



### DESCRIZIONE DEL PRODOTTO

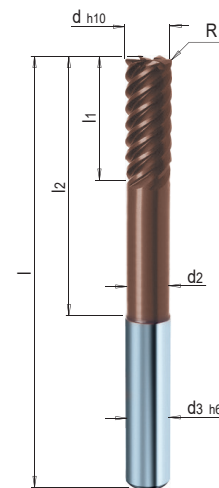
- » Fresa ad alta prestazione per lavori di finitura sul duro con tagliente centrale continuo
- » Scaricata dietro il tagliente

### MATERIALE

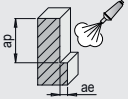
» Metallo duro integrale, rivestimento multistrato TiAlSiN



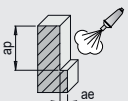
Z	d2	d3	l	l1	l2	R	d	N°	EUR
6	5,7	6	75	13	39	0,5	6	WZF 13576/ 6	< >
6	7,7	8	100	19	64	0,5	8	WZF 13576/ 8	< >
6	9,5	10	100	22	60	0,5	10	WZF 13576/10	< >
6	11,5	12	150	26	105	1	12	WZF 13576/12	< >
6	15,5	16	150	32	102	1	16	WZF 13576/16	< >



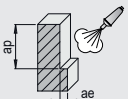
### VALORI DI RIFERIMENTO PER LA FINITURA

WZF 13556	Materiale	Resistenza	Vc <sup>1</sup> m/min.	d					
				6	8	10	12	16	20
				fz <sup>2</sup> (mm/z)					
 ae = 0.05 x d ap = 3 x d	1.2083	52 HRC	70	0.010	0.013	0.018	0.022	0.027	0.032
	1.2162	52 HRC	110	0.010	0.013	0.018	0.022	0.027	0.032
	1.2343	52 HRC	110	0.010	0.013	0.018	0.022	0.027	0.032
	1.2379	60 HRC	70	0.010	0.013	0.018	0.022	0.027	0.032
	1.2714HH	43 HRC	120	0.010	0.013	0.018	0.022	0.027	0.032
	1.2767	52 HRC	100	0.010	0.013	0.018	0.022	0.027	0.032
	1.2842	60 HRC	70	0.010	0.013	0.018	0.022	0.027	0.032
	Acciaio	1400 N/mm <sup>2</sup>	120	0.010	0.013	0.018	0.022	0.027	0.032

### VALORI DI RIFERIMENTO PER LA FINITURA


WZF 13556	Materiale	Resistenza	Vc <sup>1</sup> m/min.	d					
				6	8	10	12	16	20
				fz <sup>2</sup> (mm/z)					
 ae = 0.05 x d ap = 2 x d	1.2083	52 HRC	70	0.013	0.017	0.023	0.027	0.034	0.040
	1.2162	52 HRC	110	0.013	0.017	0.023	0.027	0.034	0.040
	1.2343	52 HRC	110	0.013	0.017	0.023	0.027	0.034	0.040
	1.2379	60 HRC	70	0.013	0.017	0.023	0.027	0.034	0.040
	1.2714HH	43 HRC	120	0.013	0.017	0.023	0.027	0.034	0.040
	1.2767	52 HRC	100	0.013	0.017	0.023	0.027	0.034	0.040
	1.2842	60 HRC	70	0.013	0.017	0.023	0.027	0.034	0.040
	Acciaio	1400 N/mm <sup>2</sup>	120	0.013	0.017	0.023	0.027	0.034	0.040

### VALORI DI RIFERIMENTO PER LA FINITURA

WZF 13576	Materiale	Resistenza	Vc <sup>1</sup> m/min.	d				
				6	8	10	12	16
				fz <sup>2</sup> (mm/z)				
 ae = 0.05 x d ap = 1.5 x d	1.2083	52 HRC	70	0.010	0.013	0.018	0.022	0.027
	1.2162	52 HRC	110	0.010	0.013	0.018	0.022	0.027
	1.2343	52 HRC	110	0.010	0.013	0.018	0.022	0.027
	1.2379	60 HRC	70	0.010	0.013	0.018	0.022	0.027
	1.2714HH	43 HRC	110	0.010	0.013	0.018	0.022	0.027
	1.2767	52 HRC	100	0.010	0.013	0.018	0.022	0.027
	1.2842	60 HRC	70	0.010	0.013	0.018	0.022	0.027
	Acciaio	1400 N/mm <sup>2</sup>	110	0.010	0.013	0.018	0.022	0.027

1) Vc: Velocità di taglio (m/min.)

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

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