

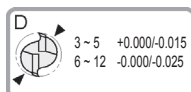
The background of the advertisement features a large, detailed image of a Vonnex Y535 solid carbide end mill on the right side. The left side of the background is a light green color with several stylized green leaves scattered across it. The Vonnex logo is positioned at the top left.

VONNEX[®]

NEW Y535
TOUCH THE FUTURE

SOLID CARBIDE END MILLS

2017



ØD	R	I 1	d 1	I 2	Ød	L	Z
3,0	1,5	4,5	2,9	9	6	70	4
4,0	2,0	6	3,9	12	6	70	4
5,0	2,5	7,5	4,8	15	6	70	4
6,0	3,0	9	-	-	6	80	4
6,0	3,0	9	5,8	18	6	80	4
8,0	4,0	12	-	-	8	100	4
8,0	4,0	12	7,7	24	8	100	4
10,0	5,0	15	-	-	10	100	4
10,0	5,0	15	9,6	30	10	100	4
12,0	6,0	18	-	-	12	110	4
12,0	6,0	18	11,5	36	12	110	4

Roughing / Sgrossatura		Semi-Finishing / Semi-Finitura		Finishing / Finitura		 Dry Machining		 MQL (mist)		 Coolant Emulsion	
Carbon Steels Alloy Steels Tools Steels Acciai al carbonio Acciai legati Acciai per utensili	Hardened Steels			Stainless Steels	Cast iron Ductile cast iron	Copper alloys	Aluminium alloys	Graphite	Plastic	Titanium alloys	Heat resistant alloys
	Acciai temprati			Acciai inossidabili	Ghisa Ghisa duttile	Leghe di rame	Leghe di alluminio	Grafite	Plastica	Leghe di titanio	Acciai refrattari
	≥ 350HB	~45HRC	~55HRC	~60HRC	~65HRC	~350 HB					
											

535 sgrossatura / roughing / vorbearbeitung / 粗加工

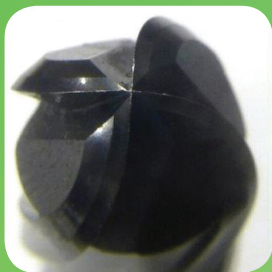
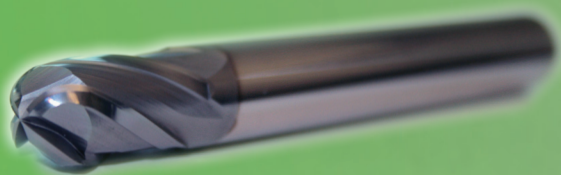
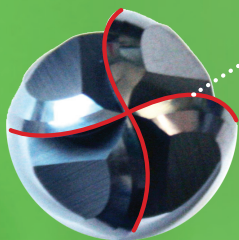
Materiali Material			Acciai da utensili/Acciai temprati/HSS Tools Steels/Hardened Steels/HSS								
Hardness			55 ~ 60 HRC			60 ~ 65 HRC			65 ~ 70 HRC		
Ap Ae [Pf]			 Ap = 0.07 D Ae (Pf) = 0.15 D			 Ap = 0.05 D Ae (Pf) = 0.1 D			 Ap = 0.04 D Ae (Pf) = 0.1 D		
Vc m/min.			110			90			70		
D	R	Z	rpm	F	Fz	rpm	F	Fz	rpm	F	Fz
3	1,5	4	11677	1490	0,032	9554	960	0,025	7431	740	0,025
4	2	4	8758	1580	0,045	7166	950	0,033	5573	740	0,033
5	2,5	4	7006	1540	0,055	5732	920	0,04	4459	710	0,04
6	3	4	5839	1520	0,065	4777	960	0,05	3715	740	0,05
8	4	4	4379	1580	0,09	3583	1000	0,07	2787	780	0,07
10	5	4	3503	1540	0,11	2866	1010	0,088	2229	780	0,088
12	6	4	2919	1400	0,12	2389	960	0,1	1858	740	0,1

535 H.S.C.

finitura / finishing / fertiggearbeitung / 精加工

Materiali Material	Acciai al carbonio / Acciai da costruzione / Ghisa Carbon Steels / Cast iron					Acciai legati / Acciai da utensili Carbon Alloy / Tools Steels					Acciai da utensili/Acciai temprati/HSS Tools Steels/Hardened Steels/HSS									
Hardness	750N/mm ²					35 ~ 45 HRC			45 ~ 55 HRC			55 ~ 60 HRC			60 ~ 65 HRC			65 ~ 70 HRC		
Ap Ae [Pf]						Ap = 0.1 D Ae (Pf) = 0.2 D			Ap = 0.08 D Ae (Pf) = 0.2 D						Ap = 0.05 D Ae (Pf) = 0.1 D			Ap = 0.03 D Ae (Pf) = 0.1 D		
Vc m/min.	250 ~ 300					230 ~ 270			170 ~ 210			150 ~ 170			140 ~ 160			90 ~ 120		
D	R	Z	rpm	F	Fz	rpm	F	Fz	rpm	F	Fz	rpm	F	Fz	rpm	F	Fz	rpm	F	Fz
3	1,5	4	29724	4760	0,04	26539	4250	0,04	20170	3230	0,04	16985	2720	0,04	15924	1340	0,021	10616	890	0,021
4	2	4	22293	4900	0,055	19904	4380	0,055	15127	3030	0,05	12739	2550	0,05	11943	1340	0,028	7962	890	0,028
5	2,5	4	17834	4990	0,07	15924	4460	0,07	12102	2900	0,06	10191	2450	0,06	9554	1340	0,035	6369	890	0,035
6	3	4	14862	4760	0,08	13270	4250	0,08	10085	2820	0,07	8493	2380	0,07	7962	1340	0,042	5308	890	0,042
8	4	4	11146	4460	0,1	9952	3980	0,1	7564	2720	0,09	6369	2290	0,09	5971	1310	0,055	3981	880	0,055
10	5	4	8917	4280	0,12	7962	3820	0,12	6051	2420	0,1	5096	2040	0,1	4777	1340	0,07	3185	890	0,07
12	6	4	7431	4160	0,14	6635	3720	0,14	5042	2220	0,11	4250	1870	0,11	3981	1270	0,08	2654	850	0,08

4 Taglienti al Centro



YONNEX



COMPETITOR A

 **ITT Technical Tools SpA**

V.le della Navigazione Interna, 70
35129 PADOVA - Italy
tel. +39 049 8060140
Fax +39 049 8060180
e-mail: ittvend@itt.it
Website: www.itt.it



infoyonnex@itt.it
www.yonnextools.com