

3119/1

HSSE DIN 844 NRF

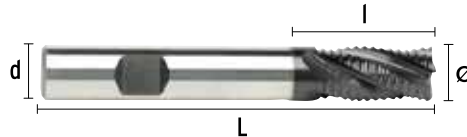
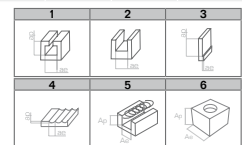


Vc (m/min)	P				M		K			N				S		H		
	<800 ● 48-80	<1.000 ○ 40-45	<1.200	<1.400	<950 ○ 25-35	<1.200	<500 ● 55-60	<800 ● 20-38	<1.400	Al	Cu	Mg/Zn	Plastic	Ni ○ 25-35	Ti	50 HRC	55 HRC	60 HRC
K	1	1	0,7	0,7	0,7	1	1	1	0,7	1,3	1	1	1,3	0,7	0,7	0,7	0,7	0,7
fz	Ap	Ae	Ø1	Ø2	Ø3	Ø4	Ø5	Ø6	Ø8	Ø10	Ø12	Ø14	Ø16	Ø18	Ø20	Ø25	Ø32	Ø40
	1																	
	2																	
	3	1,5xD	0,5xD		0,016	0,020	0,023	0,026	0,033	0,046	0,052	0,078	0,091	0,104	0,117	0,130	0,156	
	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	57	13	1
8,00	4	10	69	19	1
10,00	4	10	72	22	1
12,00	4	12	83	26	1
14,00	4	12	83	26	1

Ø mm	Z	d mm	L mm	l mm	
16,00	4	16	92	32	1
18,00	4	16	92	32	1
20,00	4	20	104	38	1
25,00	5	25	121	45	1
30,00	5	25	121	45	1

Bajo demanda / Sur commande / upon request