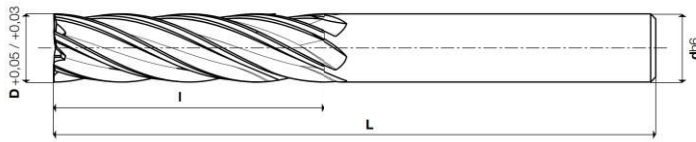


Serie/Series 17135

Frese a **FINIRE**
Finishing end mills

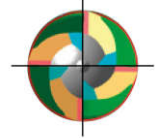


Cod. Art.	X-85 (PM Co 8.5%)	COATED	D +0,05 +0,03	I	L	dh6	Z
171350600	CM	CMX	6	56	106	10	4
171350700	CM	CMX	7	63	113	10	4
171350800	CM	CMX	8	63	113	10	4
171350900	CM	CMX	9	70	120	10	4
171351000	CM	CMX	10	70	120	10	4
171351200	CM	CMX	12	80	137	12	4
171351400	CM	CMX	14	80	137	12	4
171351500	CM	CMX	15	90	150	16	4
171351600	CM	CMX	16	90	150	16	4
171351800	CM	CMX	18	100	166	20	4
171352000	CM	CMX	20	110	176	20	4
171352200	CM	CMX	22	110	176	20	4
171352500	CM	CMX	25	125	201	25	5
171352800	CM	CMX	28	135	211	25	5
171353000	CM	CMX	30	140	216	25	6
171353200	CM	CMX	32	150	230	32	6



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

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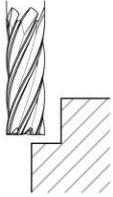
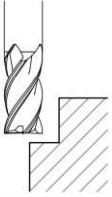
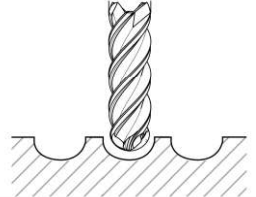


MATERIALI LAVORABILI / WORKPIECE MATERIALS

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
17135	○	○	●	○	○	●	●

● 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%