

# HSS-PM HSS-PM Line

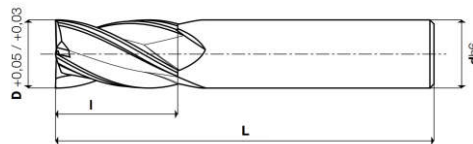
## Serie/Series 17305

Frese a **FINIRE** con tagliente al centro  
Finishing end mills center cutting

**ALTE PRESTAZIONI**  
**HIGH PERFORMANCE**

## 17305

Frese a **FINIRE** con tagliente al centro  
Finishing end mills center cutting

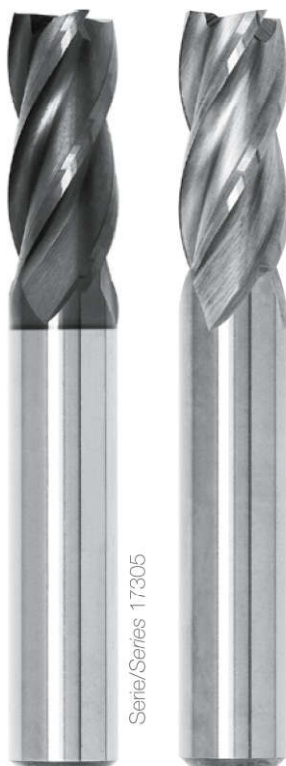
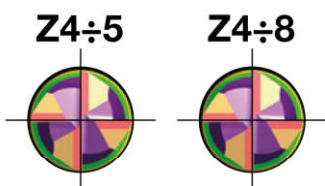
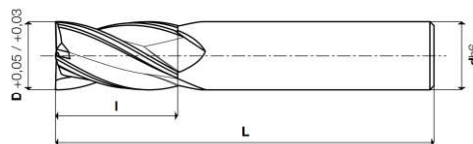


COATING <b>Skin</b>	W A RICHIESTA ON REQUEST	F A RICHIESTA ON REQUEST	$\lambda^{\circ}s$ 32	N	UNI 8244 DIN 844A ISO 1641/1	
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Cod. Art.	X-105 (PM Co 10,5%)	D +0,05 +0,03	I	L	dh6	Z
173050600	EMX	6	13	57	6	4
173050800	EMX	8	19	69	10	4
173051000	EMX	10	22	72	10	4
173051200	EMX	12	26	83	12	4
173051400	EMX	14	26	83	12	4
173051600	EMX	16	32	92	16	4
173051800	EMX	18	32	92	16	4
173052001	EMX	20	38	104	20	4
173052200	EMX	22	38	104	20	4
173052500	EMX	25	45	121	25	5



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



Serie/Series 17305

Serie/Series 17305

COATING <b>Skin</b>	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-85 (PM Co 8,5%)	COATED	D +0,05 +0,03	I	L	dh6	Z
173050200	CM	CMX	2	7	51	6	4
173050300	CM	CMX	3	8	52	6	4
173050400	CM	CMX	4	11	55	6	4
173050500	CM	CMX	5	13	57	6	4
173050600	CM	CMX	6	13	57	6	4
173050800	CM	CMX	8	19	69	10	4
173051000	CM	CMX	10	22	72	10	4
173051200	CM	CMX	12	26	83	12	4
173051400	CM	CMX	14	26	83	12	4
173051500	CM	CMX	15	32	92	16	4
173051600	CM	CMX	16	32	92	16	4
173051800	CM	CMX	18	32	92	16	4
173052000	CM	CMX	20	38	98	16	4
173052001	CM	CMX	20	38	104	20	4
173052200	CM	CMX	22	38	104	20	4
173052400	CM	CMX	24	45	121	25	5
173052500	CM	CMX	25	45	121	25	5
173052600	CM	CMX	26	45	121	25	5
173052800	CM	CMX	28	45	121	25	5
173053000	CM	CMX	30	45	121	25	6
173053200	CM	CMX	32	53	133	32	6
173053600	CM	CMX	36	53	133	32	6
173054000	CM	CMX	40	63	143	32	8
173055000	CM	CMX	50	75	155	32	8

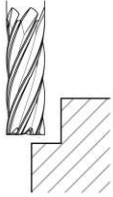
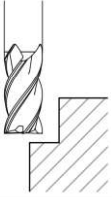
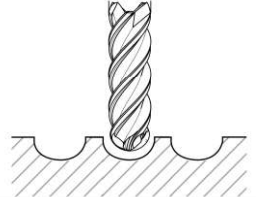


MATERIALI LAVORABILI / WORKPIECE MATERIALS

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

serie	TITANIO TITANIUM	HRSA HRSA	ACCIAI INOSSIDABILI STAINLESS STEELS	MATERIALI NON FERROSI NON FERROUS MATERIALS	LEGHE LEGGERE LIGHT ALLOYS	ACCIAI STEELS	GHISE CAST IRON
17305 EMX	●	●	●	●	○	●	●
17305 CM/CMX	○	○	●	○	○	●	●

# Parametri di taglio/Cutting parameters

		17105 - 17120* 17135** - <b>17305</b> 17320	18105	17505 17520*	
<b>Materiali</b> <i>Materials</i>		Contornatura <i>Shouldering</i> $ap = 1,5\phi$ $ae = 0,15\phi$	Contornatura <i>Shouldering</i> $ap = 1,5\phi$ $ae = 0,15\phi$	Sgrossatura <i>Roughing</i> $ap = 0,4\phi$ $ae = 0,9\phi$	
					
<b>Gruppo e descrizione</b> <i>Group and description</i>		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 <i>Cast Iron</i>	Grigia e sferoidale <i>Grey and spheroidal</i>	20 - 25	45 - 50	20 - 25	45 - 50
	Basso contenuto di C <i>Low carbon content</i>	30 - 35	60 - 70	30 - 35	60 - 70
	Medio contenuto di C <i>Medium carbon content</i>	25 - 30	50 - 60	25 - 30	50 - 60
Acciaio <i>Steel</i>	Basso legato <i>Low alloyed</i>	25 - 30	50 - 60	25 - 30	50 - 60
	Alto legato <i>High alloyed</i>	20 - 25	40 - 50	20 - 25	40 - 50
	Acciaio da stampi e utensili <i>Die/tool steel</i>	15 - 20	30 - 40	15 - 20	30 - 40
Acciaio inossidabile <i>Stainless Steel</i>	AISI 304 - 416 - 420	-	-	15 - 20	-
	AISI 316 - 440	-	-	15 - 20	-
	17-4 ph 15-5 ph	-	-	10 - 15	-
	Leghe Cr - Co <i>Cr - Co alloys</i>	-	-	10 - 15	-
	Duplex F51	-	-	5 - 10	-
	Super Duplex F55	-	-	5 - 10	-
Superleghe resistenti al calore <i>Heat Resistant Super Alloys</i>	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 <i>Titanium alloys</i>	-	-	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%