

# HSS-PM HSS-PM Line

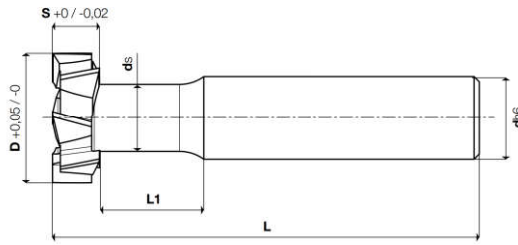
Serie/Series

## 27120

Frese per scanalature a T  
T-slot cutters

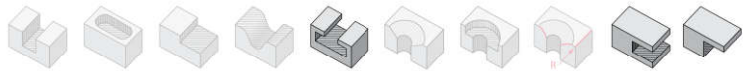
## 27135

Frese per scanalature a T  
T-slot cutters

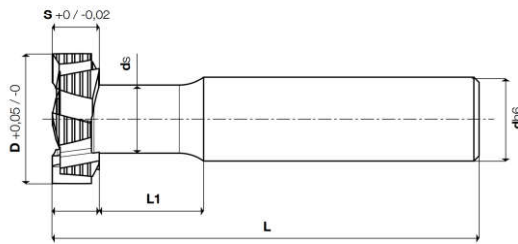


COATING <b>Skin</b>	W A RICHIESTA ON REQUEST	F A RICHIESTA ON REQUEST	N	UNI 7339A DIN 851 ISO 3337
------------------------	--------------------------------	--------------------------------	---	----------------------------------

Cod. Art.	M-TK (HSS-E)	X-85 (PM Co 8.5%)	COATED	D +0,05 -0	S +0 -0,02	ds	L1	L	dh6	λ°	Z
271201256 AM	CM	CMX		12,5	6	5	11	57	10	12	6
271201608 AM	CM	CMX		16	8	7	14	62	10	12	6
271201808 AM	CM	CMX		18	8	8	15	70	12	15	6
271201909 AM	CM	CMX		19	9	8	15	70	12	15	8
271202109 AM	CM	CMX		21	9	10	18	74	12	15	8
271202210 AM	CM	CMX		22	10	10	17	74	12	15	8
271202511 AM	CM	CMX		25	11	12	20	82	16	15	8
271202812 AM	CM	CMX		28	12	13	22	85	16	15	8
271203214 AM	CM	CMX		32	14	15	25	90	16	15	8

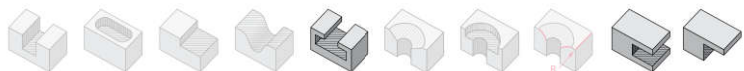


parametri tecnici a pag. / for technical parameters see page 129



COATING <b>Skin</b>	W A RICHIESTA ON REQUEST	F A RICHIESTA ON REQUEST	NF	UNI 7339A DIN 851 ISO 3337
------------------------	--------------------------------	--------------------------------	----	----------------------------------

Cod. Art.	M-TK (HSS-E)	X-85 (PM Co 8.5%)	COATED	D +0,05 -0	S +0 -0,02	ds	L1	L	dh6	Z
271351256 AM	CM	CMX		12,5	6	5	11	57	10	4
271351608 AM	CM	CMX		16	8	7	14	62	10	6
271351808 AM	CM	CMX		18	8	8	15	70	12	6
271351909 AM	CM	CMX		19	9	8	15	70	12	6
271352109 AM	CM	CMX		21	9	10	18	74	12	6
271352210 AM	CM	CMX		22	10	10	17	74	12	6
271352511 AM	CM	CMX		25	11	12	20	82	16	8
271352812 AM	CM	CMX		28	12	13	22	85	16	8
271353214 AM	CM	CMX		32	14	15	25	90	16	8



parametri tecnici a pag. / for technical parameters see page 129

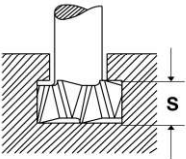
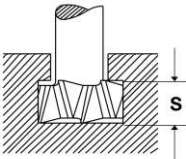


### MATERIALI LAVORABILI / WORKPIECE MATERIALS

serie	TITANIO TITANIUM	HRSA HRSA	ACCIAI INOSSIDABILI STAINLESS STEELS	MATERIALI NON FERROSI NON FERROUS MATERIALS	LEGHE LEGGERE LIGHT ALLOYS	ACCIAI STEELS	GHISE CAST IRON
27120	●	●	●	○	○	●	●
27135	●	●	●	○	○	●	●

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

# Parametri di taglio/Cutting parameters

		27120		27135 NF	
Materiali Materials		Cava Slotting $ap = S \quad ae = 1\phi$		Cava Slotting $ap = S \quad ae = 1\phi$	
					
Gruppo e descrizione Group and description		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>
Ghisa Cast Iron	Grigia e sferoidale Grey and spheroidal	20 - 25	45 - 50	20 - 25	45 - 50
	Basso contenuto di C Low carbon content	30 - 35	70 - 80	30 - 35	70 - 80
	Medio contenuto di C Medium carbon content	30 - 35	70 - 80	30 - 35	70 - 80
Acciaio Steel	Basso legato Low alloyed	25 - 30	70 - 75	25 - 30	70 - 75
	Alto legato High alloyed	20 - 30	60 - 70	20 - 30	60 - 70
	Acciaio da stampi e utensili Die/tool steel	15 - 20	30 - 40	15 - 20	30 - 40
Acciaio Inossidabile Stainless Steel	AISI 304 - 416 - 420	-	15 - 20	-	15 - 20
	AISI 316 - 440	-	15 - 20	-	15 - 20
	17-4 ph 15-5 ph	-	10 - 15	-	10 - 15
	Leghe Cr - Co Cr - Co alloys	-	10 - 15	-	10 - 15
	Duplex F51	-	5 - 10	-	5 - 10
	Super Duplex F55	-	5 - 10	-	5 - 10

D	S	Avanzamento fz mm/giro FEED mm/rpm			
		X-85 NON RIVESTITA UNCOATED	X-85 <b>Skin</b>	X-85 NON RIVESTITA UNCOATED	X-85 <b>Skin</b>
12,5	6	0,035	0,035	0,039	0,039
16	8	0,040	0,040	0,045	0,045
18	8	0,045	0,045	0,050	0,050
19	9	0,050	0,050	0,056	0,056
21	9	0,055	0,055	0,062	0,062
22	10	0,060	0,060	0,067	0,067
25	11	0,064	0,064	0,072	0,072
28	12	0,068	0,068	0,076	0,076
32	14	0,072	0,072	0,081	0,081
36	16	0,076	0,076	0,085	0,085
40	18	0,080	0,080	0,090	0,090
45	20	0,083	0,083	0,093	0,093
50	22	0,086	0,086	0,096	0,096
56	24	0,090	0,090	0,101	0,101