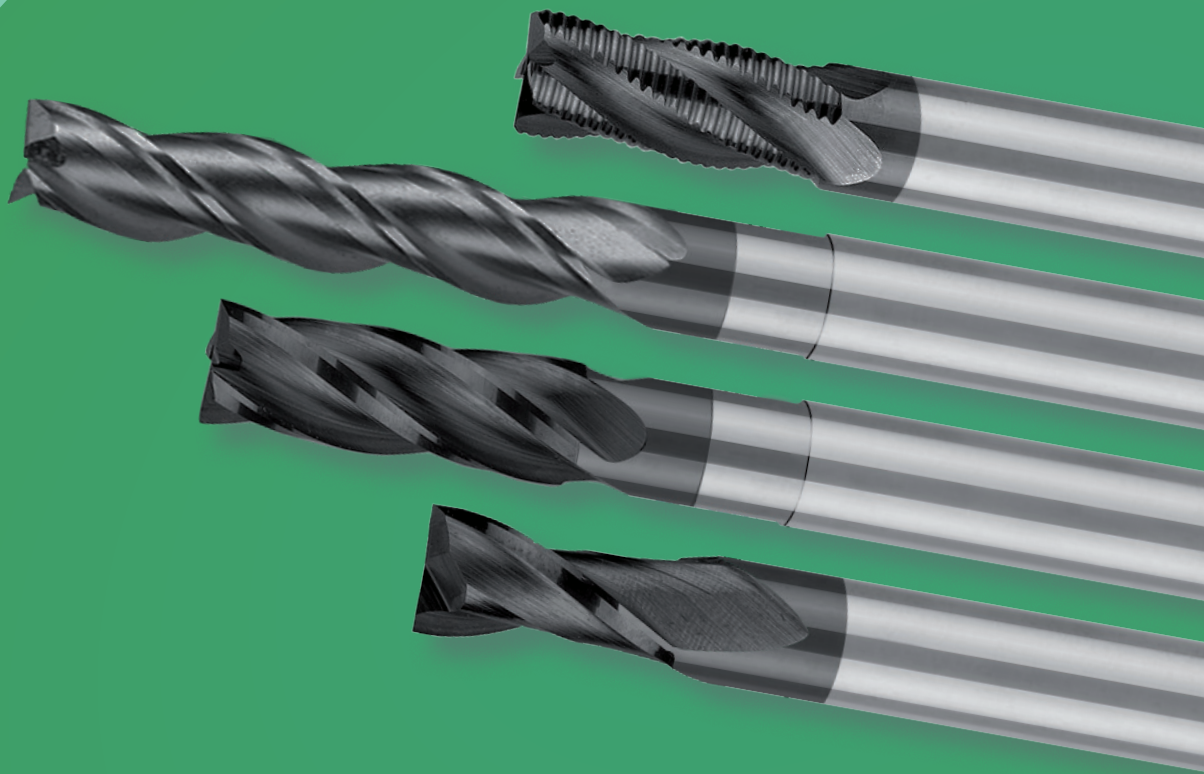




SILSAVING

SOLID CARBIDE END MILLS



Quality as a standard



SILSAVING

Frese in metallo duro integrale Solid Carbide End Mills

BALINIT® ALCRONA



4

893S

Fresa universale
a 4 taglienti per la
fresatura in rampa

4 flute multi-purpose
end mill suitable
for ramp milling

892S

Fresa a finire ad
elevate prestazioni

High-performance
end mill finishing

897S

Fresa a sgrossare ad
elevate prestazioni

High-performance
end mill roughing

5

821S

Fresa a 2 taglienti
serie extra corta

2 flute end mill
extra short series

806S

Fresa a 2 taglienti
serie normale

2 flute end mill
standard series

806SCr

Fresa a 2 taglienti
serie normale

2 flute end mill
standard series

6

816S

Fresa semisferica
a 2 taglienti serie normale

2 flute ball nose end mill
standard series

801S

Fresa a 2 taglienti
per sedi di chiavetta

2 flute end mill key slot

879S

Fresa a 2 taglienti
serie lunga

2 flute end mill
long series

7

881S

Fresa semisferica
a 2 taglienti serie lunga

2 flute ball nose end mill
long series

826S

Fresa a 3 taglienti
serie extra corta

3 flute end mill
extra short series

836S

Fresa a 3 taglienti
serie normale

3 flute end mill
standard series



8

876SFresa a 3 taglienti
serie lunga3 flute end mill
long series**829S**Fresa a 4 taglienti
serie extra corta4 flute end mill
extra short series**856S**Fresa a 4 taglienti
serie normale4 flute end mill
standard series

9

856SCrFresa a 4 taglienti
serie normale4 flute end mill
standard series**871S**Fresa a sgrossare
a 4 taglienti serie normale4 flute end mill for
roughing standard series**866S**Fresa semisferica
a 4 taglienti serie normale4 flute ball nose end mill
standard series

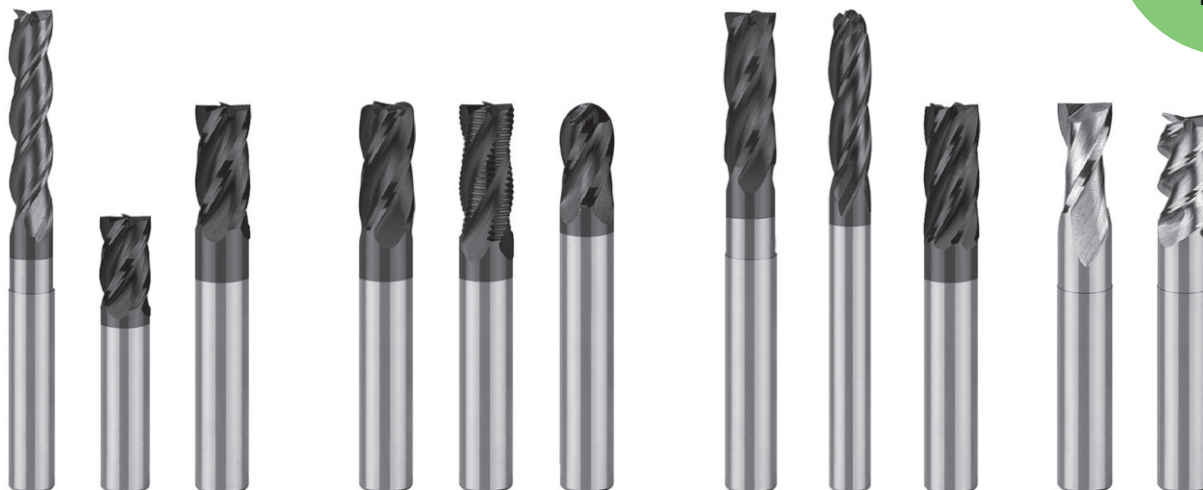
10

859SFresa a 4 taglienti
serie lunga4 flute end mill
long series**883S**Fresa semisferica a 4 taglienti
serie lunga4 flute ball nose
end mill long series**861S**Fresa a 6 taglienti
serie normale6 flute end mill
standard series

11

810SFresa a 2 taglienti
per alluminio2 flute end mill
for aluminium**812S**Fresa a 3 taglienti
per alluminio3 flute end mill
for aluminiumParametri
di lavoroWorking
parameters

Pag. 12

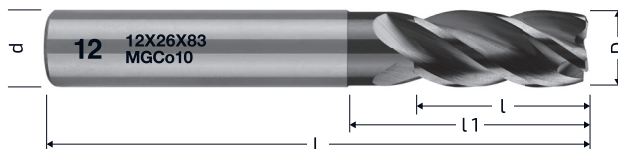


Tutte le frese sono disponibili anche con collarino.
Consegna: 2 giorni lavorativi. / All end mills are available
also with neck relief. Delivery time: 2 working days.

893S

Fresa universale a 4 taglienti adatta per la fresatura in rampa

4 flute multi-purpose end mill suitable for ramp milling



Divisione irregolare Unequal flute spacing $\alpha \neq \beta$

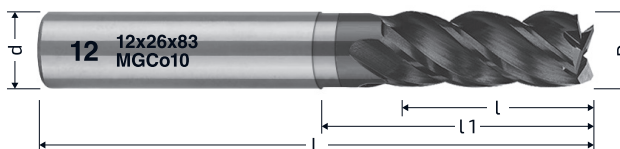
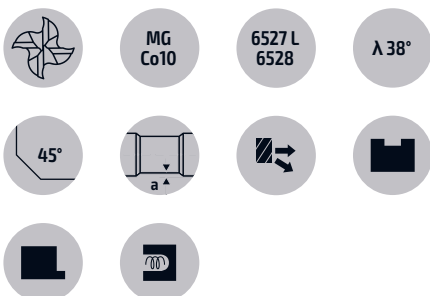
Codice Item code	D h10	d h5	L	l ap	l1	45°	a	Z
893S D.4	4,0	6	57	11	15	0,20	0,15	4
893S D.5	5,0	6	57	13	18	0,20	0,15	4
893S D.6	6,0	6	57	13	20	0,25	0,15	4
893S D.8	8,0	8	63	19	25	0,30	0,15	4
893S D.10	10,0	10	72	22	30	0,35	0,15	4
893S D.12	12,0	12	83	26	36	0,40	0,20	4
893S D.16	16,0	16	92	32	42	0,45	0,20	4
893S D.20	20,0	20	104	38	52	0,50	0,20	4

Disponibile KIT BOX Diam. 6-8-10-12 / Available KIT BOX Diam. 6-8-10-12

892S

Fresa a FINIRE 4 taglienti serie normale

4 flute end mill for FINISHING standard series



Divisione irregolare Unequal flute spacing $\alpha \neq \beta$

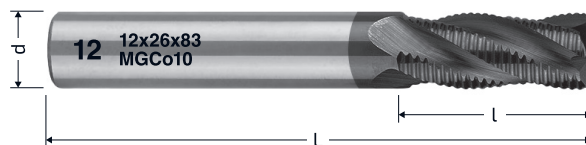
Codice Item code	D h10	d h6	L	l ap	l1	45°	a	Z
892S D.3	3,0	3	38	8	-	0,10	-	4
892S D.4	4,0	4	50	11	16	0,15	0,15	4
892S D.5	5,0	5	50	13	18	0,15	0,15	4
892S D.6	6,0	6	57	13	20	0,15	0,15	4
892S D.8	8,0	8	63	19	25	0,20	0,15	4
892S D.10	10,0	10	72	22	30	0,20	0,15	4
892S D.12	12,0	12	83	26	36	0,20	0,20	4
892S D.14	14,0	14	83	26	36	0,20	0,20	4
892S D.16	16,0	16	92	32	42	0,25	0,20	4
892S D.18	18,0	18	92	32	42	0,25	0,20	4
892S D.20	20,0	20	104	38	52	0,25	0,20	4

Disponibile KIT BOX Diam. 6-8-10-12 / Available KIT BOX Diam. 6-8-10-12

897S

Fresa a SGROSSARE 4 taglienti serie normale

4 flute end mill for ROUGHING standard series



Divisione irregolare Unequal flute spacing $\alpha \neq \beta$

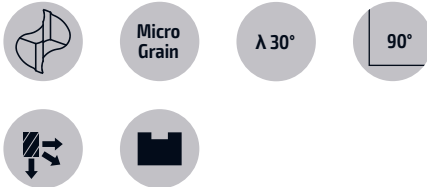
Codice Item code	D h11	d h6	L	l ap	45°	Z
897S D.4	4,0	6	57	13	0,70	4
897S D.5	5,0	6	57	13	0,80	4
897S D.6	6,0	6	57	13	0,80	4
897S D.8	8,0	8	63	19	0,80	4
897S D.10	10,0	10	72	22	0,80	4
897S D.12	12,0	12	83	26	0,90	4
897S D.16	16,0	16	92	32	0,90	4

Disponibile KIT BOX Diam. 6-8-10-12 / Available KIT BOX Diam. 6-8-10-12

821S

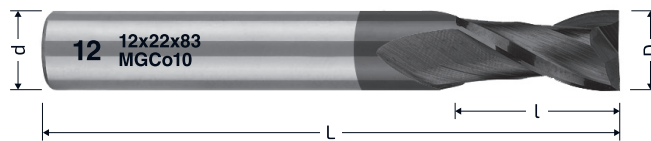


Fresa a 2 taglienti serie extra corta
2 flute end mill extra short series



Codice Item code	D h10	d h6	L	l ap	Z
821S D.2	2,0	6	38	3	2
821S D.3	3,0	6	38	4	2
821S D.4	4,0	6	38	5	2
821S D.5	5,0	6	38	6	2
821S D.6	6,0	6	38	7	2
821S D.7	7,0	8	43	9	2
821S D.8	8,0	8	43	9	2
821S D.9	9,0	10	50	11	2
821S D.10	10,0	10	50	11	2

806S

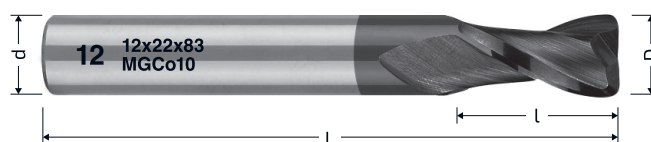


Fresa a 2 taglienti serie normale
2 flute end mill standard series



Codice Item code	D h10	d h6	L	l ap	Z
806S D.2	2,0	4	50	5	2
806S D.2,5	2,5	4	50	7	2
806S D.3	3,0	4	50	7	2
806S D.3,5	3,5	4	50	7	2
806S D.4	4,0	4	50	8	2
806S D.4,5	4,5	5	50	8	2
806S D.5	5,0	5	50	10	2
806S D.5,5	5,5	6	57	10	2
806S D.6	6,0	6	57	10	2
806S D.7	7,0	7	60	13	2
806S D.8	8,0	8	63	16	2
806S D.9	9,0	9	67	16	2
806S D.10	10,0	10	72	19	2
806S D.11	11,0	11	83	22	2
806S D.12	12,0	12	83	22	2
806S D.13	13,0	13	83	22	2
806S D.14	14,0	14	83	22	2
806S D.15	15,0	15	92	26	2
806S D.16	16,0	16	92	26	2
806S D.17	17,0	17	92	26	2
806S D.18	18,0	18	92	26	2
806S D.19	19,0	19	92	26	2
806S D.20	20,0	20	104	32	2

806S^{Cr}



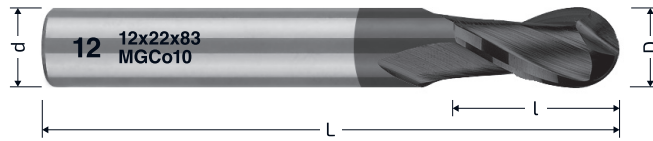
Fresa a 2 taglienti serie normale
2 flute end mill standard series



Codice Item code	D h10	d h6	L	l ap	Cr	Z
806S D.2 CR05	2,0	4	50	5	0,5	2
806S D.3 CR05	3,0	4	50	7	0,5	2
806S D.4 CR05	4,0	4	50	8	0,5	2
806S D.5 CR10	5,0	5	50	10	1,0	2
806S D.6 CR05	6,0	6	57	10	0,5	2
806S D.6 CR10	6,0	6	57	10	1,0	2
806S D.8 CR05	8,0	8	63	16	0,5	2
806S D.8 CR10	8,0	8	63	16	1,0	2
806S D.10 CR05	10,0	10	72	19	0,5	2
806S D.10 CR10	10,0	10	72	19	1,0	2
806S D.10 CR20	10,0	10	72	19	2,0	2
806S D.12 CR05	12,0	12	83	22	0,5	2
806S D.12 CR10	12,0	12	83	22	1,0	2
806S D.12 CR20	12,0	12	83	22	2,0	2

816S

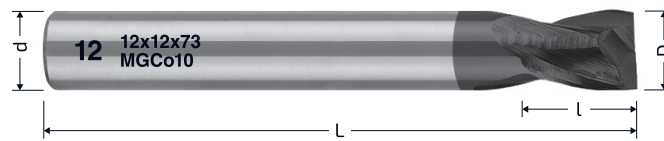
Fresa semisferica a 2 taglienti serie normale
2 flute ball nose end mill standard series



Codice Item code	D h10	d h6	L	l ap	r	Z
816S D.2	2,0	4	50	5	1,0	2
816S D.3	3,0	4	50	7	1,5	2
816S D.4	4,0	4	50	8	2,0	2
816S D.5	5,0	5	50	10	2,5	2
816S D.6	6,0	6	57	10	3,0	2
816S D.8	8,0	8	63	16	4,0	2
816S D.10	10,0	10	72	19	5,0	2
816S D.12	12,0	12	83	22	6,0	2

801S

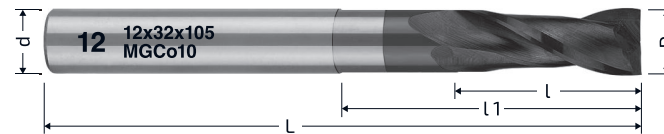
Fresa a 2 taglienti per sedi di chiave
2 flute end mill key slot



Codice Item code	D e8	d h6	L	l ap	Z
801S D.2	2,0	6	50	3	2
801S D.3	3,0	6	50	4	2
801S D.4	4,0	6	54	5	2
801S D.5	5,0	6	54	6	2
801S D.6	6,0	6	54	7	2
801S D.7	7,0	8	58	9	2
801S D.8	8,0	8	58	9	2
801S D.9	9,0	10	66	11	2
801S D.10	10,0	10	66	11	2
801S D.11	11,0	12	73	12	2
801S D.12	12,0	12	73	12	2
801S D.13	13,0	14	75	14	2
801S D.14	14,0	14	75	14	2
801S D.16	16,0	16	82	16	2
801S D.20	20,0	20	92	20	2

879S

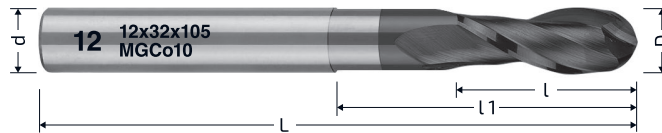
Fresa a 2 taglienti serie lunga
2 flute end mill long series



Codice Item code	D h10	d h6	L	l ap	l1	a	Z
879S D.4	4,0	4	62	16	-	-	2
879S D.5	5,0	5	62	20	-	-	2
879S D.6	6,0	6	78	20	30	0,15	2
879S D.8	8,0	8	78	25	35	0,15	2
879S D.10	10,0	10	105	28	48	0,15	2
879S D.12	12,0	12	105	32	52	0,20	2
879S D.16	16,0	16	130	40	60	0,20	2

881S

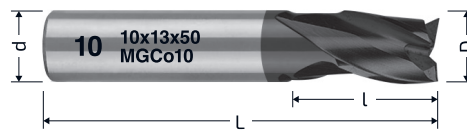
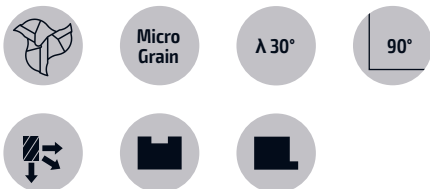
Fresa semisferica a 2 taglienti serie lunga
2 flute ball nose end mill long series



Codice Item code	D h10	d h6	L	l ap	r	l1	a	Z
881S D.4	4,0	4	62	16	2,0	-	-	2
881S D.5	5,0	5	62	20	2,5	-	-	2
881S D.6	6,0	6	78	20	3,0	30	0,15	2
881S D.8	8,0	8	78	25	4,0	35	0,15	2
881S D.10	10,0	10	105	28	5,0	48	0,15	2
881S D.12	12,0	12	105	32	6,0	52	0,20	2
881S D.16	16,0	16	130	40	8,0	60	0,20	2

826S

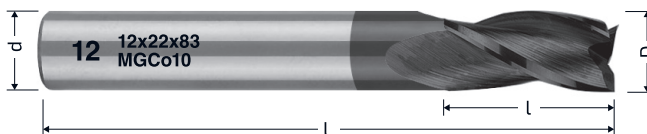
Fresa a 3 taglienti serie extra corta
3 flute end mill extra short series



Codice Item code	D h10	d h6	L	l ap	Z
826S D.2	2,0	6	38	4	3
826S D.2,5	2,5	6	38	4	3
826S D.3	3,0	6	38	5	3
826S D.3,5	3,5	6	38	6	3
826S D.4	4,0	6	38	7	3
826S D.4,5	4,5	6	38	8	3
826S D.5	5,0	6	38	8	3
826S D.6	6,0	6	38	8	3
826S D.7	7,0	8	43	11	3
826S D.8	8,0	8	43	11	3
826S D.9	9,0	10	50	13	3
826S D.10	10,0	10	50	13	3

836S

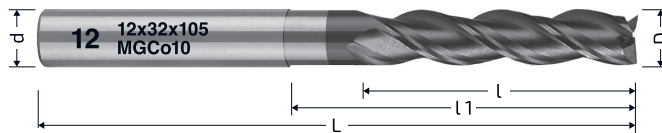
Fresa a 3 taglienti serie normale
3 flute end mill standard series



Codice Item code	D h10	d h6	L	l ap	Z
836S D.2	2,0	4	50	5	3
836S D.3	3,0	4	50	7	3
836S D.4	4,0	4	50	8	3
836S D.5	5,0	5	50	10	3
836S D.6	6,0	6	57	10	3
836S D.8	8,0	8	63	16	3
836S D.10	10,0	10	72	19	3
836S D.12	12,0	12	83	22	3
836S D.16	16,0	16	92	26	3
836S D.20	20,0	20	104	32	3

876S

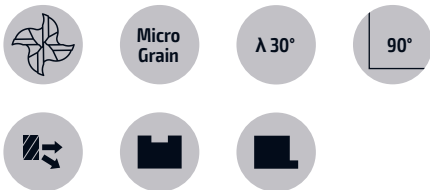
Fresa a 3 taglienti serie lunga
3 flute end mill long series



Codice Item code	D h10	d h6	L	l ap	l1	a	Z
876S D.4	4,0	4	62	16	-	-	3
876S D.5	5,0	5	62	20	-	-	3
876S D.6	6,0	6	78	20	30	0,15	3
876S D.8	8,0	8	78	25	35	0,15	3
876S D.10	10,0	10	105	28	48	0,15	3
876S D.12	12,0	12	105	32	52	0,20	3
876S D.16	16,0	16	130	40	60	0,20	3

829S

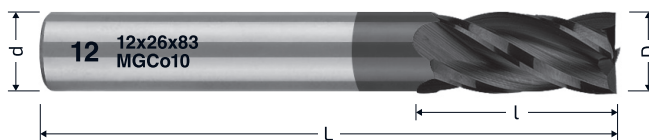
Fresa a 4 taglienti serie extra corta
4 flute end mill extra short series



Codice Item code	D h10	d h6	L	l ap	Z
829S D.2	2,0	6	38	4	4
829S D.3	3,0	6	38	5	4
829S D.4	4,0	6	38	7	4
829S D.5	5,0	6	38	8	4
829S D.6	6,0	6	38	8	4
829S D.8	8,0	8	43	11	4
829S D.10	10,0	10	50	13	4

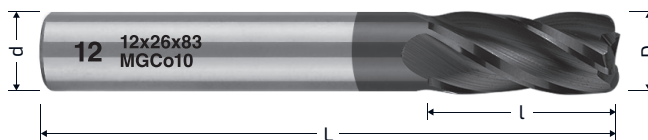
856S

Fresa a 4 taglienti serie normale
4 flute end mill standard series



Codice Item code	D h10	d h6	L	l ap	Z
856S D.2	2,0	4	50	7	4
856S D.2,5	2,5	4	50	8	4
856S D.3	3,0	4	50	8	4
856S D.3,5	3,5	4	50	10	4
856S D.4	4,0	4	50	11	4
856S D.4,5	4,5	5	50	11	4
856S D.5	5,0	5	50	13	4
856S D.5,5	5,5	6	57	13	4
856S D.6	6,0	6	57	13	4
856S D.6,5	6,5	7	60	16	4
856S D.7	7,0	7	60	16	4
856S D.7,5	7,5	8	63	19	4
856S D.8	8,0	8	63	19	4
856S D.8,5	8,5	9	67	19	4
856S D.9	9,0	9	67	19	4
856S D.9,5	9,5	10	72	22	4
856S D.10	10,0	10	72	22	4
856S D.11	11,0	11	83	26	4
856S D.12	12,0	12	83	26	4
856S D.13	13,0	13	83	26	4
856S D.14	14,0	14	83	26	4
856S D.15	15,0	15	92	32	4
856S D.16	16,0	16	92	32	4
856S D.18	18,0	18	92	32	4
856S D.20	20,0	20	104	38	4

856S^{Cr}



Fresa a 4 taglienti serie normale
4 flute end mill standard series



Micro
Grain

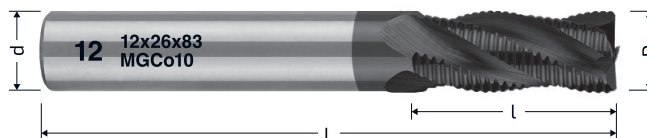
6527 L
6528

$\lambda 30^\circ$



Codice Item code	D h10	d h6	L	l ap	Cr	Z
856S D.3 CR05	3,0	4	50	8	0,5	4
856S D.4 CR05	4,0	4	50	11	0,5	4
856S D.5 CR10	5,0	5	50	13	1,0	4
856S D.6 CR05	6,0	6	57	13	0,5	4
856S D.6 CR10	6,0	6	57	13	1,0	4
856S D.8 CR05	8,0	8	63	19	0,5	4
856S D.8 CR10	8,0	8	63	19	1,0	4
856S D.10 CR05	10,0	10	72	22	0,5	4
856S D.10 CR10	10,0	10	72	22	1,0	4
856S D.10 CR20	10,0	10	72	22	2,0	4
856S D.12 CR05	12,0	12	83	26	0,5	4
856S D.12 CR10	12,0	12	83	26	1,0	4
856S D.12 CR20	12,0	12	83	26	2,0	4

871S



Fresa a sgrossare 4 taglienti
con rompitruciolo serie normale

4 flute end mill for roughing
with chip breaker standard series



Micro
Grain

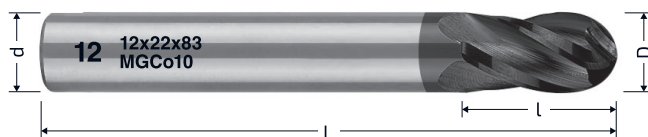
6527 L

$\lambda 30^\circ$



Codice Item code	D h11	d h6	L	l ap	Z
871S D.4	4,0	6	57	13	4
871S D.5	5,0	6	57	13	4
871S D.6	6,0	6	57	13	4
871S D.8	8,0	8	63	19	4
871S D.10	10,0	10	72	22	4
871S D.12	12,0	12	83	26	4
871S D.16	16,0	16	92	32	4
871S D.20	20,0	20	104	38	4

866S



Fresa semisferica a 4 taglienti serie normale
a4 flute ball nose end mill standard series



Micro
Grain

$\lambda 30^\circ$



Codice Item code	D h10	d h6	L	l ap	r	Z
866S D.2	2,0	3	38	5	1,0	4
866S D.3	3,0	3	38	7	1,5	4
866S D.4	4,0	4	50	8	2,0	4
866S D.5	5,0	5	50	10	2,5	4
866S D.6	6,0	6	57	10	3,0	4
866S D.7	7,0	7	60	13	3,5	4
866S D.8	8,0	8	63	16	4,0	4
866S D.9	9,0	9	67	16	4,5	4
866S D.10	10,0	10	72	19	5,0	4
866S D.12	12,0	12	83	22	6,0	4
866S D.13	13,0	13	83	22	6,5	4
866S D.14	14,0	14	83	22	7,0	4
866S D.16	16,0	16	92	26	8,0	4
866S D.18	18,0	18	92	26	9,0	4
866S D.20	20,0	20	104	32	10,0	4

859S

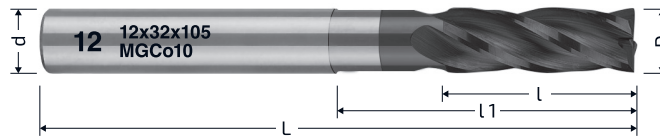
Fresa a 4 taglienti serie lunga
4 flute end mill long series



Micro
Grain

λ 30°

90°



Codice Item code	D h10	d h6	L	l ap	l1	a	Z
859S D.3	3,0	3	62	14	-	-	4
859S D.4	4,0	4	62	16	-	-	4
859S D.5	5,0	5	62	20	-	-	4
859S D.6	6,0	6	78	20	30	0,15	4
859S D.8	8,0	8	78	25	35	0,15	4
859S D.10	10,0	10	105	28	48	0,15	4
859S D.12	12,0	12	105	32	52	0,20	4
859S D.16	16,0	16	130	40	60	0,20	4

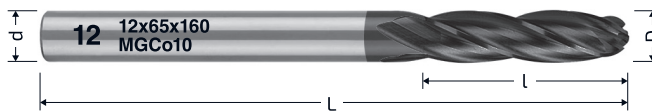
883S

Fresa semisferica a 4 taglienti serie lunga
4 flute ball nose end mill long series



Micro
Grain

λ 30°



Codice Item code	D h10	d h6	L	l ap	r	Z
883S D.6	6,0	6	105	42	3,0	4
883S D.8	8,0	8	105	50	4,0	4
883S D.10	10,0	10	120	50	5,0	4
883S D.12	12,0	12	160	65	6,0	4
883S D.16	16,0	16	160	70	8,0	4

861S

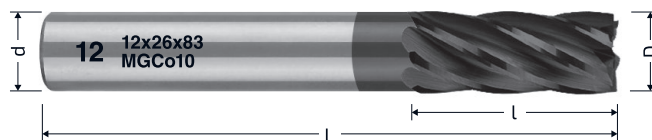
Fresa a 6 taglienti serie normale
6 flute end mill standard series



Micro
Grain

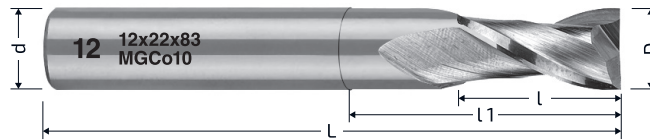
6527 L

λ 30°

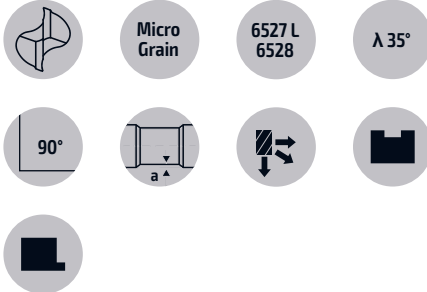


Codice Item code	D h10	d h6	L	l ap	Z
861S D.6	6,0	6	57	13	6
861S D.8	8,0	8	63	19	6
861S D.10	10,0	10	72	22	6
861S D.12	12,0	12	83	26	6
861S D.14	14,0	14	83	26	6
861S D.16	16,0	16	92	32	6
861S D.20	20,0	20	104	38	8

810

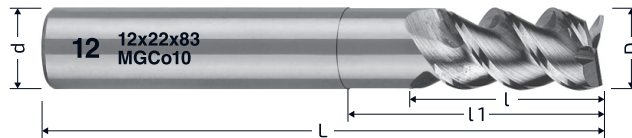


Fresa a 2 taglienti per alluminio
2 flute end mill for aluminium

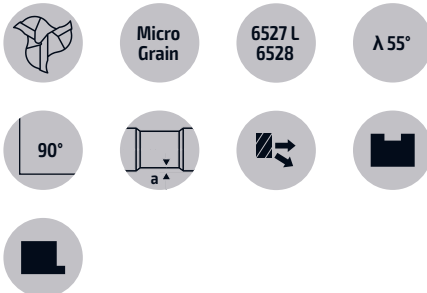


Codice Item code	D h6	d h6	L	l ap	l1	a	Z
810 D.2	2,0	3	50	6	-	-	2
810 D.3	3,0	3	50	7	18	0,10	2
810 D.4	4,0	4	50	8	19	0,10	2
810 D.5	5,0	5	50	10	21	0,10	2
810 D.6	6,0	6	57	10	21	0,15	2
810 D.8	8,0	8	63	16	27	0,15	2
810 D.10	10,0	10	72	19	30	0,15	2
810 D.12	12,0	12	83	22	38	0,20	2
810 D.14	14,0	14	83	22	38	0,20	2
810 D.16	16,0	16	92	26	42	0,20	2
810 D.20	20,0	20	104	32	54	0,20	2

812



Fresa a 3 taglienti per alluminio
3 flute end mill for aluminium



Codice Item code	D h6	d h6	L	l ap	l1	a	Z
812 D.4	4,0	4	50	8	19	0,10	3
812 D.5	5,0	5	50	10	21	0,10	3
812 D.6	6,0	6	57	10	21	0,15	3
812 D.7	7,0	7	60	13	24	0,15	3
812 D.8	8,0	8	63	16	27	0,15	3
812 D.9	9,0	9	67	16	27	0,15	3
812 D.10	10,0	10	72	19	30	0,15	3
812 D.12	12,0	12	83	22	38	0,20	3
812 D.14	14,0	14	83	22	38	0,20	3
812 D.16	16,0	16	92	26	42	0,20	3
812 D.20	20,0	20	104	32	54	0,20	4

BALINIT® ALCRONA

La linea Silsaving usa la tecnologia Balinit® Alcrona per rivestimenti estremamente resistenti nella lavorazione ad alte velocità di taglio

The Silsaving line uses Balinit® Alcrona technology for extremely resistant coatings when machining at high cutting speeds

Eccellente resistenza all'usura

Excellent wear resistance

Miglioramento della velocità di taglio

Improvement of cutting speed

Stabilità sotto shock termici e durezza a caldo

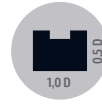
Stability under thermal shock and hot hardness

Aumento di utilizzo e produttività

Increase of use and productivity

810S

812S



	D mm	fz mm/z	F mm/min	n rpm	fz mm/z	F mm/min	n rpm	fz mm/z	F mm/min	n rpm	fz mm/z	F mm/min	n rpm		
														Vc = 600 m/min	
ALU & LEGHE < 6% SI ALU & ALLOYS < 6% SI	2	0,010	1.910	95.493	0,010	2.531	126.528	-	-	-	-	-	-		
	3	0,014	1.783	63.662	0,014	2.362	84.352	-	-	-	-	-	-		
	4	0,024	2.292	47.746	0,024	3.037	63.264	0,021	3.008	47.746	0,021	3.986	63.264		
	5	0,044	3.361	38.197	0,044	4.454	50.611	0,035	4.011	38.197	0,035	5.314	50.611		
	6	0,060	3.820	31.831	0,060	5.061	42.176	0,050	4.775	31.831	0,050	6.326	42.176		
	8	0,086	4.106	23.873	0,086	5.441	31.632	0,073	5.228	23.873	0,073	6.927	31.632		
	10	0,106	4.049	16.099	0,106	5.365	25.306	0,091	5.214	19.099	0,091	6.908	25.306		
	12	0,122	3.883	15.915	0,122	5.145	21.088	0,105	5.013	15.915	0,105	6.643	21.088		
	14	0,136	3.711	13.642	0,136	4.917	18.075	0,118	4.829	13.642	0,118	6.399	18.075		
	16	0,148	3.533	11.937	0,148	4.682	15.816	0,128	4.584	11.937	0,128	6.073	15.816		
20	0,160	3.056	9.549	0,160	4.049	12.653	0,140	4.011	9.549	0,140	5.314	12.653			
ALU & LEGHE > 6% SI ALU & ALLOYS > 6% SI	2	0,010	716	35.810	0,010	955	47.746	-	-	-	-	-	-		
	3	0,014	668	23.873	0,014	891	31.831	-	-	-	-	-	-		
	4	0,024	859	17.905	0,024	1.146	23.873	0,021	1.128	17.905	0,021	1.504	23.873		
	5	0,044	1.261	14.324	0,044	1.681	19.099	0,035	1.504	14.324	0,035	2.005	19.099		
	6	0,060	1.432	11.937	0,060	1.910	15.915	0,050	1.790	11.937	0,050	2.387	15.915		
	8	0,086	1.540	8.952	0,086	2.053	11.937	0,073	1.961	8.952	0,073	2.614	11.937		
	10	0,106	1.518	7.162	0,106	2.024	9.549	0,091	1.955	7.162	0,091	2.607	9.549		
	12	0,122	1.456	5.968	0,122	1.942	7.958	0,105	1.880	5.968	0,105	2.057	7.958		
	14	0,136	1.391	5.116	0,136	1.855	6.821	0,118	1.811	5.116	0,118	2.415	6.821		
	16	0,148	1.325	4.476	0,148	1.767	5.968	0,128	1.719	4.476	0,128	2.292	5.968		
20	0,160	1.146	3.581	0,160	1.528	4.775	0,140	1.504	3.581	0,140	2.005	4.775			
RAMME & LEGHE COPPER & ALLOYS	2	0,010	1.194	59.683	0,010	1.576	78.782	-	-	-	-	-	-		
	3	0,014	1.114	39.789	0,014	1.471	52.521	-	-	-	-	-	-		
	4	0,024	1.432	29.842	0,024	1.891	39.391	0,021	1.880	29.842	0,021	2.482	39.391		
	5	0,044	2.101	23.873	0,044	2.773	31.513	0,035	2.507	23.873	0,035	3.309	31.513		
	6	0,060	2.387	19.894	0,060	3.151	26.261	0,050	2.984	19.894	0,050	3.939	26.261		
	8	0,086	2.566	14.921	0,086	3.388	19.695	0,073	3.268	14.921	0,073	4.313	19.695		
	10	0,106	2.531	11.937	0,106	3.340	15.756	0,091	3.259	11.937	0,091	4.301	15.756		
	12	0,122	2.427	9.947	0,122	3.204	13.130	0,105	3.133	9.947	0,105	4.136	13.130		
	14	0,136	2.319	8.526	0,136	3.061	11.255	0,118	3.018	8.526	0,118	3.984	11.255		
	16	0,148	2.208	7.460	0,148	2.915	9.848	0,128	2.865	7.460	0,128	3.782	9.848		
20	0,160	1.910	5.968	0,160	2.521	7.878	0,140	2.507	5.968	0,140	3.309	7.878			
TERMOPLASTICI THERMOPLASTICS	2	0,010	1.432	71.620	0,010	1.894	94.697	-	-	-	-	-	-		
	3	0,014	1.337	47.746	0,014	1.768	63.131	-	-	-	-	-	-		
	4	0,024	1.719	35.810	0,024	2.273	47.349	0,021	2.256	35.810	0,021	2.983	47.349		
	5	0,044	2.521	28.648	0,044	3.333	37.879	0,035	3.008	28.648	0,035	3.977	37.879		
	6	0,060	2.865	23.873	0,060	3.788	31.566	0,050	3.581	23.873	0,050	4.735	31.566		
	8	0,086	3.080	17.905	0,086	4.072	23.674	0,073	3.921	17.905	0,073	5.185	23.674		
	10	0,106	3.037	14.324	0,106	4.015	18.939	0,091	3.910	14.324	0,091	5.170	18.939		
	12	0,122	2.913	11.937	0,122	3.851	15.783	0,105	3.760	11.937	0,105	4.972	15.783		
	14	0,136	2.783	10.231	0,136	3.680	13.528	0,118	3.622	10.231	0,118	4.789	13.528		
	16	0,148	2.650	8.952	0,148	3.504	11.837	0,128	3.438	8.952	0,128	4.545	11.837		
20	0,160	2.292	7.162	0,160	3.030	9.470	0,140	3.008	7.162	0,140	3.977	9.470			

15%

SERIE LUNGA: -15% rispetto ai parametri di lavoro del corrispettivo utensile serie normale.

LONG SERIES: 15% less than the working parameters of the corresponding tool standard series.

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