

Parametri di lavoro

Frese HSS-E PRISMATICHE

Material	Strength	A _p	V _c	$f_z(\text{mm/z})$ Ø 50	Ø 63	Ø 80	Ø 100
P.1 Free-cutting steels, general construction steels	≤ 600 N/mm ²	0,8xS	37,5	0.03	0.035	0.04	0.045
P.3 Tool steels low alloyed	≤ 1100 N/mm ²	0,8xS	18	0.03	0.035	0.04	0.045
P.4 Heat treatable steels	≤ 900 N/mm ²	0,8xS	25	0.03	0.035	0.04	0.045
P.6 Tool and treated steels	> 1100 N/mm ²	0,8xS	16	0.021	0.025	0.028	0.0315
M.2 Corrosion- and acid-proof steels	750 - 850 N/mm ²	0,8xS	10	0.03	0.035	0.04	0.045
K.1 Cast iron (≤ 240 HB)	≤ 820 N/mm ²	0,8xS	30	0.03	0.035	0.04	0.045
K.2 Cast iron (> 240 HB)	> 800 N/mm ²	0,8xS	22	0.03	0.035	0.04	0.045
N.4 Cooper-zinc alloys, cooper-tin alloys	≤ 800 N/mm ²	0,8xS	60-100	0.03	0.035	0.04	0.045
S.2 Titanium, Titanium alloys	≤ 1250 N/mm ²	0,8xS	9	0.021	0.025	0.028	0.0315

