

3199

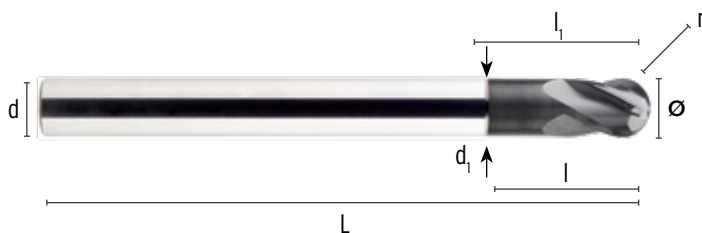
HM-MD DIN 6527 EL



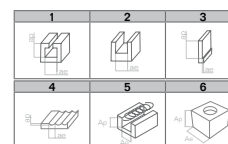
| Vc<br>(m/min) | P                    |                        |                        |                        | M                    |                       | K                    |                     |                        | N     |       |       |         | S     |       | H                     |                       |                       |
|---------------|----------------------|------------------------|------------------------|------------------------|----------------------|-----------------------|----------------------|---------------------|------------------------|-------|-------|-------|---------|-------|-------|-----------------------|-----------------------|-----------------------|
|               | <800<br>●<br>160-240 | <1.000<br>●<br>140-210 | <1.200<br>●<br>150-200 | <1.400<br>●<br>100-140 | <950<br>●<br>120-180 | <1.200<br>●<br>90-130 | <500<br>●<br>120-180 | <800<br>●<br>90-130 | <1.400<br>●<br>100-140 | Al    | Cu    | Mg/Zn | Plastic | Ni    | Ti    | 50 HRC<br>●<br>90-150 | 55 HRC<br>●<br>70-130 | 60 HRC<br>●<br>60-110 |
| K             | 0,7                  | 0,7                    | 0,7                    | 0,7                    | 0,7                  | 0,7                   | 0,7                  | 1,3                 | 1,3                    | 1,3   | 1,3   | 1,3   | 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                    |                        |                        |                        |                      |                       |                      |                     |                        |       |       |       |         |       |       |                       |                       |                       |
|               | 3                    |                        |                        |                        |                      |                       |                      |                     |                        |       |       |       |         |       |       |                       |                       |                       |
|               | 4                    | 0,5xØ                  | 0,5xØ                  | -                      | 0,040                | 0,060                 | 0,080                | 0,100               | 0,120                  | 0,160 | 0,200 | 0,240 | 0,280   | 0,320 | 0,360 | 0,400                 |                       |                       |
|               | 5                    |                        |                        |                        |                      |                       |                      |                     |                        |       |       |       |         |       |       |                       |                       |                       |

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

● Optima / Optimun ○ Alternativo / Alternative



Fresado  
Fraisage  
Milling  
Fräsen



| Ø<br>mm | l<br>mm | d<br>mm | d1<br>mm | L<br>mm | l<br>mm | r    | Z |   |
|---------|---------|---------|----------|---------|---------|------|---|---|
| 2,00    | 7       | 6       | 1,90     | 62      | 3       | 1,00 | 4 | 1 |
| 3,00    | 9       | 6       | 2,80     | 62      | 4       | 1,50 | 4 | 1 |
| 4,00    | 12      | 6       | 3,80     | 62      | 5       | 2,00 | 4 | 1 |
| 5,00    | 14      | 6       | 4,80     | 80      | 6       | 2,50 | 4 | 1 |
| 6,00    | 17      | 6       | 5,70     | 80      | 7       | 3,00 | 4 | 1 |
| 8,00    | 22      | 8       | 7,60     | 90      | 9       | 4,00 | 4 | 1 |

| Ø<br>mm | l<br>mm | d<br>mm | d1<br>mm | L<br>mm | l<br>mm | r     | Z |   |
|---------|---------|---------|----------|---------|---------|-------|---|---|
| 10,00   | 17      | 10      | 9,50     | 100     | 11      | 5,00  | 4 | 1 |
| 12,00   | 32      | 12      | 11,50    | 120     | 13      | 6,00  | 4 | 1 |
| 14,00   | 37      | 14      | 13,50    | 120     | 15      | 7,00  | 4 | 1 |
| 16,00   | 42      | 16      | 15,50    | 140     | 17      | 8,00  | 4 | 1 |
| 18,00   | 47      | 18      | 17,50    | 140     | 19      | 9,00  | 4 | 1 |
| 20,00   | 52      | 20      | 19,50    | 160     | 21      | 10,00 | 4 | 1 |