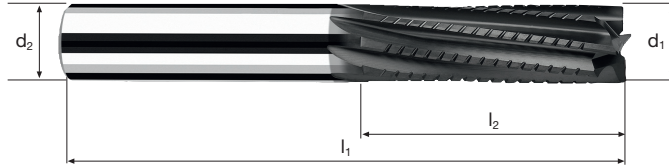


Zylindrische Fräser

Normale Ausführung, ziehende Schneide



HM
MG6 λ **8°**
 γ **18°**

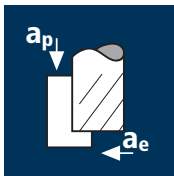


Verschleissresistenz



Beispiel: Bestell-Nr. B 20025 220									DIAMANT
									B20025
Ø Code	d1 h10	d2 h6	l1	l2	45°	α	z		
220	4	6	60	16	0.1	2.9°	8		●
260	5	6	60	18	0.1	1.4°	8		●
300	6	6	60	20	0.1	0.0°	8		●
302	6	6	65	25	0.1	0.0°	8		●
304	6	6	75	28	0.1	0.0°	8		●
391	8	8	63	22	0.2	0.0°	8		●
393	8	8	75	32	0.2	0.0°	8		●
450	10	10	72	32	0.2	0.0°	8		●
501	12	12	83	32	0.2	0.0°	8		●

Anwendung



Werkstoff

CFK

d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
4	8	200	0.025	7.2	1.6	15915	3185
5	8	200	0.030	9.0	2.0	12735	3055
6	8	200	0.040	10.8	2.4	10610	3395
8	8	200	0.045	14.4	3.2	7960	2865
10	8	200	0.050	18.0	4.0	6365	2545
12	8	200	0.060	21.6	4.8	5305	2545

GFK

4	8	150	0.030	7.2	1.6	11935	2865
5	8	150	0.035	9.0	2.0	9550	2675
6	8	150	0.040	10.8	2.4	7960	2545
8	8	150	0.050	14.4	3.2	5970	2390
10	8	150	0.055	18.0	4.0	4775	2100
12	8	150	0.065	21.6	4.8	3980	2070

Anwendung



Werkstoff

CFK

d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
4	8	150	0.020	3.2	4	11935	1910
5	8	150	0.025	4.0	5	9550	1910
6	8	150	0.030	4.8	6	7960	1910
8	8	150	0.035	6.4	8	5970	1670
10	8	150	0.040	8.0	10	4775	1530
12	8	150	0.050	9.6	12	3980	1590

GFK

4	8	100	0.025	3.2	4	7960	1590
5	8	100	0.030	4.0	5	6365	1530
6	8	100	0.030	4.8	6	5305	1275
8	8	100	0.040	6.4	8	3980	1275
10	8	100	0.045	8.0	10	3185	1145
12	8	100	0.050	9.6	12	2655	1060

