

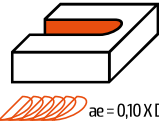
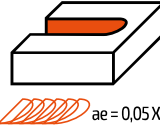


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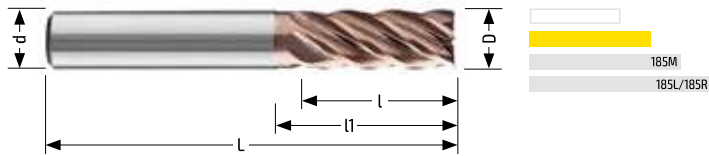
Parametri di lavoro/Working Parameters/Bearbeitungsparameter/Paramètres d'usinage

Materiale Material	Diametro Diameter												
		1,0D	0,3D										
Inox ferritico Ferritic stainless steel	m/min	Vc=130			Vc=130			Vc=160			Vc=160		
	D mm	fz mm/z	F mm/min	n rpm	fz mm/z	F mm/min	n rpm	fz mm/z	F mm/min	n rpm	fz mm/z	F mm/min	n rpm
	6	0,017	586	6897	0,033	1138	6897	0,102	4329	8488	0,102	4870	9549
	8	0,022	569	5173	0,042	1086	5173	0,131	4170	6366	0,131	4691	7162
	10	0,027	559	4138	0,050	1035	4138	0,157	3998	5093	0,157	4498	5730
	12	0,031	534	3448	0,058	1000	3448	0,181	3841	4244	0,181	4321	4775
Inox austenitico Austenitic stainless steel	m/min	Vc=110			Vc=110			Vc=120			Vc=180		
	D mm	fz mm/z	F mm/min	n rpm	fz mm/z	F mm/min	n rpm	fz mm/z	F mm/min	n rpm	fz mm/z	F mm/min	n rpm
	6	0,017	496	5836	0,033	963	5836	0,102	3247	6366	0,102	4870	9549
	8	0,022	481	4377	0,042	919	4377	0,131	3127	4775	0,131	4691	7162
	10	0,027	473	3501	0,050	875	3501	0,157	2998	3820	0,157	4498	5730
	12	0,031	452	2918	0,058	846	2918	0,181	2881	3183	0,181	4321	4775
PH-Duplex	m/min	Vc=90			Vc=90			Vc=120			Vc=160		
	D mm	fz mm/z	F mm/min	n rpm	fz mm/z	F mm/min	n rpm	fz mm/z	F mm/min	n rpm	fz mm/z	F mm/min	n rpm
	6	0,017	496	5836	0,033	963	5836	0,102	3247	6366	0,102	4870	9549
	8	0,022	481	4377	0,042	919	4377	0,131	3127	4775	0,131	4691	7162
	10	0,027	473	3501	0,050	875	3501	0,157	2998	3820	0,157	4498	5730
	12	0,031	452	2918	0,058	846	2918	0,181	2881	3183	0,181	4321	4775
Titanio Titanium	m/min	Vc=80			Vc=80			Vc=80			Vc=100		
	D mm	fz mm/z	F mm/min	n rpm	fz mm/z	F mm/min	n rpm	fz mm/z	F mm/min	n rpm	fz mm/z	F mm/min	n rpm
	6	0,010	239	4775	0,026	621	4775	0,082	2610	6366	0,082	3480	8488
	8	0,012	215	3581	0,034	609	3581	0,105	2507	4775	0,105	3342	6366
	10	0,015	215	2865	0,040	573	2865	0,126	2406	3820	0,126	3209	5093
	12	0,017	203	2387	0,047	561	2387	0,145	2308	3183	0,145	3077	4244
	16	0,021	188	1790	0,057	510	1790	0,179	2137	2387	0,179	2849	3183
	20	0,025	179	1432	0,067	480	1432	0,209	1996	1910	0,209	2661	2546

Notes

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Fresa 5 taglienti per lavorazioni ad elevate asportazioni  
5 flute end mill for high chip removal  
Fünfschneidige Fräser mit hohem Spanabfuhr  
Fraise à 5 dents, pour débit coupeaux élevés



6527 L

λ 38°

45



4 5 6

45°

D h10	d h6	L	l ap	l1	a	45°	Z	Balinit® Tisaflex	Balinit® Tisaflex
6,0	6	57	13,0	20,0	0,15	0,10	5		
8,0	8	63	19,0	25,0	0,15	0,15	5		
10,0	10	72	22,0	30,0	0,15	0,15	5		
12,0	12	83	26,0	36,0	0,20	0,15	5		
16,0	16	92	32,0	42,0	0,20	0,20	5		
20,0	20	104	38,0	52,0	0,20	0,20	5		

Cr

D h10	d h6	L	l ap	l1	a	Cr	Z	Balinit® Tisaflex	Balinit® Tisaflex
6,0	6	57	13,0	20,0	0,15	0,50	5		
6,0	6	57	13,0	20,0	0,15	1,00	5		
8,0	8	63	19,0	25,0	0,15	0,50	5		
8,0	8	63	19,0	25,0	0,15	1,00	5		
8,0	8	63	19,0	25,0	0,15	2,00	5		
10,0	10	72	22,0	30,0	0,15	0,50	5		
10,0	10	72	22,0	30,0	0,15	1,00	5		
10,0	10	72	22,0	30,0	0,15	2,00	5		
12,0	12	83	26,0	36,0	0,20	0,50	5		
12,0	12	83	26,0	36,0	0,20	1,00	5		
12,0	12	83	26,0	36,0	0,20	2,00	5		
12,0	12	83	26,0	36,0	0,20	3,00	5		
16,0	16	92	32,0	42,0	0,20	1,00	5		
16,0	16	92	32,0	42,0	0,20	2,00	5		
16,0	16	92	32,0	42,0	0,20	3,00	5		
16,0	16	92	32,0	42,0	0,20	4,00	5		
20,0	20	104	38,0	52,0	0,20	2,00	5		
20,0	20	104	38,0	52,0	0,20	3,00	5		
20,0	20	104	38,0	52,0	0,20	4,00	5		

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Acciaio Inox  
Stainless Steel  
Edelstahl  
Acier Inoxydable

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PH-Duplex

6

Titanio  
Titanium  
Titan  
Titane

8

Superleghe  
Superalloys  
Superlegierungen  
Superalliages