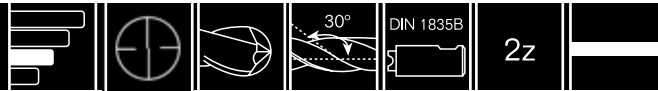


# 3112 HSSE DIN ~1889 N

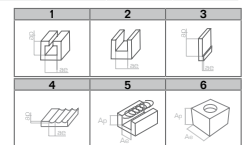


| Vc<br>(m/min) | P                  |                      |        |        | M                  |        | K                  |                    |        | N     |                  |       |         | S              |       | H      |        |        |
|---------------|--------------------|----------------------|--------|--------|--------------------|--------|--------------------|--------------------|--------|-------|------------------|-------|---------|----------------|-------|--------|--------|--------|
|               | <800<br>●<br>30-50 | <1.000<br>○<br>25-30 | <1.200 | <1.400 | <950<br>○<br>15-20 | <1.200 | <500<br>○<br>34-38 | <800<br>○<br>20-24 | <1.400 | Al    | Cu<br>○<br>45-90 | Mg/Zn | Plastic | Ni<br>○<br>2-4 | Ti    | 50 HRC | 55 HRC | 60 HRC |
| K             | 1                  | 1                    | 0,7    | 0,7    | 0,7                | 1      | 1                  | 1                  | 0,7    | 1,3   | 1                | 1     | 1,3     | 0,7            | 0,7   | 0,7    | 0,7    | 0,7    |
| Z             | Ap                 | Ae                   | Ø1     | Ø2     | Ø3                 | Ø4     | Ø5                 | Ø6                 | Ø8     | Ø10   | Ø12              | Ø14   | Ø16     | Ø18            | Ø20   | Ø25    | Ø32    | Ø40    |
|               | 1                  |                      |        |        |                    |        |                    |                    |        |       |                  |       |         |                |       |        |        |        |
|               | 2                  |                      |        |        |                    |        |                    |                    |        |       |                  |       |         |                |       |        |        |        |
|               | 3                  |                      |        |        |                    |        |                    |                    |        |       |                  |       |         |                |       |        |        |        |
|               | 4                  | 0,05xØ               | 0,05xØ |        | 0,020              | 0,022  | 0,025              | 0,029              | 0,036  | 0,044 | 0,058            | 0,062 | 0,065   | 0,073          | 0,080 | 0,100  | 0,130  |        |
|               | 5                  |                      |        |        |                    |        |                    |                    |        |       |                  |       |         |                |       |        |        |        |
|               | 6                  |                      |        |        |                    |        |                    |                    |        |       |                  |       |         |                |       |        |        |        |

vf(mm/min) = rpm x Z x fz x K  
rpm = (Vc x 1000) / (Ø x π)

● Optima / Optimun ○ Alternativo / Alternative

Fresado  
Fraisage  
Milling  
Fräsen



| Ø<br>mm | d<br>mm | L<br>mm | l<br>mm |   |
|---------|---------|---------|---------|---|
| 3,00    | 6       | 49      | 5       | 1 |
| 4,00    | 6       | 51      | 7       | 1 |
| 5,00    | 6       | 52      | 8       | 1 |
| 6,00    | 6       | 52      | 8       | 1 |
| 7,00    | 10      | 60      | 10      | 1 |
| 8,00    | 10      | 61      | 11      | 1 |
| 9,00    | 10      | 61      | 11      | 1 |
| 10,00   | 10      | 63      | 13      | 1 |
| 12,00   | 12      | 73      | 16      | 1 |

| Ø<br>mm | d<br>mm | L<br>mm | l<br>mm |   |
|---------|---------|---------|---------|---|
| 13,00   | 10      | 73      | 16      | 1 |
| 14,00   | 12      | 73      | 16      | 1 |
| 15,00   | 14      | 73      | 16      | 1 |
| 16,00   | 16      | 79      | 19      | 1 |
| 18,00   | 18      | 79      | 19      | 1 |
| 20,00   | 20      | 88      | 22      | 1 |
| 22,00   | 20      | 88      | 22      | 1 |
| 24,00   | 20      | 102     | 26      | 1 |
| 25,00   | 20      | 102     | 26      | 1 |