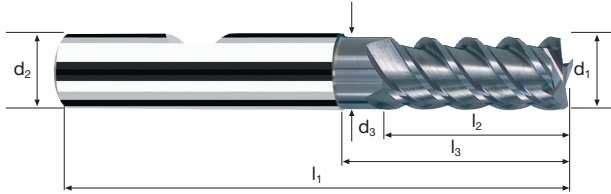


Zylindrische Fräser

Glattschneidig, normale Ausführung mit Kurzhals



**HM
MG10** λ 55°
 γ 15°



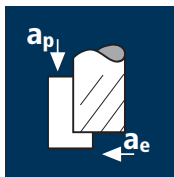
Schuppen

Schichten

Rm < 850	Rm 850-1100	Rm 1100-1300				Inox Stainless	Ti Titanium	GG(G)
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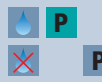
ø Code	d1 e8	d2 h6	d3	l1	l2	l3	45°	α	z	POLYCHROM	
180	3	6	2.8	57	8	14	0.10	4.5°	4		●
220	4	6	3.7	57	11	16	0.10	3.0°	4		●
260	5	6	4.6	57	13	18	0.15	1.5°	4		●
300	6	6	5.5	57	13	20	0.15	0.0°	4		●
391	8	8	7.4	63	19	26	0.15	0.0°	4		●
450	10	10	9.2	72	22	31	0.20	0.0°	4		●
501	12	12	11.0	83	26	37	0.20	0.0°	4		●
570	14	14	13.0	83	26	37	0.20	0.0°	4		●
610	16	16	15.0	92	32	43	0.20	0.0°	4		●
640	18	18	17.0	92	32	43	0.20	0.0°	4		●
682	20	20	19.0	104	38	53	0.20	0.0°	4		●

Anwendung

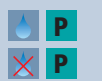


Werkstoff

Stahl
< 850 N/mm²



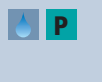
Stahl
850 - 1100 N/mm²



Nichtrostender Stahl
[Cr-Ni/1.4301]

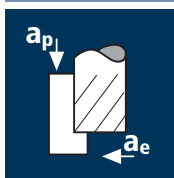


Titanlegierungen ausg.
>300 HB
[Ti6Al4V]



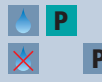
d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
4	4	160	0.015	6.0	1.0	12735	765
6	4	160	0.020	9.0	1.5	8490	680
8	4	160	0.025	12.0	2.0	6365	635
10	4	160	0.035	15.0	2.5	5095	715
12	4	160	0.040	18.0	3.0	4245	680
14	4	160	0.045	21.0	3.5	3640	655
16	4	160	0.055	24.0	4.0	3185	700
18	4	160	0.060	27.0	4.5	2830	680
20	4	160	0.065	30.0	5.0	2545	660
4	4	120	0.015	6.0	1.0	9550	575
6	4	120	0.020	9.0	1.5	6365	510
8	4	120	0.025	12.0	2.0	4775	480
10	4	120	0.035	15.0	2.5	3820	535
12	4	120	0.040	18.0	3.0	3185	510
14	4	120	0.045	21.0	3.5	2730	490
16	4	120	0.055	24.0	4.0	2385	525
18	4	120	0.060	27.0	4.5	2120	510
20	4	120	0.065	30.0	5.0	1910	495
4	4	90	0.015	6.0	1.0	7160	430
6	4	90	0.020	9.0	1.5	4775	380
8	4	90	0.025	12.0	2.0	3580	360
10	4	90	0.035	15.0	2.5	2865	400
12	4	90	0.040	18.0	3.0	2385	380
14	4	90	0.045	21.0	3.5	2045	370
16	4	90	0.055	24.0	4.0	1790	395
18	4	90	0.060	27.0	4.5	1590	380
20	4	90	0.065	30.0	5.0	1430	370
4	4	50	0.015	6.0	1.0	3980	240
6	4	50	0.020	9.0	1.5	2655	210
8	4	50	0.025	12.0	2.0	1990	200
10	4	50	0.035	15.0	2.5	1590	225
12	4	50	0.040	18.0	3.0	1325	210
14	4	50	0.045	21.0	3.5	1135	205
16	4	50	0.055	24.0	4.0	995	220
18	4	50	0.060	27.0	4.5	885	210
20	4	50	0.065	30.0	5.0	795	205

Anwendung



Werkstoff

Stahl
< 850 N/mm²



Stahl
850 - 1100 N/mm²



Nichtrostender Stahl
[Cr-Ni/1.4301]



Titanlegierungen ausg.
>300 HB
[Ti6Al4V]



d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
4	4	170	0.010	6.0	0.10	13530	540
6	4	170	0.015	9.0	0.10	9020	540
8	4	170	0.025	12.0	0.15	6765	675
10	4	170	0.030	15.0	0.15	5410	650
12	4	170	0.035	18.0	0.20	4510	630
14	4	170	0.040	21.0	0.20	3865	620
16	4	170	0.045	24.0	0.25	3380	610
18	4	170	0.050	27.0	0.25	3005	600
20	4	170	0.055	30.0	0.30	2705	595
4	4	140	0.010	6.0	0.10	11140	445
6	4	140	0.015	9.0	0.10	7425	445
8	4	140	0.025	12.0	0.15	5570	555
10	4	140	0.030	15.0	0.15	4455	535
12	4	140	0.035	18.0	0.20	3715	520
14	4	140	0.040	21.0	0.20	3185	510
16	4	140	0.045	24.0	0.25	2785	500
18	4	140	0.050	27.0	0.25	2475	495
20	4	140	0.055	30.0	0.30	2230	490
4	4	100	0.010	6.0	0.10	7960	320
6	4	100	0.015	9.0	0.10	5305	320
8	4	100	0.025	12.0	0.15	3980	400
10	4	100	0.030	15.0	0.15	3185	380
12	4	100	0.035	18.0	0.20	2655	370
14	4	100	0.040	21.0	0.20	2275	365
16	4	100	0.045	24.0	0.25	1990	360
18	4	100	0.050	27.0	0.25	1770	355
20	4	100	0.055	30.0	0.30	1590	350
4	4	60	0.010	6.0	0.10	4775	190
6	4	60	0.015	9.0	0.10	3185	190
8	4	60	0.025	12.0	0.15	2385	240
10	4	60	0.030	15.0	0.15	1910	230
12	4	60	0.035	18.0	0.20	1590	225
14	4	60	0.040	21.0	0.20	1365	220
16	4	60	0.045	24.0	0.25	1195	215
18	4	60	0.050	27.0	0.25	1060	210
20	4	60	0.055	30.0	0.30	955	210