

END MILLS-DRILLS FOR METAL Z3/Z4 - FLUTING

END MILL DIAMETER	0,8	1	2	3	4	5	6	8	10	12	16	20
WHEEL SHAPE	14A1 100X3X6	14A1 100X3X6	14A1 100X4X6	14A1 100X4X6	14A1 100X6X6	14A1 100X6X6	1A1 100X8X6	1A1 100X8X6	1A1 100X10X6	1A1 100X12X6	1A1 100X12X6	1A1 100X12X6
GRIT SIZE	D20	D20	D30	D30	D46	D46	D46	D46	D64	D64	D64	D64
BOND	MX 7.0	MX 7.0	MX 7.0	MX 7.0	MX 7.0	MX 7.0	MX 7.0	MX 7.0	MX 7.0	MX 7.0	MX 7.0	MX 7.0
Peripheral Speed	18 Mt/sec	18 Mt/sec	18 Mt/sec	18 Mt/sec	18 Mt/sec	18 Mt/sec	15 Mt/sec	15 Mt/sec	15 Mt/sec	15 Mt/sec	15 Mt/sec	15 Mt/sec
Depth of Cut [Ae]	0,16	0,2	0,4	0,6	0,8	1	1,2	1,6	2	2,4	3,2	4
Feedrate [F]	900	720	360	240	225	180	170	128	114	95	71	57

END MILLS-DRILLS FOR WOOD Z2/Z3 - FLUTING

END MILL DIAMETER	6	8	10	12	16	20
WHEEL SHAPE	1A1 100x8x6	1A1 100x8x6	1A1 100x10x6	1A1 100x10x6	1A1 100X12X6	1A1 100X12X6
GRIT SIZE	D64	D64	D64	D64	D91	D91
BOND	MX 7.0	MX 7.0	MX 7.0	MX 7.0	MX 7.0	MX 7.0
Peripheral Speed	15 Mt/sec	15 Mt/sec	15 Mt/sec	15 Mt/sec	15 Mt/sec	15 Mt/sec
Depth of Cut [Ae]	1,5	2	2,5	3	4	5
Feedrate [F]	152	114	91	76	63	50

CLEARANCE ANGLES SHARPENING - GASHING

END MILL DIAMETER	6	8	10	12	16	20
WHEEL SHAPE	12V9 45° 125X3X10 1V1 125x8x10 V=45°	12V9 45° 125X3X10 1V1 125x8x10 V=45°	12V9 45° 125X3X10 1V1 125x8x10 V=45°	12V9 45° 125X3X10 1V1 125x8x10 V=45°	12V9 45° 125X3X10 1V1 125x8x10 V=45°	12V9 45° 125X3X10 1V1 125x8x10 V=45°
GRIT SIZE	D64	D64	D64	D64	D64	D64
BOND	MX 7.0	MX 7.0	MX 7.0	MX 7.0	MX 7.0	MX 7.0
Peripheral Speed	20 Mt/sec	20 Mt/sec	20 Mt/sec	20 Mt/sec	20 Mt/sec	20 Mt/sec
Feedrate [F]	90	90	90	90	90	80

CLEARANCE ANGLES SHARPENING - END RELIEVES

END MILL DIAMETER	6	8	10	12	16	20
WHEEL SHAPE	11V9 100X3X10	11V9 100X3X10	11V9 100X3X10	11V9 100X3X10	11V9 100X3X10	11V9 100X3X10
GRIT SIZE	D46	D64	D64	D64	D91	D91
BOND	MX 7.0	MX 7.0	MX 7.0	MX 7.0	MX 7.0	MX 7.0
Peripheral Speed	25 Mt/sec	25 Mt/sec	25 Mt/sec	25 Mt/sec	25 Mt/sec	25 Mt/sec
Feedrate [F]	90	90	90	90	90	80

CLEARANCE ANGLES SHARPENING - OD1 & OD2

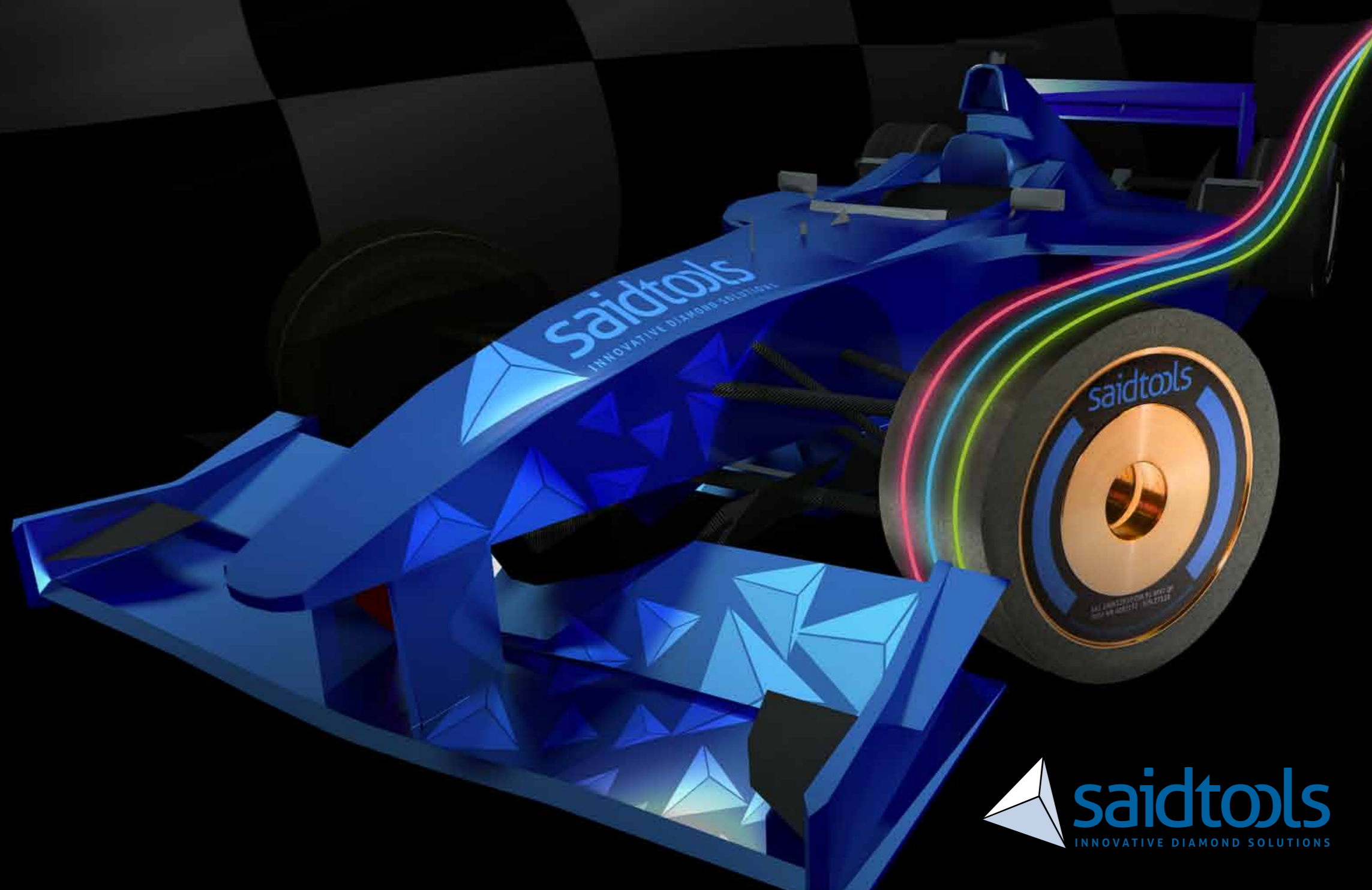
END MILL DIAMETER	6	8	10	12	16	20
WHEEL SHAPE	11V9 100X3X10	11V9 100X3X10	11V9 100X3X10	11V9 100X3X10	11V9 100X3X10	11V9 100X3X10
GRIT SIZE	D46	D64	D64	D64	D91	D91
BOND	MX 7.0	MX 7.0	MX 7.0	MX 7.0	MX 7.0	MX 7.0
Peripheral Speed	25 Mt/sec	25 Mt/sec	25 Mt/sec	25 Mt/sec	25 Mt/sec	25 Mt/sec
Feedrate [F]	150	150	150	150	150	150



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MX 7.0

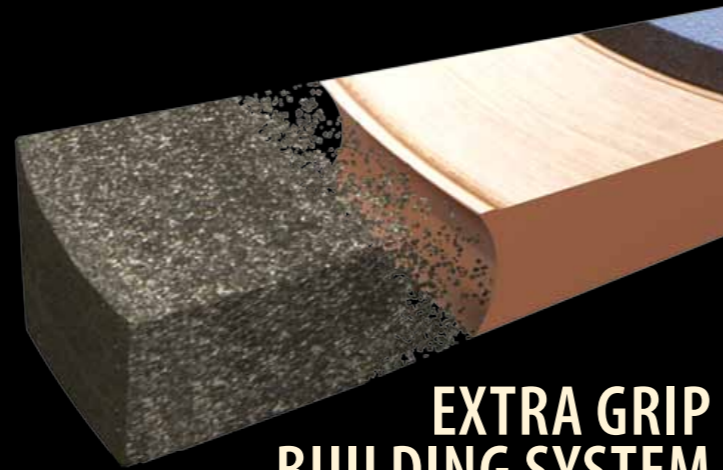
Top performance for your machines



Reliability, the key of our success

Every year SAIDTOOLS invests considerable economic resources and a lot of time to grant more and more reliability and a constant level of performance.

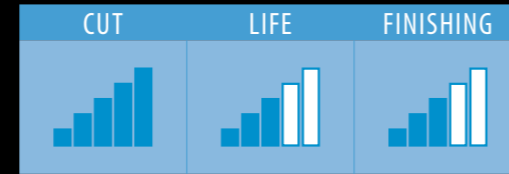
After intense research and development activities, we have manufactured the MX 7.0 line, a point of reference in hard metal tools production, that has a new grip system making the wheel output more stable and more precise.



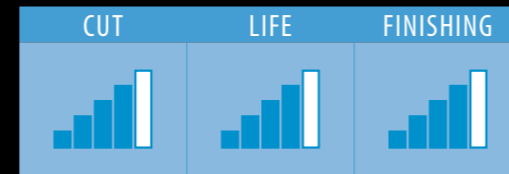
EXTRA GRIP BUILDING SYSTEM



FAST
HIGHEST FEEDRATES
MX 7.0-F



MEDIUM
BALANCED PERFORMANCES
MX 7.0-M



HARD
LONG LIFE
MX 7.0-H



A wheel designed to boost productivity

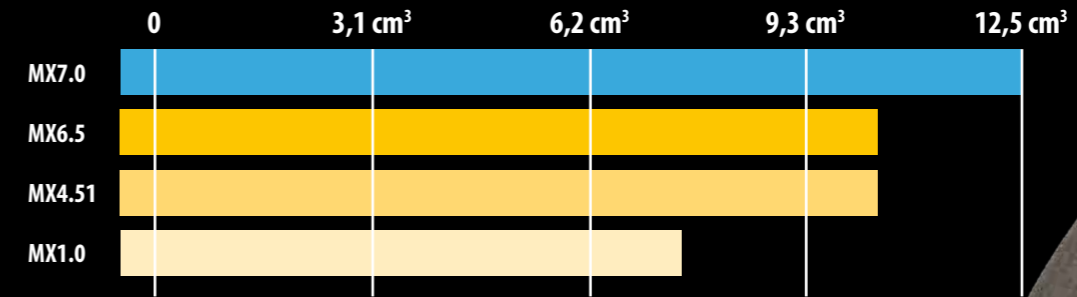
Maximum productivity means to be competitive, most of all reducing the operator intervention.

This is the reason why we have planned a wheel that can produce a lot of tools before it needs to be cleaned by an abrasive stick.

Faster feedings and a spindle load always under control.

MX7.0 system allows to carry out a bigger quantity of flutes before of reaching the limit value (31% improvement on the dressing interval compared to the previous MX hybrid metal bond).

VOLUME REMOVAL WITHOUT WHEEL CLEANING



To grant excellent performances means a wheel minimum wear, in order to respect the size tolerances of the tool that one is manufacturing.

Finally a uniform wear always under your control!

With MX 7.0 bond we have reduced the 34% wear of the grinding wheel, increasing the life to record values!

WHEEL WEAR μm/end-mill

