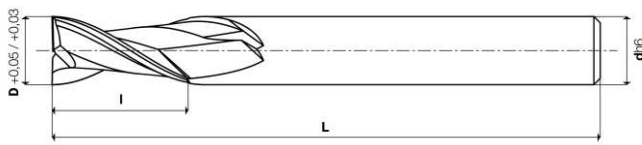


Serie/Series 12120

Frese a due taglienti
Two flute end mills

12505

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

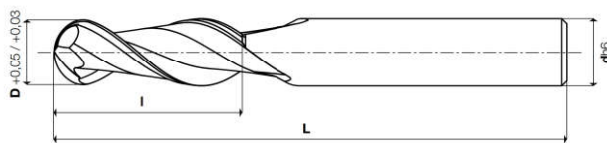


COATING Skin Alu	W A RICHIESTA ON REQUEST	F A RICHIESTA ON REQUEST	λ° s 40	W	UNI 8244 DIN 844A ISO 1641/I	
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Cod. Art.	X-85 (PM Co 8,5%)	COATED	D ^{+0,05} / _{+0,03}	I	L	dh6	Z
121200300 CM	CMX	3	12	56	6	2	
121200400 CM	CMX	4	19	63	6	2	
121200500 CM	CMX	5	24	68	6	2	
121200600 CM	CMX	6	24	68	6	2	
121200700 CM	CMX	7	30	80	10	2	
121200800 CM	CMX	8	38	88	10	2	
121200900 CM	CMX	9	38	88	10	2	
121201000 CM	CMX	10	45	95	10	2	
121201100 CM	CMX	11	45	102	12	2	
121201200 CM	CMX	12	53	110	12	2	
121201300 CM	CMX	13	53	110	12	2	
121201400 CM	CMX	14	53	110	12	2	
121201500 CM	CMX	15	63	123	16	2	
121201600 CM	CMX	16	63	123	16	2	
121201800 CM	CMX	18	63	123	16	2	
121202000 CM	CMX	20	75	141	20	2	
121202200 CM	CMX	22	75	141	20	2	
121202500 CM	CMX	25	90	166	25	2	
121202800 CM	CMX	28	90	166	25	2	
121203000 CM	CMX	30	90	166	25	2	
121203200 CM	CMX	32	106	186	32	2	



parametri tecnici a pag. / for technical parameters see page 120

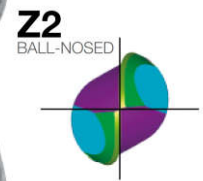
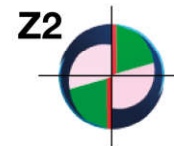


COATING Skin Alu	W A RICHIESTA ON REQUEST	F A RICHIESTA ON REQUEST	λ° s 40	W	ISO 1641/I	
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Cod. Art.	X-85 (PM Co 8,5%)	COATED	D ^{+0,05} / _{+0,03}	I	L	dh6	Z
125050200 CM	CMX	2	7	51	6	2	
125050300 CM	CMX	3	8	52	6	2	
125050400 CM	CMX	4	11	55	6	2	
125050500 CM	CMX	5	13	57	6	2	
125050600 CM	CMX	6	13	57	6	2	
125050800 CM	CMX	8	19	69	10	2	
125051000 CM	CMX	10	22	72	10	2	
125051200 CM	CMX	12	26	83	12	2	
125051400 CM	CMX	14	26	83	12	2	
125051500 CM	CMX	15	32	92	16	2	
125051600 CM	CMX	16	32	92	16	2	
125051800 CM	CMX	18	32	92	16	2	
125052000 CM	CMX	20	38	104	20	2	
125052200 CM	CMX	22	38	104	20	2	
125052500 CM	CMX	25	45	121	25	2	
125052800 CM	CMX	28	45	121	25	2	
125053000 CM	CMX	30	45	121	25	2	
125053200 CM	CMX	32	53	133	32	2	



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



Serie/Series 12120




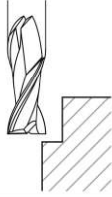
Serie/Series 12505

MATERIALI LAVORABILI / WORKPIECE MATERIALS

serie	TITANIO TITANIUM	HRSA HRSA	ACCIAI INOSSIDABILI STAINLESS STEELS	MATERIALI NON FERROSI NON FERROUS MATERIALS	LEGHE LEGGERE LIGHT ALLOYS	ACCIAI STEELS	GHISE CAST IRON
12120	○	○	●	●	●	○	○
12505	○	○	●	●	●	○	○

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

Parametri di taglio/Cutting parameters

	11405 12105 12120*		11405 12105 12120*		11405 12105 12120*		11405 12105 12120*	
Materiali <i>Materials</i>	Cava Slotting <i>ap = 1σ ae = 1σ</i>		Sgrossatura Roughing <i>ap = 0,5σ ae = 0,1σ</i>		Sgrossatura Roughing <i>ap = 1,5σ ae = 0,5σ</i>		Contornatura leggera Light shouldering <i>ap = 1,5σ ae = 0,15σ</i>	
								
Gruppo e descrizione <i>Group and description</i>	Vc (mt /min.)		Vc (mt /min.)		Vc (mt /min.)		Vc (mt /min.)	
	X-85 NON RIVESTITA UNCOATED	X-85 Skin Alu	X-85 NON RIVESTITA UNCOATED	X-85 Skin Alu	X-85 NON RIVESTITA UNCOATED	X-85 Skin Alu	X-85 NON RIVESTITA UNCOATED	X-85 Skin Alu
Alluminio non legato <i>Unalloyed aluminium</i>	110 - 120	250 - 260	110 - 120	250 - 260	110 - 120	250 - 260	110 - 120	250 - 260
Alluminio Si < 6% <i>si < 6% aluminium</i>	70 - 80	170 - 180	70 - 80	170 - 180	70 - 80	170 - 180	70 - 80	170 - 180
Materiali termoplastici <i>Thermoplastic materials</i>	130 - 140	270 - 280	130 - 140	270 - 280	130 - 140	270 - 280	130 - 140	270 - 280
Rame/Ottone <i>Copper/Brass</i>	30 - 35	75 - 80	30 - 35	75 - 80	30 - 35	75 - 80	30 - 35	75 - 80
	Avanzamento fz mm/tagliante <i>FEED mm/tooth</i>							
D	0,007		0,007		0,007		0,007	
3	0,007		0,007		0,007		0,007	
4	0,008		0,010		0,008		0,010	
5	0,010		0,016		0,010		0,016	
6	0,012		0,020		0,012		0,020	
8	0,016		0,032		0,016		0,030	
10	0,022		0,045		0,022		0,040	
12	0,030		0,060		0,024		0,050	
16	0,036		0,100		0,030		0,080	
20	0,045		0,120		0,036		0,105	

* series **12120** fz consigliato | *RECOMMENDED -50%*

Materiali non ferrosi
Light alloys
Non ferrous materials
Light alloys