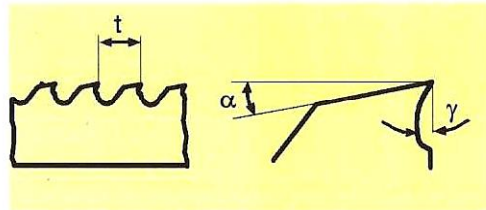
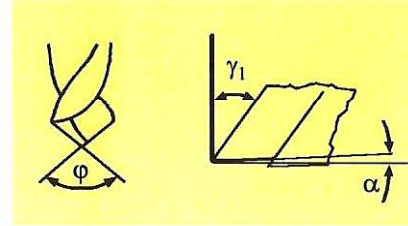


### ZEDEX 100: TAGLIO



$\alpha$  = Angolo spoglia inf. [°]  
 $\gamma$  = Angolo spoglia sup. [°]  
 $v$  = Velocita' taglio [m/min]  
 $t$  = Passo dei denti [mm]  
 Indice K = Sega a disco  
 Indice B = Sega a nastro

### ZEDEX 100: ALESATURA

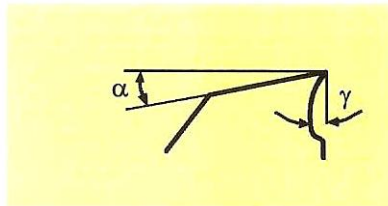


$\alpha$  = Angolo spoglia inf. [°]  
 $\gamma_1$  = Angolo spoglia sup. [°]  
 $\phi$  = Angolo tra taglienti [°]  
 $v$  = Velocita' taglio [m/min]  
 $S$  = Avanzamento [mm/U]

Attrezzatura	$\alpha$	$\gamma_K$	$\gamma_B$	$t$	$V_K$	$V_B$
SS	30 a 40	5 a 8	0 a 8	2 a 8	a 3000	a 3000
HM	10 a 15	0 a 5	0 a 8	2 a 8	a 3000	a 3000

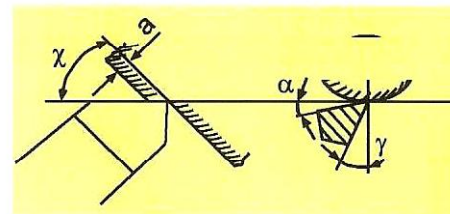
Attrezzatura	$\alpha$	$\gamma_1$	$\phi$	$v$	$S$
SS	0 a 12	3 a 5	60 a 90	50 a 100	0.2 a 0.5

### ZEDEX 100: FRESATURA



$\alpha$  = Angolo spoglia inf. [°]  
 $\gamma$  = Angolo spoglia sup. [°]  
 $v$  = Velocita' taglio [m/min]  
 $S$  = Avanzamento [mm/dente]  
 $a$  = Profondita' passata [mm]

### ZEDEX 100: TORNITURA



$\alpha$  = Angolo spoglia inf. [°]  
 $\gamma$  = Angolo spoglia sup. [°]  
 $\chi$  = Angolo registrazione [°]  
 $v$  = Velocita' taglio [m/min]  
 $S$  = Avanzamento [mm/dente]  
 $a$  = Profondita' passata [mm]

Materiale attrezzatura	$\alpha$	$\gamma$	$v$
SS	5 a 15	a 15	a 1000

Attrezzatura	$\alpha$	$\gamma$	$\chi$	$v$	$S$	$a$
SS	5 a 15	0 a 10	45 a 60	200...500	0.1 a 0.5	a 6
HM	5 a 10	0 a 4	ca.15	200...300	0.1 a 0.2	a 6