

NEW

Tipo C - Fresatura a tuffo - Cave

v_c [m/min] a_p [mm]
 $f_{z,p}$ [mm] $f_{z,s}$ [mm]

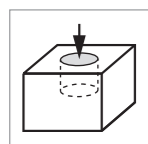
RACCOMANDAZIONI PER L'USO

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

P	N	S ₃
M	S ₁	H ₁
K	S ₂	H ₂

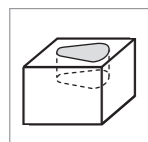
FRESARE CON RAFFREDDAMENTO INTEGRATO | VISTA D'INSIEME DEI DATI DI TAGLIO

Fresatura a tuffo



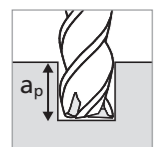
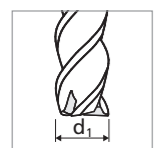
■ $f_{z,p}$: per fresatura a tuffo

Fresatura di cave



■ $f_{z,p}$: per fresatura a tuffo

■ $f_{z,s}$: per fresatura cave



Gruppo materiali	Materiale	Mat. no.	DIN	AISI/ASTM/UNS	1.0 mm				1.5 mm 1/16"				2.0 mm 3/32"				3.0 mm 1/8"				4.0 mm 5/32"				5.0 mm 3/16" - 7/32"				6.0 mm - 8.0 mm 1/4"									
					v_c	$f_{z,p}$	$f_{z,s}$	a_p	v_c	$f_{z,p}$	$f_{z,s}$	a_p	v_c	$f_{z,p}$	$f_{z,s}$	a_p	v_c	$f_{z,p}$	$f_{z,s}$	a_p	v_c	$f_{z,p}$	$f_{z,s}$	a_p	v_c	$f_{z,p}$	$f_{z,s}$	a_p	v_c	$f_{z,p}$	$f_{z,s}$	a_p						
P	Acciai non legati Rm < 800 N/mm ²	1.0301	C10	AISI 1010																																		
		1.0401	C15	AISI 1015																																		
		1.1191	C45E/CK45	AISI 1045		100	0.0013	0.0046	0.5xd1																													
		1.0044	S275JR	AISI 1020																																		
	Acciai debolmente legati Rm > 900 N/mm ²	1.0715	11SMn30	AISI 1215																																		
		1.5752	15NiCr13	ASTM 3415 / AISI 3310																																		
		1.7131	16MnCr5	AISI 5115																																		
		1.3505	100Cr6	AISI 52100		100	0.0014	0.0049	0.5xd1																													
		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																																		
		1.2436	X210CrW12	AISI D4/D6																																		
1.3343		HS6-5-2C	AISI M2 / UNS T11302		100	0.0012	0.0042	0.25xd1																														
1.3355		HS18-0-1	AISI T1 / UNS T12001																																			
M	Acciai inossidabili ferritici	1.4016	X6Cr17	AISI 430 / UNS S43000		100	0.0010	0.0035	0.5xd1																													
		1.4105	X6CrMoS17	AISI 430F																																		
	Acciai inossidabili martensitici	1.4034	X46Cr13	AISI 420C		100	0.0010	0.0035	0.25xd1																													
		1.4112	X90CrMoV18	AISI 440B																																		
	Acciai inossidabili martensitici - PH	1.4542	X5CrNiCuNb16-4	AISI 630 / ASTM 17-4 PH		100	0.0010	0.0035	0.25xd1																													
		1.4545	X5CrNiCuNb15-5	ASTM 15-5 PH																																		
	Acciai inossidabili austenitici	1.4301	X5CrNi18-10	AISI 304																																		
		1.4435	X2CrNiMo18-14-3	AISI 316L		100	0.0010	0.0035	0.5xd1																													
1.4441		X2CrNiMo18-15-3	AISI 316LM																																			
1.4539	X1NiCrMoCu25-20-5	AISI 904L																																				
K	Ghise	0.6020	GG20	ASTM 30																																		
		0.6030	GG30	ASTM 40B																																		
		0.7040	GGG40	ASTM 60-40-18		100	0.0013	0.0042	0.5xd1																													
		0.7060	GGG60	ASTM 80-60-03																																		
N	Leghe d'alluminio battute	3.2315	AlMgSi1	ASTM 6351		100	0.0012	0.0100	0.5xd1																													
		3.4365	AlZnMgCu1.5	ASTM 7075																																		
	Leghe d'alluminio pressofuse	3.2163	GD-ALSi9Cu3	ASTM A380		100	0.0012	0.0100	0.5xd1																													
		3.2381	GD-ALSi10Mg	UNS A03590																																		
	Rame	2.0040	Cu-OF / CW008A	UNS C10100		100	0.0012	0.0100	0.5xd1																													
		2.0065	Cu-ETP / CW004A	UNS C11000																																		
	Ottoni senza piombo	2.0321	CuZn37 CW508L	UNS C27400		100	0.0012	0.0100	0.5xd1																													
		2.0360	CuZn40 CW509L	UNS C28000																																		
Ottoni, Bronzi Rm < 400 N/mm ²	2.0401	CuZn39Pb3 / CW614N	UNS C38500		100	0.0012	0.0100	0.5xd1																														
	2.1020	CuSn6	UNS C51900																																			
Bronzi Rm < 600 N/mm ²	2.0966	CuAl10Ni5Fe4	UNS C63000		100	0.0012	0.0100	0.5xd1																														
	2.0960	CuAl9Mn2	UNS C63200																																			
S ₁	Superleghe	2.4856		Inconel 625																																		
		2.4668		Inconel 718																																		
		2.4617	NiMo28	Hastelloy B-2		40	0.0010	0.0035	0.25xd1																													
		2.4665	NiCr22Fe18Mo	Hastelloy X																																		
S ₂	Titanio puro	3.7035	Gr.2	ASTM B348 / F67		80	0.0010	0.0032	0.25xd1																													
		3.7065	Gr.4	ASTM B348 / F68																																		
S ₃	Leghe di titanio	3.7165	TiAl6V4	ASTM B348 / F136		80	0.0010	0.0032	0.25xd1																													
		9.9367	TiAl6Nb7	ASTM F1295																																		
H ₁	Acciai temprati < 55 HRC	2.4964	CoCr20W15Ni	Haynes 25		60	0.0010	0.0035	0.25xd1																													
			CrCoMo28	ASTM F1537																																		
H ₂	Acciai temprati ≥ 55 HRC	1.2510	100MnCrMoW4	AISI O1																																		
		1.2379	X153CrMoV12	AISI D2																																		