Zylindrische Fräser AX-V3

Glattschneidig, lange Ausführung

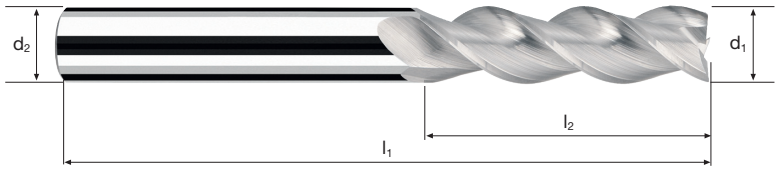
X-Generation X

III

HM MG10 | λ 40° γ 20°

90°

Vario



Schruppen

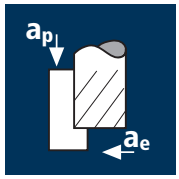
Schlichten

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