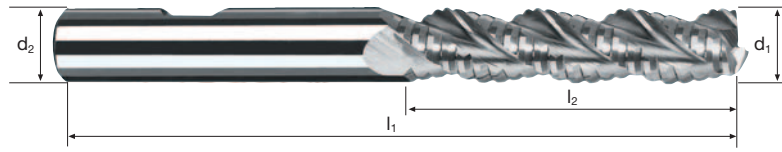


# Zylindrische Fräser

Profiliert, mittellange Ausführung



**HSS-E  
Co8**     $\lambda$  **40°**  
                   $\gamma$  **18°**



Schruppen



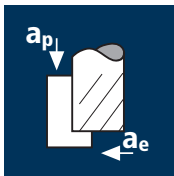
Schichten



<b>Rm</b> < 850			<b>Al</b> Aluminium > 99%	<b>Al</b> Aluminium Alloy		<b>Cu</b> Copper	<b>Plastic</b> Thermoplast
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Beispiel: Bestell-Nr.								<b>CELERO</b>
								<b>C0393</b>
		Beschichtung	Artikel-Nr.	ø-Code				
		<b>C</b>	<b>0393</b>	<b>.450</b>				
Ø Code	d1 k8	d2 h6	l1	l2	45°	z		
<b>.450</b>	10	10	95	45	0.4	3	●	
<b>.501</b>	12	12	110	53	0.4	3	●	
<b>.610</b>	16	16	123	63	0.5	3	●	
<b>.682</b>	20	20	141	75	0.5	3	●	
<b>.772</b>	25	25	166	90	0.7	3	●	

## Anwendung



## Werkstoff

Al-Knetlegierung  
Si < 6%



d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>f</sub> [mm/min]	Q [cm <sup>3</sup> /min]
10	3	173	0.060	30	2.0	5505	990	59.5
12	3	173	0.090	36	2.4	4590	1240	107.0
16	3	173	0.120	48	3.2	3440	1240	190.5
20	3	173	0.145	60	4.0	2755	1200	288.0
25	3	173	0.185	75	5.0	2205	1225	459.5

Reinkupfer



10	3	73	0.060	30	2.0	2325	420	25.0
12	3	73	0.090	36	2.4	1935	520	45.0
16	3	73	0.120	48	3.2	1450	520	80.0
20	3	73	0.145	60	4.0	1160	505	121.0
25	3	73	0.185	75	5.0	930	515	193.0

Thermoplaste



10	3	183	0.060	30	2.0	5825	1050	63.0
12	3	183	0.090	36	2.4	4855	1310	113.0
16	3	183	0.120	48	3.2	3640	1310	201.0
20	3	183	0.145	60	4.0	2915	1270	305.0
25	3	183	0.185	75	5.0	2330	1295	485.5

## Anwendung



## Werkstoff

Al-Knetlegierung  
Si < 6%



d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>f</sub> [mm/min]	Q [cm <sup>3</sup> /min]
10	3	157	0.050	5	10	5000	750	37.5
12	3	157	0.070	6.0	12	4165	875	63.0
16	3	157	0.095	8.0	16	3125	890	114.0
20	3	157	0.120	10.0	20	2500	900	180.0
25	3	157	0.145	12.5	25	2000	870	272.0

Reinkupfer



10	3	68	0.050	5.0	10	2165	325	16.5
12	3	68	0.070	6.0	12	1805	380	27.5
16	3	68	0.095	8.0	16	1355	385	49.5
20	3	68	0.120	10.0	20	1080	390	78.0
25	3	68	0.145	12.5	25	865	375	117.0

Thermoplaste



10	3	168	0.050	5.0	10	5350	805	40.5
12	3	168	0.070	6.0	12	4455	935	67.5
16	3	168	0.095	8.0	16	3340	950	121.5
20	3	168	0.120	10.0	20	2675	965	193.0
25	3	168	0.145	12.5	25	2140	930	290.5