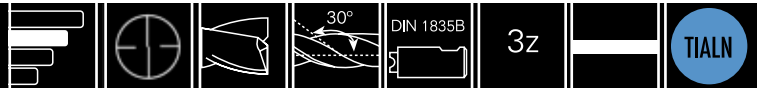


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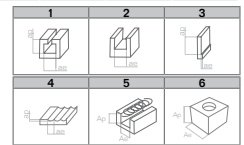


Vc (m/min)	P				M		K			N				S		H		
	<800 ● 48-80	<1.000 ● 40-45	<1.200 ○ 30-35	<1.400	<950 ○ 25-35	<1.200	<500 ● 55-60	<800 ● 30-40	<1.400 ○ 30-35	Al	Cu	Mg/Zn	Plastic	Ni	Ti	50 HRC	55 HRC	60 HRC
K	1	1	0,7	0,7	0,7	1	1	1	0,7	1,3	1	1	1,3	0,7	0,7	0,7	0,7	0,7
fz	Ap	Ae	Ø1	Ø2	Ø3	Ø4	Ø5	Ø6	Ø8	Ø10	Ø12	Ø14	Ø16	Ø18	Ø20	Ø25	Ø32	Ø40
	1																	
	2	0,5xØ	1xØ		0,012	0,017	0,021	0,029	0,038	0,047	0,057	0,066	0,075	0,085	0,095	0,118	0,151	
	3																	
	4																	
	5																	
	6																	

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

● Optima / Optimun ○ Alternativo / Alternative

Fresado
Fraisage
Milling
Fräsen



Ø mm	Z	d mm	L mm	l mm	
3	3	6	52	8	1
4	3	6	55	11	1
5	3	6	57	13	1
6	3	6	57	13	1
7	3	10	63	16	1
8	3	10	69	19	1
9	3	10	69	22	1
10	3	10	72	22	1
11	3	12	79	22	1

Ø mm	Z	d mm	L mm	l mm	
12	3	12	83	26	1
13	3	12	83	26	1
14	3	12	83	26	1
15	3	12	92	26	1
16	3	16	92	32	1
18	3	16	186	32	1
20	3	20	104	38	1
22	3	20	104	38	1
25	3	25	121	45	1

P
Aceros
Aciers
Steels
Stähle

M
Aceros Inox
Aciers Inox
Stainless Steels
Edelstahl

K
Fundición
Fonte
Cast Iron
Gusseisen

N
Metales no ferrosos
Métal non Ferreux
Non Ferrous metals
NE-Metalle

S
Titanio y Superalloys
Titanium et Superalloys
Titanium and Superalloys
Titan und Superlegierungen

H
Materiales Duros
Materiels Durs
Hard materials
Hartmaterialien