

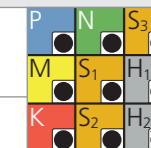
NEW

Tipo N - Semi-finitura

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

RACCOMANDAZIONI PER L'USO

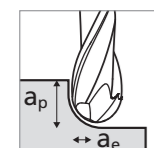
● Perfettamente consigliato | ● Consigliato | ○ Parzialmente consigliato | ☒ Non consigliato



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

Possibilità 1

Inclinazione 0°

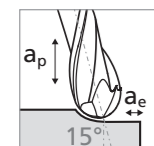


■  $a_p = 0.5 \times d$

■  $a_e = 0.2 \times d$

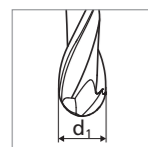
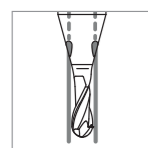
Possibilità 2

Inclinazione 15°



■  $a_p = 0.5 \times d$

■  $a_e = 0.2 \times d$



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	C10	AISI 1010																							
		1.0401	C15	AISI 1015																							
		1.1191	C45E/CK45	AISI 1045		140	0.013	140	0.014																		
		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		140	0.012	140	0.014																		
		1.7225	42CrMo4	AISI 4140																							
		1.2842	90MnCrV8	AISI O2																							
Acciai da utensili fortemente legati Rm < 1200 N/mm²		1.2379	X153CrMoV12	AISI D2																							
	1.2436	X210CrW12	AISI D4/D6																								
	1.3343	HS6-5-2C	AISI M2 / UNS T11302		140	0.009	140	0.011																			
	1.3355	HS18-0-1	AISI T1 / UNS T12001																								
M	Acciai inossidabili ferritici	1.4016	X6Cr17	AISI 430 / UNS S43000		140	0.014	140	0.015																		
		1.4105	X6CrMoS17	AISI 430F																							
		1.4034	X46Cr13	AISI 420C		140	0.013	140	0.014																		
	Acciai inossidabili martensitici	1.4112	X90CrMoV18	AISI 440B																							
		1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH		140	0.013	140	0.014																		
	Acciai inossidabili martensitici - PH	1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH																							
		1.4301	X5CrNi18-10	AISI 304																							
		1.4435	X2CrNiMo18-14-3	AISI 316L		140	0.010	140	0.012																		
K	Ghise	1.4441	X2CrNiMo18-15-3	AISI 316LM																							
		1.4539	X1NiCrMoCu25-20-5	AISI 904L																							
		0.6020	GG20	ASTM 30																							
		0.6030	GG30	ASTM 40B																							
		0.7040	GGG40	ASTM 60-40-18		120	0.009	120	0.019																		
N	Leghe d'alluminio battute Leghe d'alluminio pressofuse Rame Ottoni senza piombo Ottoni, Bronzi Rm < 400 N/mm² Bronzi Rm < 600 N/mm²	0.7060	GGG60	ASTM 80-60-03																							
		3.2315	AlMgSi1	ASTM 6351		140	0.015	140	0.017																		
		3.4365	AlZnMgCu1.5	ASTM 7075																							
		3.2163	GD-AlSi9Cu3	ASTM A380																							
		3.2381	GD-AlSi10Mg	UNS A03590		140	0.015	140	0.017																		
		2.0040	Cu-OF / CW008A	UNS C10100																							
		2.0065	Cu-ETP / CW004A	UNS C11000		140	0.017	140	0.019																		
		2.0321	CuZn37 CW508L	UNS C27400																							
		2.0360	CuZn40 CW509L	UNS C28000		140	0.017	140	0.019																		
		2.0401	CuZn39Pb3 / CW614N	UNS C38500																							
S1	Superleghe	2.1020	CuSn6	UNS C51900		140	0.017	140	0.019																		
		2.0966	CuAl10Ni5Fe4	UNS C63000																							
		2.0960	CuAl9Mn2	UNS C63200		140	0.015	140	0.017																		
		2.4856		Inconel 625																							
S2	Titanio puro	2.4668		Inconel 718																							
		2.4617	NiMo28	Hastelloy B-2		120	0.006	120	0.007																		
		2.4665	NiCr22Fe18Mo	Hastelloy X																							
		3.7035	Gr.2	ASTM B348 / F67																							
S3	Leghe di titanio	3.7065	Gr.4	ASTM B348 / F68		120	0.014	120	0.015																		
		3.7165	TiAl6V4	ASTM B348 / F136																							
H1	Acciai temprati < 55 HRC	9.9367	TiAl6Nb7	ASTM F1295		120	0.014	120	0.015																		
		2.4964	CoCr20W15Ni	Haynes 25																							
H2	Acciai temprati ≥ 55 HRC		CrCoMo28	ASTM F1537		140	0.006	140	0.007																		
		1.2510	100MnCrMoW4	AISI O1		100	0.009	100	0.010																		
		1.2379	X153CrMoV12	AISI D2																							