

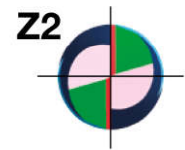
# HSS-PM HSS-PM Line

## Serie/Series 10110

Frese a due taglienti in tolleranza e8  
Two flute slot drills in tolerance e8



Cod. Art.	M-TK (HSS-E)	X-85 (PM Co 8,5%)	COATED	De8	I	L	dh6	Z
101100100 -		CM	CMX	1	3	47	6	2
101100150 -		CM	CMX	1,5	3	47	6	2
101100200 -		CM	CMX	2	4	48	6	2
101100250 -		CM	CMX	2,5	5	49	6	2
101100300 -		CM	CMX	3	5	49	6	2
101100350 -		CM	CMX	3,5	6	50	6	2
101100400 -		CM	CMX	4	7	51	6	2
101100450 -		CM	CMX	4,5	7	51	6	2
101100500 -		CM	CMX	5	8	52	6	2
101100550 -		CM	CMX	5,5	8	52	6	2
101100600 AM		CM	CMX	6	8	52	6	2
101100650 AM		CM	CMX	6,5	10	60	10	2
101100700 AM		CM	CMX	7	10	60	10	2
101100750 AM		CM	CMX	7,5	10	60	10	2
101100800 AM		CM	CMX	8	11	61	10	2
101100850 AM		CM	CMX	8,5	11	61	10	2
101100900 AM		CM	CMX	9	11	61	10	2
101100950 AM		CM	CMX	9,5	13	63	10	2
101101000 AM		CM	CMX	10	13	63	10	2
101101050 AM		CM	CMX	10,5	13	70	12	2
101101100 AM		CM	CMX	11	13	70	12	2
101101200 AM		CM	CMX	12	16	73	12	2
101101300 AM		CM	CMX	13	16	73	12	2
101101400 AM		CM	CMX	14	16	73	12	2
101101500 AM		CM	CMX	15	19	79	16	2
101101600 AM		CM	CMX	16	19	79	16	2
101101700 AM		CM	CMX	17	19	79	16	2
101101800 AM		CM	CMX	18	19	79	16	2
101101801 AM		CM	CMX	18	19	85	20	2
101101900 AM		CM	CMX	19	22	82	16	2
101101901 AM		CM	CMX	19	22	88	20	2
101102000 AM		CM	CMX	20	22	82	16	2
101102001 AM		CM	CMX	20	22	88	20	2
101102100 AM		CM	CMX	21	22	88	20	2
101102200 AM		CM	CMX	22	22	88	20	2
101102201 AM		CM	CMX	22	22	98	25	2
101102300 AM		CM	CMX	23	22	88	20	2
101102400 AM		CM	CMX	24	26	102	25	2
101102500 AM		CM	CMX	25	26	102	25	2
101102600 AM		CM	CMX	26	26	102	25	2
101102800 AM		CM	CMX	28	26	102	25	2
101103000 AM		CM	CMX	30	26	102	25	2
101103200 AM		CM	CMX	32	32	112	32	2
101103400 AM		CM	CMX	34	32	112	32	2
101103500 AM		CM	CMX	35	32	112	32	2
101103600 AM		CM	CMX	36	32	112	32	2
101103800 AM		CM	CMX	38	38	118	32	2
101104000 AM		CM	CMX	40	38	118	32	2
101104500 AM		CM	CMX	45	38	118	32	2
101105000 AM		CM	CMX	50	45	125	32	2




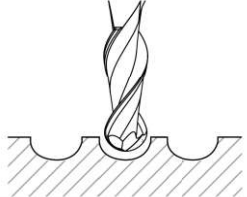
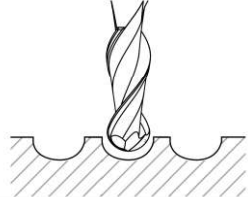
parametri tecnici a pag. 1 for technical parameters see page 119

### 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
10110	●	●	●	●	○	●	●

● 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 $ap = 0,5\phi$ $ae = 1\phi$	Sgrossatura Roughing $ap = 0,4\phi$ $ae = 0,9\phi$	Sgrossatura Roughing $ap = 0,4\phi$ $ae = 0,9\phi$			
							
Gruppo e descrizione Group and description		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	-	-
	Basso contenuto di C Low carbon content	30 - 35	60 - 70	30 - 35	60 - 70	-	-
Acciaio Steel	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 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
		Avanzamento fz mm/tagliente FEED mm/tooth					
D							
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%