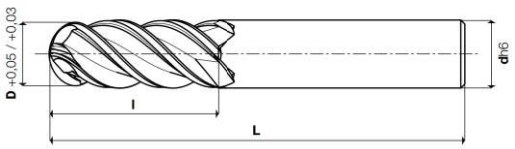
Serie/Series 17505

Frese a testa semisferica
Ball nosed end mills



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

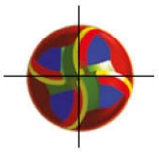
Cod. Art.	X-85 (PM Co 8,5%)	COATED	D +0,05 +0,03	l	L	dh6	Z
175050200 CM		CMX	2	7	51	6	4
175050300 CM		CMX	3	8	52	6	4
175050400 CM		CMX	4	11	55	6	4
175050500 CM		CMX	5	13	57	6	4
175050600 CM		CMX	6	13	57	6	4
175050800 CM		CMX	8	19	69	10	4
175051000 CM		CMX	10	22	72	10	4
175051200 CM		CMX	12	26	83	12	4
175051400 CM		CMX	14	26	83	12	4
175051500 CM		CMX	15	32	92	16	4
175051600 CM		CMX	16	32	92	16	4
175051800 CM		CMX	18	32	92	16	4
175052000 CM		CMX	20	38	98	16	4
175052001 CM		CMX	20	38	104	20	4
175052200 CM		CMX	22	38	104	20	4
175052400 CM		CMX	24	45	121	25	5
175052500 CM		CMX	25	45	121	25	5
175052600 CM		CMX	26	45	121	25	5
175052800 CM		CMX	28	45	121	25	5
175053000 CM		CMX	30	45	121	25	6
175053200 CM		CMX	32	53	133	32	6
175053600 CM		CMX	36	53	133	32	6
175054000 CM		CMX	40	63	143	32	8
175055000 CM		CMX	50	75	155	32	8

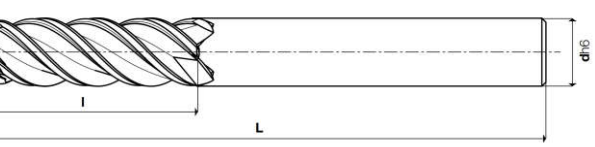
parametri tecnici a pag. / *for technical parameters see page 123*

17520

Frese a testa semisferica
Ball nosed end mills

Z4÷8
BALL-NOSED





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

Cod. Art.	X-85 (PM Co 8,5%)	COATED	D +0,05 +0,03	l	L	dh6	Z
175200200 CM		CMX	2	10	54	6	4
175200300 CM		CMX	3	12	56	6	4
175200400 CM		CMX	4	19	63	6	4
175200500 CM		CMX	5	24	68	6	4
175200600 CM		CMX	6	24	68	6	4
175200800 CM		CMX	10	38	88	6	4
175201000 CM		CMX	10	45	95	10	4
175201200 CM		CMX	12	53	110	12	4
175201400 CM		CMX	14	53	110	12	4
175201500 CM		CMX	15	63	123	16	4
175201600 CM		CMX	16	63	123	16	4
175201800 CM		CMX	18	63	123	16	4
175202000 CM		CMX	20	75	135	16	4
175202001 CM		CMX	20	75	141	20	4
175202200 CM		CMX	22	75	141	20	4
175202400 CM		CMX	24	90	166	25	5
175202500 CM		CMX	25	90	166	25	5
175202600 CM		CMX	26	90	166	25	5
175202800 CM		CMX	28	90	166	25	5
175203000 CM		CMX	30	90	166	25	6
175203200 CM		CMX	32	106	186	32	6
175203600 CM		CMX	36	106	186	32	6
175204000 CM		CMX	40	125	205	32	8

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

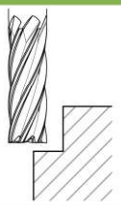
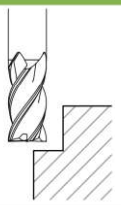
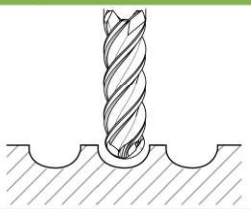
Z4÷8
BALL-NOSED

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*
17505	○	○	◪	○	○	●	●
17520	○	○	◪	○	○	●	●

● 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%