# Zylindrische Fräser AX-V3

Glattschneidig, lange Ausführung

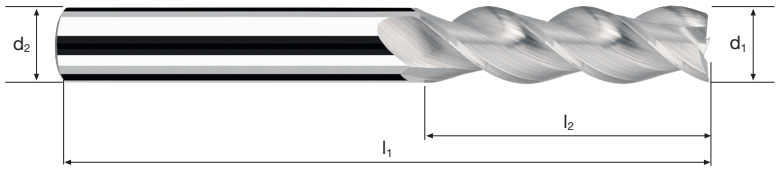
X-Generation X

III

HM MG10 | λ 40° γ 20°

90°

Vario




Schruppen

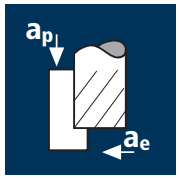
Schlichten

Rm < 850 | Al Aluminium > 99% | Al Aluminium Alloy | Al Aluminium Cast | Cu Copper | Plastic Thermoplast

Beispiel: **Bestell-Nr.** Beschichtung **C** Artikel-Nr. **15561** ø-Code **300**

| ø Code | d1 e8 | d2 h6 | l1 | l2 | z | 15661 | CELERO C15661 |
|---|---|---|---|---|---|---|---|
| | | | | | | 15561 | C15561 |
| **300** | 6 | 6 | 70 | 26 | 3 | ● | ● |
| **391** | 8 | 8 | 80 | 36 | 3 | ● | ● |
| **450** | 10 | 10 | 100 | 45 | 3 | ● | ● |
| **501** | 12 | 12 | 110 | 53 | 3 | ● | ● |
| **610** | 16 | 16 | 123 | 63 | 3 | ● | ● |
| **682** | 20 | 20 | 141 | 75 | 3 | ● | ● |

Anwendung




| Werkstoff | d1 [mm] | z | $v_c$ [m/min] | $f_z$ [mm] | $a_p$ [mm] | $a_e$ [mm] | n [min⁻¹] | $v_f$ [mm/min] | Q [cm³/min] |
|---|---|---|---|---|---|---|---|---|---|
| Al-Knetlegierung Si < 6% | 6 | 3 | 350 | 0.065 | 18.0 | 0.9 | 18570 | 3620 | 58.5 |
| | 8 | 3 | 350 | 0.080 | 24.0 | 1.2 | 13925 | 3340 | 96.0 |
| | 10 | 3 | 350 | 0.100 | 30.0 | 1.5 | 11140 | 3340 | 150.5 |
| | 12 | 3 | 350 | 0.120 | 36.0 | 1.8 | 9285 | 3345 | 217.0 |
| | 16 | 3 | 350 | 0.130 | 48.0 | 2.4 | 6965 | 2715 | 313.0 |
| | 20 | 3 | 350 | 0.150 | 60.0 | 3.0 | 5570 | 2505 | 451.0 |
| Reinkupfer | 6 | 3 | 220 | 0.050 | 18.0 | 0.9 | 11670 | 1750 | 28.5 |
| | 8 | 3 | 220 | 0.065 | 24.0 | 1.2 | 8755 | 1705 | 49.0 |
| | 10 | 3 | 220 | 0.080 | 30.0 | 1.5 | 7005 | 1680 | 75.5 |
| | 12 | 3 | 220 | 0.095 | 36.0 | 1.8 | 5835 | 1665 | 108.0 |
| | 16 | 3 | 220 | 0.105 | 48.0 | 2.4 | 4375 | 1380 | 159.0 |
| | 20 | 3 | 220 | 0.120 | 60.0 | 3.0 | 3500 | 1260 | 227.0 |
| Thermoplaste | 6 | 3 | 600 | 0.065 | 18.0 | 0.9 | 31830 | 6205 | 100.5 |
| | 8 | 3 | 600 | 0.080 | 24.0 | 1.2 | 23875 | 5730 | 165.0 |
| | 10 | 3 | 600 | 0.100 | 30.0 | 1.5 | 19100 | 5730 | 258.0 |
| | 12 | 3 | 600 | 0.120 | 36.0 | 1.8 | 15915 | 5730 | 371.5 |
| | 16 | 3 | 600 | 0.130 | 48.0 | 2.4 | 11935 | 4655 | 536.5 |
| | 20 | 3 | 600 | 0.150 | 60.0 | 3.0 | 9550 | 4300 | 774.0 |
| Aluminiumguss Si 6% - 15% | 6 | 3 | 200 | 0.045 | 18.0 | 0.9 | 10610 | 1430 | 23.0 |
| | 8 | 3 | 200 | 0.055 | 24.0 | 1.2 | 7960 | 1315 | 38.0 |
| | 10 | 3 | 200 | 0.070 | 30.0 | 1.5 | 6365 | 1335 | 60.0 |
| | 12 | 3 | 200 | 0.085 | 36.0 | 1.8 | 5305 | 1355 | 88.0 |
| | 16 | 3 | 200 | 0.090 | 48.0 | 2.4 | 3980 | 1075 | 124.0 |
| | 20 | 3 | 200 | 0.105 | 60.0 | 3.0 | 3185 | 1005 | 181.0 |