

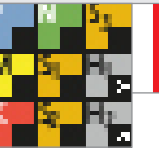
**NEW**

# Tipo C - Z3 - Contornatura - Sgrossatura

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

RACCOMANDAZIONI PER L'USO

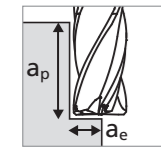
● Perfettamente consigliato | ● Consigliato | ○ Parzialmente consigliato | ✗ Non consigliato



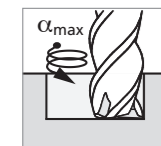
## FRESARE CON RAFFREDDAMENTO INTEGRATO | VISTA D'INSIEME DEI DATI DI TAGLIO

**Contornatura**

**Sgrossatura**

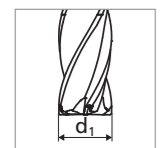
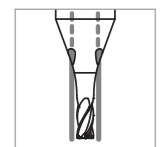


■  $a_p = 1 \times d_1$   
■  $a_e = 0.1 \times d_1$



**Nota:**

In caso di fresatura con interpolazione elicoidale vedere  $\alpha_{max}$  alla pagina 35



Gruppo materiali	Materiale	Mat. no.	DIN	AISI/ASTM/UNS	Geometria di taglio	0.2 mm		0.3 mm		0.4 mm 1/64"		0.5 mm		$\phi_{d1}$ 0.6 mm		0.7 mm		0.8 mm 1/32"		0.9 - 1.0 mm		
						$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$	
<b>P</b>	Acciai non legati Rm < 800 N/mm <sup>2</sup>	1.0301	C10	AISI 1010	<b>GEOMETRIA S</b>		15 - 25	0.004	20 - 40	0.006	25 - 50	0.010	30 - 65	0.012	40 - 75	0.014	45 - 90	0.017	50 - 100	0.019	55 - 115	0.021
		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 <sup>2</sup>	1.5752	15NiCr13	ASTM 3415 / AISI 3310																		
		1.7131	16MnCr5	AISI 5115																		
		1.3505	100Cr6	AISI 52100																		
		1.7225	42CrMo4	AISI 4140																		
		1.2842	90MnCrV8	AISI O2																		
Acciai da utensili forte-mente legati Rm < 1200 N/mm <sup>2</sup>	1.2379	X153CrMoV12	AISI D2																			
	1.2436	X210CrW12	AISI D4/D6																			
	1.3343	HS6-5-2C	AISI M2 / UNS T11302																			
	1.3355	HS18-0-1	AISI T1 / UNS T12001																			
	<b>M</b>	Acciai inossidabili ferritici	1.4016	X6Cr17	AISI 430 / UNS S43000	<b>GEOMETRIA S</b>		15 - 25	0.004	20 - 40	0.006	25 - 50	0.010	30 - 65	0.012	40 - 75	0.014	45 - 90	0.017	50 - 100	0.019	55 - 115
1.4105			X6CrMoS17	AISI 430F																		
Acciai inossidabili martensitici		1.4034	X46Cr13	AISI 420C																		
		1.4112	X90CrMoV18	AISI 440B																		
Acciai inossidabili mar-tensitici - PH		1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH																		
		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH																		
Acciai inossidabili austenitici		1.4301	X5CrNi18-10	AISI 304																		
		1.4435	X2CrNiMo18-14-3	AISI 316L																		
	1.4441	X2CrNiMo18-15-3	AISI 316LM																			
<b>K</b>	Ghise	0.6020	GG20	ASTM 30	<b>GEOMETRIA S</b>		15 - 25	0.003	20 - 40	0.005	25 - 50	0.007	30 - 65	0.009	40 - 75	0.011	45 - 90	0.013	50 - 100	0.015	55 - 115	0.017
		0.6030	GG30	ASTM 40B																		
		0.7040	GGG40	ASTM 60-40-18																		
		0.7060	GGG60	ASTM 80-60-03																		
		<b>N</b>	Leghe d'alluminio battute	3.2315																		
3.4365	AlZnMgCu1.5			ASTM 7075																		
Leghe d'alluminio pressofuse	3.2163		GD-AlSi9Cu3	ASTM A380																		
	3.2381		GD-AlSi10Mg	UNS A03590																		
Rame	2.0040		Cu-OF / CW008A	UNS C10100																		
	2.0065		Cu-ETP / CW004A	UNS C11000																		
Ottoni senza piombo	2.0321		CuZn37 CW508L	UNS C27400																		
	2.0360		CuZn40 CW509L	UNS C28000																		
Ottoni, Bronzi Rm < 400 N/mm <sup>2</sup>	2.0401		CuZn39Pb3 / CW614N	UNS C38500																		
	2.1020		CuSn6	UNS C51900																		
Bronzi Rm < 600 N/mm <sup>2</sup>	2.0966	CuAl10Ni5Fe4	UNS C63000																			
	2.0960	CuAl9Mn2	UNS C63200																			
<b>S<sub>1</sub></b>	Superleghe	2.4856		Inconel 625	<b>GEOMETRIA SX</b>		15 - 25	0.002	20 - 40	0.004	25 - 50	0.006	30 - 65	0.008	40 - 75	0.009	45 - 90	0.010	50 - 100	0.012	55 - 115	0.014
		2.4668		Inconel 718																		
		2.4617	NiMo28	Hastelloy B-2																		
		2.4665	NiCr22Fe18Mo	Hastelloy X																		
<b>S<sub>2</sub></b>	Titanio puro	3.7035	Gr.2	ASTM B348 / F67	<b>GEOMETRIA S</b>		15 - 25	0.004	20 - 40	0.006	25 - 50	0.008	30 - 65	0.012	40 - 75	0.013	45 - 90	0.014	50 - 100	0.015	55 - 115	0.017
		3.7065	Gr.4	ASTM B348 / F68																		
<b>S<sub>2</sub></b>	Leghe di titanio	3.7165	TiAl6V4	ASTM B348 / F136	<b>GEOMETRIA S</b>		15 - 25	0.003	20 - 40	0.005	25 - 50	0.007	30 - 65	0.009	40 - 75	0.011	45 - 90	0.013	50 - 100	0.015	55 - 115	0.017
		9.9367	TiAl6Nb7	ASTM F1295																		
<b>S<sub>3</sub></b>	Leghe CoCr	2.4964	CoCr20W15Ni CrCoMo28	Haynes 25 ASTM F1537	<b>GEOMETRIA SX</b>		15 - 25	0.002	20 - 40	0.004	25 - 50	0.006	30 - 65	0.008	40 - 75	0.009	45 - 90	0.010	50 - 100	0.012	55 - 115	0.014
<b>H<sub>1</sub></b> <b>H<sub>2</sub></b>	Acciai temprati < 55 HRC	1.2510	100MnCrMoW4	AISI O1																		
	Acciai temprati ≥ 55 HRC	1.2379	X153CrMoV12	AISI D2																		