

**SEGHE A NASTRO BIMETALLICHE**
**Tabella N. 47/a**

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 <sup>2</sup> /min	refrigeranti-lubrificanti		
								olio emuls.	olio da taglio	lubrif. non grasso
Acciaio da costruzione	1.0204	UQSt 36-2	150-175	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4-3	76 84 85 76	52,0-64,5 58,0-77,5 77,5-97,0 58,0-77,5	1:20	x	
	1.0306	USt 34-7	150-175	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4-3	76 84 85 76	52,0-64,5 58,0-77,5 77,5-97,0 58,0-77,5	1:20	x	
Acciaio automatico	1.0711- 1.0712	9S 20	125-150	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4-3	91 100 84 67	52,0-71,0 71,0-84,0 77,5-97,0 77,5-97,0	1:10	x	
Acciaio da bonifica	1.0501	C 35	160-175	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4-3	76 84 76 70	52,0-65,0 58,0-77,5 77,5-97,0 58,0-77,5	1:20		x
	1.1146	30 MN 4	160-180	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4-3	61 61 53 46	32,0-45,0 32,0-45,0 52,0-65,0 39,0-52,0	1:20		x
	1.1221	Ck 60	160-180	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4-3	61 61 53 46	32,0-45,0 32,0-45,0 52,0-65,0 39,0-52,0	1:20		x
Acciaio per molle	1.0904 1.0906	55 Si 7 65 Si 7	150-180	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4-3	61 55 55 46	13,0-27,0 19,0-32,0 19,0-32,0 19,0-32,0	1:30		x
	1.0961	60 SiCr 7	200-230	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4-3	61 49 55 46	6,0-19,0 13,0-19,0 13,0-27,0 13,0-19,0	1:30		x
Filo di acciaio per molle	1.1230	17223	180-205	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4-3	61 61 46 37	27,0-39,0 32,0-45,0 39,0-52,0 39,0-52,0	1:30		x
Acciaio per molle	1.1274	Ck 101	180-205	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4-3	61 61 46 37	27,0-39,0 32,0-45,0 39,0-52,0 39,0-52,0	1:30		x
Acciaio per utensili per lavorazione a freddo	1.2080	x 210 Cr 12	217-241	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4	34 30 27 24	6,0-13,0 6,0-13,0 6,0-13,0 6,0-13,0	1:30		x
	1.2303	100 CrMo 5	180-230	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4	61 55 46 30	13,0-27,0 19,0-32,0 19,0-32,0 13,0-27,0	1:30		x
Acciaio per utensili per lavorazione a caldo	1.2344	x 40 CrMoV 51	205-228	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4	46 38 38 38	13,0-27,0 19,0-32,0 13,0-19,0 13,0-27,0	1:20	x	
Acciaio per utensili per lavorazione a freddo	1.2363	x100 CrMoV51	217-241	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4	64 61 58 55	13,0-19,0 19,0-27,0 19,0-27,0 13,0-19,0	1:20	x	
	1.2379	x155 CrVMo 121	217-241	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4	34 30 27 24	6,0-13,0 6,0-13,0 6,0-13,0 6,0-13,0	1:30	x	

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**Tabella N. 47/b**

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 <sup>2</sup> /min	refrigeranti-lubrificanti		
								olio emuls.	olio da taglio	lubrif. non grasso
Acciaio per utensili per lavorazione a freddo	1.2510	100 MnCrW 4	187-207	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4	73 64 58 52	19,0-27,0 27,0-32,0 32,0-39,0 27,0-32,0	1:20		x
	1.2542	45 WCrV 7	177-212	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4	67 55 50 46	13,0-27,0 19,0-32,0 19,0-32,0 13,0-27,0	1:20		x
Acciaio per utensili per lavorazione a caldo	1.2581	x 30 WCrV 93	205-228	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4	46 38 38 38	13,0-27,0 19,0-32,0 13,0-19,0 13,0-27,0	1:20		x
	1.2606	x 37 CrMoW51	205-228	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4	46 38 38 38	13,0-27,0 19,0-32,0 13,0-19,0 13,0-27,0	1:20		x
Acciaio per utensili per lavorazione a freddo	1.2714	56 NiCrMOV 7	190-230	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4	61 55 52 46	13,0-27,0 19,0-32,0 19,0-32,0 13,0-27,0	1:30		x
	1.2842	90 MnV 8	187-207	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4	73 64 58 52	19,0-27,0 27,0-32,0 32,0-39,0 27,0-32,0	1:30		x
Acciaio rapido HSS	1.3202	S 12-1-4-5	228-255	fino a 25 25-70 70-150 oltre 150	10-8 10-8 6-4 4	24 24 21 15	6,0 6,0 6,0 6,0	1:30		x
	1.3251	S 12-1-2-5	220-293	fino a 25 25-70 70-150 oltre 150	10-8 10-8 6-4 4	34 30 24 21	6,0-13,0 6,0-13,0 6,0-13,0 6,0-13,0	1:30		x
	1.3255	S 18-1-2-5	235-255	fino a 25 25-70 70-150 oltre 150	10-8 10-8 6-4 4-3	34 30 27 24	6,0-13,0 6,0-13,0 13,0-19,0 6,0-13,0	1:30		x
	1.3265	S 18-1-2-10	235-255	fino a 25 25-70 70-150 oltre 150	10-8 10-8 6-4 4-3	34 30 27 24	6,0-13,0 6,0-13,0 13,0-19,0 6,0-13,0	1:30		x
	1.3343	S 6-5-2	217-241	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4	37 34 30 24	6,0-13,0 13,0-19,0 19,0-27,0 13,0-19,0	1:30		x
	1.3344	S 6-5-3	217-241	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4	37 34 30 24	6,0-13,0 13,0-19,0 19,0-27,0 13,0-19,0	1:30		x
	1.3345	S 0-8-2	217-228	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4	30 27 24 18	6,0-13,0 6,0-13,0 6,0-19,0 6,0-13,0	1:30		x
	1.3346	S 2-9-1	217-228	fino a 25 25-70 70-150 oltre 150	10-8 8-6 6-4 4	46 43 40 34	6,0-19,0 13,0-27,0 19,0-32,0 13,0-27,0	1:30		x
	1.3355	S 18-0-1	217-248	fino a 25 25-70 70-150 oltre 150	10-8 10-8 6-4 4-3	40 34 30 27	6,0-13,0 13,0-19,0 13,0-27,0 13,0-27,0	1:30		x

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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 <sup>2</sup> /min	refrigeranti-lubrificanti		
								olio emuls.	olio da taglio	lubrif. non grasso
<b>Acciaio HSS</b>	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			
<b>Acciaio per cuscinetti a sfere</b>	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				
<b>Acciaio inossidabile</b>	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			