

FRESAS HSSE ESPECIALES
FRAISES HSSE SPÉCIALES / HSSE SPECIAL MILLS / HSSE SPEZIALFRÄSER

3156

HSSE DIN 1833 B

DIN 1835B



ISO 3859

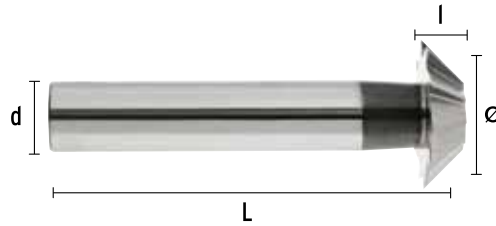
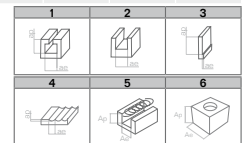
ToI
D (js16)
d (h8)

Vc (m/min)	P				M		K			N				S		H		
	<800 ● 30-40	<1.000 ● 15-25	<1.200	<1.400	<950 ●	<1.200 ●	<500 ○	<800 ○	<1.400 ○	Al ○ 60-150	Cu ● 55-95	Mg/Zn ○ 60-100	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	Ø8	Ø12	Ø16	Ø20	Ø25	Ø32	Ø45									
	1																	
	2	-	1x1	0,040	0,055	0,070	0,075	0,080	0,100									
	3																	
	4																	
	5																	
	6																	

$v_f(\text{mm/min}) = \text{rpm} \times Z \times f_z \times K$
 $\text{rpm} = (V_c \times 1000) / (\pi \times D)$

● Optima / Optimun ○ Alternativo / Alternative

Fresado
Fraisage
Milling
Fräsen



Ø mm	d mm	Ang°	L mm	l mm	Z	
16,00	12	45	60	4,00	10	1
20,00	12	45	63	5,00	10	1
25,00	12	45	67	6,30	10	1
32,00	16	45	71	8,00	12	1

Ø mm	d mm	Ang°	L mm	l mm	Z	
16,00	12	60	60	6,30	10	1
20,00	12	60	63	8,00	10	1
25,00	12	60	67	10,00	10	1
32,00	16	60	71	12,50	12	1