

HSS-PM HSS-PM Line

Serie/Series 12520

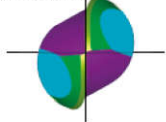
Frese a due taglienti a testa semisferica
Ball nosed two flute end drills

14105

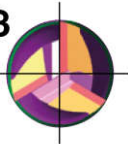
Frese a tre taglienti ad alte prestazioni
Three flute end mills

**ALTE PRESTAZIONI
HIGH PERFORMANCE**

Z2
BALL-NOSED



Z3



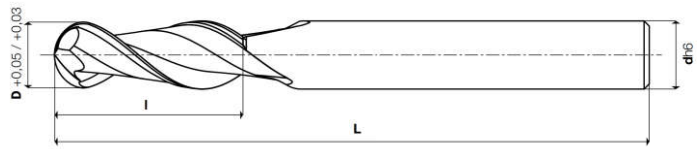
Skin
Rivestimento/Coating



Serie/Series 12520

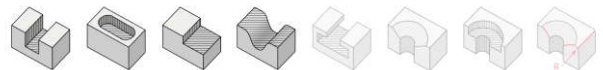


Serie/Series 14105

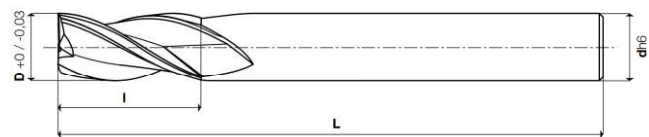


COATING Skin Alu	W A RICHIESTA ON REQUEST	F A RICHIESTA ON REQUEST	$\lambda^{\circ}s$ 40	W	ISO 1641/1	
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Cod. Art.	X-85 (PM Co 8,5%)	COATED	D +0,05 +0,03	I	L	dh6	Z
125200300	CM	CMX	3	12	56	6	2
125200400	CM	CMX	4	19	63	6	2
125200500	CM	CMX	5	24	68	6	2
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



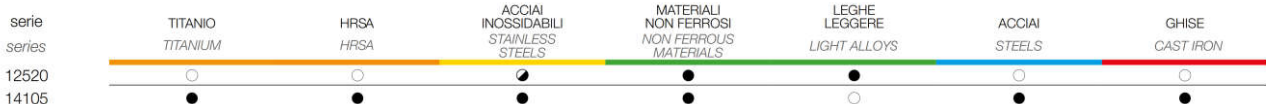
COATING Skin	W A RICHIESTA ON REQUEST	F A RICHIESTA ON REQUEST	$\lambda^{\circ}s$ 32	N	UNI 8244 DIN 844A ISO 1641/1	
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Cod. Art.	X-105 (PM Co 10,5%)	D +0 -0,03	I	L	dh6	Z
141050600	EMX	6	13	57	6	3
141050800	EMX	8	19	69	10	3
141051000	EMX	10	22	72	10	3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

10110

14105

Materiali
Materials

Cava
Slotting
 $ap = 0,5\phi$ $ae = 1\phi$

Contornatura
Shouldering
 $ap = 1,5\phi$ $ae = 0,15\phi$



		Vc (mt /min.)	Vc (mt /min.)
Gruppo e descrizione Group and description		X-105 Skin	X-105 Skin
Ghisa Cast Iron	Grigia e sferoidale Grey and spheroidal	45 - 50	45 - 50
	Basso contenuto di C Low carbon content	70 - 80	70 - 80
Acciaio Steel	Medio contenuto di C Medium carbon content	70 - 80	70 - 80
	Basso legato Low alloyed	65 - 75	65 - 75
	Alto legato High alloyed	50 - 60	50 - 60
	Acciaio da stampi e utensili Die/tool steel	30 - 40	30 - 40
Acciaio inossidabile Stainless Steel	AISI 304 - 416 - 420	15 - 20	15 - 20
	AISI 316 - 440	15 - 20	15 - 20
	17-4 ph 15-5 ph	10 - 15	10 - 15
	Leghe Cr - Co Cr - Co alloys	10 - 15	10 - 15
	Duplex F51	5 - 10	5 - 10
	Super Duplex F55	5 - 10	5 - 10
Superleghe resistenti al calore Heat Resistant Super Alloys	HRSA Hastelloy	5 - 10	5 - 10
	HRSA Inconel 625	5 - 10	5 - 10
	HRSA Inconel 718	5 - 10	5 - 10
	HRSA Nimonic	5 - 10	5 - 10
Ti	Titanio - Titanium	15 - 20	15 - 20
	Leghe di titanio Titanium alloys	15 - 20	15 - 20
Materiali non ferrosi Leghe leggere Non ferrous materials Light alloys	Alluminio non legato Unalloyed aluminium	-	-
	Alluminio Si < 6% si < 6% aluminium	-	-
	Materiali termoplastici Thermoplastic materials	-	-
	Rame/Ottone Copper/Brass	75 - 85	75 - 85
		Avanzamento fz mm/tagliente FEED mm/tooth	
D			
6		0,018	0,025
8		0,024	0,035
10		0,030	0,045
12		0,040	0,060
16		0,066	0,090
20		0,090	0,120