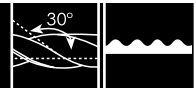


3150

HSSE DIN 1880 NR

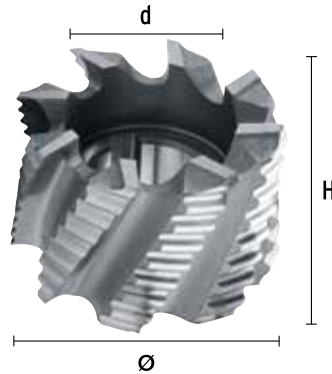
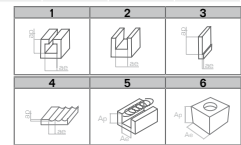


| Vc<br>(m/min) | P                  |                      |        |        | M                  |        | K                  |      |        | N   |                  |       |         | S   |                  | H      |        |        |
|---------------|--------------------|----------------------|--------|--------|--------------------|--------|--------------------|------|--------|-----|------------------|-------|---------|-----|------------------|--------|--------|--------|
|               | <800<br>●<br>35-50 | <1.000<br>●<br>25-35 | <1.200 | <1.400 | <950<br>●<br>10-20 | <1.200 | <500<br>●<br>20-30 | <800 | <1.400 | Al  | Cu<br>●<br>30-35 | Mg/Zn | Plastic | Ni  | Ti<br>●<br>15-20 | 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                   | Ø40    | Ø50    | Ø80                | Ø100   | Ø160               | Ø200 |        |     |                  |       |         |     |                  |        |        |        |
|               | 1                  |                      |        |        |                    |        |                    |      |        |     |                  |       |         |     |                  |        |        |        |
|               | 2                  |                      |        |        |                    |        |                    |      |        |     |                  |       |         |     |                  |        |        |        |
|               | 3                  | 0,05xØ               | 0,75xØ | 0,080  | 0,085              | 0,110  | 0,110              |      |        |     |                  |       |         |     |                  |        |        |        |
|               | 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<br>mm | Z | d<br>mm | H<br>mm |   | Ø<br>mm | Z | d<br>mm | H<br>mm |   |
|---------|---|---------|---------|---|---------|---|---------|---------|---|
| 40,00   | 6 | 16      | 32      | 1 | 63,00   | 8 | 27      | 40      | 1 |
| 50,00   | 8 | 22      | 36      | 1 | 80,00   | 8 | 27      | 45      | 1 |