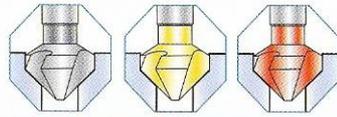


Maggiormente Raccomandato
most suggested

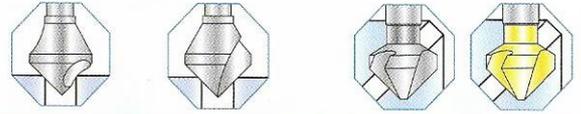
Raccomandato
suggested

Vc = velocità / speed = m/min.
Vf = avanzamento / feed = mm/min.
 $\frac{Vc \times 1000}{\pi \times \varnothing} =$ giri al minuto
Rev. / min.

SVASATURA / COUNTERSINKING



CONTORNATURA CONTOURING



MATERIALE / MATERIAL

MATERIALE / MATERIAL		SVASATURA / COUNTERSINKING				CONTORNATURA CONTOURING				
		HSS 5% Co	HSS 5% Co + TiN	HSS 8% Co + AlTiCN	Metallo Duro Carbide	HSS 5% Co	HSS 5% Co	HSS 5% Co	HSS 5% Co + TiN	Metallo Duro Carbide
ACCIAIO/Steel < 500 N/mm ²	Vc m/min.	17÷22	17÷22	35÷45	40÷80	35÷45	35÷45	17÷22	17÷22	40÷80
	∅ 10	85	85	165	250	165	165	85	85	250
	∅ 20	45	45	85	125	85	85	45	45	125
ACCIAIO/Steel 500 ÷ 800 N/mm ²	Vc m/min.	10÷15	10÷15	20÷30	30÷60	20÷30	20÷30	10÷15	10÷15	30÷60
	∅ 10	60	60	110	170	110	110	60	60	170
	∅ 20	30	30	55	85	55	55	30	30	85
ACCIAIO/Steel 800 ÷ 1000 N/mm ²	Vc m/min.	8÷12	8÷12	16÷20	20÷40	15÷20	15÷20	8÷12	8÷12	20÷40
	∅ 10	35	35	55	100	55	55	35	35	100
	∅ 20	25	25	35	60	35	35	25	25	60
ACCIAIO INOX/ Stainless Steel 1000 ÷ 1300 N/mm ²	Vc m/min.	6÷10	6÷10	12÷15	20÷40	12÷15	12÷15	6÷10	6÷10	20÷40
	∅ 10	30	30	45	100	45	45	30	30	100
	∅ 20	15	15	25	60	25	25	15	15	60
ACCIAIO RESISTENTE AD ABRASIONE/ Abrasion Resistant Steel <420 HB	Vc m/min.			12÷15	15÷20					15÷20
	∅ 10			40	55					55
	∅ 20			30	35					35
BRONZO DURO/ Hard Bronze	Vc m/min.			4÷6	10÷12					10÷12
	∅ 10			16	30					30
	∅ 20			8	16					16
ACCIAIO TRATTATO/ Treated Steel > 60 HRC	Vc m/min.				8÷10					8÷10
	∅ 10				20					20
	∅ 20				10					10
GHISA/Cast Iron	Vc m/min.	15÷25	15÷25	20÷40	40÷80	20÷40	20÷40	15÷25	15÷25	40÷80
	∅ 10	70	70	125	250	125	125	70	70	250
	∅ 20	40	40	75	150	75	75	40	40	150
ALLUMINIO/ Aluminium	Vc m/min.	35÷45	35÷45	50÷60	40÷100	50÷60	50÷60	35÷45	35÷45	40÷100
	∅ 10	200	200	255	350	255	255	200	200	350
	∅ 20	130	130	180	230	180	180	130	130	230
OTTONE/Bronze Brass	Vc m/min.	20÷30	20÷30	30÷40		30÷40	30÷40	20÷30	20÷30	
	∅ 10	120	120	150		150	150	120	120	
	∅ 20	85	85	110		110	110	85	85	
RAME/Copper	Vc m/min.	15÷25	15÷25	20÷30	50÷80	20÷30	20÷30	15÷25	15÷25	50÷80
	∅ 10	95	95	120	300	120	120	95	95	300
	∅ 20	60	60	80	200	80	80	60	60	200
LAMINATI/Laminated	Vc m/min.	35÷70	35÷70	35÷70		50÷100	50÷100	35÷70	35÷70	
	∅ 10	300	300	300		400	400	300	300	
	∅ 20	200	200	200		300	300	200	200	
NYLON-PVC-PLASTICA/ Plastics	Vc m/min.	35÷70	35÷70	35÷70		50÷100	50÷100	35÷70	35÷70	
	∅ 10	400	400	400		450	450	400	400	
	∅ 20	300	300	300		350	350	300	300	