

NEW

Tipo B - Finitura

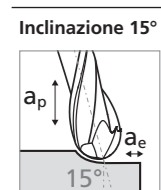
v_c [m/min]
 f_z [mm]

RACCOMANDEZIONI PER L'USO

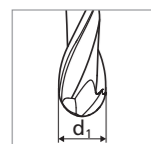
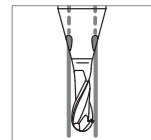
● Perfettamente consigliato | ● Consigliato | ○ Parzialmente consigliato | ☒ Non consigliato



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



■ $a_p = 0.1 \times d$
■ $a_e = 0.05 - 0.1 \times d$
 $n_{max} = 60'000$ rpm



Gruppo materiali	Materiale	Mat. no.	DIN	AISI/ASTM/UNS	1.0 mm		1.2 mm		1.5 mm 1/16"		1.8 mm		Ød1 2.0 mm		2.5 mm 3/32"		3.0 mm 1/8"		4.0 mm 5/32"		5.0 mm 3/16"		6.0 mm–8.0 mm 7/32–1/4"			
					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	v_c	f_z	v_c	f_z	v_c	f_z
					P	Acciai non legati Rm < 800 N/mm²	1.0301 1.0401 1.1191 1.0044 1.0715 1.5752	C10 C15 C45E/CK45 S275JR 11Mn30 15NiCr13	AISI 1010 AISI 1015 AISI 1045 AISI 1020 AISI 1215 ASTM 3415 / AISI 3310	140	0.015	140	0.017	200	0.024	200	0.026	220	0.034	220	0.036	240	0.040	260	0.044	260
	Acciai debolmente legati Rm > 900 N/mm²	1.7131 1.3505 1.7225 1.2842 1.2379	16MnCr5 100Cr6 42CrMo4 90MnCrV8 X153CrMoV12	AISI 5115 AISI 52100 AISI 4140 AISI O2 AISI D2	140	0.014	140	0.016	200	0.022	200	0.024	220	0.032	220	0.034	240	0.039	260	0.042	260	0.042	260	0.045		
	Acciai da utensili fortemente legati Rm < 1200 N/mm²	1.2436 1.3343 1.3355	X210CrW12 HS6-5-2C HS18-0-1	AISI D4/D6 AISI M2 / UNS T11302 AISI T1 / UNS T12001	140	0.011	140	0.013	200	0.020	200	0.022	220	0.030	220	0.032	240	0.035	260	0.037	260	0.037	260	0.039		
M	Acciai inossidabili ferritici	1.4016 1.4105	X6Cr17 X6CrMoS17	AISI 430 / UNS S43000 AISI 430F	140	0.016	140	0.018	200	0.024	200	0.026	220	0.034	220	0.036	240	0.039	260	0.042	260	0.042	260	0.045		
	Acciai inossidabili martensitici	1.4034 1.4112	X46Cr13 X90CrMoV18	AISI 420C AISI 440B	140	0.015	140	0.017	200	0.022	200	0.024	220	0.032	220	0.034	240	0.039	260	0.040	260	0.040	260	0.043		
	Acciai inossidabili martensitici - PH	1.4542 1.4545	X5CrNiCuNb16-4 X5CrNiCuNb15-5	AISI 630 / ASTM 17-4 PH ASTM 15-5 PH	140	0.015	140	0.017	200	0.022	200	0.024	220	0.032	220	0.034	240	0.039	260	0.040	260	0.040	260	0.043		
	Acciai inossidabili austenitici	1.4301 1.4435 1.4441 1.4539	X5CrNi18-10 X2CrNiMo18-14-3 X2CrNiMo18-15-3 X1NiCrMoCu25-20-5	AISI 304 AISI 316L AISI 316LM AISI 904L	140	0.012	140	0.014	200	0.016	200	0.018	220	0.030	220	0.032	240	0.035	260	0.039	260	0.039	260	0.041		
K	Ghise	0.6020 0.6030 0.7040 0.7060	GG20 GG30 GGG40 GGG60	ASTM 30 ASTM 40B ASTM 60-40-18 ASTM 80-60-03	120	0.011	120	0.022	140	0.024	140	0.026	160	0.028	160	0.036	180	0.038	200	0.044	200	0.046	200	0.049		
N	Leghe d'alluminio battute	3.2315 3.4365	AlMgSi1 AlZnMgCu1.5	ASTM 6351 ASTM 7075	140	0.018	140	0.020	200	0.026	200	0.028	220	0.036	220	0.040	240	0.051	260	0.053	260	0.053	260	0.056		
	Leghe d'alluminio pressofuse	3.2163 3.2381	GD-AlSi9Cu3 GD-AlSi10Mg	ASTM A380 UNS A03590	140	0.018	140	0.020	200	0.026	200	0.028	220	0.036	220	0.040	240	0.051	260	0.053	260	0.053	260	0.056		
	Rame	2.0040 2.0065	Cu-OF / CW008A Cu-ETP / CW004A	UNS C10100 UNS C11000	140	0.020	140	0.022	200	0.026	200	0.028	220	0.036	220	0.040	240	0.051	260	0.053	260	0.053	260	0.056		
	Ottoni senza piombo	2.0321 2.0360	CuZn37 CW508L CuZn40 CW509L	UNS C27400 UNS C28000	140	0.020	140	0.022	200	0.026	200	0.028	220	0.036	220	0.040	240	0.051	260	0.053	260	0.053	260	0.056		
	Ottoni, Bronzi Rm < 400 N/mm²	2.0401 2.1020	CuZn39Pb3 / CW614N CuSn6	UNS C38500 UNS C51900	140	0.020	140	0.022	200	0.026	200	0.028	220	0.036	220	0.040	240	0.051	260	0.053	260	0.053	260	0.056		
	Bronzi Rm < 600 N/mm²	2.0966 2.0960	CuAl10Ni5Fe4 CuAl9Mn2	UNS C63000 UNS C63200	140	0.018	140	0.020	200	0.026	200	0.028	220	0.036	220	0.040	240	0.051	260	0.053	260	0.053	260	0.056		
S₁	Superleghe	2.4856 2.4668 2.4617 2.4665	 NiMo28 NiCr22Fe18Mo	Inconel 625 Inconel 718 Hastelloy B-2 Hastelloy X	120	0.007	120	0.008	130	0.009	130	0.010	140	0.010	140	0.012	150	0.013	170	0.018	170	0.018	170	0.019		
S₂	Titanio puro	3.7035 3.7065	Gr.2 Gr.4	ASTM B348 / F67 ASTM B348 / F68	120	0.016	120	0.018	130	0.020	130	0.022	140	0.028	140	0.030	150	0.035	170	0.039	170	0.039	170	0.041		
	Leghe di titanio	3.7165 9.9367	TiAl6V4 TiAl6Nb7	ASTM B348 / F136 ASTM F1295	120	0.016	120	0.018	130	0.020	130	0.022	140	0.028	140	0.030	150	0.035	170	0.039	170	0.039	170	0.041		
S₃	Leghe CrCo	2.4964	CoCr20W15Ni CrCoMo28	Haynes 25 ASTM F1537	140	0.007	140	0.008	180	0.009	180	0.010	200	0.010	200	0.012	220	0.013	240	0.018	240	0.018	240	0.019		
H₁	Acciai temprati < 55 HRC	1.2510	100MnCrMoW4	AISI O1	100	0.010	100	0.012	140	0.014	140	0.018	180	0.020	180	0.026	200	0.029	240	0.035	240	0.035	240	0.037		
H₂	Acciai temprati ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2																						