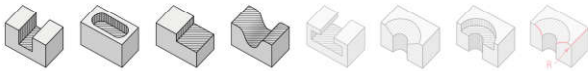


Cod. Art.	X-85 (PM Co 8,5%)	COATED	Dh10	I	L	dh6	Z
241201000 CM	CMX		10	30	200	10	2
241201200 CM	CMX		12	30	200	12	2
241201600 CM	CMX		16	35	200	16	2
241202000 CM	CMX		20	35	200	20	2
241202500 CM	CMX		25	40	200	25	2



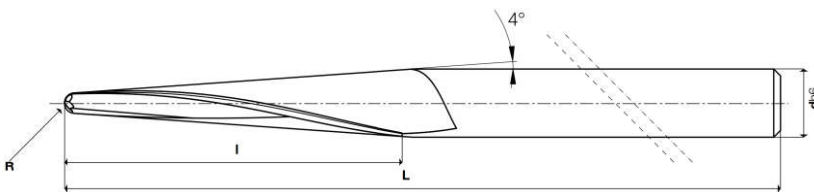
Serie/Series

## 24120

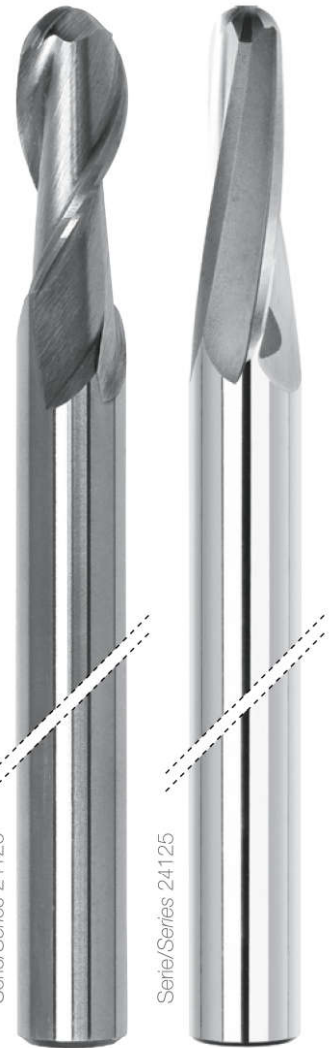
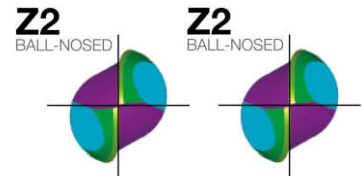
Frese a due taglienti a testa semisferica  
Ball-nosed two flute slot drills

## 24125

Frese coniche a due taglienti a testa semisferica  
Conicità 4° laterali  
Ball nosed milling cutters Taper 4°



Cod. Art.	X-85 (PM Co 8,5%)	COATED	R	I	L	dh6	Z
241250150 CM	CMX		1,5	50	180	10	2
241250200 CM	CMX		2	45	180	10	2
241250250 CM	CMX		2,5	38	180	10	2
241250300 CM	CMX		3	45	200	12	2
241250350 CM	CMX		3,5	40	200	12	2
241250400 CM	CMX		4	47	200	14	2
241250500 CM	CMX		5	47	200	16	2
241250600 CM	CMX		6	63	200	20	2
241250800 CM	CMX		8	72	200	25	2


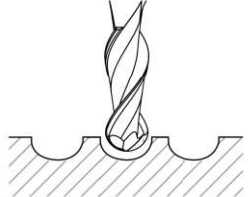
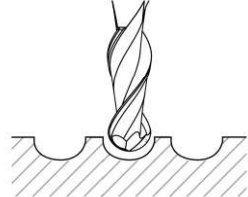


### MATERIALI LAVORABILI / WORKPIECE MATERIALS

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
24120	●	●	●	○	○	●	●
24125	●	●	●	○	○	●	●

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

# Parametri di taglio/Cutting parameters

		10102 - 10105 10110 - 10125*	10140 - 10155* <b>24120</b>	12505 - 12520*			
<b>Materiali</b> <i>Materials</i>		Cava Slotting $ap = 0,5\phi$ $ae = 1\phi$	Sgrossatura Roughing $ap = 0,4\phi$ $ae = 0,9\phi$	Sgrossatura Roughing $ap = 0,4\phi$ $ae = 0,9\phi$			
							
Gruppo e descrizione <i>Group and description</i>		Vc (mt/min.)		Vc (mt/min.)			
		X-85 NON RIVESTITA UNCOATED	X-85 <b>Skin</b>	X-85 NON RIVESTITA UNCOATED	X-85 <b>Skin</b>	X-85 NON RIVESTITA UNCOATED	X-85 <b>Skin</b> Alu
Ghisa Cast Iron	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	-	-
Acciaio Steel	Medio contenuto di C <i>Medium carbon content</i>	25 - 30	50 - 60	25 - 30	50 - 60	-	-
	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	-	-
Materiali non ferrosi Light alloys	Alluminio non legato <i>Unalloyed aluminium</i>	-	-	-	-	110 - 120	250 - 260
	Alluminio Si < 6% <i>si &lt; 6% aluminium</i>	-	-	-	-	70 - 80	170 - 180
	Materiali termoplastici <i>Thermoplastic materials</i>	-	-	-	-	130 - 140	270 - 280
	Rame/Ottone <i>Copper/Brass</i>	30 - 35	75 - 80	30 - 35	75 - 80	30 - 35	75 - 80
		Avanzamento fz mm/tagliente FEED mm/tooth					
<b>D</b>							
3		0,009		0,009		0,006	
4		0,013		0,012		0,010	
5		0,015		0,016		0,015	
6		0,018		0,018		0,020	
8		0,025		0,025		0,035	
10		0,030		0,035		0,050	
12		0,040		0,050		0,070	
16		0,065		0,090		0,120	
20		0,090		0,110		0,145	

\* series 10125; series 24120 series 12520 fz consigliato | RECOMMENDED -50%