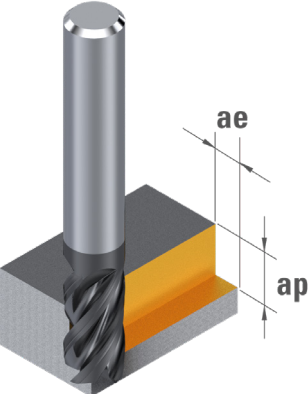


CONTORNATURA

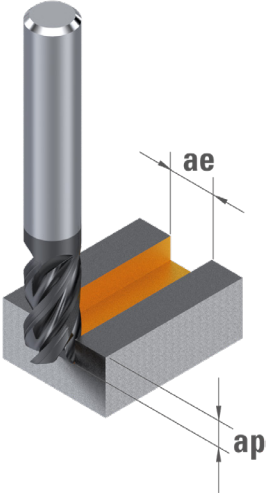
		VDI 3323		MD nudo Vc [m/min]	ae (mm)	ap (mm)
P	Acciaio non legato	1 - 5		155	< 0.3×ØD1	< 1×L1
N	Leghe d'alluminio < 12% Si	21 - 22		200	< 0.5×ØD1	< 1×L1
	Fusioni d'alluminio >12% Si	23 - 25		175	< 0.4×ØD1	< 1×L1
	Leghe Cu bronzo ottone con Pb	26		170	< 0.5×ØD1	< 1×L1
	Lega di rame difficile da lavorare	27 - 28		150	< 0.4×ØD1	< 1×L1
	Plastica, legno	29 - 30		150	< 0.5×ØD1	< 1×L1
	Oro, argento	-		150	< 0.3×ØD1	< 1×L1
S	Titanio e relative leghe	36 - 37		60	< 0.2×ØD1	< 1×L1

$$n \text{ [g/min]} = \frac{Vc \text{ [m/min]} \times 1000}{\pi \times D_1 \text{ [mm]}}$$

$$Vf \text{ [mm/min]} = n \text{ [g/min]} \times fz \text{ [mm]} \times Z$$

Avanzamento al dente fz [mm]						
Ø D ₁ 0.40 - 0.90	Ø D ₁ 1.00 - 1.50	Ø D ₁ 1.60 - 2.00	Ø D ₁ 2.20 - 2.80	Ø D ₁ 3.00 - 4.00	Ø D ₁ 4.50 - 6.00	
0.004 - 0.009	0.010 - 0.015	0.016 - 0.020	0.022 - 0.028	0.030 - 0.040	0.046 - 0.060	
0.006 - 0.014	0.015 - 0.023	0.024 - 0.030	0.033 - 0.042	0.045 - 0.060	0.068 - 0.090	
0.005 - 0.012	0.013 - 0.020	0.021 - 0.026	0.029 - 0.036	0.039 - 0.052	0.058 - 0.080	
0.006 - 0.014	0.015 - 0.023	0.024 - 0.030	0.033 - 0.042	0.045 - 0.060	0.068 - 0.090	
0.005 - 0.011	0.012 - 0.018	0.019 - 0.024	0.026 - 0.034	0.036 - 0.048	0.054 - 0.070	
0.006 - 0.014	0.015 - 0.023	0.024 - 0.030	0.033 - 0.042	0.045 - 0.060	0.068 - 0.090	
0.004 - 0.009	0.010 - 0.015	0.016 - 0.020	0.022 - 0.028	0.030 - 0.040	0.046 - 0.060	
0.003 - 0.007	0.008 - 0.011	0.012 - 0.015	0.017 - 0.021	0.023 - 0.030	0.034 - 0.045	

LAVORAZIONE

		VDI 3323		MD nudo Vc [m/min]	ae (mm)	ap (mm)
P	Acciaio non legato	1 - 5		80	1×ØD1	< 0.3×ØD1
N	Leghe d'alluminio < 12% Si	21 - 22		70	1×ØD1	< 0.5×ØD1
	Fusioni d'alluminio >12% Si	23 - 25		60	1×ØD1	< 0.4×ØD1
	Leghe Cu bronzo ottone con Pb	26		120	1×ØD1	< 0.5×ØD1
	Lega di rame difficile da lavorare	27 - 28		105	1×ØD1	< 0.4×ØD1
	Plastica, legno	29 - 30		55	1×ØD1	< 0.5×ØD1
	Oro, argento	-		105	1×ØD1	< 0.3×ØD1
S	Titanio e relative leghe	36 - 37		40	1×ØD1	< 0.2×ØD1

Avanzamento al dente fz [mm]						
Ø D ₁ 0.40 - 0.90	Ø D ₁ 1.00 - 1.50	Ø D ₁ 1.60 - 2.00	Ø D ₁ 2.20 - 2.80	Ø D ₁ 3.00 - 4.00	Ø D ₁ 4.50 - 6.00	
0.003 - 0.007	0.008 - 0.011	0.012 - 0.015	0.017 - 0.021	0.023 - 0.030	0.034 - 0.045	
0.005 - 0.011	0.011 - 0.017	0.018 - 0.023	0.025 - 0.032	0.034 - 0.045	0.052 - 0.070	
0.004 - 0.009	0.010 - 0.015	0.016 - 0.020	0.022 - 0.027	0.029 - 0.039	0.044 - 0.060	
0.005 - 0.011	0.011 - 0.017	0.018 - 0.023	0.025 - 0.032	0.034 - 0.045	0.052 - 0.070	
0.004 - 0.008	0.009 - 0.014	0.014 - 0.018	0.020 - 0.026	0.027 - 0.036	0.040 - 0.055	
0.005 - 0.011	0.011 - 0.017	0.018 - 0.023	0.025 - 0.032	0.034 - 0.045	0.052 - 0.070	
0.003 - 0.007	0.008 - 0.011	0.012 - 0.015	0.017 - 0.021	0.023 - 0.030	0.034 - 0.045	
0.002 - 0.005	0.006 - 0.008	0.009 - 0.011	0.013 - 0.016	0.017 - 0.023	0.026 - 0.035	