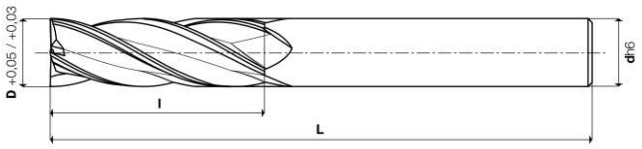


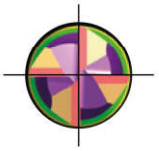
Serie/*Series*
17320
Frese a **FINIRE** con tagliente al centro
Finishing end mills center cutting

COATING	W	F	λ°s			
Skin	A RICHIESTA *ON REQUEST*	A RICHIESTA *ON REQUEST*	32	N	UNI 8244 DIN 844A ISO 1641/I	

Cod. Art. X-85 (PM Co 8,5%)	COATED	D +0,05 +0,03	l	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*

Z4÷8

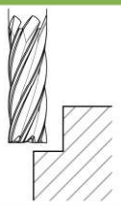
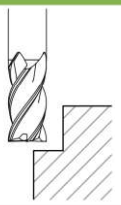
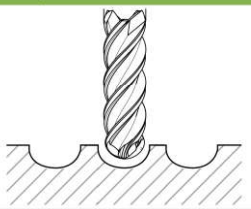


MATERIALI LAVORABILI / *WORKPIECE MATERIALS*

serie *series*	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 *Materials*	**Contornatura** *Shouldering* *ap = 1,5ø ae = 0,15ø*		**Contornatura** *Shouldering* *ap = 1,5ø ae = 0,15ø*		**Sgrossatura** *Roughing* *ap = 0,4ø ae = 0,9ø*	
							
	Gruppo e descrizione *Group and description*	**Vc (mt /min.)**		**Vc (mt /min.)**		**Vc (mt /min.)**	
		X-85 NON RIVESTITA *UNCOATED*	**X-85 Skin**	**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	20 - 25	45 - 50
Acciaio *Steel*	**Basso contenuto di C** *Low carbon content*	30 - 35	60 - 70	30 - 35	60 - 70	30 - 35	60 - 70
	Medio contenuto di C *Medium carbon content*	25 - 30	50 - 60	25 - 30	50 - 60	25 - 30	50 - 60
	Basso legato *Low alloyed*	25 - 30	50 - 60	25 - 30	50 - 60	25 - 30	50 - 60
	Alto legato *High alloyed*	20 - 25	40 - 50	20 - 25	40 - 50	20 - 25	40 - 50
	Acciaio da stampi e utensili *Die/tool steel*	15 - 20	30 - 40	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%