

HSS-PM HSS-PM Line

Serie/Series

12520

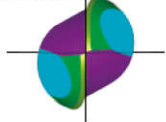
Frese a due taglienti a testa semisferica
Ball nosed two flute end drills

14105

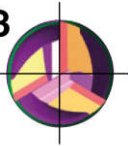
Frese a tre taglienti ad alte prestazioni
Three flute end mills

ALTE PRESTAZIONI
HIGH PERFORMANCE

Z2
BALL-NOSED



Z3



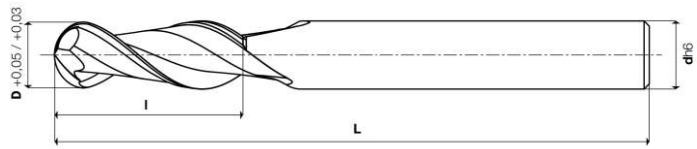
Skin
Rivestimento/Coating



Serie/Series 12520



Serie/Series 14105

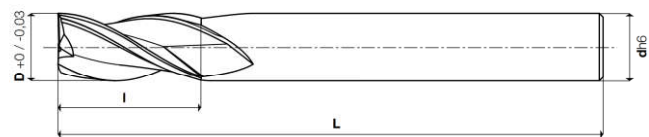


COATING Skin Alu	W A RICHIESTA ON REQUEST	F A RICHIESTA ON REQUEST	$\lambda^{\circ}s$ 40	W	ISO 1641/1	
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Cod. Art.	X-85 (PM Co 8,5%)	COATED	D +0,05 +0,03	I	L	dh6	Z
125200300	CM	CMX	3	12	56	6	2
125200400	CM	CMX	4	19	63	6	2
125200500	CM	CMX	5	24	68	6	2
125200600	CM	CMX	6	24	68	6	2
125200800	CM	CMX	8	38	88	10	2
125201000	CM	CMX	10	45	95	10	2
125201200	CM	CMX	12	53	110	12	2
125201400	CM	CMX	14	53	110	12	2
125201500	CM	CMX	15	63	123	16	2
125201600	CM	CMX	16	63	123	16	2
125201800	CM	CMX	18	63	123	16	2
125202000	CM	CMX	20	75	141	20	2
125202200	CM	CMX	22	75	141	20	2
125202500	CM	CMX	25	90	166	25	2
125202800	CM	CMX	28	90	166	25	2
125203000	CM	CMX	30	90	166	25	2
125203200	CM	CMX	32	106	186	32	2



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



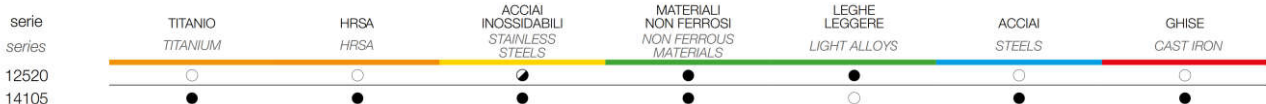
COATING Skin	W A RICHIESTA ON REQUEST	F A RICHIESTA ON REQUEST	$\lambda^{\circ}s$ 32	N	UNI 8244 DIN 844A ISO 1641/1	
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Cod. Art.	X-105 (PM Co 10,5%)	D +0 -0,03	I	L	dh6	Z
141050600	EMX	6	13	57	6	3
141050800	EMX	8	19	69	10	3
141051000	EMX	10	22	72	10	3
141051200	EMX	12	26	83	12	3
141051400	EMX	14	26	83	12	3
141051600	EMX	16	32	92	16	3
141051800	EMX	18	32	92	16	3
141052001	EMX	20	38	104	20	3




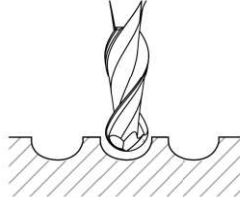
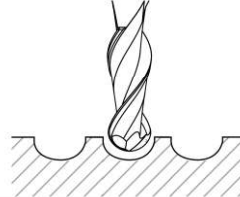
parametri tecnici a pag. / for technical parameters see page 126

MATERIALI LAVORABILI / WORKPIECE MATERIALS



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

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 <i>Cast Iron</i>	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 <i>Steel</i>	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 <i>Non ferrous materials</i>	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%