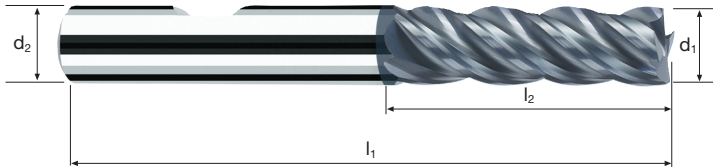
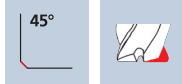


Zylindrische Fräser NF-NV

Glattschneidig, mittellange Ausführung



HM	λ 40° γ 6°
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Schruppen



Schichten



Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless	Ti Titanium	GG(G) Tool Steel Nickel Alloys
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Beispiel: Bestell-Nr.		Beschichtung P	Artikel-Nr. 45322	α -Code 140						
\emptyset Code	d1 e8	d2 h6	l1	l2	45°	α	z			
140	2.0	6	63	12	0.10	6.0°	4			POLYCHROM
160	2.5	6	63	12	0.10	5.0°	4			P45322
180	3.0	6	63	13	0.10	4.5°	4			P45222
220	4.0	6	63	13	0.10	3.5°	4			
260	5.0	6	63	16	0.15	1.5°	4			
300	6.0	6	63	21	0.15	0.0°	4			
391	8.0	8	72	31	0.15	0.0°	4			
450	10.0	10	84	37	0.20	0.0°	4			
501	12.0	12	97	44	0.20	0.0°	4			
570	14.0	14	102	48	0.20	0.0°	4			
610	16.0	16	108	53	0.20	0.0°	4			
682	20.0	20	122	62	0.20	0.0°	4			
772	25.0	25	144	72	0.20	0.0°	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]
3	4	170	0.010	5.4	0.6	18040	720	2.5
4	4	170	0.015	7.2	0.8	13530	810	4.5
5	4	170	0.020	9.0	1.0	10825	865	8.0
6	4	170	0.025	10.8	1.2	9020	900	11.5
8	4	170	0.035	14.4	1.6	6765	945	22.0
10	4	170	0.045	18.0	2.0	5410	975	35.0
12	4	170	0.050	21.6	2.4	4510	900	46.5
16	4	170	0.065	28.8	3.2	3380	880	81.0
20	4	170	0.080	36.0	4.0	2705	865	124.5

Stahl
850 - 1100 N/mm²

3	4	120	0.010	5.4	0.6	12735	510	1.5
4	4	120	0.015	7.2	0.8	9550	575	3.5
5	4	120	0.020	9.0	1.0	7640	610	5.5
6	4	120	0.025	10.8	1.2	6365	635	8.0
8	4	120	0.035	14.4	1.6	4775	670	15.5
10	4	120	0.045	18.0	2.0	3820	690	25.0
12	4	120	0.050	21.6	2.4	3185	635	33.0
16	4	120	0.065	28.8	3.2	2385	620	57.0
20	4	120	0.080	36.0	4.0	1910	610	88.0

Nichtrostender Stahl
[Cr-Ni/1.4301]

3	4	80	0.005	5.4	0.6	8490	170	0.5
4	4	80	0.010	7.2	0.8	6365	255	1.5
5	4	80	0.015	9.0	1.0	5095	305	2.5
6	4	80	0.015	10.8	1.2	4245	255	3.5
8	4	80	0.025	14.4	1.6	3185	320	7.5
10	4	80	0.030	18.0	2.0	2545	305	11.0
12	4	80	0.035	21.6	2.4	2120	295	15.5
16	4	80	0.045	28.8	3.2	1590	285	26.5
20	4	80	0.055	36.0	4.0	1275	280	40.5

Gusseisen
GG(G)

3	4	135	0.010	5.4	0.6	14325	575	2.0
4	4	135	0.015	7.2	0.8	10745	645	3.5
5	4	135	0.020	9.0	1.0	8595	690	6.0
6	4	135	0.030	10.8	1.2	7160	860	11.0
8	4	135	0.040	14.4	1.6	5370	860	20.0
10	4	135	0.050	18.0	2.0	4295	860	31.0
12	4	135	0.055	21.6	2.4	3580	790	41.0
16	4	135	0.070	28.8	3.2	2685	750	69.0
20	4	135	0.090	36.0	4.0	2150	775	111.5

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]
3	4	135	0.010	3.0	3	14325	575	5.0
4	4	135	0.010	4.0	4	10745	430	7.0
5	4	135	0.015	5.0	5	8595	515	13.0
6	4	135	0.020	6.0	6	7160	575	20.5
8	4	135	0.025	8.0	8	5370	535	34.0
10	4	135	0.035	10.0	10	4295	600	60.0
12	4	135	0.040	12.0	12	3580	575	83.0
16	4	135	0.050	8.0	16	2685	535	68.5
20	4	135	0.060	10.0	20	2150	515	103.0

Stahl
850 - 1100 N/mm²

3	4	95	0.010	3.0	3	10080	405	3.5
4	4	95	0.010	4.0	4	7560	300	5.0
5	4	95	0.015	5.0	5	6050	365	9.0
6	4	95	0.020	6.0	6	5040	405	14.5
8	4	95	0.025	8.0	8	3780	380	24.5
10	4	95	0.035	10.0	10	3025	425	42.5
12	4	95	0.040	12.0	12	2520	405	58.5
16	4	95	0.050	8.0	16	1890	380	48.5
20	4	95	0.060	10.0	20	1510	360	72.0

Nichtrostender Stahl
[Cr-Ni/1.4301]

3	4	65	0.005	2.1	3	6895	140	1.0
4	4	65	0.010	2.8	4	5175	205	2.5
5	4	65	0.010	3.5	5	4140	165	3.0
6	4	65	0.010	4.2	6	3450	140	3.5
8	4	65	0.020	8.0	8	2585	205	13.0
10	4	65	0.025	10.0	10	2070	205	20.5
12	4	65	0.025	12.0	12	1725	175	25.0
16	4	65	0.035	8.0	16	1295	180	23.0
20	4	65	0.040	10.0	20	1035	165	33.0

Gusseisen
GG(G)

3	4	115	0.010	3.0	3	12200	490	4.5
4	4	115	0.010	4.0	4	9150	365	6.0
5	4	115	0.015	5.0	5	7320	440	11.0
6	4	115	0.025	6.0	6	6100	610	22.0
8	4	115	0.030	8.0	8	4575	550	35.0
10	4	115	0.040	10.0	10	3660	585	58.5
12	4	115	0.040	12.0	12	3050	490	70.5
16	4	115	0.055	8.0	16	2290	505	64.5
20	4	115	0.070	10.0	20	1830	510	102.0