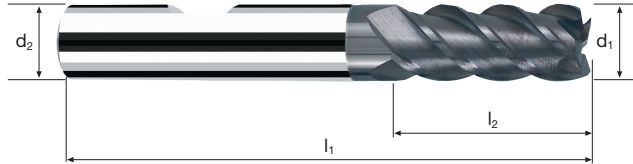


Zylindrische Fräser

Glattschneidig, normale Ausführung

HM
MG10 λ 45°
 γ 15°



Schruppen



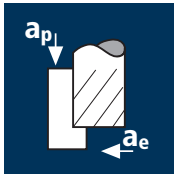
Schichten



Rm < 850	Rm 850-1100	Rm 1100-1300				Inox Stainless	Ti Titanium	GG(G) Copper
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Ø Code	d1 e8	d2 h6	l1	l2	45°	α	z	Beispiel: Bestell-Nr.	
								Beschichtung P	Artikel-Nr. 5340
									POLYCHROM
									P5340
									P5240
140	2.0	6	54	7	0.10	7.5°	4		●
160	2.5	6	54	8	0.10	6.5°	4		●
178 *	3.0	3	45	8	0.10	0.0°	4		●
180	3.0	6	57	8	0.10	6.0°	4		●
218 *	4.0	4	50	11	0.10	0.0°	4		●
220	4.0	6	57	11	0.10	3.5°	4		●
258 *	5.0	5	50	13	0.15	0.0°	4		●
260	5.0	6	57	13	0.15	2.0°	4		●
300	6.0	6	57	13	0.15	0.0°	4		●
331	7.0	8	63	16	0.15	1.5°	4		●
391	8.0	8	63	19	0.15	0.0°	4		●
420	9.0	10	72	19	0.20	1.5°	4		●
450	10.0	10	72	22	0.20	0.0°	4		●
501	12.0	12	83	26	0.20	0.0°	4		●
570	14.0	14	83	26	0.20	0.0°	4		●
610	16.0	16	92	32	0.20	0.0°	4		●
640	18.0	18	92	32	0.20	0.0°	4		●
682	20.0	20	104	38	0.20	0.0°	4		●
* nur ohne Seitenspannfläche									

Anwendung



Werkstoff

Stahl
< 850 N/mm²



Stahl
850 - 1100 N/mm²



Stahl
1100 - 1300 N/mm²



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]
3	4	160	0.010	4.5	0.3	16975	680
4	4	160	0.015	6.0	0.4	12735	765
5	4	160	0.015	7.5	0.5	10185	610
6	4	160	0.020	9.0	0.6	8490	680
8	4	160	0.025	12.0	0.8	6365	635
10	4	160	0.035	15.0	1.0	5095	715
12	4	160	0.040	18.0	1.2	4245	680
16	4	160	0.055	24.0	1.6	3185	700
20	4	160	0.065	30.0	2.0	2545	660
3	4	100	0.010	4.5	0.3	10610	425
4	4	100	0.015	6.0	0.4	7960	480
5	4	100	0.015	7.5	0.5	6365	380
6	4	100	0.020	9.0	0.6	5305	425
8	4	100	0.025	12.0	0.8	3980	400
10	4	100	0.035	15.0	1.0	3185	445
12	4	100	0.040	18.0	1.2	2655	425
16	4	100	0.055	24.0	1.6	1990	440
20	4	100	0.065	30.0	2.0	1590	415
3	4	75	0.010	4.5	0.3	7960	320
4	4	75	0.015	6.0	0.4	5970	360
5	4	75	0.015	7.5	0.5	4775	285
6	4	75	0.020	9.0	0.6	3980	320
8	4	75	0.025	12.0	0.8	2985	300
10	4	75	0.035	15.0	1.0	2385	335
12	4	75	0.040	18.0	1.2	1990	320
16	4	75	0.055	24.0	1.6	1490	330
20	4	75	0.065	30.0	2.0	1195	310
3	4	90	0.010	4.5	0.3	9550	380
4	4	90	0.015	6.0	0.4	7160	430
5	4	90	0.015	7.5	0.5	5730	345
6	4	90	0.020	9.0	0.6	4775	380
8	4	90	0.025	12.0	0.8	3580	360
10	4	90	0.035	15.0	1.0	2865	400
12	4	90	0.040	18.0	1.2	2385	380
16	4	90	0.055	24.0	1.6	1790	395
20	4	90	0.065	30.0	2.0	1430	370

Werkstoff

Gusseisen
GG(G)



Reinkupfer



Titanlegierungen
bis 300 HB
[Ti5Al2.5Sn]



Hitzebeständiger Stahl
Duplex Stahl
[1.4462]
[17-4 PH]



d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
3	4	120	0.010	4.5	0.3	12735	510
4	4	120	0.015	6.0	0.4	9550	575
5	4	120	0.015	7.5	0.5	7640	460
6	4	120	0.020	9.0	0.6	6365	510
8	4	120	0.025	12.0	0.8	4775	480
10	4	120	0.035	15.0	1.0	3820	535
12	4	120	0.040	18.0	1.2	3185	510
16	4	120	0.055	24.0	1.6	2385	525
20	4	120	0.065	30.0	2.0	1910	495
3	4	230	0.010	4.5	0.3	24405	975
4	4	230	0.015	6.0	0.4	18305	1100
5	4	230	0.015	7.5	0.5	14645	880
6	4	230	0.020	9.0	0.6	12200	975
8	4	230	0.025	12.0	0.8	9150	915
10	4	230	0.035	15.0	1.0	7320	1025
12	4	230	0.040	18.0	1.2	6100	975
16	4	230	0.055	24.0	1.6	4575	1005
20	4	230	0.065	30.0	2.0	3660	950
3	4	95	0.010	4.5	0.3	10080	405
4	4	95	0.015	6.0	0.4	7560	455
5	4	95	0.015	7.5	0.5	6050	365
6	4	95	0.020	9.0	0.6	5040	405
8	4	95	0.025	12.0	0.8	3780	380
10	4	95	0.035	15.0	1.0	3025	425
12	4	95	0.040	18.0	1.2	2520	405
16	4	95	0.055	24.0	1.6	1890	415
20	4	95	0.065	30.0	2.0	1510	395
3	4	50	0.010	4.5	0.3	5305	210
4	4	50	0.015	6.0	0.4	3980	240
5	4	50	0.015	7.5	0.5	3185	190
6	4	50	0.020	9.0	0.6	2655	210
8	4	50	0.025	12.0	0.8	1990	200
10	4	50	0.035	15.0	1.0	1590	225
12	4	50	0.040	18.0	1.2	1325	210
16	4	50	0.055	24.0	1.6	995	220
20	4	50	0.065	30.0	2.0	795	205