



DESCRIZIONE DEL PRODOTTO

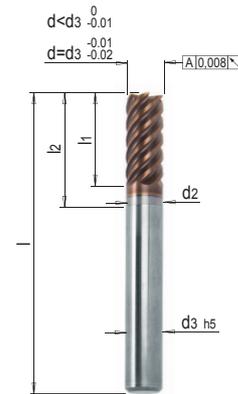
» Fresa ad alta prestazione per lavori di finitura sul duro con tagliente centrale continuo

MATERIALE

» Metallo duro integrale, rivestimento TiSiN



Z	d2	d3	l	l2	l1	d	N°	EUR
4	2,9	4	50	15	9	3	WZF 13746/ 3	< >
4	3,9	6	60	16	11	4	WZF 13746/ 4	< >
4	4,9	6	60	20	13	5	WZF 13746/ 5	< >
6	5,9	6	60	20	13	6	WZF 13746/ 6	< >
6	7,9	8	70	25	19	8	WZF 13746/ 8	< >
6	9,9	10	80	30	22	10	WZF 13746/10	< >
6	11,9	12	80	35	26	12	WZF 13746/12	< >
8	15,9	16	90	40	32	16	WZF 13746/16	< >



VALORI DI RIFERIMENTO PER LA FINITURA

WZF 13746	Materiale	Resistenza	Vc ¹ m/min.	d							
				3	4	5	6	8	10	12	16
				fz ² (mm/z)							
<p>ae = 0.03 x d ap = 1.7 x d</p>	1.2083	52 HRC	100	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2162	52 HRC	130	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2343	52 HRC	130	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2379	60 HRC	75	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2767	52 HRC	90	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2842	60 HRC	75	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2714HH	43 HRC	140	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.3343	64 HRC	65	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.3344 PM	64 HRC	65	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	M V10 PM	62 HRC	70	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	M W10 PM	65 HRC	60	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046

VALORI DI RIFERIMENTO PER LA FINITURA

WZF 13746	Materiale	Resistenza	Vc ¹ m/min.	d							
				3	4	5	6	8	10	12	16
				fz ² (mm/z)							
<p>ae = 0.06 x d ap = 1.7 x d</p>	1.2083	52 HRC	90	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2162	52 HRC	120	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2343	52 HRC	120	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2379	60 HRC	70	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2767	52 HRC	90	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2842	60 HRC	70	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.2714HH	43 HRC	120	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.3343	64 HRC	60	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	1.3344 PM	64 HRC	60	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	M V10 PM	62 HRC	65	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046
	M W10 PM	65 HRC	55	0.009	0.012	0.015	0.02	0.025	0.03	0.035	0.046

1) Vc: Velocità di taglio (m/min.)

2) fz: Avanzamento per taglio (mm/z)

i Nel calcolatore dei parametri di taglio potete trovare altri materiali e valori di taglio