





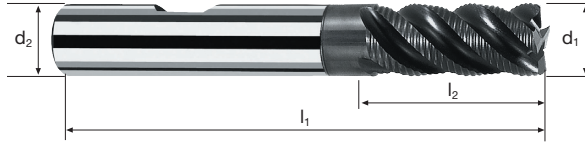


Zylindrische Fräser Supracut FP

Profiliert, normale Ausführung

HSS

HSS PM/F	λ 45° γ 2°
	
	
	



Schuppen



Schichten



Rm
< 850

Rm
850-1100

Rm
1100-1300

Inox
Stainless

Beispiel: Bestell-Nr.								POLYCHROM
		Beschichtung P	Artikel-Nr. 0540	Ø-Code 300				P0540
\emptyset Code	d1 k8	d2 h6	l1	l2	45°	z		
300	6	6	57	13	0.35	4		●
391	8	8	63	19	0.45	4		●
450	10	10	72	22	0.60	4		●
501	12	12	83	26	0.60	4		●
610	16	16	92	32	0.70	4		●
682	20	20	104	38	0.70	4		●
772	25	25	121	45	0.85	4		●

Anwendung

Werkstoff

Stahl
< 850 N/mm²

d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]
6	4	68	0.030	9.0	2	3610	435	9.5
8	4	68	0.040	12.0	3	2705	435	16.5
10	4	68	0.050	15.0	4	2165	435	26.0
12	4	68	0.080	18.0	5	1805	580	50.0
16	4	68	0.105	24.0	6	1355	570	87.5
20	4	68	0.130	30.0	8	1080	560	134.5
25	4	68	0.165	37.5	10	865	570	214.0

Stahl
850 - 1100 N/mm²

6	4	52	0.030	9.0	2	2760	330	7.0
8	4	52	0.040	12.0	3	2070	330	12.5
10	4	52	0.050	15.0	4	1655	330	20.0
12	4	52	0.080	18.0	5	1380	440	38.0
16	4	52	0.105	24.0	6	1035	435	67.0
20	4	52	0.130	30.0	8	830	430	103.0
25	4	52	0.165	37.5	10	660	435	163.0

Stahl
1100 - 1300 N/mm²

6	4	40	0.030	9.0	2	2120	255	5.5
8	4	40	0.040	12.0	3	1590	255	10.0
10	4	40	0.050	15.0	4	1275	255	15.5
12	4	40	0.080	18.0	5	1060	340	29.5
16	4	40	0.105	24.0	6	795	335	51.5
20	4	40	0.130	30.0	8	635	330	79.0
25	4	40	0.165	37.5	10	510	335	125.5

Nichtrostender Stahl
[Cr-Ni/1.4301]

6	4	30	0.030	9.0	2	1590	190	4.0
8	4	30	0.040	12.0	3	1195	190	7.5
10	4	30	0.050	15.0	4	955	190	11.5
12	4	30	0.080	18.0	5	795	255	22.0
16	4	30	0.105	24.0	6	595	250	38.5
20	4	30	0.130	30.0	8	475	245	59.0
25	4	30	0.165	37.5	10	380	250	94.0

Anwendung

Werkstoff

Stahl
< 850 N/mm²

d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]
6	4	62	0.020	6	6	3290	265	9.5
8	4	62	0.030	8	8	2465	295	19.0
10	4	62	0.035	10	10	1975	275	27.5
12	4	62	0.060	12	12	1645	395	57.0
16	4	62	0.080	16	16	1235	395	101.0
20	4	62	0.100	20	20	985	395	158.0
25	4	62	0.125	25	25	790	395	247.0

Stahl
850 - 1100 N/mm²

6	4	50	0.020	6	6	2655	210	7.5
8	4	50	0.030	8	8	1990	240	15.5
10	4	50	0.035	10	10	1590	225	22.5
12	4	50	0.060	12	12	1325	320	46.0
16	4	50	0.080	16	16	995	320	82.0
20	4	50	0.100	20	20	795	320	128.0
25	4	50	0.125	25	25	635	320	200.0

Stahl
1100 - 1300 N/mm²

6	4	37	0.020	6	6	1965	155	5.5
8	4	37	0.030	8	8	1470	175	11.0
10	4	37	0.035	10	10	1180	165	16.5
12	4	37	0.060	12	12	980	235	34.0
16	4	37	0.080	16	16	735	235	60.0
20	4	37	0.100	20	20	590	235	94.0
25	4	37	0.125	25	25	470	235	147.0

Nichtrostender Stahl
[Cr-Ni/1.4301]

6	4	25	0.020	6	6	1325	105	4.0
8	4	25	0.030	8	8	995	120	7.5
10	4	25	0.035	10	10	795	110	11.0
12	4	25	0.060	12	12	665	160	23.0
16	4	25	0.080	16	16	495	160	41.0
20	4	25	0.100	20	20	400	160	64.0
25	4	25	0.125	25	25	320	160	100.0