f [mm/giro]													
								T4 Ød1 0.25 mm f	T5 Ød1 0.30 mm f	T6 Ød1 0.30 mm f	T7 Ød1 0.30 mm f	T8 Ød1 0.40 mm f	T10 Ød1 0.50 mm f	T15 Ød1 0.60 mm f	T20 Ød1 0.70 mm f	T25 Ød1 0.80 mm f	T30 Ød1 1.00 mm f				
	M Acciai inossidabili austenitici	1.4435	X2CrNiMo 18-14-3	AISI 316L	30 - 45	1-4xd1	1-2xd1														
		1.4441	X2CrNiMo 18-15-3	AISI 316LM																	
	S ₃ Leghe CrCo	2.4964	CoCr20W15Ni	Haynes 25	40 - 50	1-3xd1	1-2xd1														
			CrCoMo28	ASTM F1537																	
	M Acciai inossidabili austenitici	1.4435	X2CrNiMo 18-14-3	AISI 316L	25 - 30	0.5-1xd1	0.5xd1														
		1.4441	X2CrNiMo 18-15-3	AISI 316LM																	
	S ₃ Leghe CrCo	2.4964	CoCr20W15Ni	Haynes 25	25 - 35	0.5-1xd1	0.5xd1														
			CrCoMo28	ASTM F1537																	

Pre-foratura

Gruppo materiali	Materiale	Mat. no.	DIN	AISI/ASTM/UNS	v _c [m/min]	v _c [m/min] f [mm/giro]															
						T4 Ød1 0.9 mm f	T5 Ød1 1.0 mm f	T6 Ød1 1.2 mm f	T7 Ød1 1.4 mm f	T8 Ød1 1.6 mm f	T10 Ød1 1.9 mm f	T15 Ød1 2.3 mm f	T20 Ød1 2.7 mm f	T25 Ød1 3.1 mm f	T30 Ød1 3.8 mm f						
	M Acciai inossidabili austenitici	1.4435	X2CrNiMo 18-14-3	AISI 316L	25 - 35																
		1.4441	X2CrNiMo 18-15-3	AISI 316LM																	
	S ₂ Leghe di titanio	3.7165	TiAl6V4	ASTM B348 / F136	20 - 30																
		9.9367	TiAl6Nb7	ASTM F1295																	
	S ₃ Leghe CrCo	2.4964	CoCr20W15Ni	Haynes 25	25 - 35																
			CrCoMo28	ASTM F1537																	