

# performances

Recommendations  
Recomendación  
Suggerimento

N° 1

N° 2

Autres  
Others  
Otro  
Altre  
soluzioni

Vc = vitesse speed velocidad velocità: m/min.

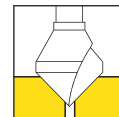
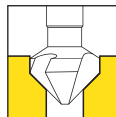
Vf = avance feed avance avanzamento: mm/min.

$\frac{Vc \times 1000}{\pi \times \varnothing}$  Tours par min. Rev. / min.  
Giri / min. revoluciones por minuto.

## Ébavurage • Chanfreinage Deburring • Countersinking

Desbarbado • Avellanado

Svasatura • Sbvatura



Matière Material Materiale		HSS-Co	HSS-Co + TiN	HSS 8% Co	HSS 8% Co + Red'X	Carbure Carbide Metallo Duro	Carbure Carbide + Hard'X	HSS-Co	HSS-Co + TiN	HSS-Co	HSS-Co + TiN	
Pages Páginas Page		54 ~ 65		51 ~ 58		50 ~ 64		68 ~ 69		70 ~ 71		
P	Aciers / Steels Aceros / Acciai ≤ 500 N/mm <sup>2</sup>	Vc	17~22	17~22	35~45	35~45	40~80	40~80	35~45	35~45	35~45	35~45
		Ø 10 Vf	85	85	165	165	250	250	165	165	165	165
		Ø 20	45	45	85	85	125	125	85	85	85	85
	Ø 30	30	30	55	55	85	85	55	55	55	55	
	Aciers / Steels Aceros / Acciai 500 ~ 800 N/mm <sup>2</sup>	Vc	10~15	10~15	20~30	20~30	30~60	30~60	20~30	20~30	20~30	20~30
		Ø 10 Vf	60	60	110	110	170	170	110	110	110	110
		Ø 20	30	30	55	55	85	85	55	55	55	55
	Ø 30	20	20	35	35	60	60	35	35	35	35	
	Aciers / Steels Aceros / Acciai 800 ~ 1000 N/mm <sup>2</sup>	Vc	8~12	8~12	16~20	16~20	20~40	20~40	15~20	15~20	15~20	15~20
Ø 10 Vf		35	35	55	55	100	100	55	55	55	55	
Ø 20		25	25	35	35	60	60	35	35	35	35	
Ø 30	15	15	25	25	45	45	25	25	25	25		
M	Inox / Stainless steel Aceros Inoxidables 1000 ~ 1300 N/mm <sup>2</sup>	Vc	6~10	6~10	12~15	12~15	20~40	20~40	12~15	12~15	12~15	12~15
		Ø 10 Vf	30	30	45	45	100	100	45	45	45	45
		Ø 20	15	15	25	25	60	60	25	25	25	25
Ø 30	10	10	20	20	40	40	20	20	20	20		
H	Acier anti-abrasion / Abrasive tough Steel Acero resistente a la abrasión < 420 HB	Vc				12~15	15~20	15~20				
		Ø 10 Vf				40	55	55				
		Ø 20				30	35	35				
Ø 30				20	25	25						
S	Bronze dur Inconel, Nimonic Hard bronze Bronce / Bronzo duro	Vc			4~6	4~6	10~12	10~12				
		Ø 10 Vf			16	16	30	30				
		Ø 20			8	8	16	16				
Ø 30			6	6	10	10						
H	Acier traité / Treated steel Acero tratado / Acciai trattati ≥ 60 HRC	Vc					8~10	10~12				
		Ø 10 Vf					20	30				
		Ø 20					10	16				
Ø 30					8	10						
K	Fonte / Cast iron Fundición / Ghisa	Vc	15~25	15~25	20~40	20~40	40~80	40~80	20~40	20~40	20~40	20~40
		Ø 10 Vf	70	70	125	125	250	250	125	125	125	125
		Ø 20	40	40	75	75	150	150	75	75	75	75
Ø 30	30	30	50	50	100	100	50	50	50	50		
N	Aluminium Alluminio	Vc	35~45	35~45	50~60	50~60	40~100	40~100	50~60	50~60	50~60	50~60
		Ø 10 Vf	200	200	255	255	350	350	255	255	255	255
		Ø 20	130	130	180	180	230	230	180	180	180	180
Ø 30	110	110	150	150	200	200	150	150	150	150		
N	Laiton / Brass Latón / Ottonne Bronze / Bronze Bronce / Bronzo	Vc	20~30	20~30	30~40	30~40			30~40	30~40	30~40	30~40
		Ø 10 Vf	120	120	150	150			150	150	150	150
		Ø 20	85	85	110	110			110	110	110	110
Ø 30	70	70	90	90			90	90	90	90		
N	Cuivre / Copper Cobre / Rame	Vc	15~25	15~25	20~30	20~30	50~80	50~80	20~30	20~30	20~30	20~30
		Ø 10 Vf	95	95	120	120	300	300	120	120	120	120
		Ø 20	60	60	80	80	200	200	80	80	80	80
Ø 30	45	45	65	65	175	175	65	65	65	65		
N	Stratifié / Laminated Laminados / Laminati	Vc	35~70	35~70	35~70	35~70			50~100	50~100	50~100	50~100
		Ø 10 Vf	300	300	300	300			400	400	400	400
		Ø 20	200	200	200	200			300	300	300	300
Ø 30	150	150	150	150			250	250	250	250		
N	Nylon PVC / Plastics Plásticos / Plastiche	Vc	35~70	35~70	35~70	35~70			50~100	50~100	50~100	50~100
		Ø 10 Vf	400	400	400	400			450	450	450	450
		Ø 20	300	300	300	300			350	350	350	350
Ø 30	250	250	250	250			300	300	300	300		



# magafor *Le choix! The choice! La elección! La scelta!*

## Contournage Contouring

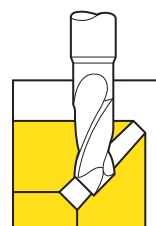
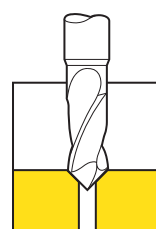
Contorneado  
Scontornatura



Matière Material Materiale		HSS-Co	HSS-Co + TiN	HSS 8% Co	HSS 8% Co + Red'X	Carbure Carbide Metallo Duro	Carbure Carbide + Hard'X	
Pages Páginas Page		54 ~ 65		51 ~ 58		50 ~ 64		
P	Aciers / Steels Aceros / Acciai ≤ 500 N/mm <sup>2</sup>	Vc	17~22	17~22	35~45	35~45	40~80	40~80
	Ø 10	Vf	85	85	165	165	250	250
	Ø 20		45	45	85	85	125	125
	Ø 30		30	30	55	55	85	85
	Aciers / Steels Aceros / Acciai 500 ~ 800 N/mm <sup>2</sup>	Vc	10~15	10~15	20~30	20~30	30~60	30~60
	Ø 10	Vf	60	60	110	110	170	170
	Ø 20		30	30	55	55	85	85
	Ø 30		20	20	35	35	60	60
	Aciers / Steels Aceros / Acciai 800 ~ 1000 N/mm <sup>2</sup>	Vc	8~12	8~12	16~20	16~20	20~40	20~40
Ø 10	Vf	35	35	55	55	100	100	
Ø 20		25	25	35	35	60	60	
Ø 30		15	15	25	25	45	45	
M	Inox / Stainless steel Aceros Inoxidables 1000 ~ 1300 N/mm <sup>2</sup>	Vc	6~10	6~10	12~15	12~15	20~40	20~40
	Ø 10	Vf	30	30	45	45	100	100
	Ø 20		15	15	25	25	60	60
Ø 30		10	10	20	20	40	40	
H	Acier anti-abrasion / Abrasive tough Steel Acero resistente a la abrasión < 420 HB	Vc				12~15	15~20	15~20
	Ø 10	Vf				40	55	55
	Ø 20					30	35	35
Ø 30					20	25	25	
S	Bronze dur Inconel, Nimonic Hard bronze Bronce / Bronzo duro	Vc			4~6	4~6	10~12	10~12
	Ø 10	Vf			16	16	30	30
	Ø 20				8	8	16	16
Ø 30				6	6	10	10	
H	Acier traité / Treated steel Acero tratado / Acciai trattati ≥ 60 HRC	Vc					8~10	10~12
	Ø 10	Vf					20	30
	Ø 20						10	16
Ø 30						8	10	
K	Fonte / Cast iron Fundición / Ghisa	Vc	15~25	15~25	20~40	20~40	40~80	40~80
	Ø 10	Vf	70	70	125	125	250	250
	Ø 20		40	40	75	75	150	150
Ø 30		30	30	50	50	100	100	
N	Aluminium Alluminio	Vc	35~45	35~45	50~60	50~60	40~100	40~100
	Ø 10	Vf	200	200	255	255	350	350
	Ø 20		130	130	180	180	230	230
	Ø 30		110	110	150	150	200	200
	Laiton / Brass Latón / Ottone Bronze / Bronze Bronce / Bronzo	Vc	20~30	20~30	30~40	30~40		
	Ø 10	Vf	120	120	150	150		
	Ø 20		85	85	110	110		
	Ø 30		70	70	90	90		
	Cuivre / Copper Cobre / Rame	Vc	15~25	15~25	20~30	20~30	50~80	50~80
Ø 10	Vf	95	95	120	120	300	300	
Ø 20		60	60	80	80	200	200	
Ø 30		45	45	65	65	175	175	
Stratifié / Laminated Laminados / Laminati	Vc	35~70	35~70	35~70	35~70			
	Ø 10	Vf	300	300	300	300		
	Ø 20		200	200	200	200		
Ø 30		150	150	150	150			
Nylon PVC / Plastics Plásticos / Plastiche	Vc	35~70	35~70	35~70	35~70			
	Ø 10	Vf	400	400	400	400		
	Ø 20		300	300	300	300		
Ø 30		250	250	250	250			

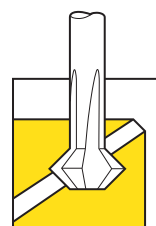
## Autres solutions Other solutions

Oltres soluzioni  
Altre soluzioni



1 = MULTI-V®  
10 operations

> p. 90 ~ 95

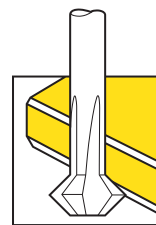


Bi-face

Fraises à chanfreiner  
avant et arrière  
Front and back  
chamfering

Avellanadores  
frontal y trasero  
Frese per sbavare  
in spinta ed in trazione

> p. 100



Fraises à angler  
multidentés  
Multi-flutes  
conical cutters

Fresas cónicas multilabio  
Frese multi-denti per  
smussature

> p. 61



Chanfreinage • Lamage / Contersinking • Counterboring  
Avelanado • Refrentado / Sbovatura • Svatsatura