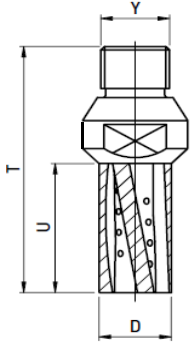


FRESE DIAMANTATE / DIAMOND MILLING TOOLS

Vetro / Glass	Duezeta Code	Dimensioni / Dimensions	Specifica DUEZETA	Nr.sett /segm.	Durata / Life	Note / Notes
5÷12	650.000.364	FRESA D.10 U.27 T.67	70 HP15	3 sett. ⁽¹⁾	150-200 mt	
3÷19		FRESA D.14 U45 T.83	50 HP15	3 sett. ⁽²⁾	220-270 Mt	
3÷19	650.000.367	FRESA D.16 U.45 T.83	50 HP15	4 sett. ⁽²⁾	310-340 Mt	
3÷19	650.000.322	FRESA D.20 U.45 T.83	50 HP15	5 sett. ⁽³⁾	330-350 Mt	
3÷19		FRESA D.22 U.45 T.83	50 HP15	5 sett. ⁽⁴⁾	" "	
3÷19	650.000.368	FRESA D.26 U.45 T.83	50 HP15	6 sett. ⁽⁵⁾	440-525 Mt	
3÷19	650.000.365	FRESA D.10 U.20 T.110	70 HP15	3 sett. ⁽⁶⁾		
3÷19	650.000.369	FRESA D.16 U.20 T.110	50 HP15	4 sett. ⁽⁶⁾		
3÷19	650.000.366	FRESA D.20 U.20 T.110	50 HP15	5 sett. ⁽⁶⁾		

(1) Piccoli raggi, schegge minime /Small radi, low chipping

(4) Per vetro laminato / Laminated glass

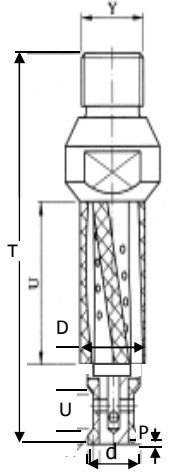
(2) Standard per piccoli raggi /Std. for small radi

(5) Lunga durata e per spessori piccoli / long life for small thickness

(3) Per lavorazioni standard / For standard processing

(6) Per le macchine FORVET / for Forvet machines

"FE+FA" FRESATURA + PROFILATURA / MILLING + EDGING TOOLS

6		16x95 YG1/2 U25-3,5 P2 X3 X2,5	50 FR15 140 GX	4 segm. d.16		
8	650000370	FRESA COMBINATA D.16 4S U.22 + TRAPEZIO VET.8 GR.MEDIA H.85	50 FR15 140 GX	4 segm. d.16		
10	650000371	FRESA COMBINATA D.16 4S U.22 + TRAPEZIO VET.8 GR.MEDIA H.85	50 FR15 140 GX	4 segm. d.16		
12		16x95 YG1/2 U25-9 P2 X3 X2,5	50 FR15 140 GX	4 segm. d.16		
15		16x95 YG1/2 U25-12 P2 X3 X2,5	50 FR15 140 GX	4 segm. d.16		

Working parameters suggested for diamond milling cutters

Diam.	Passaggio refrigerante / cooling	Velocità di rotazione / Rotation speed (r.p.m.)	Avanz. / Feed (m/1')	Note / Notes
Ø 22 - Ø 16	Acqua interna / Internal water	8000÷9000	0,3÷0,8	Usare sempre l'acqua interna per tutti gli spessori di vetro ed in particolare per i spessori 20mm e oltre. Verificare che non ci siano vibrazioni sulla fresa /The use of internal water is suggested for milling of all thicknesses of glass and especially for 20mm and higher. After mounting, first check that there are no vibrations present, otherwise machining performance will be reduced. Le frese sulle macchine Master-edge, Compact, etc, possono essere usate fino a 12000 a 14000 g/min / Milling tools are usable up to 12000 ÷ 14000 rpm on machines models like Master-edge, Compact, etc.
Ø 22 - Ø 20	Acqua esterna / External water	7000÷8000	0,4÷0,6	
Ø10 e Ø14		9000	0,3÷0,5	
Ø 22 - Ø 20	Testina per acqua interna / Head for internal water	5000÷6000	0,4÷0,6	
Ø10 e Ø 14		≥ 6000	0,3÷0,5	

Working parameters suggested for "FA" shape (Edging)

Glass	Giri / RPM	Asportazione / Removal	Avanzamento / Feed speed
6÷15	7000 ÷ 12.000	0,1 ÷ 0,3 mm	0,2 ÷ 0,7 m/min