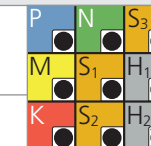


Tipo B - Sgrossatura

V_c [m/min]
f_z [mm]

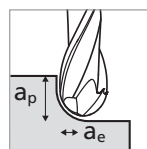
RACCOMANDAZIONI PER L'USO

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



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

Sgrossatura

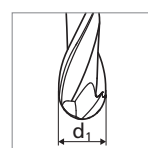
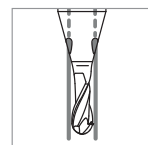


■ a_p = 0.5 x d_i
(Ød_i < 0.5 mm)

■ a_p = 1 x d_i
(Ød_i > 0.5 mm)

■ a_e = 0.3 x d_i

Angolo di lavoro = 0°



Gruppo materiali	Materiale	Mat. no.	DIN	AISI/ASTM/UNS	0.3 mm–0.4 mm 1/64"		0.5 mm–0.8 mm 1/32"		1.0 mm–1.2 mm		Ød1 1.5 mm–1.8 mm 1/16"		2.0 mm–2.5 mm 3/32"		3.0 mm 1/8"		4.0 mm–6.0 mm 5/32–3/16–7/32–1/4"		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 ²	1.0301	C10	AISI 1010	60	0.005–0.007																
		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 ²	1.5752	15NiCr13	ASTM 3415 / AISI 3310	60	0.004–0.006																
		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 ²	1.2379	X153CrMoV12	AISI D2	60	0.004–0.006																
		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	60	0.005–0.007																
		1.4105	X6CrMoS17	AISI 430F																		
		1.4034	X46Cr13	AISI 420C																		
	Acciai inossidabili martensitici	1.4112	X90CrMoV18	AISI 440B	60	0.004–0.006																
		1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH																		
		1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH																		
	Acciai inossidabili martensitici - PH	1.4301	X5CrNi 18-10	AISI 304	60	0.004–0.006																
		1.4435	X2CrNiMo 18-14-3	AISI 316L																		
Acciai inossidabili austenitici	1.4441	X2CrNiMo 18-15-3	AISI 316LM	60	0.004–0.006																	
	1.4539	X1NiCrMoCu 25-20-5	AISI 904L																			
K	Ghise	0.6020	GG20	ASTM 30	60	0.003–0.005																
		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	60	0.006–0.008																
		3.4365	AlZnMgCu1.5	ASTM 7075																		
	Leghe d'alluminio pressofuse	3.2163	GD-AlSi9Cu3	ASTM A380	60	0.006–0.008																
		3.2381	GD-AlSi10Mg	UNS A03590																		
	Rame	2.004	Cu-OF / CW008A	UNS C10100	60	0.006–0.008																
		2.0065	Cu-ETP / CW004A	UNS C11000																		
	Ottoni senza piombo	2.0321	CuZn37 CW508L	UNS C27400	60	0.006–0.008																
		2.036	CuZn40 CW509L	UNS C28000																		
	Ottoni, Bronzi Rm < 400 N/mm ²	2.0401	CuZn39Pb3 / CW614N	UNS C38500	60	0.006–0.008																
		2.102	CuSn6	UNS C51900																		
Bronzi Rm < 600 N/mm ²	2.0966	CuAl10Ni5Fe4	UNS C63000	60	0.006–0.008																	
	2.096	CuAl9Mn2	UNS C63200																			
S ₁	Superleghe	2.4856		Inconel 625	60	0.003–0.004																
		2.4668		Inconel 718																		
		2.4617	NiMo28	Hastelloy B-2																		
		2.4665	NiCr22Fe18Mo	Hastelloy X																		
S ₂	Titanio puro	3.7035	Gr.2	ASTM B348 / F67	60	0.004–0.006																
		3.7065	Gr.4	ASTM B348 / F68																		
S ₂	Leghe di titanio	3.7165	TiAl6V4	ASTM B348 / F136	60	0.004–0.006																
		9.9367	TiAl6Nb7	ASTM F1295																		
S ₃	Leghe CrCo	2.4964	CoCr20W15Ni CrCoMo28	Haynes 25 ASTM F1537	60	0.003–0.004																
H ₁	Acciai temprati < 55 HRC	1.2510	100MnCrMoW4	AISI O1	60	0.004–0.006																
H ₂	Acciai temprati ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2																		