

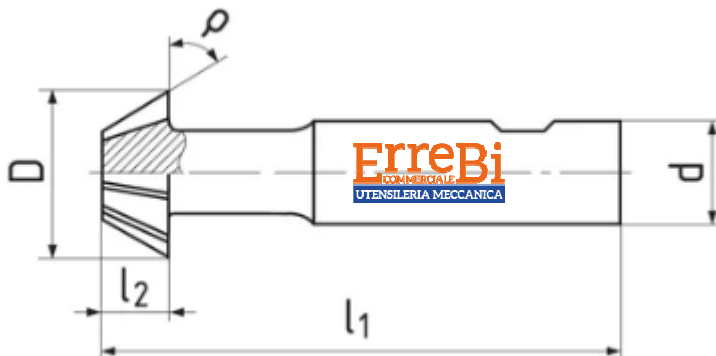
Parametri di lavoro

Frese HSS-E CONVERGENTI

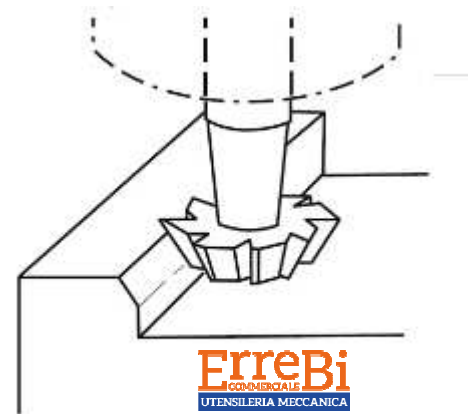
| Gruppo materiale | | Acciai da costruzione | Acciai NON bonificati | INOX allo zolfo | Ghisa | ALLUMINIO |
|------------------|----|---------------------------|---------------------------|--------------------|-----------------------|---------------------|
| Hardness/Rm | | $\leq 800 \text{ N/mm}^2$ | $\leq 750 \text{ N/mm}^2$ | | $\leq 350 \text{ HB}$ | |
| ap x ae | | 0.2D x 0.15D | 0.2D x 0.15D | | 0.2D x 0.15D | 0.2D x 0.15D |
| Vc (m/min) | | 30+50 | 15+25 | | 30+40 | 50+70 |
| D (mm) | z | fz (mm/z) | fz (mm/z) | | fz (mm/z) | fz (mm/z) |
| 16 | 6 | 0.015 | 0.011 | | 0.013 | 0.017 |
| 20 | 6 | 0.017 | 0.012 | | 0.014 | 0.018 |
| 22 | 6 | 0.018 | 0.013 | | 0.015 | 0.020 |
| 25 | 8 | 0.020 | 0.014 | | 0.017 | 0.022 |
| 28 | 8 | 0.023 | 0.016 | | 0.019 | 0.025 |
| 32 | 10 | 0.025 | 0.018 | | 0.021 | 0.028 |
| 38 | 12 | 0.028 | 0.020 | | 0.024 | 0.031 |

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