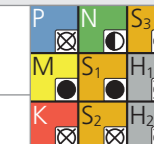


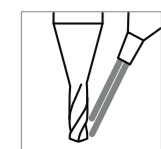
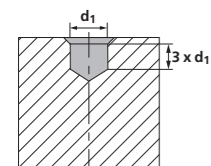
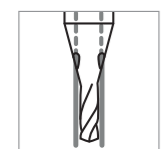
3 x d - svasatura 90°

RACCOMANDAZIONI PER L'USO

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



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



Nota:
Per raffreddamento esterno ridurre v_c ed f del 20%

Gruppo materiali	Materiale	Mat. no.	DIN	AISI/ASTM/UNS	v _c [m/min]	f [mm/giro]									
						0.2 mm f	0.5 mm 1/64" f	0.8 mm 1/32" f	1.0 mm f	Ød ₁ 1.2 mm f	1.2 mm f	1.6 mm 1/16" f	1.8 mm f	2.0 mm f	
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											
		1.0044	S275JR	AISI 1020											
		1.0715	11SMn30	AISI 1215											
		1.5752	15NiCr13	ASTM 3415 / AISI 3310											
	Acciai debolmente legati Rm > 900 N/mm ²	1.7131	16MnCr5	AISI 5115											
		1.3505	100Cr6	AISI 52100											
		1.7225	42CrMo4	AISI 4140											
		1.2842	90MnCrV8	AISI O2											
		1.2379	X153CrMoV12	AISI D2											
		1.2436	X210CrW12	AISI D4/D6											
	Acciai da utensili fortemente legati Rm < 1200 N/mm ²	1.3343	HS6-5-2C	AISI M2 / UNS T11302											
1.3355		HS18-0-1	AISI T1 / UNS T12001												
Acciai inossidabili ferritici		1.4016	X6Cr17	AISI 430 / UNS S43000	35 - 50	0.015	0.020	0.030	0.035	0.040	0.050	0.055	0.060	0.070	
		1.4105	X6CrMoS17	AISI 430F											
Acciai inossidabili martensitici		1.4034	X46Cr13	AISI 420C	35 - 50	0.020	0.030	0.040	0.055	0.060	0.070	0.075	0.080	0.100	
		1.4112	X90CrMoV18	AISI 440B											
Acciai inossidabili martensitici - PH	1.4542	X5CrNiCuNb 16-4	AISI 630 / ASTM 17-4 PH	35 - 50	0.015	0.020	0.025	0.030	0.040	0.050	0.055	0.060	0.070		
	1.4545	X5CrNiCuNb 15-5	ASTM 15-5 PH												
Acciai inossidabili austenitici	1.4301	X5CrNi 18-10	AISI 304												
	1.4435	X2CrNiMo 18-14-3	AISI 316L	30 - 45	0.010	0.020	0.025	0.030	0.035	0.045	0.050	0.055	0.060		
	1.4441	X2CrNiMo 18-15-3	AISI 316LM												
	1.4539	X1NiCrMoCu 25-20-5	AISI 904L												
K	Ghise	0.6020	GG20	ASTM 30											
		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											
		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	40 - 100	0.040	0.060	0.080	0.090	0.100	0.120	0.140	0.160	0.180	
		2.0065	Cu-ETP / CW004A	UNS C11000											
	Ottoni senza piombo	2.0321	CuZn37 CW508L	UNS C27400	40 - 100	0.040	0.060	0.080	0.090	0.100	0.120	0.140	0.160	0.180	
		2.0360	CuZn40 CW509L	UNS C28000											
Ottoni, Bronzi Rm < 400 N/mm ²	2.0401	CuZn39Pb3 / CW614N	UNS C38500												
	2.1020	CuSn6	UNS C51900												
Bronzi Rm < 600 N/mm ²	2.0966	CuAl10Ni5Fe4	UNS C63000												
	2.0960	CuAl9Mn2	UNS C63200												
S ₁	Superleghe	2.4856		Inconel 625	15 - 30	0.010	0.015	0.020	0.022	0.025	0.035	0.037	0.045	0.055	
		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											
		3.7065	Gr.4	ASTM B348 / F68											
S ₃	Leghe di titanio	3.7165	TiAl6V4	ASTM B348 / F136											
		9.9367	TiAl6Nb7	ASTM F1295											
H ₁	Acciai temprati < 55 HRC	2.4964	CoCr20W15Ni	Haynes 25	40 - 50	0.020	0.030	0.040	0.055	0.060	0.070	0.075	0.080	0.100	
			CrCoMo28	ASTM F1537											
H ₂	Acciai temprati ≥ 55 HRC	1.2510	100MnCrMoW4	AISI O1											
		1.2379	X153CrMoV12	AISI D2											