

3149

HSSE DIN 1880 N

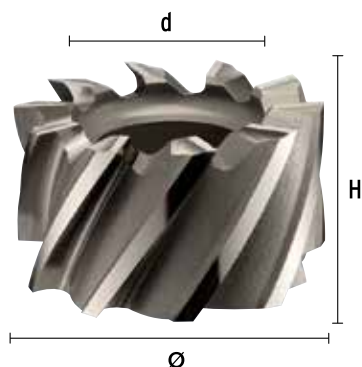
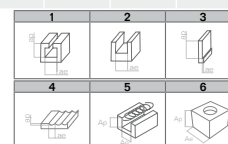


| Vc<br>(m/min) | P     |        |        |        | M     |        | K     |       |        | N   |       |       |         | S   |       | H      |        |        |
|---------------|-------|--------|--------|--------|-------|--------|-------|-------|--------|-----|-------|-------|---------|-----|-------|--------|--------|--------|
|               | <800  | <1.000 | <1.200 | <1.400 | <950  | <1.200 | <500  | <800  | <1.400 | Al  | Cu    | Mg/Zn | Plastic | Ni  | Ti    | 50 HRC | 55 HRC | 60 HRC |
| ●             | 30-40 | 15-25  |        |        | 10-15 |        |       | 20-24 |        |     | 30-35 |       |         |     | 10-15 |        |        |        |
| 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     | Ø40    | Ø50    | Ø80   | Ø100   | Ø160  | Ø200  |        |     |       |       |         |     |       |        |        |        |
|               | 1     |        |        |        |       |        |       |       |        |     |       |       |         |     |       |        |        |        |
|               | 2     |        |        |        |       |        |       |       |        |     |       |       |         |     |       |        |        |        |
|               | 3     | 0,05xD | 0,75xD | 0,080  | 0,085 | 0,110  | 0,110 |       |        |     |       |       |         |     |       |        |        |        |
|               | 4     |        |        |        |       |        |       |       |        |     |       |       |         |     |       |        |        |        |
|               | 5     |        |        |        |       |        |       |       |        |     |       |       |         |     |       |        |        |        |

$vf(\text{mm/min}) = \text{rpm} \times Z \times fz \times K$   
 $\text{rpm} = (Vc \times 1000) / (\phi \times \pi)$

● Optima / Optimun ○ Alternativo / Alternative

Fresado  
Fraisage  
Milling  
Fräsen



| Ø<br>mm | Z | d<br>mm | H<br>mm |   |
|---------|---|---------|---------|---|
| 40,00   | 6 | 16      | 32      | 1 |
| 50,00   | 8 | 22      | 36      | 1 |

| Ø<br>mm | Z  | d<br>mm | H<br>mm |   |
|---------|----|---------|---------|---|
| 63,00   | 8  | 27      | 40      | 1 |
| 80,00   | 10 | 27      | 45      | 1 |