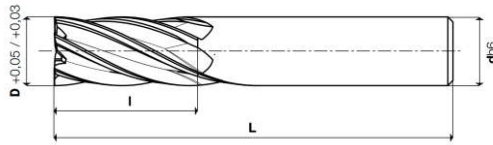


Serie/Series 17105

Frese a **FINIRE**
Finishing end mills

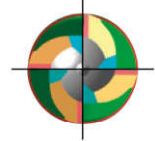


Cod. Art.	X-85 (PM Co 8,8%)	COATED	D +0,05 +0,03	I	L	dh6	Z
171050200	CM	CMX	2	7	51	6	4
171050250	CM	CMX	2,5	8	52	6	4
171050300	CM	CMX	3	8	52	6	4
171050350	CM	CMX	3,5	10	54	6	4
171050400	CM	CMX	4	11	55	6	4
171050450	CM	CMX	4,5	11	55	6	4
171050500	CM	CMX	5	13	57	6	4
171050550	CM	CMX	5,5	13	57	6	4
171050600	CM	CMX	6	13	57	6	4
171050650	CM	CMX	6,5	16	66	10	4
171050700	CM	CMX	7	16	66	10	4
171050800	CM	CMX	8	19	69	10	4
171050900	CM	CMX	9	19	69	10	4
171051000	CM	CMX	10	22	72	10	4
171051100	CM	CMX	11	22	79	12	4
171051200	CM	CMX	12	26	83	12	4
171051300	CM	CMX	13	26	83	12	4
171051400	CM	CMX	14	26	83	12	4
171051500	CM	CMX	15	32	92	16	4
171051600	CM	CMX	16	32	92	16	4
171051700	CM	CMX	17	32	92	16	4
171051800	CM	CMX	18	32	92	16	4
171051900	CM	CMX	19	38	98	16	4
171052000	CM	CMX	20	38	98	16	4
171052001	CM	CMX	20	38	104	20	4
171052200	CM	CMX	22	38	104	20	4
171052400	CM	CMX	24	45	121	25	5
171052500	CM	CMX	25	45	121	25	5
171052600	CM	CMX	26	45	121	25	5
171052800	CM	CMX	28	45	121	25	5
171053000	CM	CMX	30	45	121	25	6
171053200	CM	CMX	32	53	133	32	6
171053400	CM	CMX	34	53	133	32	6
171053500	CM	CMX	35	53	133	32	6
171053600	CM	CMX	36	53	133	32	6
171053800	CM	CMX	38	63	143	32	6
171054000	CM	CMX	40	63	143	32	8
171054500	CM	CMX	45	63	143	32	8
171054800	CM	CMX	48	75	155	32	8
171055000	CM	CMX	50	75	155	32	8



parametri tecnici a pag. 1 for technical parameters see page 123

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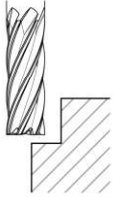
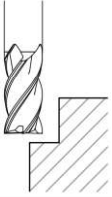
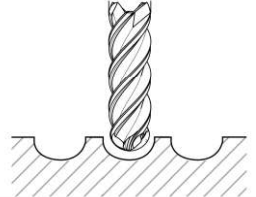


MATERIALI LAVORABILI / WORKPIECE MATERIALS

serie séries	TITANIO TITANIUM	HRSA HRSA	ACCIAI INOSSIDABILI STAINLESS STEELS	MATERIALI NON FERROSI NON FERROUS MATERIALS	LEGHE LEGGERE LIGHT ALLOYS	ACCIAI STEELS	GHISE CAST IRON
17105	○	○	●	○	○	●	●

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

Parametri di taglio/Cutting parameters

		17105 - 17120* 17135** - 17305 17320	18105	17505 17520*	
Materiali Materials		Contornatura Shouldering $ap = 1,5\phi$ $ae = 0,15\phi$	Contornatura Shouldering $ap = 1,5\phi$ $ae = 0,15\phi$	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 Skin	X-85 NON RIVESTITA UNCOATED	X-85 Skin
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
	Medio contenuto di C Medium carbon content	25 - 30	50 - 60	25 - 30	50 - 60
Acciaio Steel	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
Acciaio inossidabile Stainless Steel	AISI 304 - 416 - 420	-	-	-	15 - 20
	AISI 316 - 440	-	-	-	15 - 20
	17-4 ph 15-5 ph	-	-	-	10 - 15
	Leghe Cr - Co Cr - Co alloys	-	-	-	10 - 15
	Duplex F51	-	-	-	5 - 10
	Super Duplex F55	-	-	-	5 - 10
Superleghe resistenti al calore Heat Resistant Super Alloys	HRSA Hastelloy	-	-	-	5 - 10
	HRSA Inconel 625	-	-	-	5 - 10
	HRSA Inconel 718	-	-	-	5 - 10
	HRSA Nimonic	-	-	-	5 - 10
Ti	Titanio - Titanium	-	-	-	10 - 15
	Leghe di titanio Titanium alloys	-	-	-	10 - 15
D		Avanzamento fz mm/tagliente FEED mm/tooth			
3		0,010		0,007	
4		0,015		0,009	
5		0,020		0,012	
6		0,025		0,014	
8		0,035		0,021	
10		0,045		0,028	
12		0,056		0,038	
16		0,090		0,065	
20		0,120		0,090	

* series 17120; series 17520 fz consigliato | RECOMMENDED -30%

** series 17135 fz consigliato | RECOMMENDED -50%