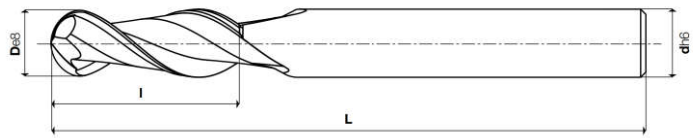


# HSS-PM HSS-PM Line

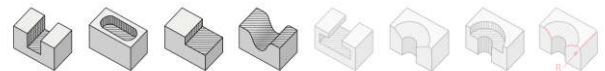
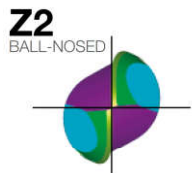
Serie/Series

## 10155

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



Cod. Art.	X-85 (PM Co 8.5%)	COATED	De8	I	L	dh6	Z
101550300 CM	CMX	3	9	60	6	2	
101550400 CM	CMX	4	13	67	6	2	
101550500 CM	CMX	5	16	70	6	2	
101550600 CM	CMX	6	16	76	6	2	
101550700 CM	CMX	7	19	79	10	2	
101550800 CM	CMX	8	19	79	10	2	
101550900 CM	CMX	9	22	83	10	2	
101551000 CM	CMX	10	22	83	10	2	
101551100 CM	CMX	11	25	95	12	2	
101551200 CM	CMX	12	28	98	12	2	
101551300 CM	CMX	13	28	98	12	2	
101551400 CM	CMX	14	32	102	12	2	
101551500 CM	CMX	15	32	108	16	2	
101551600 CM	CMX	16	32	108	16	2	
101551700 CM	CMX	17	35	114	16	2	
101551800 CM	CMX	18	35	114	16	2	
101551900 CM	CMX	19	38	132	20	2	
101552000 CM	CMX	20	38	132	20	2	
101552200 CM	CMX	22	41	135	20	2	
101552500 CM	CMX	25	44	159	25	2	
101552800 CM	CMX	28	44	159	25	2	
101553000 CM	CMX	30	50	159	25	2	
101553200 CM	CMX	32	52	165	32	2	




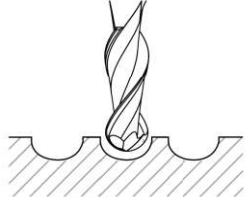
parametri tecnici a pag. / for technical parameters see page 119

### MATERIALI LAVORABILI / WORKPIECE MATERIALS



serie  
series  
10155

# Parametri di taglio/Cutting parameters

		10102 - 10105 10110 - 10125*	10140 - <b>10155*</b> 24120	12505 - 12520*			
<b>Materiali</b> <i>Materials</i>		Cava <i>Slotting</i> $ap = 0,5\phi$ $ae = 1\phi$		Sgrossatura <i>Roughing</i> $ap = 0,4\phi$ $ae = 0,9\phi$			
							
<b>Gruppo e descrizione</b> <i>Group and description</i>		Vc (mt/min.)		Vc (mt/min.)			
		X-85 NON RIVESTITA UNCOATED	X-85 <b>Skin</b>	X-85 NON RIVESTITA UNCOATED	X-85 <b>Skin</b>	X-85 NON RIVESTITA UNCOATED	X-85 <b>Skin</b> 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 &lt; 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					
<b>D</b>							
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%