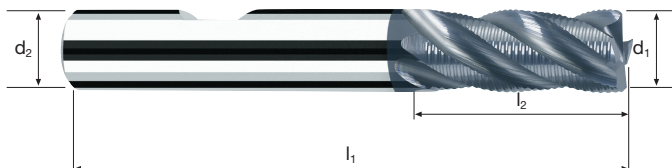
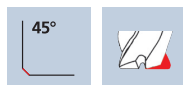


Zylindrische Fräser NF-RP

Profiliert, normale Ausführung



HM λ 38°
 γ 0°



Schruppen



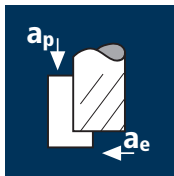
Schichten



Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless	Ti Titanium	GG(G)
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Beispiel: Bestell-Nr.									POLYCHROM	
									P45371	
									P45371	
									P45371	
\emptyset Code	d1 e8	d2 h6	l1	l2	45°	α	z			
180	3	6	57	8	0.25	6.0°	3	●		
220	4	6	57	11	0.30	4.0°	3	●		
260	5	6	57	13	0.35	2.0°	4	●		
300	6	6	57	13	0.35	0.0°	4	●		
391	8	8	63	19	0.45	0.0°	4	●		
450	10	10	72	22	0.60	0.0°	4	●		
501	12	12	83	26	0.60	0.0°	4	●		
610	16	16	92	32	0.70	0.0°	4	●		
612	16	16	92	32	0.70	0.0°	6	●		
682	20	20	104	38	0.70	0.0°	4	●		
684	20	20	104	38	0.70	0.0°	6	●		

Anwendung



Werkstoff

Stahl
< 850 N/mm²

Stahl
850 - 1100 N/mm²

Titanlegierungen ausg.
>300 HB
[Ti6Al4V]

Nichtrostender Stahl
[Cr-Ni/1.4301]

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	3	180	0.015	3.6	1.8	19100	860	5.5
4	3	180	0.020	4.8	2.4	14325	860	10.0
5	4	180	0.025	6.0	3.0	11460	1145	20.5
6	4	180	0.030	7.2	3.6	9550	1145	29.5
8	4	180	0.040	9.6	4.8	7160	1145	53.0
10	4	180	0.050	12.0	6.0	5730	1145	82.5
12	4	180	0.055	14.4	7.2	4775	1050	109.0
16	4	180	0.055	19.2	9.6	3580	790	145.5
20	4	180	0.060	24.0	12.0	2865	690	198.5

3	3	130	0.015	3.6	1.8	13795	620	4.0
4	3	130	0.020	4.8	2.4	10345	620	7.0
5	4	130	0.025	6.0	3.0	8275	830	15.0
6	4	130	0.030	7.2	3.6	6895	825	21.5
8	4	130	0.040	9.6	4.8	5175	830	38.0
10	4	130	0.050	12.0	6.0	4140	830	60.0
12	4	130	0.055	14.4	7.2	3450	760	79.0
16	4	130	0.055	19.2	9.6	2585	570	105.0
20	4	130	0.060	24.0	12.0	2070	495	142.5

3	3	45	0.010	3.6	1.8	4775	145	1.0
4	3	45	0.015	4.8	2.4	3580	160	2.0
5	4	45	0.020	6.0	3.0	2865	230	4.0
6	4	45	0.025	7.2	3.6	2385	240	6.0
8	4	45	0.030	9.6	4.8	1790	215	10.0
10	4	45	0.040	12.0	6.0	1430	230	16.5
12	4	45	0.045	14.4	7.2	1195	215	22.5
16	4	45	0.045	19.2	9.6	895	160	29.5
20	4	45	0.050	24.0	12.0	715	145	42.0

3	3	55	0.010	3.6	1.8	5835	175	1.0
4	3	55	0.015	4.8	2.4	4375	195	2.0
5	4	55	0.020	6.0	3.0	3500	280	5.0
6	4	55	0.025	7.2	3.6	2920	290	7.5
8	4	55	0.030	9.6	4.8	2190	265	12.0
10	4	55	0.040	12.0	6.0	1750	280	20.0
12	4	55	0.045	14.4	7.2	1460	265	27.5
16	4	55	0.045	19.2	9.6	1095	195	36.0
20	4	55	0.050	24.0	12.0	875	175	50.5

Anwendung



Werkstoff

Stahl
< 850 N/mm²

Stahl
850 - 1100 N/mm²

Titanlegierungen ausg.
>300 HB
[Ti6Al4V]

Nichtrostender Stahl
[Cr-Ni/1.4301]

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	3	150	0.015	3.0	3	15915	715	6.5
4	3	150	0.020	4.0	4	11935	715	11.5
5	4	150	0.025	5.0	5	9550	955	24.0
6	4	150	0.030	6.0	6	7960	955	34.5
8	4	150	0.040	8.0	8	5970	955	61.0
10	4	150	0.050	10.0	10	4775	955	95.5
12	4	150	0.055	12.0	12	3980	875	126.0
16	4	150	0.055	16.0	16	2985	655	167.5
20	4	150	0.060	20.0	20	2385	570	228.0

3	3	80	0.015	3.0	3	8490	380	3.5
4	3	80	0.020	4.0	4	6365	380	6.0
5	4	80	0.025	5.0	5	5095	510	13.0
6	4	80	0.030	6.0	6	4245	510	18.5
8	4	80	0.040	8.0	8	3185	510	32.5
10	4	80	0.050	10.0	10	2545	510	51.0
12	4	80	0.055	12.0	12	2120	465	67.0
16	4	80	0.055	16.0	16	1590	350	89.5
20	4	80	0.060	20.0	20	1275	305	122.0

3	3	35	0.010	3.0	3	3715	110	1.0
4	3	35	0.015	4.0	4	2785	125	2.0
5	4	35	0.020	5.0	5	2230	180	4.5
6	4	35	0.025	6.0	6	1855	185	6.5
8	4	35	0.030	8.0	8	1395	165	10.5
10	4	35	0.040	10.0	10	1115	180	18.0
12	4	35	0.045	12.0	12	930	165	24.0
16	4	35	0.045	16.0	16	695	125	32.0
20	4	35	0.050	20.0	20	555	110	44.0

3	3	45	0.010	3.0	3	4775	145	1.5
4	3	45	0.015	4.0	4	3580	160	2.5
5	4	45	0.020	5.0	5	2865	230	6.0
6	4	45	0.025	6.0	6	2385	240	8.5
8	4	45	0.030	8.0	8	1790	215	14.0
10	4	45	0.040	10.0	10	1430	230	23.0
12	4	45	0.045	12.0	12	1195	215	31.0
16	4	45	0.045	16.0	16	895	160	41.0
20	4	45	0.050	20.0	20	715	145	58.0