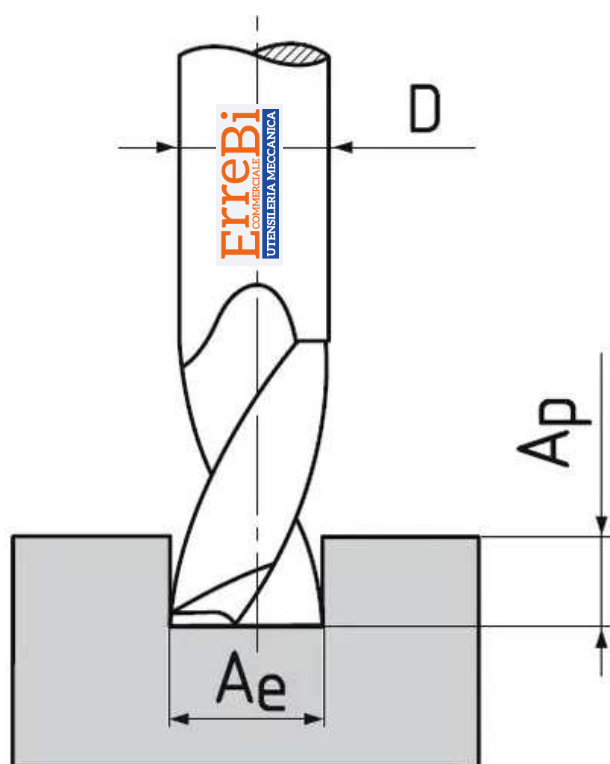
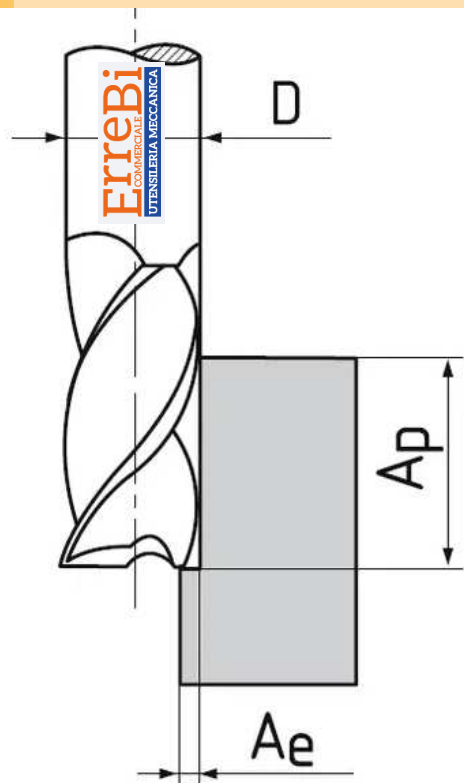


# Parametri di lavoro

## Frese HSS-8%Co 4 tagli FINIRE serie LUNGA riv. TialN

Material	Strength	A <sub>p</sub>	A <sub>e</sub>	V <sub>c</sub>	f <sub>z</sub> (mm/z) Ø 3	Ø 6	Ø 8	Ø 10	Ø 12	Ø 16	Ø 18	Ø 20	Ø 25	Ø 32	Ø 40
P.1   Free-cutting steels, general construction steels	≤ 600 N/mm²	1xD	0,1xD	67,5	0.006	0.015	0.021	0.028	0.034	0.044	0.051	0.057	0.071	0.091	0.11
P.2   General construction steels, steel castings	≤ 850 N/mm²	1xD	0,1xD	58,5	0.006	0.015	0.021	0.028	0.034	0.044	0.051	0.057	0.071	0.091	0.11
P.3   Tool steels low alloyed	≤ 1100 N/mm²	1xD	0,1xD	36	0.006	0.015	0.021	0.028	0.034	0.044	0.051	0.057	0.071	0.091	0.11
P.4   Heat treatable steels	≤ 900 N/mm²	1xD	0,1xD	45	0.006	0.015	0.021	0.028	0.034	0.044	0.051	0.057	0.071	0.091	0.11
P.6   Tool and treated steels	> 1100 N/mm²	1xD	0,1xD	30	0.0042	0.0105	0.0147	0.0196	0.0238	0.0308	0.0357	0.0399	0.0497	0.0637	0.077
M.2   Corrosion- and acid-proof steels	750 - 850 N/mm²	1xD	0,1xD	22,5	0.006	0.015	0.021	0.028	0.034	0.044	0.051	0.057	0.071	0.091	0.11
K.2   Cast iron (> 240 HB)	> 800 N/mm²	1xD	0,1xD	52,5	0.006	0.015	0.021	0.028	0.034	0.044	0.051	0.057	0.071	0.091	0.11
N.2   Aluminium cast alloys Si (Si ≤ 12%)	≤ 600 N/mm²	1xD	0,1xD	240-450	0.0078	0.0195	0.0273	0.0364	0.0442	0.0572	0.0663	0.0741	0.0923	0.1183	0.143
S.1   Chrome-nickel alloys	≤ 1500 N/mm²	1xD	0,1xD	18	0.0042	0.0105	0.0147	0.0196	0.0238	0.0308	0.0357	0.0399	0.0497	0.0637	0.077



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