



5104T

ACCIAI STEEL
STAHL

ACCIAI INOX STAINLESS STEEL
ROSTFREIER STAHL

5104T

NOVITÀ NEW
NEU

21.1 | VERSION
210127

MANUFACTURED



100% ITALY

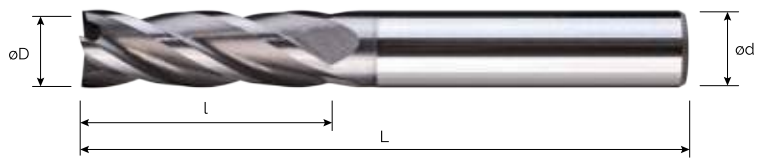
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TOOLS and EQUIPMENT



www.ttetec.eu

5104T

FRESA PIANA 4T SERIE CORTA E LUNGA - GV / 4 FLUTE SQUARE END MILL, SHORT & LONG SERIES - GV
 4-NUTIGER SCHAFTFRÄSER - GV MISURE DISPONIBILI D 6 - 16 / AVAILABLE SIZES D 6 - 16 / ABMESSUNGSBEREICH D 6 - 16



Cod.	øD	l	L	ød
5104T-060-180	6	18	58	6
5104T-080-240	8	24	64	8
5104T-100-300	10	30	73	10
5104T-120-360	12	36	84	12
5104T-160-320	16	32	93	16

CARATTERISTICHE CHARACTERISTICS EIGENSCHAFTEN

Filo tagliente rinforzato con micro geometria, migliora la durata e la qualità superficiale.

Cutting edge preparation, increase tool life and improve the surface quality of work piece. ✓

Schneidkanten-Konditionierung, zur Standzeitverbesserung und für glatte Werkstückoberflächen.



Run out tra gambo e taglienti < 4 µ, migliora la durata, consumo omogeneo dei taglienti.

Run out < 4 µ improve the surface quality of work piece and increase tool life. ✓

Rundlaufgenauigkeit unter 4µ, verbessert die Oberflächengüte und verlängert die Standzeit.



Vano truciolo con angoli irregolari. Diametro nocciolo robusto, conico.

Chip pocket Core diameter. Special profile to improve chip evacuation. ✓

Nutengeometrie, Kerndurchmesser. Optimiertes Profil zur besseren Spanabfuhr und besserer Stabilität der Fräser.

Geometria variabile, diminuisce le vibrazioni.

Variable geometry, no vibrations and no chattering. Variable Schneidgeometrie, verhindert Vibrationen und Rattern. ✓



Frontale scaricato per utilizzo con elevati angoli di penetrazione.

Gash angle with micro geometry. Improve chip evacuation in ramp milling. Stirnschliff mit Mikrogeometrie. Optimale Spanabfuhr beim Eintauchen. ✓



P		ACCIAI / STEEL / STAHL			P		Ae=D		Ae		Trochoidal 10% Ae	
		Materiale / Material / Werkstoff					GR		Ap		Ap	
Vc (m/min)	Non legati / Non-alloyed steel / Unlegierte Stähle			1 - 2 - 3 - 4 - 5		100		180		220		
	Basso legati / Low-alloyed steel / Niedrig-legierte Stähle			6 - 7 - 8		80 - 90		120 - 160		160 - 190		
	Medio legati / Medium-alloyed steel / Legierte Stähle			9 - 10 - 11		60 - 80		90 - 120		100 - 150		
GR												
1 - 2 - 3 - 4 - 5		Fz (mm/z)					Ap		Ap		Ae	
fz	Ø 6	0.037	0.074	0.115	Ap Ae	Ø 6	6	12	0.12	15	0.60	
	Ø 8	0.050	0.099	0.154		Ø 8	12	16	0.16	20	0.80	
	Ø 10	0.062	0.124	0.192		Ø 10	15	20	0.20	25	1.00	
	Ø 12	0.074	0.149	0.231		Ø 12	18	24	0.24	30	1.20	
	Ø 16	0.099	0.198	0.308		Ø 16	24	32	0.32	40	1.60	
6 - 7 - 8		Fz (mm/z)					Ap		Ap		Ae	
fz	Ø 6	0.035	0.070	0.104	Ap Ae	Ø 6	6	12	0.12	12	0.60	
	Ø 8	0.046	0.093	0.139		Ø 8	12	16	0.16	16	0.80	
	Ø 10	0.058	0.116	0.174		Ø 10	15	20	0.20	20	1.00	
	Ø 12	0.070	0.139	0.209		Ø 12	18	24	0.24	24	1.20	
	Ø 16	0.093	0.186	0.278		Ø 16	24	32	0.32	32	1.60	
9 - 10 - 11		Fz (mm/z)					Ap		Ap		Ae	
fz	Ø 6	0.030	0.060	0.090	Ap Ae	Ø 6	3	12	0.10	12	0.45	
	Ø 8	0.040	0.080	0.120		Ø 8	9.6	16	0.14	16	0.60	
	Ø 10	0.050	0.100	0.150		Ø 10	12	20	0.17	20	0.75	
	Ø 12	0.060	0.120	0.180		Ø 12	14.4	24	0.20	24	0.90	
	Ø 16	0.080	0.160	0.240		Ø 16	19.2	32	0.27	32	1.20	

M		ACCIAI INOX / STAINLESS STEEL / ROSTFREIER STAHL			M		Ae=D		Ae		Trochoidal 10% Ae	
		Materiale / Material / Werkstoff					GR		Ap		Ap	
Vc (m/min)	Martensitico / Martensitic / Martensitische Stähle			12		100		140		150		
	Austenitico / Austenitic / Austenitische Stähle			13		85		119		128		
	Duplex			14		65		91		98		
GR												
12		Fz (mm/z)					Ap		Ap		Ae	
fz	Ø 6	0.025	0.050	0.088	Ap Ae	Ø 6	6	12	0.12	12	0.48	
	Ø 8	0.034	0.067	0.118		Ø 8	8	16	0.16	16	0.64	
	Ø 10	0.042	0.084	0.147		Ø 10	10	20	0.20	20	0.80	
	Ø 12	0.050	0.101	0.176		Ø 12	12	24	0.24	24	0.96	
	Ø 16	0.067	0.134	0.235		Ø 16	16	32	0.32	32	1.28	
13		Fz (mm/z)					Ap		Ap		Ae	
fz	Ø 6	0.024	0.048	0.084	Ap Ae	Ø 6	6	12	0.12	12	0.48	
	Ø 8	0.032	0.064	0.112		Ø 8	8	16	0.16	16	0.64	
	Ø 10	0.040	0.080	0.140		Ø 10	10	20	0.20	20	0.80	
	Ø 12	0.048	0.096	0.168		Ø 12	12	24	0.24	24	0.96	
	Ø 16	0.064	0.128	0.224		Ø 16	16	32	0.32	32	1.28	
14		Fz (mm/z)					Ap		Ap		Ae	
fz	Ø 6	0.023	0.046	0.071	Ap Ae	Ø 6	4.5	9	0.11	9	0.36	
	Ø 8	0.030	0.061	0.094		Ø 8	6	12	0.14	12	0.48	
	Ø 10	0.038	0.076	0.118		Ø 10	7.5	15	0.18	15	0.60	
	Ø 12	0.046	0.091	0.141		Ø 12	9	18	0.22	18	0.72	
	Ø 16	0.061	0.122	0.188		Ø 16	12	24	0.29	24	0.96	

LEGENDA / KEY / LEGENDE

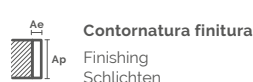
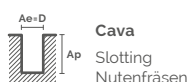
Vc (m/min) Cutting speed
Schnittgeschwindigkeit

Fz (mm/z) Feed per tooth
Vorschub pro Zahn

Ae (mm) Radial depth of cut
Radiale Zustellung

Ap (mm) Axial depth of cut
Axiale Zustellung

LAVORAZIONI / TYPE OF OPERATION / ART DER ANWENDUNG





(uemme)
TOOLS and EQUIPMENT

5104FT-EN-DE-REV-211