

HSS-PM
HSS-PM Line

Serie/Series
21505

Frese a **SGROSSARE**, testa semisferica
Ball nosed roughing end mills

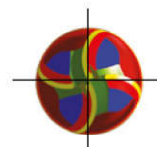


Cod. Art.	X-85 (PM Co 8,5%)	COATED	D _{+0,05 -0}	I	L	dh6	Z
215050603 CM	CMX		6	13	57	6	3
215050703 CM	CMX		7	16	66	10	3
215050803 CM	CMX		8	19	69	10	4
215050903 CM	CMX		9	19	69	10	4
215051003 CM	CMX		10	22	72	10	4
215051103 CM	CMX		11	22	79	12	4
215051203 CM	CMX		12	26	83	12	4
215051303 CM	CMX		13	26	83	12	4
215051403 CM	CMX		14	26	83	12	4
215051503 CM	CMX		15	32	92	16	4
215051603 CM	CMX		16	32	92	16	4
215051803 CM	CMX		18	32	92	16	4
215051807 CM	CMX		18	32	98	20	4
215052003 CM	CMX		20	38	98	16	4
215052007 CM	CMX		20	38	104	20	4
215052203 CM	CMX		22	38	104	20	4
215052207 CM	CMX		22	38	114	25	4
215052403 CM	CMX		24	45	121	25	5
215052503 CM	CMX		25	45	121	25	5
215052603 CM	CMX		26	45	121	25	5
215052803 CM	CMX		28	45	121	25	5
215053003 CM	CMX		30	45	121	25	5
215053203 CM	CMX		32	53	133	32	5
215053603 CM	CMX		36	53	133	32	6
215054003 CM	CMX		40	63	143	32	6
215054503 CM	CMX		45	63	143	32	6
215055003 CM	CMX		50	75	155	32	7



parametri tecnici a pag. / for technical parameters see page 125

Z3÷7
BALL-NOSED



MATERIALI LAVORABILI / WORKPIECE MATERIALS

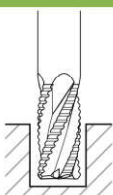
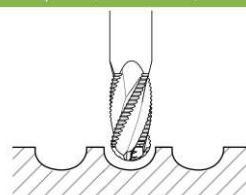
serie series	TITANIO TITANIUM	HRSA HRSA	ACCIAI INOSSIDABILI STAINLESS STEELS	MATERIALI NON FERROSI NON FERROUS MATERIALS	LEGHE LEGGERE LIGHT ALLOYS	ACCIAI STEELS	GHISE CAST IRON
21505	●	●	●	○	○	●	●

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

WWW.UOP.IT

85

Parametri di taglio/Cutting parameters

	21305 NR 	21305 NR 	21505 21520* NF NR 			
Materiali Materials	Cava Slotting $ap = 1\phi \quad ae = 1\phi$ 	Sgrossatura Roughing $ap = 1,5\phi \quad ae = 0,5\phi$ 	Sgrossatura Roughing $ap = 0,4\phi \quad ae = 0,9\phi$ 			
Gruppo e descrizione Group and description	Vc (mt /min.)		Vc (mt /min.)		Vc (mt /min.)	
	X-85 NON RIVESTITA UNCOATED	X-85 Skin Inox	X-85 NON RIVESTITA UNCOATED	X-85 Skin Inox	X-85 NON RIVESTITA UNCOATED	X-85 Skin
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	30 - 35	50 - 60	30 - 35	50 - 60	30 - 35	50 - 60
Basso legato Low alloyed	25 - 30	50 - 60	25 - 30	50 - 60	25 - 30	50 - 60
Alto legato High alloyed	20 - 30	40 - 50	20 - 30	40 - 50	20 - 30	40 - 50
Acciaio da stampi e utensili Die/tool steel	15 - 20	30 - 40	15 - 20	30 - 40	15 - 20	30 - 40
AISI 304 - 416 - 420	—	15 - 20	—	15 - 20	—	15 - 20
AISI 316 - 440	—	15 - 20	—	15 - 20	—	15 - 20
17-4 ph 15-5 ph	—	10 - 15	—	10 - 15	—	10 - 15
Leghe Cr - Co Cr - Co alloys	—	10 - 15	—	10 - 15	—	10 - 15
Duplex F51	—	5 - 10	—	5 - 10	—	5 - 10
Super Duplex F55	—	5 - 10	—	5 - 10	—	5 - 10
HRSA Hastelloy	—	—	—	—	—	5 - 10
HRSA Inconel 625	—	—	—	—	—	5 - 10
HRSA Inconel 718	—	—	—	—	—	5 - 10
HRSA Nimonic	—	—	—	—	—	5 - 10
Titanio - Titanium	—	—	—	—	—	10 - 15
Leghe di titanio Titanium alloys	—	—	—	—	—	10 - 15
Alluminio non legato Unalloyed aluminium	—	—	—	—	—	—
Alluminio Si < 6% si < 6% aluminium	—	—	—	—	—	—
Materiali termoplastici Thermoplastic materials	—	—	—	—	—	—
Rame/Ottone Copper/Brass	—	—	—	—	—	—
D	Avanzamento fz mm/tagliente FEED mm/tooth					
6	0,013		0,022		0,014	
8	0,016		0,028		0,020	
10	0,022		0,035		0,030	
12	0,026		0,045		0,040	
16	0,038		0,070		0,065	
20	0,050		0,090		0,090	

* series **fz** consigliato | RECOMMENDED -50%