



DESCRIZIONE DEL PRODOTTO

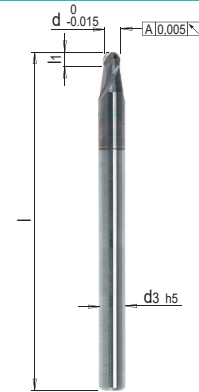
- » Fresa ad alta prestazione con tagliente centrale continuo, per lavorazione in 3D
- » Con elevata precisione nell'ordine di micron

MATERIALE

- » rivestimento AlCrN

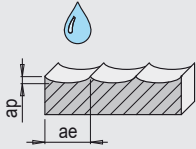


Z	l	l1	d3	d	N°	EUR
2	38	1	3	0,5	WZF 28246/0,5	< >
2	38	1,2	3	0,6	WZF 28246/0,6	< >
2	38	1,4	3	0,7	WZF 28246/0,7	< >
2	38	1,6	3	0,8	WZF 28246/0,8	< >
2	38	1,8	3	0,9	WZF 28246/0,9	< >
2	38	2	3	1	WZF 28246/1	< >
2	38	3	3	1,5	WZF 28246/1,5	< >
2	38	4	3	2	WZF 28246/2	< >
2	38	5	3	2,5	WZF 28246/2,5	< >
2	38	6	3	3	WZF 28246/3	< >



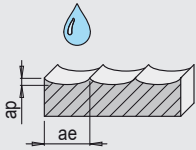
VALORI DI RIFERIMENTO PER LA SGROSSATURA

WZF 28246	Materiale	Resistenza	Vc ¹ m/min.	d									
				0.5	0.6	0.7	0.8	0.9	1	1.5	2	2.5	3
				fz ² (mm/z)									
	1.1730	640 N/mm ²	70	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2083	780 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2085	1080 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2162	660 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2311	1080 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2312	1080 N/mm ²	70	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2316	1010 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2343	780 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2379	780 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2714 HH	1350 N/mm ²	70	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2767	830 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2842	775 N/mm ²	70	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	Acciaio	1400 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	ap (mm)			0.125	0.150	0.175	0.200	0.225	0.250	0.375	0.500	0.625	0.750
	ae (mm)			0.050	0.060	0.070	0.080	0.090	0.100	0.150	0.200	0.250	0.300



VALORI DI RIFERIMENTO PER LA FINITURA

WZF 28246	Materiale	Resistenza	Vc ¹ m/min.	d									
				0.5	0.6	0.7	0.8	0.9	1	1.5	2	2.5	3
				fz ² (mm/z)									
	1.1730	640 N/mm ²	90	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2083	780 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2085	1080 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2162	660 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2311	1080 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2312	1080 N/mm ²	90	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2316	1010 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2343	780 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2379	780 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2714 HH	1350 N/mm ²	90	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2767	830 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2842	775 N/mm ²	90	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	Acciaio	1400 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	ap (mm)			0.025	0.03	0.035	0.040	0.045	0.050	0.075	0.10	0.125	0.15
	ae (mm)			0.015	0.018	0.021	0.024	0.027	0.030	0.045	0.06	0.075	0.09



1) Vc: Velocità di taglio (m/min.)

2) fz: Avanzamento per taglio (mm/z)

i Nel calcolatore dei parametri di taglio potete trovare altri materiali e valori di taglio