

HSS-PM HSS-PM Line

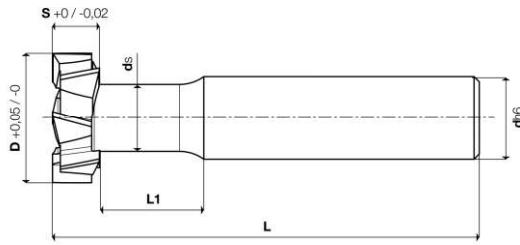
Serie/Series

27120

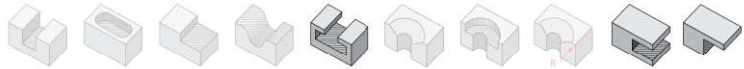
Frese per scanalature a T
T-slot cutters

27135

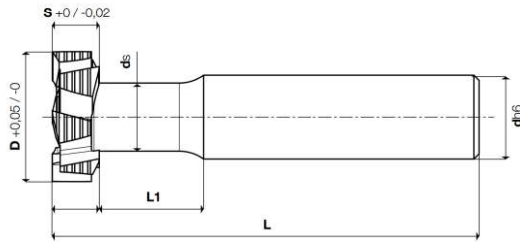
Frese per scanalature a T
T-slot cutters



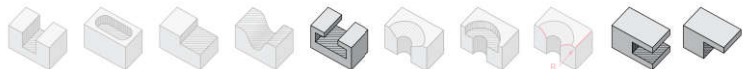
Cod. Art.	M-TK (HSS-E)	X-85 (PM Co 8.5%)	COATED	D ^{+0,05} ₋₀	S ⁺⁰ _{-0,02}	ds	L1	L	dh6	λ°	Z
271201256 AM	CM	CMX		12,5	6	5	11	57	10	12	6
271201608 AM	CM	CMX		16	8	7	14	62	10	12	6
271201808 AM	CM	CMX		18	8	8	15	70	12	15	6
271201909 AM	CM	CMX		19	9	8	15	70	12	15	8
271202109 AM	CM	CMX		21	9	10	18	74	12	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



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

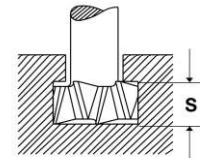
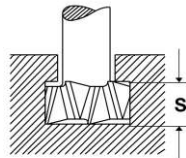
27135



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.)

Ghisa
Cast Iron

Grigia e sferoidale
Grey and spheroidal

X-85
NON RIVESTITA
UNCOATED

X-85
Skin

X-85
NON RIVESTITA
UNCOATED

X-85
Skin

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

AVANZAMENTO fz mm/tagliente
FEED mm/tooth

D	S	Avanzamento fz mm/giro FEED mm/rpm			
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