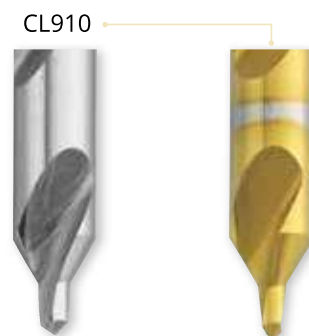
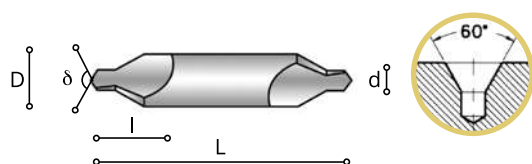
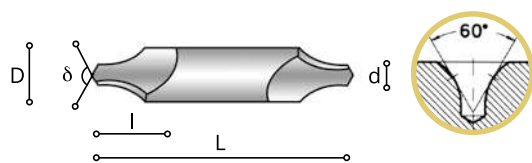


CL 910



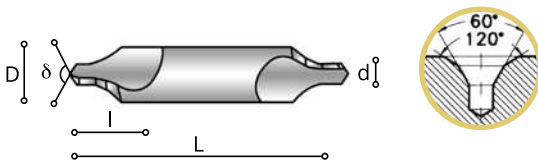
d k13	D h9	L	CODE	HSS 5910..... €	HSS 6910..... € QUARTZ
1	3,15	31,500100	6,84	9,49
1,25	3,15	31,500125	6,72	9,40
1,6	4	35,500160	6,52	9,19
2	5	4000200	7,06	10,49
2,5	6,3	4500250	7,96	11,99
3,15	8	5000315	9,45	13,62
4	10	5600400	15,58	21,01
5	12,5	6300500	22,33	28,76
6,3	16	7100630	32,02	39,42

CL 920



d k13	D h9	L	CODE	HSS 5920..... €	HSS 6920..... € QUARTZ
1	3,15	31,500100	6,99	9,66
1,25	3,15	31,500125	6,89	9,58
1,6	4	35,500160	5,61	8,20
2	5	4000200	9,01	12,62
2,5	6,3	4500250	9,60	13,79
3,15	8	5000315	10,28	14,55
4	10	5600400	16,06	21,52
5	12,5	6300500	23,59	30,15
6,3	16	7100630	33,68	41,25

CL 930



d k13	D h9	L	CODE	HSS 5930..... €	HSS 6930..... € QUARTZ
1	4	35,500100	11,18	14,24
1,25	5	4000125	11,41	15,17
1,6	6,3	4500160	11,75	16,15
2	8	5000200	11,75	16,15
2,5	10	5600250	16,13	21,57
3,15	11,2	6000315	20,06	25,90
4	14	6700400	29,02	36,09
5	18	7500500	40,32	49,83
6,3	20	8000630	51,84	64,39

Carmon

PUNTE DA CENTRO CENTER DRILLS



$$\text{rpm} = (\text{m/min} \times 1000) / (D \times 3,14)$$



$$\text{mm/min} = \text{mm/rev} \times \text{rpm}$$



$$= \text{m/min}$$



$$= \text{mm/rev}$$

(vedi tabella - see table page 23)



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TIPO DI ACCIAIO TYPE OF STEEL		N/mm ²	HV	m/min	mm/rev
ACCIAI COMUNI COMMON STEEL	Acciai teneri Soft steel	1	500	157	30 b
	Acciai da costruzione Structural steel	2	700	219	22 c
	Acciai da tempra Hardening steel	3	900	280	13 c
	Acciaio automatico Automatic steel	4	1200	373	
ACCIAI INOX STAINLESS STEEL	Acciaio automatico Automatic steel	3	850	265	17 b
	Austenitico Austenitic	3	850	265	8 c
	Ferritico-austenitico Ferritic austenitic	4	1000	311	10 b
GHISA CAST IRON	Ghisa fino a 180 hb Cast iron up to 180hb	2	500	157	30 d
	Ghisa oltre 180 hb Cast iron over 180hb	3	700	219	20 b
TITANIO TITANIUM	Titanio non legato Unalloyed titanium	5	500	157	22 b
	Leghe di titanio Titanium alloys	5	900	280	10 a
RAME COPPER	Rame Copper	9	350	110	30 c
	Ottone Brass	9	700	219	33 c
	Bronzo Bronze	9	700	219	15 c
NICHEL NICKEL	Nichel non legato Unalloyed nichel	6	700	219	10 b
	Leghe di nichel Nichel alloys	6	900	280	5 a
ALLUMINIO ALUMINIUM	Alluminio non legato Unalloyed aluminium	7	350	110	35 d
	Alluminio con leghe Alloyed aluminium	7	400	125	30 d
	Alluminio con leghe Alloyed aluminium	7	500	157	25 c

FORATURA DRILLING

TABELLA PARAMETRI DI AVANZAMENTO mm/giro RECOMMENDED FEED DATA mm/rev.

LETTERA DI RIFERIMENTO REFERENCE LETTER

DIAMETRO DELLA PUNTA DRILL DIAMETER

	D.1	D.2	D.3	D.4	D.5	D.6
a	0,015	0,030	0,038	0,047	0,053	0,060
b	0,020	0,050	0,070	0,085	0,100	0,120
c	0,023	0,080	0,100	0,130	0,150	0,180
d	0,030	0,100	0,160	0,180	0,220	0,240