

HSS-PM HSS-PM Line

Serie/Series 17320

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

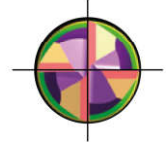
COATING Skin	W A RICHIESTA ON REQUEST	F A RICHIESTA ON REQUEST	$\lambda^{\circ}s$ 32	N	UNI 8244 DIN 844A ISO 1641/1	
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Cod. Art.	X-85 (PM Co 8.5%)	COATED	D +0,05 +0,03	I	L	dh6	Z
173200200 CM	CMX		2	10	54	6	4
173200300 CM	CMX		3	12	56	6	4
173200400 CM	CMX		4	19	63	6	4
173200500 CM	CMX		5	24	68	6	4
173200600 CM	CMX		6	24	68	6	4
173200800 CM	CMX		8	38	88	10	4
173201000 CM	CMX		10	45	95	10	4
173201200 CM	CMX		12	53	110	12	4
173201400 CM	CMX		14	53	110	12	4
173201500 CM	CMX		15	63	123	16	4
173201600 CM	CMX		16	63	123	16	4
173201800 CM	CMX		18	63	123	16	4
173202000 CM	CMX		20	75	135	16	4
173202001 CM	CMX		20	75	141	20	4
173202200 CM	CMX		22	75	141	20	4
173202400 CM	CMX		24	90	166	25	5
173202500 CM	CMX		25	90	166	25	5
173202600 CM	CMX		26	90	166	25	5
173202800 CM	CMX		28	90	166	25	5
173203000 CM	CMX		30	90	166	25	6
173203200 CM	CMX		32	106	186	32	6
173203600 CM	CMX		36	106	186	32	6
173204000 CM	CMX		40	125	205	32	8



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

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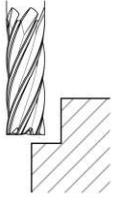
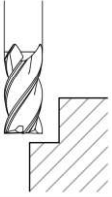
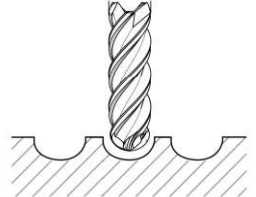


MATERIALI LAVORABILI / WORKPIECE MATERIALS

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
17320	○	○	●	○	○	●	●

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

Parametri di taglio/Cutting parameters

		17105 - 17120* 17135** - 17305 17320	18105	17505 17520*	
Materiali <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> $ap = 0,4\phi$ $ae = 0,9\phi$	
					
Gruppo e descrizione <i>Group and description</i>		Vc (mt/min.)		Vc (mt/min.)	
		X-85 NON RIVESTITA UNCOATED	X-85 <i>Skin</i>	X-85 NON RIVESTITA UNCOATED	X-85 <i>Skin</i>
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	-
D		Avanzamento fz mm/tagliente FEED mm/tooth			
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%