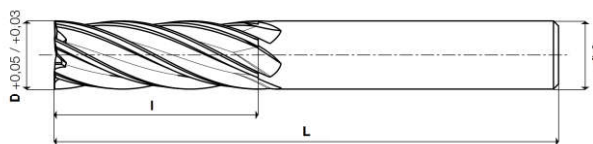


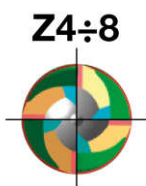
# HSS-PM HSS-PM Line

## Serie/Series 17120

Frese a **FINIRE**  
Finishing end mills



Cod. Art.	X-85 (PM Co 8,5%)	COATED	D +0,05 +0,03	I	L	dh6	Z
171200200 CM	CMX		2	10	54	6	4
171200300 CM	CMX		3	12	56	6	4
171200400 CM	CMX		4	19	63	6	4
171200500 CM	CMX		5	24	68	6	4
171200600 CM	CMX		6	24	68	6	4
171200700 CM	CMX		7	30	80	10	4
171200800 CM	CMX		8	38	88	10	4
171200900 CM	CMX		9	38	88	10	4
171201000 CM	CMX		10	45	95	10	4
171201100 CM	CMX		11	45	102	12	4
171201200 CM	CMX		12	53	110	12	4
171201300 CM	CMX		13	53	110	12	4
171201400 CM	CMX		14	53	110	12	4
171201500 CM	CMX		15	63	123	16	4
171201600 CM	CMX		16	63	123	16	4
171201700 CM	CMX		17	63	123	16	4
171201800 CM	CMX		18	63	123	16	4
171201900 CM	CMX		19	75	135	16	4
171202000 CM	CMX		20	75	135	16	4
171202001 CM	CMX		20	75	141	20	4
171202200 CM	CMX		22	75	141	20	4
171202400 CM	CMX		24	90	166	25	5
171202500 CM	CMX		25	90	166	25	5
171202600 CM	CMX		26	90	166	25	5
171202800 CM	CMX		28	90	166	25	5
171203000 CM	CMX		30	90	166	25	6
171203200 CM	CMX		32	106	186	32	6
171203400 CM	CMX		34	106	186	32	6
171203500 CM	CMX		35	106	186	32	6
171203600 CM	CMX		36	106	186	32	6
171203800 CM	CMX		38	125	205	32	6
171204000 CM	CMX		40	125	205	32	8

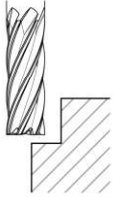
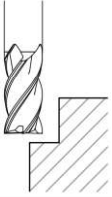
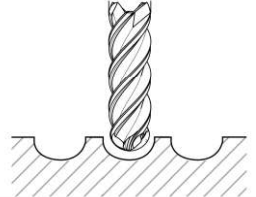


parametri tecnici a pag. / for technical parameters see page 123

### 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
17120	○	○	●	○	○	●	●

# 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 <b>Skin</b>	X-85 NON RIVESTITA UNCOATED	X-85 <b>Skin</b>
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	-
<b>D</b>		<b>Avanzamento fz mm/tagliente FEED mm/tooth</b>			
3		0,010			
4		0,015			
5		0,020			
6		0,025			
8		0,035			
10		0,045			
12		0,056			
16		0,090			
20		0,120			

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

\*\* series 17135 fz consigliato | RECOMMENDED -50%