

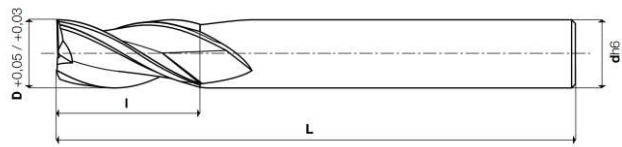
HSS-PM HSS-PM Line

Serie/Series 14805

Frese a tre taglienti
Three flute end mills

14820

Frese a tre taglienti
Three flute end mills

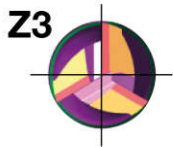


COATING: **Skin Alu** (A RICHIESTA ON REQUEST) | **W** (A RICHIESTA ON REQUEST) | **F** (A RICHIESTA ON REQUEST) | $\lambda^{\circ}s$ 40 | **W** | QUALITY STANDARD UOP ✓

Cod. Art.	X-85 (PM Co 8,5%)	COATED	D +0.05 / +0.03	I	L	dh6	Z
148050300	CM	CMX	3	14	58	6	3
148050400	CM	CMX	4	18	62	6	3
148050500	CM	CMX	5	20	64	6	3
148050600	CM	CMX	6	22	66	6	3
148050700	CM	CMX	7	22	72	10	3
148050800	CM	CMX	8	25	75	10	3
148050900	CM	CMX	9	25	75	10	3
148051000	CM	CMX	10	28	78	10	3
148051200	CM	CMX	12	32	89	12	3
148051400	CM	CMX	14	32	89	12	3
148051600	CM	CMX	16	36	96	16	3
148051800	CM	CMX	18	40	100	16	3
148052000	CM	CMX	20	45	110	20	3
148052200	CM	CMX	22	45	110	20	3
148052500	CM	CMX	25	50	125	25	3
148052800	CM	CMX	28	56	132	25	3
148053000	CM	CMX	30	63	140	25	3
148053200	CM	CMX	32	63	143	32	3
148053600	CM	CMX	36	70	150	32	3
148054000	CM	CMX	40	70	150	32	3



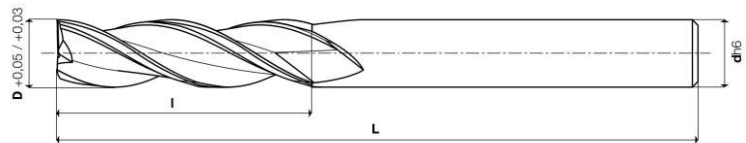
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Serie/Series 14805



Serie/Series 14820



COATING: **Skin Alu** (A RICHIESTA ON REQUEST) | **W** (A RICHIESTA ON REQUEST) | **F** (A RICHIESTA ON REQUEST) | $\lambda^{\circ}s$ 40 | **W** | QUALITY STANDARD UOP ✓

Cod. Art.	X-85 (PM Co 8,5%)	COATED	D +0.05 / +0.03	I	L	dh6	Z
148200300	CM	CMX	3	18	62	6	3
148200400	CM	CMX	4	22	65	6	3
148200500	CM	CMX	5	26	70	6	3
148200600	CM	CMX	6	30	75	6	3
148200700	CM	CMX	7	34	84	10	3
148200800	CM	CMX	8	34	84	10	3
148200900	CM	CMX	9	40	90	10	3
148201000	CM	CMX	10	40	90	10	3
148201200	CM	CMX	12	56	113	12	3
148201400	CM	CMX	14	63	120	12	3
148201600	CM	CMX	16	63	123	16	3
148201800	CM	CMX	18	71	131	16	3
148202000	CM	CMX	20	71	137	20	3
148202200	CM	CMX	22	80	146	20	3
148202500	CM	CMX	25	80	156	25	3
148202800	CM	CMX	28	90	166	25	3
148203000	CM	CMX	30	90	166	25	3
148203200	CM	CMX	32	90	170	32	3
148203600	CM	CMX	36	100	180	32	3
148204000	CM	CMX	40	100	180	32	3




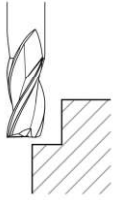
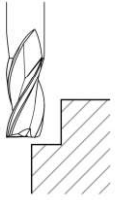
parametri tecnici a pag. / for technical parameters see page 122

MATERIALI LAVORABILI / WORKPIECE MATERIALS

serie	TITANIO	HRSA	ACCIAI INOSSIDABILI	MATERIALI NON FERROSI	LEGHE LEGGERE	ACCIAI	GHISE
series	TITANIUM	HRSA	STAINLESS STEELS	NON FERROUS MATERIALS	LIGHT ALLOYS	STEELS	CAST IRON
14805	○	○	○	●	●	○	○
14820	○	○	○	●	●	○	○

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

Parametri di taglio/Cutting parameters

		14805 14820*		14805 14820*		14805 14820*	
Materiali Materials		Cava Shouldering $ap = 1\phi \quad ae = 1\phi$		Contornatura Shouldering $ap = 1,5\phi \quad ae = 0,15\phi$		Contornatura Shouldering $ap = 1,5\phi \quad ae = 0,5\phi$	
							
Gruppo e descrizione Group and description	Vc (mt /min.)		Vc (mt /min.)		Vc (mt /min.)		
	X-85 NON RIVESTITA UNCOATED	X-85 <i>Skin</i> Alu	X-85 NON RIVESTITA UNCOATED	X-85 <i>Skin</i> Alu	X-85 NON RIVESTITA UNCOATED	X-85 <i>Skin</i> Alu	
Alluminio non legato Unalloyed aluminium	110 - 120	250 - 260	110 - 120	250 - 260	110 - 120	250 - 260	
Alluminio Si < 6% si < 6% aluminium	70 - 80	170 - 180	70 - 80	170 - 180	70 - 80	170 - 180	
Materiali termoplastici Thermoplastic materials	130 - 140	270 - 280	130 - 140	270 - 280	130 - 140	270 - 280	
Rame/Ottone Copper/Brass	30 - 35	75 - 80	30 - 35	75 - 80	30 - 35	75 - 80	
	Avanzamento fz mm/tagliante FEED mm/tooth						
D	0,007		0,007		0,007		
3	0,007		0,007		0,007		
4	0,008		0,008		0,010		
5	0,010		0,010		0,016		
6	0,012		0,012		0,020		
8	0,016		0,016		0,030		
10	0,022		0,022		0,040		
12	0,030		0,024		0,050		
16	0,036		0,030		0,080		
20	0,045		0,036		0,105		

* series 14820 fz consigliato | RECOMMENDED -50%