

COATING	H	UNI 3905B DIN 885B ISO 2587	Z18÷46
Skin			

Cod. Art.	M-TK (HSS-E)	X-85 (PM Co 8,5%)	COATED	D +0,05 -0	Sk 11	C1	dH7	Z
041051042 AM	CM	CMX	50	4	26	16	20	
041051052 AM	CM	CMX	50	5	26	16	20	
041051062 AM	CM	CMX	50	6	26	16	20	
041051072 AM	CM	CMX	50	7	26	16	18	
041051082 AM	CM	CMX	50	8	26	16	18	
041051092 AM	CM	CMX	50	9	26	16	18	
041051102 AM	CM	CMX	50	10	26	16	18	
041052042 AM	CM	CMX	63	4	33	22	20	
041052052 AM	CM	CMX	63	5	33	22	20	
041052062 AM	CM	CMX	63	6	33	22	20	
041052072 AM	CM	CMX	63	7	33	22	20	
041052082 AM	CM	CMX	63	8	33	22	20	
041052092 AM	CM	CMX	63	9	33	22	20	
041052102 AM	CM	CMX	63	10	33	22	18	
041052122 AM	CM	CMX	63	12	33	22	18	
041052142 AM	CM	CMX	63	14	33	22	18	
041052162 AM	CM	CMX	63	16	33	22	18	
041052182 AM	CM	CMX	63	18	33	22	18	
041052202 AM	CM	CMX	63	20	33	22	18	
041053042 AM	CM	CMX	80	4	36	22	24	
041053043 AM	CM	CMX	80	4	40	27	24	
041053052 AM	CM	CMX	80	5	36	22	24	
041053053 AM	CM	CMX	80	5	40	27	24	
041053062 AM	CM	CMX	80	6	36	22	24	
041053063 AM	CM	CMX	80	6	40	27	24	
041053072 AM	CM	CMX	80	7	36	22	22	
041053073 AM	CM	CMX	80	7	40	27	22	
041053082 AM	CM	CMX	80	8	36	22	22	
041053083 AM	CM	CMX	80	8	40	27	22	
041053092 AM	CM	CMX	80	9	36	22	22	
041053093 AM	CM	CMX	80	9	40	27	22	
041053102 AM	CM	CMX	80	10	36	22	20	
041053103 AM	CM	CMX	80	10	40	27	20	
041053122 AM	CM	CMX	80	12	36	22	20	
041053123 AM	CM	CMX	80	12	40	27	20	
041053142 AM	CM	CMX	80	14	36	22	20	
041053143 AM	CM	CMX	80	14	40	27	20	
041053162 AM	CM	CMX	80	16	36	22	20	
041053163 AM	CM	CMX	80	16	40	27	20	
041053182 AM	CM	CMX	80	18	36	22	20	
041053183 AM	CM	CMX	80	18	40	27	20	
041053202 AM	CM	CMX	80	20	36	22	20	
041053203 AM	CM	CMX	80	20	40	27	20	
041054042 AM	CM	CMX	100	4	46	27	26	
041054043 AM	CM	CMX	100	4	50	32	26	
041054052 AM	CM	CMX	100	5	46	27	26	
041054053 AM	CM	CMX	100	5	50	32	26	
041054062 AM	CM	CMX	100	6	46	27	24	
041054063 AM	CM	CMX	100	6	50	32	24	
041054072 AM	CM	CMX	100	7	46	27	24	
041054073 AM	CM	CMX	100	7	50	32	24	
041054082 AM	CM	CMX	100	8	46	27	22	
041054083 AM	CM	CMX	100	8	50	32	22	
041054092 AM	CM	CMX	100	9	46	27	22	



→ continua alla pagina successiva / continued on next page

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
04105	●	●	●	○	○	●	●

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

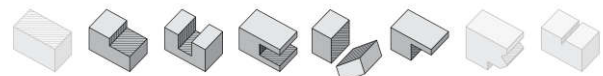
Serie/Series

04105

Frese a disco a tre taglienti dritti
Side and face milling cutters **Straight teeth**



Cod. Art.	M-TK (HSS-E)	X-85 (PM Co 8,5%)	COATED	D _{-0,05} -0	Sk 11	C1	dH7	Z
041054093 AM	CM	CM	CMX	100	9	50	32	22
041054102 AM	CM	CM	CMX	100	10	46	27	22
041054103 AM	CM	CM	CMX	100	10	50	32	22
041054122 AM	CM	CM	CMX	100	12	46	27	22
041054123 AM	CM	CM	CMX	100	12	50	32	22
041054142 AM	CM	CM	CMX	100	14	46	27	22
041054143 AM	CM	CM	CMX	100	14	50	32	22
041054152 AM	CM	CM	CMX	100	15	46	27	22
041054153 AM	CM	CM	CMX	100	15	50	32	22
041054162 AM	CM	CM	CMX	100	16	46	27	22
041054163 AM	CM	CM	CMX	100	16	50	32	22
041054182 AM	CM	CM	CMX	100	18	46	27	22
041054183 AM	CM	CM	CMX	100	18	50	32	22
041054202 AM	CM	CM	CMX	100	20	46	27	20
041054203 AM	CM	CM	CMX	100	20	50	32	20
041054222 AM	CM	CM	CMX	100	22	46	27	20
041054223 AM	CM	CM	CMX	100	22	50	32	20
041054252 AM	CM	CM	CMX	100	25	46	27	20
041054253 AM	CM	CM	CMX	100	25	50	32	20
041055052 AM	CM	CM	CMX	125	5	52	32	30
041055062 AM	CM	CM	CMX	125	6	52	32	30
041055082 AM	CM	CM	CMX	125	8	52	32	28
041055102 AM	CM	CM	CMX	125	10	52	32	28
041055122 AM	CM	CM	CMX	125	12	52	32	28
041055142 AM	CM	CM	CMX	125	14	52	32	26
041055162 AM	CM	CM	CMX	125	16	52	32	26
041055182 AM	CM	CM	CMX	125	18	52	32	26
041055202 AM	CM	CM	CMX	125	20	52	32	26
041055222 AM	CM	CM	CMX	125	22	52	32	26
041055252 AM	CM	CM	CMX	125	25	52	32	26
041055282 AM	CM	CM	CMX	125	28	52	32	26
041056062 AM	CM	CM	CMX	160	6	58	32	40
041056063 AM	CM	CM	CMX	160	6	66	40	40
041056082 AM	CM	CM	CMX	160	8	58	32	36
041056083 AM	CM	CM	CMX	160	8	66	40	36
041056102 AM	CM	CM	CMX	160	10	58	32	36
041056103 AM	CM	CM	CMX	160	10	66	40	36
041056122 AM	CM	CM	CMX	160	12	58	32	36
041056123 AM	CM	CM	CMX	160	12	66	40	36
041056142 AM	CM	CM	CMX	160	14	58	32	36
041056143 AM	CM	CM	CMX	160	14	66	40	36
041056162 AM	CM	CM	CMX	160	16	58	32	36
041056163 AM	CM	CM	CMX	160	16	66	40	36
041056182 AM	CM	CM	CMX	160	18	58	32	34
041056183 AM	CM	CM	CMX	160	18	66	40	34
041056202 AM	CM	CM	CMX	160	20	58	32	34
041056203 AM	CM	CM	CMX	160	20	66	40	34
041056222 AM	CM	CM	CMX	160	22	58	32	34
041056223 AM	CM	CM	CMX	160	22	66	40	34
041056252 AM	CM	CM	CMX	160	25	58	32	34
041056253 AM	CM	CM	CMX	160	25	66	40	34
041056282 AM	CM	CM	CMX	160	28	58	32	34
041056283 AM	CM	CM	CMX	160	28	66	40	34
041056322 AM	CM	CM	CMX	160	32	58	32	34
041056323 AM	CM	CM	CMX	160	32	66	40	34
041057082 AM	CM	CM	CMX	200	8	80	40	42
041057102 AM	CM	CM	CMX	200	10	80	40	40
041057122 AM	CM	CM	CMX	200	12	80	40	40
041057142 AM	CM	CM	CMX	200	14	80	40	40
041057162 AM	CM	CM	CMX	200	16	80	40	38
041057182 AM	CM	CM	CMX	200	18	80	40	38
041057202 AM	CM	CM	CMX	200	20	80	40	38
041057222 AM	CM	CM	CMX	200	22	80	40	38
041057252 AM	CM	CM	CMX	200	25	80	40	38
041057282 AM	CM	CM	CMX	200	28	80	40	38
041057322 AM	CM	CM	CMX	200	32	80	40	38
041058142 AM	CM	CM	CMX	250	14	90	50	46
041058162 AM	CM	CM	CMX	250	16	90	50	46
041058182 AM	CM	CM	CMX	250	18	90	50	46
041058202 AM	CM	CM	CMX	250	20	90	50	46
041058252 AM	CM	CM	CMX	250	25	90	50	46
041058282 AM	CM	CM	CMX	250	28	90	50	46
041058302 AM	CM	CM	CMX	250	30	90	50	46
041058322 AM	CM	CM	CMX	250	32	90	50	46

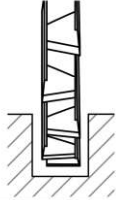
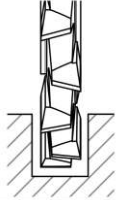
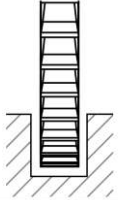


MATERIALI LAVORABILI / WORKPIECE MATERIALS

parametri tecnici a pag. / for technical parameters see page 128



Parametri di taglio/Cutting parameters

		04110*		04105*		04105**	
Materiali Materials		Cava Slotting $ap = 0,1\phi$ $ae = S$		Cava Slotting $ap = 0,1\phi$ $ae = S$		Cava Slotting $ap = 0,1\phi$ $ae = S$	
							
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	70 - 80	30 - 35	70 - 80	30 - 35	70 - 80
	Medio contenuto di C Medium carbon content	30 - 35	70 - 80	30 - 35	70 - 80	30 - 35	70 - 80
Acciaio Steel	Basso legato Low alloyed	25 - 30	70 - 75	25 - 30	70 - 75	25 - 30	70 - 75
	Alto legato High alloyed	20 - 30	60 - 70	20 - 30	60 - 70	20 - 30	60 - 70
	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	-	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

D	s	Avanzamento fz mm/giro FEED mm/rpm					
		X-85 NON RIVESTITA UNCOATED	X-85 Skin	X-85 NON RIVESTITA UNCOATED	X-85 Skin	X-85 NON RIVESTITA UNCOATED	X-85 Skin
63	1,6+3,5	0,035 ÷ 0,038	0,035 ÷ 0,038	-	-	-	-
80	2+3,5	0,041 ÷ 0,044	0,041 ÷ 0,044	-	-	-	-
100	2+3,5	0,047 ÷ 0,050	0,047 ÷ 0,050	-	-	-	-
125	2+4	0,055 ÷ 0,060	0,055 ÷ 0,060	-	-	-	-
160	3+5	0,065	0,065	-	-	-	-
200	÷6	0,070	0,070	-	-	-	-
250	6+12	0,075	0,075	-	-	-	-
50	4+10	-	-	0,040	0,040	0,025 ÷ 0,030	0,025 ÷ 0,030
63	4+20	-	-	0,050 ÷ 0,060	0,050 ÷ 0,060	0,035 ÷ 0,040	0,035 ÷ 0,040
80	4+20	-	-	0,065 ÷ 0,070	0,065 ÷ 0,070	0,042 ÷ 0,046	0,042 ÷ 0,046
100	4+25	-	-	0,075 ÷ 0,085	0,075 ÷ 0,085	0,048 ÷ 0,054	0,048 ÷ 0,054
125	5+28	-	-	0,090 ÷ 0,100	0,090 ÷ 0,100	0,056 ÷ 0,060	0,056 ÷ 0,060
160	6+32	-	-	0,105 ÷ 0,115	0,105 ÷ 0,115	0,066 ÷ 0,078	0,066 ÷ 0,078
200	8+32	-	-	0,120 ÷ 0,125	0,120 ÷ 0,125	0,084 ÷ 0,096	0,084 ÷ 0,096
250	14+32	-	-	0,128 ÷ 0,140	0,128 ÷ 0,140	0,105	0,105

* frese a disco a 3 tagli elicoidali alternati | SIDE AND FACE MILLING CUTTERS STAGGERED TEETH

** frese a disco a 3 tagli dritti | SIDE AND FACE MILLING CUTTERS STRAIGH TEETH