

SEGHE A NASTRO BIMETALLICHE
Tabella N. 47/c

caratteristiche e parametri delle seghe a nastro in riferimento ai vari materiali

Materiale	N.	denominazione DIN	durezza Brinell HB	spessore mm	numero denti p. poll. = 25,4 mm	velocità di taglio m/min	rendimento M42 cm ² /min	refrigeranti-lubrificanti		
								olio emuls.	olio da taglio	lubrif. non grasso
Acciaio HSS	1.3357	S 18-0-2	217-248	fino a 25	10-8	40	6,0-13,0	1:30		x
				25-70	10-8	34	13,0-19,0			
				70-150	6-4	30	13,0-27,0			
				oltre 150	4-3	27	13,0-27,0			
Acciaio per cuscinetti a sfere	1.3501	105 Cr 2	210-230	fino a 25	10-8	55	13,0-27,0	1:30		x
				25-70	8-6	49	19,0-32,0			
				70-150	6-4	46	27,0-39,0			
				oltre 150	4-3	30	19,0-32,0			
	1.3505	100 Cr 6	210-230	fino a 25	10-8	55	13,0-27,0	1:30		x
				25-70	8-6	49	19,0-32,0			
				70-150	6-4	46	27,0-39,0			
				oltre 150	4-3	30	27,0-39,0			
Acciaio inossidabile	1.4005	x12 CrS 13	155-195	fino a 25	10-8	61	19,0-32,0	1 :10		x
				25-70	8-6	55	27,0-39,0			
				70-150	6-4	52	32,0-45,0			
				oltre 150	4-3	46	27,0-39,0			
	1.4006	x 10 Cr 13	140-185	fino a 25	10-8	46	6,0-19,0	1 :10		x
				25-70	8-6	40	6,0-19,0			
				70-150	6-4	37	13,0-27,0			
				oltre 150	4-3	30	6,0-19,0			
	1.4016	x 8 Cr 17	170-215	fino a 25	10-8	30	6,0-19,0	1 :10		x
				25-70	8-6	27	13,0-27,0			
				70-150	6-4	24	13,0-27,0			
				oltre 150	4-3	24	6,0-19,0			
	1.4021	x 20 Cr 13	140-185	fino a 25	10-8	46	6,0-19,0	1 :10		x
				25-70	8-6	40	6,0-19,0			
				70-160	6-4	37	13,0-27,0			
				oltre 150	4-3	30	6,0-19,0			
	1.4104	x 12 CrMoS 17	155-195	fino a 25	10-8	61	19,0-32,0	1 :10		x
				25-70	8-6	55	27,0-39,0			
				70-150	6-4	52	32,0-45,0			
				oltre 150	4-3	46	27,0-39,0			
	1.4112	x 90 CrMoV 18	160-190	fino a 25	10-8	37	6,0-19,0	1 :10		x
				25-70	8-6	34	6,0-19,0			
				70-150	6-4	27	13,0-27,0			
				oltre 150	4-3	21	6,0-19,0			
	1.4125	x 105 CrMo 17	160-190	fino a 25	10-8	37	6,0-19,0	1 :10		x
				25-70	8-6	34	6,0-19,0			
				70-150	6-4	27	13,0-27,0			
				oltre 150	4-3	21	6,0-19,0			
	1.4300	x 12 CrNi 188	140-190	fino a 25	10-8	37	13,0-27,0	1 :10		x
				25-70	8-6	30	13,0-27,0			
				70-150	6-4	30	13,0-27,0			
				oltre 150	4	30	6,0-19,0			
	1.4301	x 5 CrNi 189	130-170	fino a 25	10-8	37	13,0-27,0	1 :10		x
				25-70	8-6	30	13,0-27,0			
				70-150	6-4	30	13,0-27,0			
				oltre 150	4	30	6,0-19,0			
	1.4305	x 12 CrNiS 188	150-200	fino a 25	10-8	43	13,0-27,0	1 :10		x
				25-70	8-6	37	13,0-27,0			
				70-150	6-4	30	19,0-32,0			
				oltre 150	4-3	30	13,0-27,0			
	1.4371	x 8 CrMnNi 189		fino a 25	10-8	37	13,0-27,0	1 :10		x
				25-70	8-6	30	13,0-27,0			
				70-150	6-4	30	13,0-27,0			
				oltre 150	4	30	6,0-19,0			
	1.4401	x 5 CrNiMo 18 10	160-220	fino a 25	10-8	27	6,0	1 :10		x
				25-70	8-6	24	6,0			
				70-150	6-4	21	13,0			
				oltre 150	4-3	18	6,0			