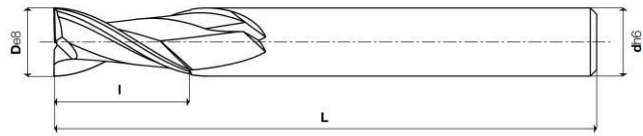


HSS-PM HSS-PM Line

Serie/Series

10125

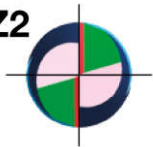
Frese a due taglienti in tolleranza e8
Two flute slot drills in tolerance e8



COATING **Skin** W **A RICHIESTA ON REQUEST** F **A RICHIESTA ON REQUEST** λ°s 32 N **QUALITY STANDARD UOP**

| Cod. Art. | M-TK (HSS-E) | X-85 (PM Co 8,5%) | COATED | Dø8 | I | L | dh6 | Z |
|--------------|--------------|-------------------|--------|------|----|-----|-----|---|
| 101250300 - | | CM | CMX | 3 | 9 | 60 | 6 | 2 |
| 101250350 - | | CM | CMX | 3,5 | 13 | 67 | 6 | 2 |
| 101250400 - | | CM | CMX | 4 | 13 | 67 | 6 | 2 |
| 101250450 - | | CM | CMX | 4,5 | 13 | 70 | 6 | 2 |
| 101250500 - | | CM | CMX | 5 | 16 | 70 | 6 | 2 |
| 101250550 - | | CM | CMX | 5,5 | 16 | 76 | 6 | 2 |
| 101250600 AM | | CM | CMX | 6 | 16 | 76 | 6 | 2 |
| 101250650 AM | | CM | CMX | 6,5 | 16 | 76 | 10 | 2 |
| 101250700 AM | | CM | CMX | 7 | 19 | 79 | 10 | 2 |
| 101250750 AM | | CM | CMX | 7,5 | 19 | 79 | 10 | 2 |
| 101250800 AM | | CM | CMX | 8 | 19 | 79 | 10 | 2 |
| 101250850 AM | | CM | CMX | 8,5 | 22 | 83 | 10 | 2 |
| 101250900 AM | | CM | CMX | 9 | 22 | 83 | 10 | 2 |
| 101250950 AM | | CM | CMX | 9,5 | 22 | 83 | 10 | 2 |
| 101251000 AM | | CM | CMX | 10 | 22 | 83 | 10 | 2 |
| 101251050 AM | | CM | CMX | 10,5 | 25 | 95 | 12 | 2 |
| 101251100 AM | | CM | CMX | 11 | 25 | 95 | 12 | 2 |
| 101251200 AM | | CM | CMX | 12 | 28 | 98 | 12 | 2 |
| 101251300 AM | | CM | CMX | 13 | 28 | 98 | 12 | 2 |
| 101251400 AM | | CM | CMX | 14 | 32 | 102 | 12 | 2 |
| 101251500 AM | | CM | CMX | 15 | 32 | 108 | 16 | 2 |
| 101251600 AM | | CM | CMX | 16 | 32 | 108 | 16 | 2 |
| 101251700 AM | | CM | CMX | 17 | 35 | 114 | 16 | 2 |
| 101251800 AM | | CM | CMX | 18 | 35 | 114 | 16 | 2 |
| 101251900 AM | | CM | CMX | 19 | 38 | 117 | 16 | 2 |
| 101252000 AM | | CM | CMX | 20 | 38 | 117 | 16 | 2 |
| 101252100 - | | CM | CMX | 21 | 38 | 132 | 20 | 2 |
| 101252200 AM | | CM | CMX | 22 | 41 | 135 | 20 | 2 |
| 101252300 - | | CM | CMX | 23 | 41 | 135 | 20 | 2 |
| 101252400 AM | | CM | CMX | 24 | 41 | 152 | 25 | 2 |
| 101252500 AM | | CM | CMX | 25 | 44 | 159 | 25 | 2 |
| 101252600 AM | | CM | CMX | 26 | 44 | 159 | 25 | 2 |
| 101252800 AM | | CM | CMX | 28 | 44 | 159 | 25 | 2 |
| 101253000 AM | | CM | CMX | 30 | 50 | 159 | 25 | 2 |
| 101253200 AM | | CM | CMX | 32 | 52 | 165 | 32 | 2 |
| 101253400 AM | | CM | CMX | 34 | 54 | 167 | 32 | 2 |
| 101253500 AM | | CM | CMX | 35 | 54 | 167 | 32 | 2 |
| 101253600 AM | | CM | CMX | 36 | 54 | 167 | 32 | 2 |
| 101253800 AM | | CM | CMX | 38 | 56 | 169 | 32 | 2 |
| 101254000 AM | | CM | CMX | 40 | 56 | 174 | 32 | 2 |
| 101254500 AM | | CM | CMX | 45 | 60 | 180 | 32 | 2 |
| 101255000 AM | | CM | CMX | 50 | 65 | 185 | 32 | 2 |

Z2




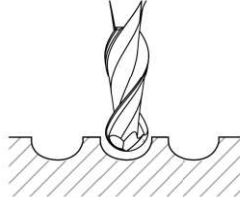
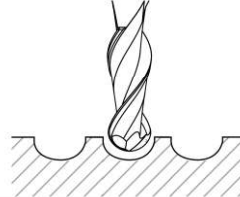
parametri tecnici a pag. / for technical parameters see page 119

MATERIALI LAVORABILI / WORKPIECE MATERIALS

serie
series
10125



Parametri di taglio/Cutting parameters

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