

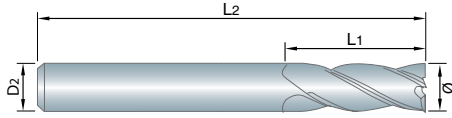
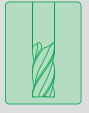
INTEGRAZIONE A CATALGO

Frese a divisione irregolare elica
indipendente lappate e rivestite



FRESE A DIVISIONE IRREGOLARE ELICA INDIPENDENTE LAPPATE E RIVESTITE

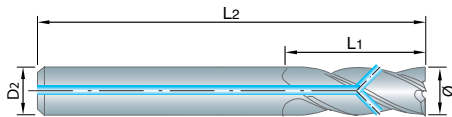
END MILLS WITH IRREGULAR
DIVISION LAPPED AND COATED



Unità : mm

Ø	D2	L1	L2
6.0	6	16	57
8.0	8	16	63
10.0	10	22	72
12.0	12	26	83
16.0	16	32	92
20.0	20	38	105

	FS130	FS140	FS150
	MD	MD	MD
	WST	WST	WST
	Z 3	Z 4	Z 5
✓	P1 P2 P3 M1	P1 P2 P3 M1	P1 P2 P3 M1
✓	M2 S1	M2 S1	M2 S1
✓	P4 P5	P1 P4 P5 M2	M1 M2 K1 N1 S1
	FS1304006	FS1404006	FS1504006
	FS1304008	FS1404008	FS1504008
	FS1304010	FS1404010	FS1504010
	FS1304012	FS1404012	FS1504012
	FS1304016	FS1404016	FS1504016
	FS1304020	FS1404020	FS1504020



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6.0	6	16	57
8.0	8	16	63
10.0	10	22	72
12.0	12	26	83
16.0	16	32	92
20.0	20	38	105

	FS138	FS148	FS158
	MD	MD	MD
	WST	WST	WST
	Z 3	Z 4	Z 5
✓	P1 P2 P3 M1	P1 P2 P3 M1	P1 P2 P3 M1
✓	M2 S1	M2 S1	M2 S1
✓	P4 P5	P1 P4 P5 M2	M1 M2 K1 N1 S1
	FS1384006	FS1484006	FS1584006
	FS1384008	FS1484008	FS1584008
	FS1384010	FS1484010	FS1584010
	FS1384012	FS1484012	FS1584012
	FS1384016	FS1484016	FS1584016
	FS1384020	FS1484020	FS1584020

LAVORAZIONE IN CAVA
FS130, FS140, FS138, FS148

Diametro (mm)	Parametri	Acciai					Inox		Leghe di Titanio
		< 500 N/mm ²	< 750 N/mm ²	< 900 N/mm ²	< 1100 N/mm ²	< 1500 N/mm ²	< 800 N/mm ²	> 800 N/mm ²	
6.00	fz (mm)	0,036	0,036	0,029	0,026	0,023	0,029	0,023	0,029
	ap (mm)	6,0	6,0	6,0	6,0	6,0	6,0	6,0	6,0
	Vc (m/min)	123	114	100	81	58	72	49	40
8.00	fz (mm)	0,047	0,047	0,038	0,035	0,031	0,039	0,030	0,039
	ap (mm)	8,0	8,0	8,0	8,0	8,0	8,0	8,0	8,0
	Vc (m/min)	123	114	100	81	58	72	49	40
10.00	fz (mm)	0,057	0,057	0,048	0,043	0,038	0,048	0,038	0,048
	ap (mm)	10,0	10,0	10,0	10,0	10,0	10,0	10,0	10,0
	Vc (m/min)	123	114	100	81	58	72	49	40
12.00	fz (mm)	0,066	0,066	0,056	0,050	0,045	0,056	0,045	0,056
	ap (mm)	12,0	12,0	12,0	12,0	12,0	12,0	12,0	12,0
	Vc (m/min)	105	97	87	61	43	63	42	35
16.00	fz (mm)	0,081	0,081	0,070	0,062	0,056	0,070	0,056	0,070
	ap (mm)	16,0	16,0	16,0	16,0	16,0	16,0	16,0	16,0
	Vc (m/min)	123	114	100	81	58	72	49	40
20.00	fz (mm)	0,092	0,092	0,080	0,070	0,064	0,080	0,064	0,080
	ap (mm)	20,0	20,0	20,0	20,0	20,0	20,0	20,0	20,0
	Vc (m/min)	123	114	100	81	58	72	49	40

• Per frese 3 taglienti ridurre l'fz del 25%
• I dati riportati nelle tabelle sono indicativi

LAVORAZIONE IN CONTORNATURA
FS140, FS150, FS148, FS158

Diametro (mm)	Parametri	Acciai					Inox		Leghe di Titanio
		< 500 N/mm ²	< 750 N/mm ²	< 900 N/mm ²	< 1100 N/mm ²	< 1500 N/mm ²	< 800 N/mm ²	> 800 N/mm ²	
6.00	fz 4 tagl. (mm)	0,045	0,045	0,036	0,033	0,029	0,037	0,029	0,036
	fz 5 tagl. (mm)	0,034	0,034	0,031	0,028	0,024	0,030	0,024	0,027
	ap (mm)	9,0	9,0	9,0	9,0	9,0	9,0	9,0	9,0
	ae (mm)	2,0	2,0	2,0	1,8	1,8	1,5	1,5	1,2
	Vc (m/min)	175	163	144	116	82	103	70	60
8.00	fz 4 tagl. (mm)	0,059	0,059	0,048	0,043	0,038	0,048	0,039	0,048
	fz 5 tagl. (mm)	0,038	0,038	0,033	0,030	0,027	0,032	0,025	0,029
	ap (mm)	12,0	12,0	12,0	12,0	12,0	12,0	12,0	12,0
	ae (mm)	2,7	2,7	2,7	2,4	2,4	2,0	2,0	1,6
	Vc (m/min)	175	163	144	116	82	103	70	60
10.00	fz 4 tagl. (mm)	0,071	0,071	0,060	0,053	0,048	0,060	0,048	0,060
	fz 5 tagl. (mm)	0,050	0,050	0,045	0,040	0,035	0,038	0,030	0,034
	ap (mm)	15,0	15,0	15,0	15,0	15,0	15,0	15,0	15,0
	ae (mm)	3,3	3,3	3,3	3,0	3,0	2,5	2,5	2,0
	Vc (m/min)	175	163	144	116	82	103	70	60
12.00	fz 4 tagl. (mm)	0,082	0,082	0,071	0,063	0,056	0,070	0,056	0,070
	fz 5 tagl. (mm)	0,063	0,063	0,059	0,050	0,046	0,063	0,046	0,057
	ap (mm)	18,0	18,0	18,0	18,0	18,0	18,0	18,0	18,0
	ae (mm)	4,0	4,0	4,0	3,6	3,6	3,0	3,0	2,4
	Vc (m/min)	175	163	144	116	82	103	70	60
16.00	fz 4 tagl. (mm)	0,101	0,101	0,088	0,077	0,070	0,087	0,070	0,088
	fz 5 tagl. (mm)	0,076	0,076	0,064	0,060	0,054	0,069	0,054	0,062
	ap (mm)	24,0	24,0	24,0	24,0	24,0	24,0	24,0	24,0
	ae (mm)	5,3	5,3	5,3	4,8	4,8	4,0	4,0	3,2
	Vc (m/min)	175	163	144	116	82	103	70	60
20.00	fz 4 tagl. (mm)	0,115	0,115	0,100	0,087	0,080	0,100	0,080	0,100
	fz 5 tagl. (mm)	0,089	0,089	0,077	0,068	0,062	0,076	0,061	0,069
	ap (mm)	30,0	30,0	30,0	30,0	30,0	30,0	30,0	30,0
	ae (mm)	6,7	6,7	6,7	6,1	6,1	5,0	5,0	4,0
	Vc (m/min)	175	163	144	116	82	103	70	60

• I dati riportati nelle tabelle sono indicativi



Distribuito da:

