Frese cilindriche NB-NVD

A taglienti lisci con rompitruciolo, esecuzione medio-lunga

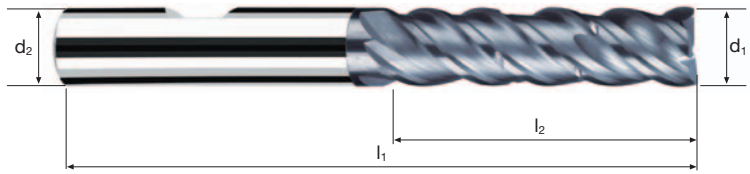
HSS | Favora® | Base-X | **B** | X-Generation

HM
MG10

λ **45°**
γ **0°**

45°

Vario



Sgrossatura

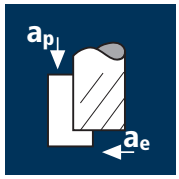
Finitura

Rm < 850	**Rm** 850-1100	**Rm** 1100-1300	**Rm** 1300-1500				**Inox** Stainless	**Ti** Titanium	**GG(G)** **Tool Steel** **Nickel-Alloys**

Esempio: **N° Ordine** — Rivestimento **P** | Articolo **15310** | Codice-ø **.300**

ø Code	d1 e8	d2 h6	l1	l2	45°	z		POLYCHROM P15310	P15210
.300	6	6	63	21	0.15	4		●	
.391	8	8	72	31	0.15	4		●	
.450	10	10	84	37	0.20	4		●	
.501	12	12	97	44	0.20	4		●	
.610	16	16	108	53	0.20	4		●	
.682	20	20	122	62	0.20	4		●	

Applicazione



Materiale	d1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min⁻¹]	v_f [mm/min]	Q [cm³/min]
Acciaio < 850 N/mm²	6	4	180	0.040	10.8	1.2	9550	1530	20.0
	8	4	180	0.050	14.4	1.6	7160	1430	33.0
	10	4	180	0.065	18.0	2.0	5730	1490	53.5
	12	4	180	0.075	21.6	2.4	4775	1435	74.5
	16	4	180	0.085	28.8	3.2	3580	1215	112.0
	20	4	180	0.105	36.0	4.0	2865	1205	173.5
Acciaio 850 - 1100 N/mm²	6	4	150	0.040	10.8	1.2	7960	1275	16.5
	8	4	150	0.050	14.4	1.6	5970	1195	27.5
	10	4	150	0.065	18.0	2.0	4775	1240	44.5
	12	4	150	0.075	21.6	2.4	3980	1195	62.0
	16	4	150	0.085	28.8	3.2	2985	1015	93.5
	20	4	150	0.105	36.0	4.0	2385	1000	144.0
Acciaio per lavorazione a freddo (12% Cr) fortemente legati [1.2379]	6	4	70	0.035	10.8	1.2	3715	520	6.5
	8	4	70	0.045	14.4	1.6	2785	500	11.5
	10	4	70	0.060	18.0	2.0	2230	535	19.5
	12	4	70	0.070	21.6	2.4	1855	520	27.0
	16	4	70	0.080	28.8	3.2	1395	445	41.0
	20	4	70	0.100	36.0	4.0	1115	445	64.0
Acciaio inossidabile [Cr-Ni/1.4301]	6	4	85	0.025	10.8	1.2	4510	450	6.0
	8	4	85	0.030	14.4	1.6	3380	405	9.5
	10	4	85	0.040	18.0	2.0	2705	435	15.5
	12	4	85	0.050	21.6	2.4	2255	450	23.5
	16	4	85	0.055	28.8	3.2	1690	370	34.0
	20	4	85	0.070	36.0	4.0	1355	380	54.5

Applicazione

Materiale	d1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min⁻¹]	v_f [mm/min]	Q [cm³/min]
Acciaio < 850 N/mm²	6	4	145	0.020	8.1	6	7695	615	30.0
	8	4	145	0.025	10.8	8	5770	575	49.5
	10	4	145	0.035	13.5	10	4615	645	87.0
	12	4	145	0.040	16.2	12	3845	615	119.5
	16	4	145	0.050	19.2	16	2885	575	176.5
	20	4	145	0.060	24.0	20	2310	555	266.5
Acciaio 850 - 1100 N/mm²	6	4	120	0.020	8.1	6	6365	510	25.0
	8	4	120	0.025	10.8	8	4775	480	41.5
	10	4	120	0.035	13.5	10	3820	535	72.0
	12	4	120	0.040	16.2	12	3185	510	99.0
	16	4	120	0.050	19.2	16	2385	475	146.0
	20	4	120	0.060	24.0	20	1910	460	221.0
Acciaio per lavorazione a freddo (12% Cr) fortemente legati [1.2379]	6	4	55	0.020	8.1	6	2920	235	11.5
	8	4	55	0.025	10.8	8	2190	220	19.0
	10	4	55	0.030	13.5	10	1750	210	28.5
	12	4	55	0.035	16.2	12	1460	205	40.0
	16	4	55	0.045	19.2	16	1095	195	60.0
	20	4	55	0.055	24.0	20	875	195	93.5
Acciaio inossidabile [Cr-Ni/1.4301]	6	4	65	0.015	8.1	6	3450	205	10.0
	8	4	65	0.020	10.8	8	2585	205	17.5
	10	4	65	0.025	13.5	10	2070	205	27.5
	12	4	65	0.030	16.2	12	1725	205	40.0
	16	4	65	0.035	19.2	16	1295	180	55.5
	20	4	65	0.045	24.0	20	1035	185	89.0