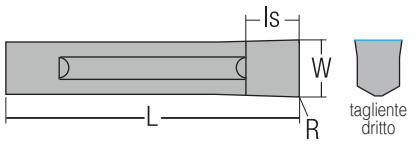
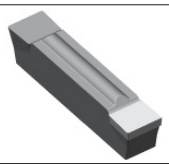
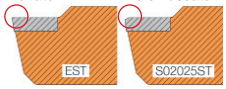
OTX PCBN

materiali temprati e ghisa







ISO 513	PCBN CBN5625GL rivestimento PVD	PCBN CBN1630GL non rivestito
P		
M		
K		★
N		
S		
H	★	☆

S	DESCRIZIONE		W	R	L	ls	STOCK CBN5625GL	STOCK CBN1630GL
30	OTX	304 EST	$3.00^{\pm0.025}$	0.4	20,00	3.00		○
		304 S02025ST	$3.00^{\pm0.025}$	0.4	20,00	3.00	○	○
40	OTX	404 EST	$4.00^{\pm0.025}$	0.4	20.00	3.30		○
		404 S02025ST	$4.00^{\pm0.025}$	0.4	20.00	3.30	○	○
50	OTX	508 EST	$5.00^{\pm0.025}$	0.8	25.00	3.50		○
		508 S02025ST	$5.00^{\pm0.025}$	0.8	25.00	3.50	○	○
60	OTX	608 EST	$6.00^{\pm0.025}$	0.8	30.00	4.00		○
		608 S02025ST	$6.00^{\pm0.025}$	0.8	30.00	4.00	○	○

Velocità di taglio Vc [m/min]			CBN5625GL	CBN1630GL
	GHISE	K		★ 250÷1000
	MATERIALI TEMPRATI	H	★ 80÷150	☆ 80÷120

◯ lavorazione stabile ⬭ uso generico ⬡ condizioni difficili

★ prima scelta - ☆ seconda scelta

Avanzamento fn [mm/giro]	Raggio inserto	Larghezza inserto W 3	4	5	6
	R 0.4	0.05÷0.15	0.08÷0.15	-	-
	R 0.8	-	-	0.08÷0.16	0.08÷0.18

H considerare dal valore minimo al valore medio

K considerare dal valore medio al valore massimo

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MATERIALI p. 263

DATI TECNICI p. 241