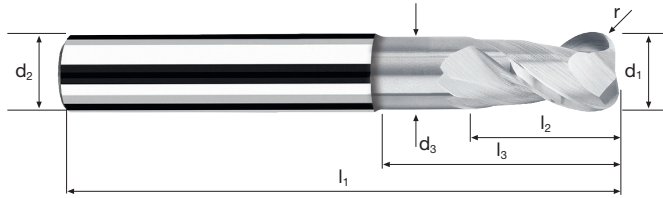
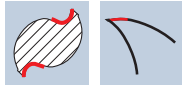
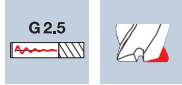


# Eckradiusfräser AX-RV2

Glattschneidig, Ausführung 3xd mit Hals



**HM**  
**MG10**     $\lambda$  40°  
                   $\gamma$  20°



Schruppen

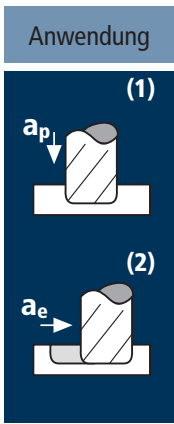


Schichten



			<b>Al</b> Aluminium > 99%	<b>Al</b> Aluminium Alloy	<b>Al</b> Aluminium Cast		<b>Cu</b> Copper	<b>Plastic</b> Thermoplast	
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Beispiel: Bestell-Nr. <b>C 15573 180</b>											CELERO	
											15573	C15573
Ø Code	d1 e8	d2 h6	d3	l1	l2	l3	l3/d1	r 0/+0.03	α	z		
180	3	6	2.8	54	4	9	3.0	0.5	5.9°	2	●	●
220	4	6	3.7	54	5	12	3.0	0.5	3.7°	2	●	●
260	5	6	4.6	54	6	15	3.0	0.5	1.7°	2	●	●
300	6	6	5.5	54	7	18	3.0	0.5	0.0°	2	●	●
302	6	6	5.5	54	7	18	3.0	1.0	0.0°	2	●	●
391	8	8	7.4	63	9	24	3.0	1.0	0.0°	2	●	●
450	10	10	9.2	72	11	30	3.0	1.0	0.0°	2	●	●
501	12	12	11.0	83	13	36	3.0	1.0	0.0°	2	●	●
608	16	16	15.0	97	18	48	3.0	1.0	0.0°	2	●	●
680	20	20	19.0	111	22	60	3.0	1.0	0.0°	2	●	●
770	25	25	24.0	132	27	75	3.0	1.0	0.0°	2	●	●
453	10	10	9.2	72	11	30	3.0	1.5	0.0°	2	●	-
503	12	12	11.0	83	13	36	3.0	1.5	0.0°	2	●	-
611	16	16	15.0	97	18	48	3.0	2.0	0.0°	2	●	-
683	20	20	19.0	111	22	60	3.0	2.0	0.0°	2	●	-



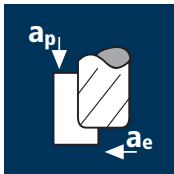
Werkstoff

Al-Integralbau  
Luftfahrt  
[AlMg15SiCu / 6061]  
[AlCu4MgSi / 2017]  
[AlCu2Mg1,5Ni / 2618]  
[AlZn5,5MgCu / 7175]  
[AlZn6CuMgZr / 7150]  
[AlCu4Mg1 / 2124]

Al-Knetlegierung  
[AlMgSi1 / 6082]

Al-Gusslegierung  
[G-AlSi11Mg]

d1 [mm]	z	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n=10000 min <sup>-1</sup> vf [mm/min]	n=15000 min <sup>-1</sup> vf [mm/min]	n=20000 min <sup>-1</sup> vf [mm/min]	n=30000 min <sup>-1</sup> vf [mm/min]
3	2	0.050	2.0	3.0	1000	1500	2000	3000
4	2	0.065	3.0	4.0	1300	1950	2600	3900
6	2	0.100	4.0	6.0	2000	3000	4000	6000
8	2	0.130	5.0	8.0	2600	3900	5200	7800
10	2	0.165	5.5	10.0	3300	4950	6600	9900
12	2	0.195	6.0	12.0	3900	5850	7800	11700
16	2	0.210	6.5	16.0	4200	6300	8400	12600
20	2	0.220	7.0	20.0	4400	6600	8800	13200
25	2	0.230	7.0	25.0	4600	6900	9200	13800



Al-Integralbau  
[AlZn5,5MgCu / 7175]  
Al-Knetlegierung  
[AlMgSi1 / 6082]  
Al-Gusslegierung  
[G-AlSi11Mg]

3	2	0.050	3.0	1.8	1000	1500	2000	3000
4	2	0.065	4.5	2.4	1300	1950	2600	3900
6	2	0.100	6.0	3.6	2000	3000	4000	6000
8	2	0.130	7.5	4.8	2600	3900	5200	7800
10	2	0.165	8.3	6.0	3300	4950	6600	9900
12	2	0.195	9.0	7.2	3900	5850	7800	11700
16	2	0.210	9.8	9.6	4200	6300	8400	12600
20	2	0.220	10.5	12.0	4400	6600	8800	13200
25	2	0.230	10.5	15.0	4600	6900	9200	13800

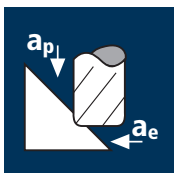


Werkstoff

Al-Integralbau  
[AlZn5,5MgCu / 7175]  
Al-Knetlegierung  
[AlMgSi1 / 6082]  
Al-Gusslegierung  
[G-AlSi11Mg]

d1 [mm]	z	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n=10000 min <sup>-1</sup> vf [mm/min]	n=15000 min <sup>-1</sup> vf [mm/min]	n=20000 min <sup>-1</sup> vf [mm/min]	n=30000 min <sup>-1</sup> vf [mm/min]
3	2	0.015	*	0.10	300	450	600	900
4	2	0.020	*	0.10	400	600	800	1200
6	2	0.030	*	0.20	600	900	1200	1800
8	2	0.040	*	0.25	800	1200	1600	2400
10	2	0.050	*	0.30	1000	1500	2000	3000
12	2	0.060	*	0.35	1200	1800	2400	3600
16	2	0.065	*	0.50	1300	1950	2600	3900
20	2	0.065	*	0.60	1300	1950	2600	3900
25	2	0.070	*	0.75	1400	2100	2800	4200

\*a<sub>plm</sub> siehe Seite 936



Al-Integralbau  
[AlZn5,5MgCu / 7175]  
Al-Knetlegierung  
[AlMgSi1 / 6082]  
Al-Gusslegierung  
[G-AlSi11Mg]

3	2	0.110	0.30	0.30	2200	3300	4400	6600
4	2	0.145	0.35	0.35	2900	4350	5800	8700
6	2	0.220	0.40	0.40	4400	6600	8800	13200
8	2	0.285	0.45	0.45	5700	8550	11400	17100
10	2	0.365	0.50	0.50	7300	10950	14600	21900
12	2	0.430	0.60	0.60	8600	12900	17200	25800
16	2	0.460	0.75	0.75	9200	13800	18400	27600
20	2	0.485	1.00	1.00	9700	14550	19400	29100
25	2	0.505	1.20	1.20	10100	15150	20200	30300

# Eckradiusfräser AX-RV2

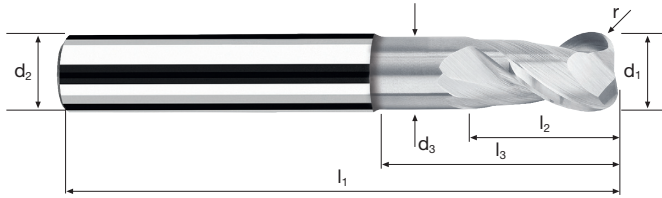
Glattschneidig, Ausführung 3xd mit Hals



**HM**  
**MG10**    λ **40°**  
                  γ **20°**

**G2.5**

**Vario**



Schruppen

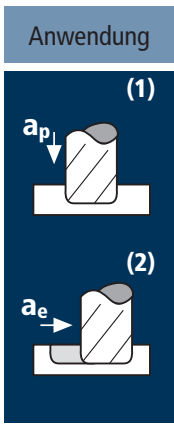


Schichten



Al Aluminium > 99%    Al Aluminium Alloy    Al Aluminium Cast    Cu Copper    Plastic Thermoplast

Beispiel: Bestell-Nr.		Beschichtung <b>C</b>	Artikel-Nr. <b>15573</b>	α-Code <b>307</b>									<b>CELERO</b>
Ø Code	d1 e8	d2 h6	d3	l1	l2	l3	l3/d1	r 0/+0.03	α	z	<b>15573</b>	<b>C15573</b>	
<b>307</b>	6	6	5.5	54	7	18	3.0	2.5	0.0°	2	●	●	
<b>397</b>	8	8	7.4	63	9	24	3.0	2.5	0.0°	2	●	●	
<b>457</b>	10	10	9.2	72	11	30	3.0	2.5	0.0°	2	●	●	
<b>506</b>	12	12	11.0	83	13	36	3.0	2.5	0.0°	2	●	●	
<b>612</b>	16	16	15.0	97	18	48	3.0	2.5	0.0°	2	●	●	
<b>684</b>	20	20	19.0	111	22	60	3.0	2.5	0.0°	2	●	●	
<b>774</b>	25	25	24.0	132	27	75	3.0	2.5	0.0°	2	●	●	
<b>459</b>	10	10	9.2	72	11	30	3.0	4.0	0.0°	2	●	●	
<b>508</b>	12	12	11.0	83	13	36	3.0	4.0	0.0°	2	●	●	
<b>614</b>	16	16	15.0	97	18	48	3.0	4.0	0.0°	2	●	●	
<b>686</b>	20	20	19.0	111	22	60	3.0	4.0	0.0°	2	●	●	
<b>776</b>	25	25	24.0	132	27	75	3.0	4.0	0.0°	2	●	●	



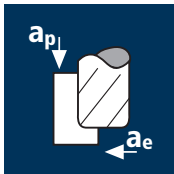
Werkstoff

Al-Integralbau  
Luftfahrt  
[AlMg15SiCu / 6061]  
[AlCu4MgSi / 2017]  
[AlCu2Mg1,5Ni / 2618]  
[AlZn5,5MgCu / 7175]  
[AlZn6CuMgZr / 7150]  
[AlCu4Mg1 / 2124]

Al-Knetlegierung  
[AlMgSi1 / 6082]

Al-Gusslegierung  
[G-AlSi11Mg]

d1 [mm]	z	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n=10000 min <sup>-1</sup> vf [mm/min]	n=15000 min <sup>-1</sup> vf [mm/min]	n=20000 min <sup>-1</sup> vf [mm/min]	n=30000 min <sup>-1</sup> vf [mm/min]
6	2	0.100	4.0	6.0	2000	3000	4000	6000
8	2	0.130	5.0	8.0	2600	3900	5200	7800
10	2	0.165	5.5	10.0	3300	4950	6600	9900
12	2	0.195	6.0	12.0	3900	5850	7800	11700
16	2	0.210	6.5	16.0	4200	6300	8400	12600
20	2	0.220	7.0	20.0	4400	6600	8800	13200
25	2	0.230	7.0	25.0	4600	6900	9200	13800



Al-Integralbau  
[AlZn5,5MgCu / 7175]  
Al-Knetlegierung  
[AlMgSi1 / 6082]  
Al-Gusslegierung  
[G-AlSi11Mg]

6	2	0.100	4.0	4.8	2000	3000	4000	6000
8	2	0.130	5.0	6.4	2600	3900	5200	7800
10	2	0.165	5.5	8.0	3300	4950	6600	9900
12	2	0.195	6.0	9.6	3900	5850	7800	11700
16	2	0.210	6.5	12.8	4200	6300	8400	12600
20	2	0.220	7.0	16.0	4400	6600	8800	13200
25	2	0.230	7.0	20.0	4600	6900	9200	13800

6	2	0.100	6.0	3.6	2000	3000	4000	6000
8	2	0.130	7.5	4.8	2600	3900	5200	7800
10	2	0.165	8.3	6.0	3300	4950	6600	9900
12	2	0.195	9.0	7.2	3900	5850	7800	11700
16	2	0.210	9.8	9.6	4200	6300	8400	12600
20	2	0.220	10.5	12.0	4400	6600	8800	13200
25	2	0.230	10.5	15.0	4600	6900	9200	13800

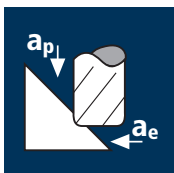


Werkstoff

Al-Integralbau  
[AlZn5,5MgCu / 7175]  
Al-Knetlegierung  
[AlMgSi1 / 6082]  
Al-Gusslegierung  
[G-AlSi11Mg]

d1 [mm]	z	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n=10000 min <sup>-1</sup> vf [mm/min]	n=15000 min <sup>-1</sup> vf [mm/min]	n=20000 min <sup>-1</sup> vf [mm/min]	n=30000 min <sup>-1</sup> vf [mm/min]
6	2	0.030	*	0.20	600	900	1200	1800
8	2	0.040	*	0.25	800	1200	1600	2400
10	2	0.050	*	0.30	1000	1500	2000	3000
12	2	0.060	*	0.35	1200	1800	2400	3600
16	2	0.065	*	0.50	1300	1950	2600	3900
20	2	0.065	*	0.60	1300	1950	2600	3900
25	2	0.070	*	0.75	1400	2100	2800	4200

\*ap<sub>im</sub> siehe Seite 936



Al-Integralbau  
[AlZn5,5MgCu / 7175]  
Al-Knetlegierung  
[AlMgSi1 / 6082]  
Al-Gusslegierung  
[G-AlSi11Mg]

6	2	0.220	0.40	0.40	4400	6600	8800	13200
8	2	0.285	0.45	0.45	5700	8550	11400	17100
10	2	0.365	0.50	0.50	7300	10950	14600	21900
12	2	0.430	0.60	0.60	8600	12900	17200	25800
16	2	0.460	0.75	0.75	9200	13800	18400	27600
20	2	0.485	1.00	1.00	9700	14550	19400	29100
25	2	0.505	1.20	1.20	10100	15150	20200	30300

6	2	0.220	0.40	0.40	4400	6600	8800	13200
8	2	0.285	0.45	0.45	5700	8550	11400	17100
10	2	0.365	0.50	0.50	7300	10950	14600	21900
12	2	0.430	0.60	0.60	8600	12900	17200	25800
16	2	0.460	0.75	0.75	9200	13800	18400	27600
20	2	0.485	1.00	1.00	9700	14550	19400	29100
25	2	0.505	1.20	1.20	10100	15150	20200	30300