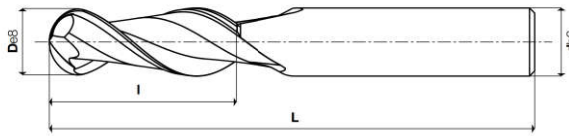


Serie/Series 10140

Frese a due taglienti a testa semisferica
Ball nosed two flute slot drills

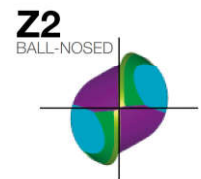


COATING Skin	W A RICHIESTA ON REQUEST	F A RICHIESTA ON REQUEST	λ° s 32	N	ISO 1641/1	
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Cod. Art.	X-85 (PM Co 8,5%)	COATED	Dø8	I	L	dh6	Z
101400100 CM	CMX	1	3	47	6	2	
101400150 CM	CMX	1,5	3	47	6	2	
101400200 CM	CMX	2	4	48	6	2	
101400300 CM	CMX	3	5	49	6	2	
101400400 CM	CMX	4	7	51	6	2	
101400500 CM	CMX	5	8	52	6	2	
101400600 CM	CMX	6	8	52	6	2	
101400700 CM	CMX	7	10	60	10	2	
101400800 CM	CMX	8	11	61	10	2	
101400900 CM	CMX	9	11	61	10	2	
101401000 CM	CMX	10	13	63	10	2	
101401100 CM	CMX	11	13	70	12	2	
101401200 CM	CMX	12	16	73	12	2	
101401300 CM	CMX	13	16	73	12	2	
101401400 CM	CMX	14	16	73	12	2	
101401500 CM	CMX	15	19	79	16	2	
101401600 CM	CMX	16	19	79	16	2	
101401700 CM	CMX	17	19	79	16	2	
101401800 CM	CMX	18	19	79	16	2	
101401900 CM	CMX	19	22	88	20	2	
101402000 CM	CMX	20	22	88	20	2	
101402200 CM	CMX	22	22	88	20	2	
101402500 CM	CMX	25	26	102	25	2	
101402800 CM	CMX	28	26	102	25	2	
101403000 CM	CMX	30	26	102	25	2	
101403200 CM	CMX	32	32	112	32	2	




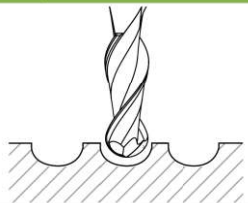
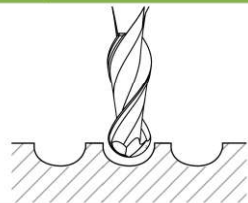
parametri tecnici a pag. 1 for technical parameters see page 119



MATERIALI LAVORABILI / WORKPIECE MATERIALS

serie séries	TITANIO TITANIUM	HRSA HRSA	ACCIAI INOSSIDABILI STAINLESS STEELS	MATERIALI NON FERROSI NON FERROUS MATERIALS	LEGHE LEGGERE LIGHT ALLOYS	ACCIAI STEELS	GHISE CAST IRON
10140	●	●	●	●	○	●	●

Parametri di taglio/Cutting parameters

		10102 - 10105 10110 - 10125*	10140 - 10155* 24120	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 Skin	X-85 NON RIVESTITA UNCOATED	X-85 Skin	X-85 NON RIVESTITA UNCOATED	X-85 Skin 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	250 - 260
	Alluminio Si < 6% <i>si < 6% aluminium</i>	-	-	-	-	70 - 80	170 - 180
	Materiali termoplastici <i>Thermoplastic materials</i>	-	-	-	-	130 - 140	270 - 280
	Rame/Ottone <i>Copper/Brass</i>	30 - 35	75 - 80	30 - 35	75 - 80	30 - 35	75 - 80
		Avanzamento fz mm/tagliente FEED mm/tooth					
D							
3		0,009					
4		0,013					
5		0,015					
6		0,018					
8		0,025					
10		0,030					
12		0,040					
16		0,065					
20		0,090					
		0,009		0,110		0,145	

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