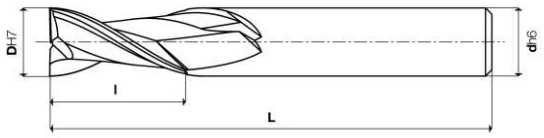
Serie/*Series*

10102

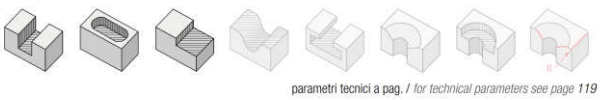
Frese a due taglienti in tolleranza H7

Two flute slot drills in tolerance H7

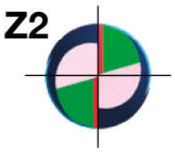


COATING	W	F	λ°s		UNI 8254 DIN 327B ISO 1641/I	
Skin	A RICHIESTA *ON REQUEST*	A RICHIESTA *ON REQUEST*	32	N		

Cod. Art.	X-85 (PM Co 8,5%)	COATED	DH7	l	L	dh6	Z
101020100 CM		**CMX**	1	3	47	6	2
101020150 CM		**CMX**	1,5	3	47	6	2
101020200 CM		**CMX**	2	4	48	6	2
101020250 CM		**CMX**	2,5	5	49	6	2
101020300 CM		**CMX**	3	5	49	6	2
101020350 CM		**CMX**	3,5	6	50	6	2
101020400 CM		**CMX**	4	7	51	6	2
101020450 CM		**CMX**	4,5	7	51	6	2
101020500 CM		**CMX**	5	8	52	6	2
101020550 CM		**CMX**	5,5	8	52	6	2
101020600 CM		**CMX**	6	8	52	6	2
101020650 CM		**CMX**	6,5	10	60	10	2
101020700 CM		**CMX**	7	10	60	10	2
101020750 CM		**CMX**	7,5	10	60	10	2
101020800 CM		**CMX**	8	11	61	10	2
101020850 CM		**CMX**	8,5	11	61	10	2
101020900 CM		**CMX**	9	11	61	10	2
101020950 CM		**CMX**	9,5	13	63	10	2
101021000 CM		**CMX**	10	13	63	10	2
101021050 CM		**CMX**	10,5	13	70	12	2
101021100 CM		**CMX**	11	13	70	12	2
101021200 CM		**CMX**	12	16	73	12	2
101021300 CM		**CMX**	13	16	73	12	2
101021400 CM		**CMX**	14	16	73	12	2
101021500 CM		**CMX**	15	19	79	16	2
101021600 CM		**CMX**	16	19	79	16	2
101021700 CM		**CMX**	17	19	79	16	2
101021800 CM		**CMX**	18	19	79	16	2
101021900 CM		**CMX**	19	22	82	16	2
101022000 CM		**CMX**	20	22	82	16	2
101022001 CM		**CMX**	20	22	88	20	2
101022100 CM		**CMX**	21	22	88	20	2
101022200 CM		**CMX**	22	22	88	20	2
101022300 CM		**CMX**	23	22	88	20	2
101022400 CM		**CMX**	24	26	102	25	2
101022500 CM		**CMX**	25	26	102	25	2
101022600 CM		**CMX**	26	26	102	25	2
101022800 CM		**CMX**	28	26	102	25	2
101023000 CM		**CMX**	30	26	102	25	2
101023200 CM		**CMX**	32	32	112	32	2
101023400 CM		**CMX**	34	32	112	32	2
101023500 CM		**CMX**	35	32	112	32	2
101023600 CM		**CMX**	36	32	112	32	2



parametri tecnici a pag. / *for technical parameters see page 119*

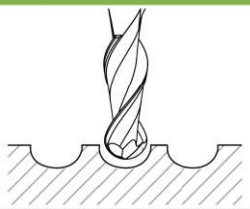
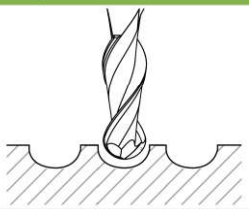


MATERIALI LAVORABILI / *WORKPIECE MATERIALS*

serie *series*	TITANIO *TITANIUM*	HRSA *HRSA*	ACCIAI INOSSIDABILI *STAINLESS STEELS*	MATERIALI NON FERROSI *NON FERROUS MATERIALS*	LEGHE LEGGERE *LIGHT ALLOYS*	ACCIAI *STEELS*	GHISE *CAST IRON*
10102	◕	◕	◕	◕	○	●	●

● consigliata/*recommended* ◕ accettabile/*acceptable* ○ non consigliata/*not recommended*

Parametri di taglio/*Cutting parameters*

		10102 - 10105 10110 - 10125*		10140 - 10155*		12505 - 12520*	
Materiali *Materials*		Cava *Slotting* *ap = 0,5ø ae = 1ø*		Sgrossatura *Roughing* *ap = 0,4ø ae = 0,9ø*		Sgrossatura *Roughing* *ap = 0,4ø ae = 0,9ø*	
							
	Gruppo e descrizione *Group and description*	Vc (mt /min.)		Vc (mt /min.)		Vc (mt /min.)	
		X-85 NON RIVESTITA *UNCOATED*	**X-85** **Skin**	**X-85** NON RIVESTITA *UNCOATED*	**X-85** **Skin**	**X-85** NON RIVESTITA *UNCOATED*	**X-85** **Skin** *Alu*
Ghisa *Cast Iron*	**Grigia e sferoidale** *Grey and spheroidal*	20 - 25	45 - 50	20 - 25	45 - 50	–	–
Acciaio *Steel*	**Basso contenuto di C** *Low carbon content*	30 - 35	60 - 70	30 - 35	60 - 70	–	–
	Medio contenuto di C *Medium carbon content*	25 - 30	50 - 60	25 - 30	50 - 60	–	–
	Basso legato *Low alloyed*	25 - 30	50 - 60	25 - 30	50 - 60	–	–
	Alto legato *High alloyed*	20 - 25	40 - 50	20 - 25	40 - 50	–	–
	Acciaio da stampi e utensili *Die/tool steel*	15 - 20	30 - 40	15 - 20	30 - 40	–	–
Materiali non ferrosi Leghe leggere *Non ferrous materials Light alloys*	**Alluminio non legato** *Unalloyed aluminium*	–	–	–	–	110 - 120	250 - 260
	Alluminio Si < 6% *si < 6% aluminium*	–	–	–	–	70 - 80	170 - 180
	Materiali termoplastici *Thermoplastic materials*	–	–	–	–	130 - 140	270 - 280
	Rame/Ottone *Copper/Brass*	30 - 35	75 - 80	30 - 35	75 - 80	30 - 35	75 - 80

D	**Avanzamento fz mm/tagliente** *FEED mm/tooth*		
3	0,009	0,009	0,006
4	0,013	0,012	0,010
5	0,015	0,016	0,015
6	0,018	0,018	0,020
8	0,025	0,025	0,035
10	0,030	0,035	0,050
12	0,040	0,050	0,070
16	0,065	0,090	0,120
20	0,090	0,110	0,145

* series **10125**; series **10155**; series **12520** **fz** consigliato | *RECOMMENDED* -50%