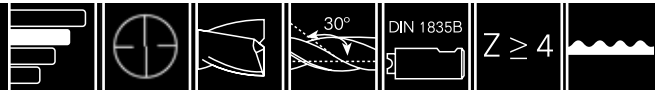


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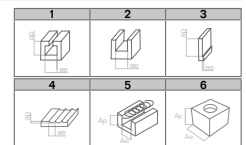


Vc (m/min)	P				M		K			N				S		H		
	<800 ● 30-50	<1.000 ○ 25-30	<1.200	<1.400	<950 ○ 15-20	<1.200	<500 ○ 34-38	<800	<1.400	Al	Cu ○ 45-90	Mg/Zn	Plastic	Ni	Ti	50 HRC	55 HRC	60 HRC
K	1	1	0,7	0,7	0,7	1	1	1	0,7	1,3	1	1	1,3	0,7	0,7	0,7	0,7	0,7
fz	Ap	Ae	Ø1	Ø2	Ø3	Ø4	Ø5	Ø6	Ø8	Ø10	Ø12	Ø14	Ø16	Ø18	Ø20	Ø25	Ø32	Ø40
	1																	
	2																	
	3	2,5xD	0,5xD		0,011	0,015	0,018	0,020	0,025	0,035	0,040	0,060	0,070	0,080	0,090	0,100	0,120	
	4																	
	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 mm	Z	d mm	L mm	l mm	
6,00	4	6	68	24	1
8,00	4	10	88	38	1
10,00	4	10	95	45	1
12,00	4	12	110	53	1
14,00	4	12	110	53	1
16,00	4	16	123	63	1
18,00	4	16	123	63	1

Ø mm	Z	d mm	L mm	l mm	
20,00	4	20	141	75	1
22,00	5	20	141	75	1
25,00	5	25	166	90	1
28,00	5	25	166	90	1
30,00	5	25	166	90	1
32,00	6	32	186	106	1