

Serie/Series 17505

Frese a testa semisferica
Ball nosed end mills

17520

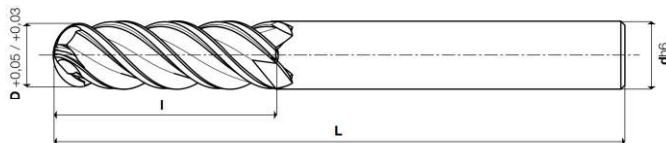
Frese a testa semisferica
Ball nosed end mills



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



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

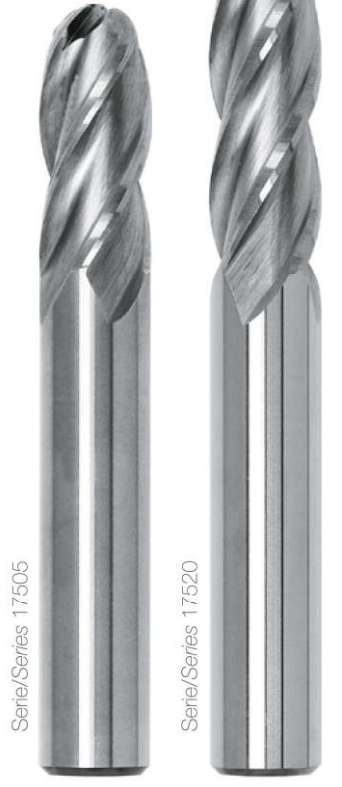
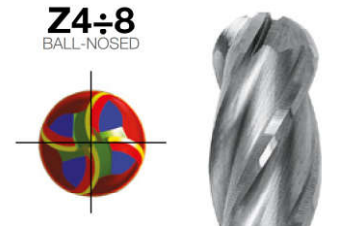


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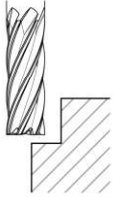
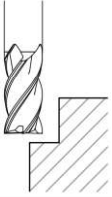
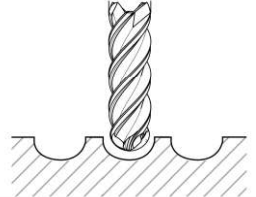
MATERIALI LAVORABILI / WORKPIECE MATERIALS

serie	TITANIO TITANIUM	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 $ap = 1,5\phi$ $ae = 0,15\phi$		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.)		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
	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
Acciaio Steel	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					
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%