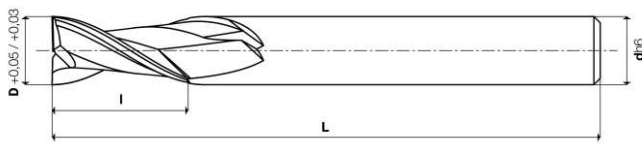


## Serie/Series 12120

Frese a due taglianti  
Two flute end mills

## 12505

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



COATING: **Skin Alu**

W: A RICHIESTA / ON REQUEST

F: A RICHIESTA / ON REQUEST

$\lambda^{\circ}$ s: 40

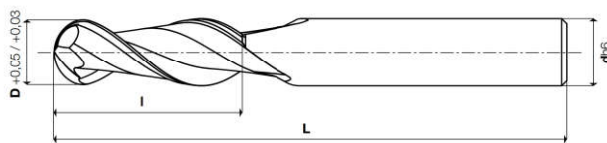
W

UNI 8244  
DIN 844A  
ISO 1641/1

Cod. Art.	X-85 (PM Co 8,5%)	COATED	D +0,05 +0,03	I	L	dh6	Z
121200300 CM	CMX	CMX	3	12	56	6	2
121200400 CM	CMX	CMX	4	19	63	6	2
121200500 CM	CMX	CMX	5	24	68	6	2
121200600 CM	CMX	CMX	6	24	68	6	2
121200700 CM	CMX	CMX	7	30	80	10	2
121200800 CM	CMX	CMX	8	38	88	10	2
121200900 CM	CMX	CMX	9	38	88	10	2
121201000 CM	CMX	CMX	10	45	95	10	2
121201100 CM	CMX	CMX	11	45	102	12	2
121201200 CM	CMX	CMX	12	53	110	12	2
121201300 CM	CMX	CMX	13	53	110	12	2
121201400 CM	CMX	CMX	14	53	110	12	2
121201500 CM	CMX	CMX	15	63	123	16	2
121201600 CM	CMX	CMX	16	63	123	16	2
121201800 CM	CMX	CMX	18	63	123	16	2
121202000 CM	CMX	CMX	20	75	141	20	2
121202200 CM	CMX	CMX	22	75	141	20	2
121202500 CM	CMX	CMX	25	90	166	25	2
121202800 CM	CMX	CMX	28	90	166	25	2
121203000 CM	CMX	CMX	30	90	166	25	2
121203200 CM	CMX	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

$\lambda^{\circ}$ s: 40

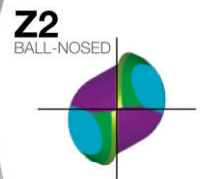
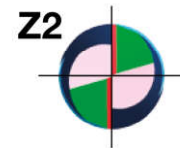
W

ISO 1641/1

Cod. Art.	X-85 (PM Co 8,5%)	COATED	D +0,05 +0,03	I	L	dh6	Z
125050200 CM	CMX	CMX	2	7	51	6	2
125050300 CM	CMX	CMX	3	8	52	6	2
125050400 CM	CMX	CMX	4	11	55	6	2
125050500 CM	CMX	CMX	5	13	57	6	2
125050600 CM	CMX	CMX	6	13	57	6	2
125050800 CM	CMX	CMX	8	19	69	10	2
125051000 CM	CMX	CMX	10	22	72	10	2
125051200 CM	CMX	CMX	12	26	83	12	2
125051400 CM	CMX	CMX	14	26	83	12	2
125051500 CM	CMX	CMX	15	32	92	16	2
125051600 CM	CMX	CMX	16	32	92	16	2
125051800 CM	CMX	CMX	18	32	92	16	2
125052000 CM	CMX	CMX	20	38	104	20	2
125052200 CM	CMX	CMX	22	38	104	20	2
125052500 CM	CMX	CMX	25	45	121	25	2
125052800 CM	CMX	CMX	28	45	121	25	2
125053000 CM	CMX	CMX	30	45	121	25	2
125053200 CM	CMX	CMX	32	53	133	32	2



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


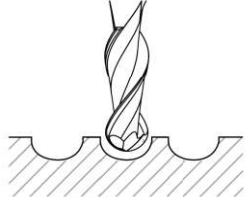
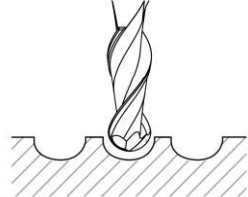


### MATERIALI LAVORABILI / WORKPIECE MATERIALS

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

		10102 - 10105 10110 - 10125*	10140 - 10155* 24120	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 <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 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 Non ferrous materials 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%