FRESE PER SCANALATURE

- NUTENFRÄSER
- SLOT CUTTERS
- FRAISES POUR RAINURES
- FRESAS PARA RANURAS

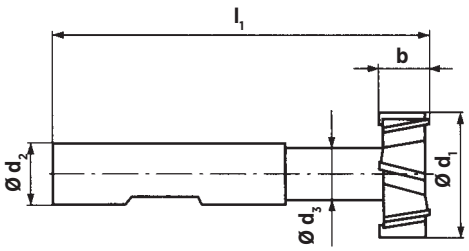
ILLI•CO HIGH QUALITY

HSS-Co5

DIN 851



PER SCANALATURE SECONDO DIN 650
FUR NUTEN NACH DIN 650 | FOR KEYWAYS ACC. DIN 650 | POUR RAINURES SELON DIN 650 | PARA RANURAS SEGUN DIN 650



Ø d_1 d_{11}	b	Ø d_3 h_{12}	l_1	Ø d_2	Z	9520	9522
						HSS-Co5	HSS-Co5
11	4	4	53,5	10	6	**€ 71,00**	**€ 66,60** ■
12,5	6	5	57	10	6	**€ 76,10**	-
16	8	7	62	10	6	**€ 96,10**	-
18	8	8	70	12	6	**€ 106,50**	**€ 71,00** ■
19▲	9	8	71	12	6	**€ 113,50**	**€ 106,00** ■
21	9	10	74	12	6	**€ 116,50**	-
22▲	10	10	75	12	6	**€ 132,50**	-
25	11	12	82	16	8	**€ 160,50**	-
28▲	12	13	85	16	8	**€ 186,50**	**€ 174,50** ■
32	14	15	90	16	8	**€ 190,00**	-
36▲	16	17	103	25	8	**€ 264,00**	-
40	18	19	108	25	10	**€ 322,00**	-
45▲	20	21	113	25	10	**€ 374,00**	**€ 353,00** ■
50	22	25	124	32	10	**€ 471,00**	-
60	28	30	139	32	10	**€ 589,00**	-

P	●●○	●●○
M	●○○	●○○
K	●●●	●●●
N	●●○	●●○
S	●○○	●○○
H	○○○	○○○

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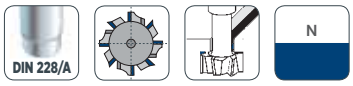
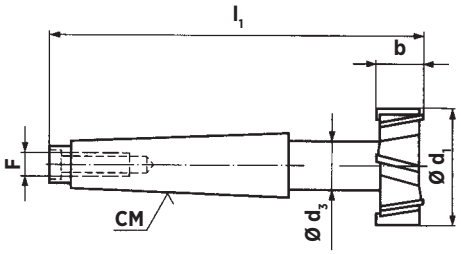
▲ ILLICO NORM

HSS-Co5

DIN 851



PER SCANALATURE SECONDO DIN 650
FUR NUTEN NACH DIN 650 | FOR KEYWAYS ACC. DIN 650 | POUR RAINURES SELON DIN 650 | PARA RANURAS SEGUN DIN 650



Ø d_1 d_{11}	b	Ø d_3 h_{12}	l_1	CM	F	Z	9524
							HSS-Co5
18	8	8	82	1	M 6	6	**€ 108,00** ■
21	9	10	102	2	M10	6	**€ 121,50** ■
25	11	12	104	2	M10	8	**€ 151,50** ■
28▲	12	13	106	2	M10	8	**€ 162,00** ■
50	22	25	187	4	M16	10	**€ 435,00** ■

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P	●○○
M	●○○
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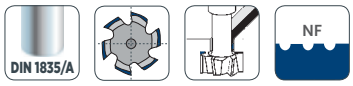
N	●○○
S	●○○
H	○○○

▲ ILLICO NORM

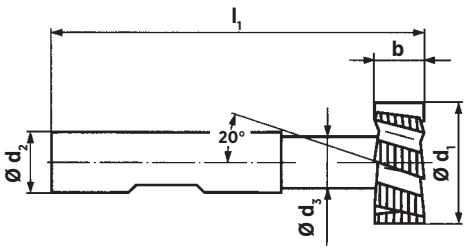
HSS-Co5

DIN 851



PER SCANALATURE SECONDO DIN 650

FUR NUTEN NACH DIN 650 | FOR KEYWAYS ACC. DIN 650 | POUR RAINURES SELON DIN 650 | PARA RANURAS SEGUN DIN 650



Ø d_1 d_{11}	b	Ø d_3 h_{12}	l_1	Ø d_2	Z	9526
						HSS-Co5
21	9	10	74	12	6	**€ 151,50**
22▲	10	10	75	12	6	**€ 156,50**
25	11	12	82	16	6	**€ 173,00**
28▲	12	13	85	16	6	**€ 184,50**
32	14	15	90	16	6	**€ 209,00**
36▲	16	17	103	25	6	**€ 274,00**
40	18	19	108	25	8	**€ 322,00**
45▲	20	21	113	25	8	**€ 401,00**

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P	●●○
M	●○○
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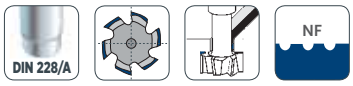
N	●●○
S	●○○
H	○○○

▲ ILLICO NORM

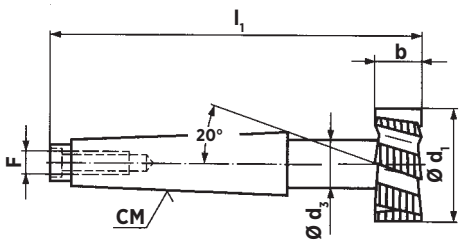
HSS-Co5

DIN 851



PER SCANALATURE SECONDO DIN 650

FUR NUTEN NACH DIN 650 | FOR KEYWAYS ACC. DIN 650 | POUR RAINURES SELON DIN 650 | PARA RANURAS SEGUN DIN 650



Ø d_1 d_{11}	b	Ø d_3 h_{12}	l_1	CM	F	Z	9530
							HSS-Co5
56▲	24	28	192	4	M16	10	**€ 574,00** ■
85	40	42	255	5	M20	10	**€ 1.145,00** ■
95	44	44	264	5	M20	10	**€ 1.356,00** ■

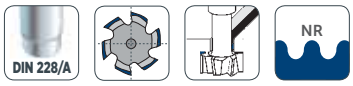
p. 220 | p. 186

P	●●○
M	●○○
K	●●●
N	●●○
S	●○○
H	○○○

▲ ILLICO NORM

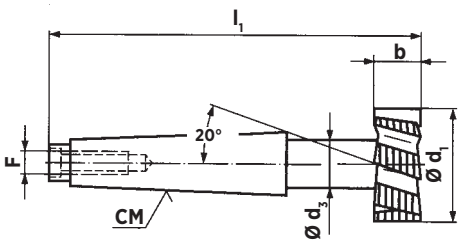
HSS-Co5

DIN 851



PER SCANALATURE SECONDO DIN 650

FUR NUTEN NACH DIN 650 | FOR KEYWAYS ACC. DIN 650 | POUR RAINURES SELON DIN 650 | PARA RANURAS SEGUN DIN 650



Ø d_1 d_{11}	b	Ø d_3 h_{12}	l_1	CM	F	Z	9536
							HSS-Co5
56▲	24	28	192	4	M16	10	**€ 548,00** ■
72	35	36	248	5	M20	10	**€ 1.059,00** ■
85	40	42	255	5	M20	10	**€ 1.359,00** ■
95	44	44	264	5	M20	10	**€ 1.356,00** ■

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P	●●○
M	●○○
K	●●●
N	●●○
S	●○○
H	○○○

▲ **ILLICO NORM**

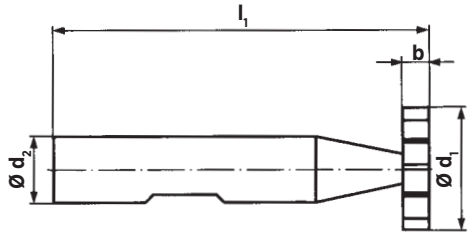
HSS-Co5

DIN 851

DIN 1835/A | DIN 1835/B | N

PER SCANALATURE SECONDO DIN 6888

FUR NUTEN NACH DIN 6888 | FOR KEYWAYS ACC. DIN 6888 | POUR RAINURES SELON DIN 6888 | PARA RANURAS SEGUN DIN 6888



Ø d_1 h10	b e_8	l_1	Ø d_2	Z		9542	9544
						HSS-Co5	HSS-Co5
10,5	2	50	6	6		**€ 56,30**	**€ 53,50** ■
10,5	2,5	50	6	6		**€ 56,30**	-
10,5	3	50	6	6		**€ 56,30**	-
13,5▲	2	56	10	6		**€ 62,60**	-
13,5	3	56	10	6		**€ 62,60**	-
13,5	4	56	10	6		**€ 64,80**	-
16,5	3	56	10	6		**€ 67,70**	**€ 64,50** ■
16,5	4	56	10	6		**€ 69,90**	-
16,5	5	56	10	6		**€ 69,90**	**€ 66,60** ■
19,5▲	3	63	10	8		**€ 88,90**	-
19,5	4	63	10	8		**€ 88,90**	-
19,5	5	63	10	8		**€ 88,90**	**€ 84,40** ■
19,5	6	63	10	8		**€ 88,90**	-
22,5▲	4	63	10	8		**€ 104,50**	-
22,5	5	63	10	8		**€ 104,50**	**€ 99,40** ■
22,5	6	63	10	8		**€ 104,50**	-
22,5	8	63	10	8		**€ 104,50**	-
25,5▲	5	63	10	10		**€ 137,00**	**€ 130,00** ■
25,5	6	63	10	10		**€ 137,00**	-
28,5	6	63	10	10		**€ 147,50**	**€ 139,00** ■
28,5	8	63	10	10		**€ 147,50**	-
28,5	10	71	12	10		**€ 147,50**	**€ 139,00** ■
32,5▲	6	71	12	10		**€ 156,50**	-
32,5	8	71	12	10		**€ 156,50**	-
32,5	10	71	12	10		**€ 156,50**	-
38,5▲	8	71	12	10		**€ 239,50**	-
45,5▲	8	71	12	12		**€ 274,00**	-
45,5	10	71	12	12		**€ 274,00**	-
					P	●●○	●●○
					M	●○○	●○○
					K	●●●	●●●
					N	●●○	●●○
					S	●○○	●○○
					H	○○○	○○○

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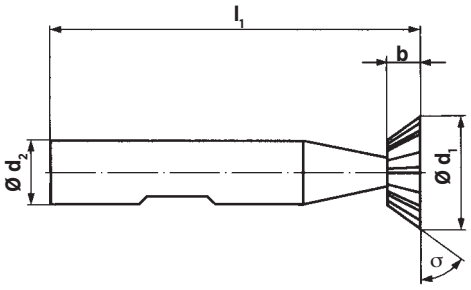
▲ ILLICO NORM

HSS-Co5

DIN 1833

DIN 1835/A | DIN 1835/B | N



Ø d_1	σ	b	l_1	Ø d_2	Z		9546	9548
							HSS-Co5	HSS-Co5
16	45°	4	60	12	8		**€ 68,70**	-
20	45°	5	63	12	10		**€ 84,40**	-
25	45°	6,3	67	12	10		**€ 118,50**	**€ 110,00** ■
16	50°	5	60	12	8		**€ 72,10**	**€ 67,20** ■
20	50°	6,3	63	12	10		**€ 85,00**	**€ 79,60** ■
25	50°	8	67	12	10		**€ 118,50**	-
16	55°	5,6	60	12	8		**€ 72,10**	**€ 67,20** ■
20	55°	7,1	63	12	10		**€ 85,00**	**€ 79,60** ■
25	55°	9	67	12	10		**€ 118,50**	**€ 110,00** ■
16	60°	6,3	60	12	8		**€ 68,70**	**€ 64,00** ■
20	60°	8	63	12	10		**€ 84,40**	-
25	60°	10	67	12	10		**€ 118,50**	-
16▲	70°	7	60	12	8		**€ 72,70**	**€ 67,70** ■
20▲	70°	9	63	12	10		**€ 91,70**	**€ 85,50** ■
25▲	70°	11	67	12	10		**€ 122,00**	**€ 114,00** ■
						P	●●○	●●○
						M	●○○	●○○
						K	●●●	●●●
						N	●●○	●●○
						S	●○○	●○○
						H	○○○	○○○

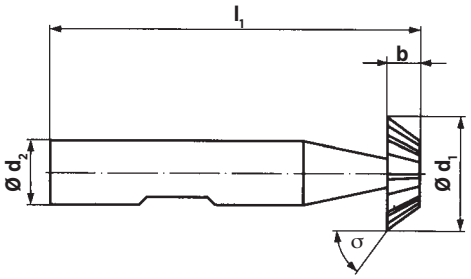
i p. 220 | V_c/F_z p. 189

▲ ILLICO NORM

HSS-Co5

DIN 1833

DIN 1835/A | DIN 1835/B | N



Ø d_1	σ	b	l_1	Ø d_2	Z		9550	9552
							HSS-Co5	HSS-Co5
16	45°	4	60	12	8		**€ 68,70**	-
20	45°	5	63	12	10		**€ 84,40**	-
25	45°	6,3	67	12	10		**€ 118,50**	-
16	60°	5	60	12	8		**€ 68,70**	-
20	60°	6,3	63	12	10		**€ 84,30**	**€ 78,40** ■
25	60°	8	67	12	10		**€ 118,00**	**€ 108,50** ■
16▲	70°	5,6	60	12	8		**€ 72,70**	-
20▲	70°	7,1	63	12	10		**€ 91,70**	**€ 85,50** ■
25▲	70°	9	67	12	10		**€ 122,00**	**€ 114,00** ■

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P	●●○	●●○
M	●○○	●○○
K	●●●	●●●
N	●●○	●●○
S	●○○	●○○
H	○○○	○○○

▲ ILLICO NORM

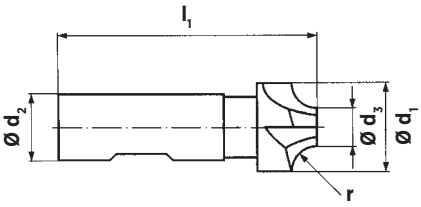
HSS-Co5

DIN 6518

DIN 1835/A | DIN 1835/B | N

1/4 CIRCOLARE

VIERTELRUND | CORNER-ROUNDING | 1/4 DE CERCLE | DE CUARTO DE CIRCULO



r_{H11}	Ø d_1	Ø d_3	l_1	Ø d_2	Z		9554	9556
							HSS-Co5	HSS-Co5
1	8	6	60	10	4		**€ 54,90**	-
1,25	8,5	6	60	10	4		**€ 59,30**	**€ 59,20** ■
1,5	9	6	60	10	4		**€ 59,30**	-
1,6	9,2	6	60	10	4		-	**€ 58,00** ■
2	10	6	60	10	4		**€ 59,30**	-
2,5	11	6	60	10	4		**€ 59,30**	-
3	12	6	60	12	4		**€ 59,30**	-
3,5	13	6	60	12	4		**€ 62,60**	**€ 63,40** ■
4	14	6	60	12	4		**€ 63,80**	**€ 63,40** ■
4,5	15	6	60	12	4		**€ 74,90**	**€ 75,30** ■
5	16	6	60	12	4		**€ 74,90**	-
5,5	19	8	67	16	4		**€ 89,40**	**€ 89,80** ■
6	20	8	67	16	4		**€ 89,40**	**€ 89,80** ■
6,3	20,6	8	71	16	4		**€ 115,00** ■	**€ 98,30** ■
6,5	21	8	71	16	4		**€ 100,00**	**€ 100,50** ■
7	22	8	71	16	4		**€ 100,00**	**€ 100,50** ■
7,5	23	8	71	16	4		**€ 104,50**	**€ 105,00** ■
8	24	8	71	16	4		**€ 100,00**	**€ 100,50** ■
8,5	25	8	85	25	4		**€ 127,00**	**€ 133,00** ■
9	26	8	85	25	4		**€ 123,50**	**€ 130,00** ■
9,5	27	8	85	25	4		**€ 130,50**	**€ 136,50** ■
10	28	8	85	25	4		**€ 130,50**	-
11	32	10	90	25	4		**€ 159,50**	**€ 165,50** ■
12	34	10	90	25	4		**€ 163,50**	-
12,5	41	16	100	25	6		**€ 247,00**	-
13	42	16	100	25	6		**€ 253,50**	-
14	44	16	100	25	6		**€ 253,50**	**€ 259,50** ■
15	46	16	100	25	6		**€ 347,00**	-
16	48	16	100	25	6		**€ 347,00**	**€ 354,00** ■
18	52	16	112	32	6		**€ 415,00**	**€ 421,00** ■
20	56	16	112	32	6		**€ 495,00**	**€ 499,00** ■

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P	●●○	●●○
M	●○○	●○○
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N	●●○	●●○
S	●○○	●○○
H	○○○	○○○

HSS

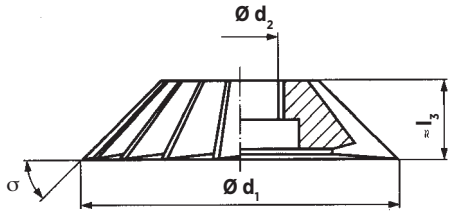
DIN 842

FRESE A MANICOTTO

AUFSTECK FRÄSER | SHELL ENDMILLS | FRAISES A TROU LISSE | FRESAS HUECAS

DIN 138

N



Ø d_1	σ	l_3	Ø d_2	Z	9575
					HSS
40	45°	10	10	16	**€ 153,00**
50	45°	13	13	18	**€ 178,50**
63	45°	18	16	20	**€ 227,50**
80	45°	22	22	22	**€ 319,00**
100	45°	28	27	26	**€ 485,00**
40	50°	13	10	16	**€ 153,00**
50	50°	16	13	18	**€ 178,50**
63	50°	20	16	20	**€ 227,50**
80	50°	25	22	22	**€ 319,00**
100	50°	32	27	26	**€ 485,00**
125	50°	40	32	28	**€ 854,00**
40	55°	13	10	14	**€ 153,00**
50	55°	16	13	16	**€ 178,50**
63	55°	20	16	18	**€ 227,50**
80	55°	25	22	20	**€ 319,00**
100	55°	32	27	22	**€ 485,00**
125	55°	40	32	24	**€ 854,00**
40	60°	13	10	14	**€ 153,00**
50	60°	16	13	16	**€ 178,50**
63	60°	20	16	18	**€ 227,50**
80	60°	25	22	20	**€ 319,00**
100	60°	32	27	22	**€ 485,00**
125	60°	40	32	24	**€ 854,00**
160	60°	50	40	28	**€ 1.479,00**

p. 220 p. 190

P	●●○
M	●○○
K	●●●
N	●●○
S	●○○
H	○○○

HSS-Co5

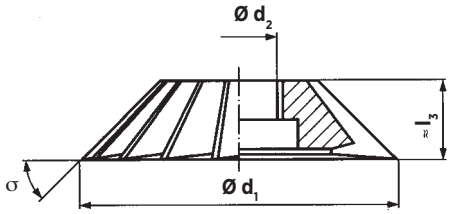
DIN 842

FRESE A MANICOTTO

AUFSTECK FRÄSER | SHELL ENDMILLS | FRAISES A TROU LISSE | FRESAS HUECAS

DIN 138

NF



Ø d_1 K_{14}	σ	l_3	Ø d_2 h_7	Z	9595
					HSS-Co5
80	45°	22	22	22	**€ 717,00**
100	45°	28	27	26	**€ 1.082,00**
160	45°	45	40	28	**€ 2.984,00**
80	50°	25	22	22	**€ 717,00**
100	50°	32	27	26	**€ 1.082,00**
125	50°	40	32	28	**€ 1.922,00**
80	60°	25	22	20	**€ 717,00**
100	60°	32	27	22	**€ 1.082,00**
125	60°	40	32	24	**€ 1.806,00**
160	60°	50	40	28	**€ 3.051,00**

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P	●●○
M	●○○
K	●●●
N	●●○
S	●○○
H	○○○

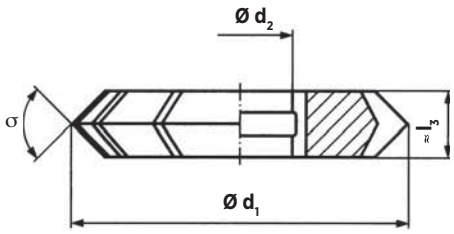
HSS

DIN 847

FRESE A MANICOTTO
AUFSTECK FRÄSER | SHELL ENDMILLS | FRAISES A TROU LISSE | FRESAS HUECAS

DIN 138

N



Ø d_1	σ	l_3	Ø d_2	Z	9576
					HSS
50	45°	8	16	20	**€ 170,00**
63	45°	10	22	22	**€ 222,00**
80	45°	12	27	24	**€ 318,00**
100	45°	18	32	26	**€ 518,00**
50	60°	10	16	18	**€ 170,00**
63	60°	14	22	20	**€ 222,00**
80	60°	18	27	22	**€ 318,00**
100	60°	25	32	24	**€ 518,00**
50	90°	14	16	16	**€ 171,00**
63	90°	20	22	18	**€ 231,00**
80	90°	22	27	20	**€ 333,00**
100	90°	32	32	24	**€ 534,00**
50▲	120°	14	16	16	**€ 170,00**
63▲	120°	20	22	16	**€ 222,00**
80▲	120°	25	27	20	**€ 318,00**
100▲	120°	36	32	24	**€ 567,00**

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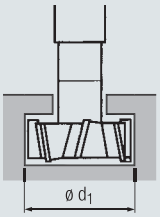
P	●●○
M	●○○
K	●●●
N	●●○
S	●○○
H	○○○

▲ ILLICO NORM

TIPO N-NR | TYPE N-NR

f_z [mm] **AVANZAMENTO AL DENTE** | f_Z [mm] TOOTH FOR FEED



Ø	**CAVA f_z** SLOTTING f_z
11	0,014
16	0,021
18	0,032
20	0,036
22	0,040
25	0,030
28	0,034
32	0,038
40	0,144
50	0,180
60	0,216

V_c [m/min] **VELOCITÀ DI TAGLIO** | V_C [m/min] CUTTING SPEED

		P_1	P_2	P_3	M_1	M_2	K_1	K_2	N_1	N_2	S_1	S_2	H
V_c [m/min] **RIVESTITO** COATED	**Min**	25	20	15	10	7	20	15	70	30	10	-	-
	Max	35	30	25	15	10	30	25	100	45	15	-	-
V_c [m/min] **NON RIVESTITO** UNCOATED	**Min**	20	15	10	7	5	15	10	60	15	7	-	-
	Max	25	20	15	10	7	20	15	90	20	10	-	-
* **COEFFICIENTE AVANZAMENTO** * FEED COEFFICIENT		**1**	**0,8**	**0,6**	**0,6**	**0,4**	**1**	**0,7**	**1,8**	**1**	**0,4**	**0,6**	**0,4**

* **Moltiplicare l'avanzamento "f_z" relativo al diametro x il coefficiente avanzamento relativo al materiale.**
Esempio: fresa Ø 11 (cava) "f_z" 0,014 materiale gruppo P_3 - 0,014x0,6 = 0,008 "f_z"

* Multiply the feed "f_z" of the diameter by the feed coefficient of the related material.
Example: Endmill Ø 11 (slotting) "f_z" 0,014 material group P_3 - 0,014x0,6 = 0,008 "f_z"

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PER ULTERIORI INFORMAZIONI CONTATTATECI

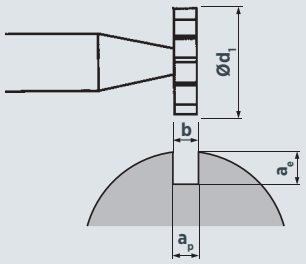
FOR MORE INFORMATION PLEASE CONTACT US

Angelo Ghezzi & C SpA

www.angeloghezzi.it

TIPO N | TYPE N

f_z [mm] **AVANZAMENTO AL DENTE** | f_Z [mm] TOOTH FOR FEED



a_e = **DIN 6888 (WOODRUFF)**

a_p = **b**

Ø	**CAVA f_z** SLOTTING f_z
10,5	0,026
13,5	0,034
16,5	0,041
19,5	0,049
22,5	0,032
28,5	0,040
32,5	0,046
38,5	0,054
45,5	0,064

V_C [m/min] **VELOCITÀ DI TAGLIO** | V_C [m/min] CUTTING SPEED

		P_1	P_2	P_3	M_1	M_2	K_1	K_2	N_1	N_2	S_1	S_2	H
V_C [m/min] **RIVESTITO** COATED	**Min**	-	-	-	-	-	-	-	-	-	-	-	-
	Max	-	-	-	-	-	-	-	-	-	-	-	-
V_C [m/min] **NON RIVESTITO** UNCOATED	**Min**	20	15	10	5	4	15	10	30	20	5	-	-
	Max	30	25	20	10	8	25	20	60	40	15	-	-
* **COEFFICIENTE AVANZAMENTO** * FEED COEFFICIENT		**1**	**0,8**	**0,6**	**0,6**	**0,4**	**1**	**0,7**	**1,8**	**1**	**0,4**	**0,6**	**0,4**

* **Moltiplicare l'avanzamento "f_z" relativo al diametro x il coefficiente avanzamento relativo al materiale.**
Esempio: fresa Ø 12 (cava) "f_z" 0,026 materiale gruppo P_3 - 0,026x0,6 = 0,015 "f_z"

* Multiply the feed "f_z" of the diameter by the feed coefficient of the related material.
Example: Endmill Ø 12 (slotting) "f_z" 0,026 material group P_3 - 0,026x0,6 = 0,015 "f_z"

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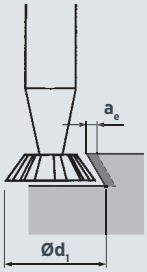
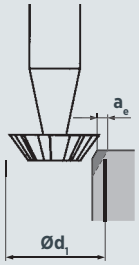
TIPO N | TYPE N

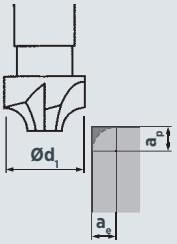
f_z [mm] **AVANZAMENTO AL DENTE** | f_z [mm] TOOTH FOR FEED



a_e = 0.2 x d_1 mm



a_e = 0.2 x d_1 mm



a_e = r

a_p = r

Ø	**CAVA f_z** SLOTTING f_z	**PROFILATURA f_z** PROFILING f_z
16	0,011	0,015
20	0,014	0,018
25	0,018	0,023

V_C [m/min] **VELOCITÀ DI TAGLIO** | V_C [m/min] CUTTING SPEED

		P_1	P_2	P_3	M_1	M_2	K_1	K_2	N_1	N_2	S_1	S_2	H
V_C [m/min] **RIVESTITO** COATED	**Min**	-	-	-	-	-	-	-	-	-	-	-	-
	Max	-	-	-	-	-	-	-	-	-	-	-	-
V_C [m/min] **NON RIVESTITO** UNCOATED	**Min**	20	15	10	5	4	15	10	30	20	5	-	-
	Max	30	25	20	10	8	25	20	60	40	15	-	-
* **COEFFICIENTE AVANZAMENTO** * FEED COEFFICIENT		**1**	**0,8**	**0,6**	**0,6**	**0,4**	**1**	**0,7**	**1,8**	**1**	**0,4**	**0,6**	**0,4**

* **Moltiplicare l'avanzamento "f_z" relativo al diametro x il coefficiente avanzamento relativo al materiale.**
Esempio: fresa Ø 16 (cava) "f_z" 0,011 materiale gruppo P_3 - 0,011x0,6 = 0,006 "f_z"

* Multiply the feed "f_z" of the diameter by the feed coefficient of the related material.
Example: Endmill Ø 16 (slotting) "f_z" 0,011 material group P_3 - 0,011x0,6 = 0,006 "f_z"

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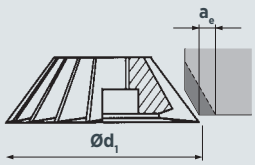
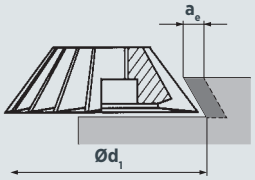
TIPO N-NF | TYPE N-NF

f_z [mm] **AVANZAMENTO AL DENTE** | f_Z [mm] TOOTH FOR FEED



a_e = 0.1 x d_1 mm



a_e = 0.1 x d_1 mm

Ø	CONTORNATURA f_z SIDE MILLING f_z	CAVA f_z SLOTTING f_z
40	0,008	0,006
50	0,010	0,008
63	0,013	0,009
80	0,016	0,012
100	0,020	0,015
125	0,025	0,019
160	0,032	0,024

V_C [m/min] **VELOCITÀ DI TAGLIO** | V_C [m/min] CUTTING SPEED

		P_1	P_2	P_3	M_1	M_2	K_1	K_2	N_1	N_2	S_1	S_2	H
V_c [m/min] **RIVESTITO** COATED	**Min**	-	-	-	-	-	-	-	-	-	-	-	-
	Max	-	-	-	-	-	-	-	-	-	-	-	-
V_c [m/min] **NON RIVESTITO** UNCOATED	**Min**	15	10	8	5	-	10	8	30	20	5	-	-
	Max	20	15	10	10	-	15	10	60	30	10	-	-
* **COEFFICIENTE AVANZAMENTO** * FEED COEFFICIENT		**1**	**0,8**	**0,6**	**0,6**	**0,4**	**1**	**0,7**	**1,8**	**1**	**0,4**	**0,6**	**0,4**

* **Moltiplicare l'avanzamento "f_z" relativo al diametro x il coefficiente avanzamento relativo al materiale.**
Esempio: fresa Ø 40 (cava) "f_z" 0,006 materiale gruppo P_3 - 0,006x0,6 = 0,0036 "f_z"

* Multiply the feed "f_z" of the diameter by the feed coefficient of the related material.
Example: Endmill Ø 40 (slotting) "f_z" 0,006 material group P_3 - 0,006x0,6 = 0,0036 "f_z"

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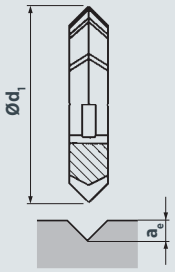
TIPO N | TYPE N

f_z [mm] **AVANZAMENTO AL DENTE** | f_z [mm] TOOTH FOR FEED



a_e = 0.1 x d_1 mm

Ø	CAVA f_z SLOTTING f_z
50	0,010
63	0,012
80	0,015
100	0,019

V_C [m/min] **VELOCITÀ DI TAGLIO** | V_C [m/min] CUTTING SPEED

		P_1	P_2	P_3	M_1	M_2	K_1	K_2	N_1	N_2	S_1	S_2	H
V_c [m/min] **RIVESTITO** COATED	**Min**	-	-	-	-	-	-	-	-	-	-	-	-
	Max	-	-	-	-	-	-	-	-	-	-	-	-
V_c [m/min] **NON RIVESTITO** UNCOATED	**Min**	15	10	8	5	-	10	8	30	20	5	-	-
	Max	20	15	10	10	-	15	10	60	30	10	-	-
* **COEFFICIENTE AVANZAMENTO** * FEED COEFFICIENT		**1**	**0,8**	**0,6**	**0,6**	**0,4**	**1**	**0,7**	**1,8**	**1**	**0,4**	**0,6**	**0,4**

* **Moltiplicare l'avanzamento "f_z" relativo al diametro x il coefficiente avanzamento relativo al materiale.**
Esempio: fresa Ø 40 (cava) "f_z" 0,006 materiale gruppo P_3 - 0,006x0,6 = 0,0036 "f_z"

* Multiply the feed "f_z" of the diameter by the feed coefficient of the related material.
Example: Endmill Ø 40 (slotting) "f_z" 0,006 material group P_3 - 0,006x0,6 = 0,0036 "f_z"

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