



### DESCRIZIONE DEL PRODOTTO

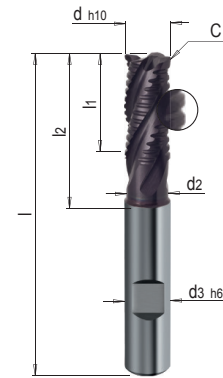
- » Scaricata dietro il tagliente
- » Fresa elicoidale ad alta prestazione con elica a passo variabile e taglio centrale

### MATERIALE

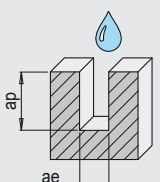
- » Metallo duro integrale, rivestimento multistrato TiAlN



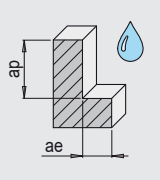
Z	d2	d3	l	l1	l2	C	d	N°	EUR
4	5,5	6	57	13	20	0,3	6	WZF 11248/ 6	< >
4	7,5	8	63	19	26	0,3	8	WZF 11248/ 8	< >
4	9,2	10	72	22	30	0,3	10	WZF 11248/10	< >
4	11,2	12	83	26	36	0,5	12	WZF 11248/12	< >
4	15	16	92	32	42	0,5	16	WZF 11248/16	< >
4	19	20	104	38	52	0,5	20	WZF 11248/20	< >
4	24	25	121	45	63	0,6	25	WZF 11248/25	< >



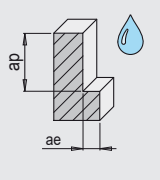
## VALORI DI RIFERIMENTO PER LA SCANALATURA

WZF 11248	Materiale	Resistenza	Vc <sup>1</sup> m/min.	d						
				6	8	10	12	16	20	25
				fz <sup>2</sup> (mm/z)						
 <p>ae = 1 x d ap = 1 x d</p>	1.1730	640 N/mm <sup>2</sup>	180	0.020	0.027	0.034	0.042	0.049	0.059	0.084
	1.2083	780 N/mm <sup>2</sup>	135	0.010	0.013	0.017	0.020	0.025	0.028	0.042
	1.2085	1080 N/mm <sup>2</sup>	135	0.010	0.013	0.017	0.020	0.025	0.028	0.042
	1.2162	660 N/mm <sup>2</sup>	160	0.018	0.025	0.031	0.038	0.045	0.054	0.076
	1.2311	1080 N/mm <sup>2</sup>	150	0.014	0.020	0.025	0.030	0.036	0.043	0.061
	1.2312	1080 N/mm <sup>2</sup>	160	0.013	0.018	0.024	0.029	0.034	0.040	0.057
	1.2316	1010 N/mm <sup>2</sup>	135	0.010	0.013	0.017	0.020	0.025	0.028	0.042
	1.2343	780 N/mm <sup>2</sup>	160	0.018	0.025	0.031	0.038	0.045	0.054	0.076
	1.2379	780 N/mm <sup>2</sup>	135	0.010	0.013	0.017	0.020	0.025	0.028	0.042
	1.2714HH	1350 N/mm <sup>2</sup>	80	0.010	0.013	0.017	0.020	0.025	0.028	0.042
	1.2767	830 N/mm <sup>2</sup>	160	0.017	0.023	0.030	0.036	0.043	0.051	0.072
	1.2842	775 N/mm <sup>2</sup>	160	0.018	0.025	0.031	0.038	0.045	0.054	0.076
	Acciaio	1400 N/mm <sup>2</sup>	70	0.010	0.013	0.017	0.020	0.025	0.028	0.042

## VALORI DI RIFERIMENTO PER LA SGROSSATURA

WZF 11248 WZF 11258	Materiale	Resistenza	Vc <sup>1</sup> m/min.	d						
				6	8	10	12	16	20	25
				fz <sup>2</sup> (mm/z)						
 <p>ae = 0.5 x d ap = 2 x d</p>	1.1730	640 N/mm <sup>2</sup>	130	0.022	0.028	0.037	0.043	0.055	0.062	0.074
	1.2083	780 N/mm <sup>2</sup>	90	0.010	0.014	0.017	0.021	0.025	0.030	0.036
	1.2085	1080 N/mm <sup>2</sup>	90	0.010	0.014	0.017	0.021	0.025	0.030	0.036
	1.2162	660 N/mm <sup>2</sup>	110	0.020	0.025	0.034	0.039	0.050	0.056	0.067
	1.2311	1080 N/mm <sup>2</sup>	110	0.016	0.020	0.027	0.031	0.040	0.045	0.054
	1.2312	1080 N/mm <sup>2</sup>	110	0.015	0.019	0.025	0.029	0.038	0.042	0.050
	1.2316	1010 N/mm <sup>2</sup>	90	0.010	0.014	0.017	0.021	0.025	0.030	0.036
	1.2343	780 N/mm <sup>2</sup>	110	0.020	0.025	0.034	0.039	0.050	0.056	0.067
	1.2379	780 N/mm <sup>2</sup>	90	0.010	0.014	0.017	0.021	0.025	0.030	0.036
	1.2714HH	1350 N/mm <sup>2</sup>	60	0.010	0.014	0.017	0.021	0.025	0.030	0.036
	1.2767	830 N/mm <sup>2</sup>	110	0.019	0.024	0.032	0.037	0.048	0.053	0.064
	1.2842	775 N/mm <sup>2</sup>	110	0.020	0.025	0.034	0.039	0.050	0.056	0.067
	Acciaio	1400 N/mm <sup>2</sup>	60	0.010	0.014	0.017	0.021	0.025	0.030	0.036

## VALORI DI RIFERIMENTO PER LA SGROSSATURA

WZF 11248 WZF 11258	Materiale	Resistenza	Vc <sup>1</sup> m/min.	d						
				6	8	10	12	16	20	25
				fz <sup>2</sup> (mm/z)						
 <p>ae = 0.25 x d ap = 2 x d</p>	1.1730	640 N/mm <sup>2</sup>	140	0.025	0.034	0.043	0.052	0.062	0.074	0.089
	1.2083	780 N/mm <sup>2</sup>	100	0.012	0.017	0.022	0.026	0.031	0.037	0.044
	1.2085	1080 N/mm <sup>2</sup>	100	0.012	0.017	0.022	0.026	0.031	0.037	0.044
	1.2162	660 N/mm <sup>2</sup>	120	0.022	0.031	0.039	0.048	0.056	0.067	0.080
	1.2311	1080 N/mm <sup>2</sup>	120	0.018	0.025	0.031	0.038	0.045	0.054	0.065
	1.2312	1080 N/mm <sup>2</sup>	120	0.017	0.023	0.029	0.036	0.042	0.050	0.060
	1.2316	1010 N/mm <sup>2</sup>	100	0.012	0.017	0.022	0.026	0.031	0.037	0.044
	1.2343	780 N/mm <sup>2</sup>	120	0.022	0.031	0.039	0.048	0.056	0.067	0.080
	1.2379	780 N/mm <sup>2</sup>	100	0.012	0.017	0.022	0.026	0.031	0.037	0.044
	1.2714HH	1350 N/mm <sup>2</sup>	80	0.012	0.017	0.022	0.026	0.031	0.037	0.044
	1.2767	830 N/mm <sup>2</sup>	120	0.021	0.029	0.037	0.045	0.053	0.064	0.077
	1.2842	775 N/mm <sup>2</sup>	120	0.022	0.031	0.039	0.048	0.056	0.067	0.080
	Acciaio	1400 N/mm <sup>2</sup>	80	0.012	0.017	0.022	0.026	0.031	0.037	0.044

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