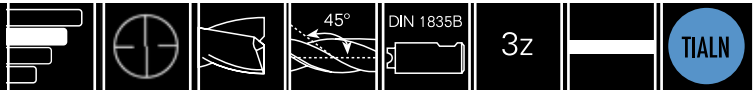


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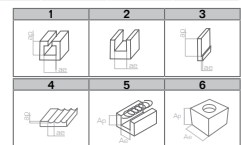


Vc (m/min)	P				M		K			N				S		H		
	<800	<1.000	<1.200	<1.400	<950	<1.200	<500	<800	<1.400	Al	Cu	Mg/Zn	Plastic	Ni	Ti	50 HRC	55 HRC	60 HRC
30-50										60-150		60-100	50-150					
K	1	1	0,7	0,7	0,7	1	1	1	0,7	1,3	1	1	1,3	0,7	0,7	0,7	0,7	0,7
fz	Ap	Ae	Ø1	Ø2	Ø3	Ø4	Ø5	Ø6	Ø8	Ø10	Ø12	Ø14	Ø16	Ø18	Ø20	Ø25	Ø32	Ø40
	1																	
	2	2,5xD	0,3xD		0,008	0,010	0,014	0,020	0,027	0,036	0,044	0,052	0,057	0,066	0,074	0,092	0,118	
	3																	
	4																	
	5																	
	6																	

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

● Optima / Optimun ○ Alternativo / Alternative

Fresado
Fraisage
Milling
Fräsen



Ø mm	Z	d mm	L mm	l mm	
6,00	3	6	68	24	1
8,00	3	10	88	38	1
10,00	3	10	95	45	1
12,00	3	12	110	53	1

Ø mm	Z	d mm	L mm	l mm	
14,00	3	12	110	53	1
16,00	3	16	123	63	1
18,00	3	16	123	63	1
20,00	3	20	141	75	1