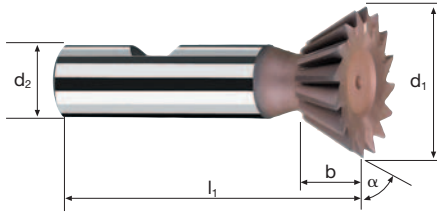


Winkelfräser



HSS-E	λ 0°
Co8	γ 0°

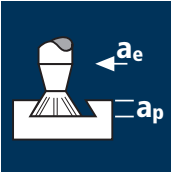


Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless	Ti Titanium	GG(G) Aluminium Copper
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Beispiel: Bestell-Nr.		Beschichtung U	Artikel-Nr. 0890	ø-Code .100				UNICUT-4X
ø Code	d1 js12	d2 h6	l1	b	α (±20°)	z		
.100	12	10	54	3.0	45°	8	●	
.120	16	12	60	4.0	45°	10	●	
.140	20	12	63	5.0	45°	12	●	
.160	25	12	67	6.3	45°	14	●	
.180	32	16	71	8.0	45°	16	●	
.300	8	6	49	3.0	60°	7	●	
.320	12	10	54	4.0	60°	8	●	
.340	16	12	60	6.3	60°	10	●	
.360	20	12	63	8.0	60°	12	●	
.380	25	12	67	10.0	60°	14	●	
.400	32	16	71	12.5	60°	16	●	

VI

Anwendung



Werkstoff

Stahl
< 850 N/mm²



Stahl
850 - 1100 N/mm²



Stahl
1100 - 1300 N/mm²



Nichtrostender Stahl
[Cr-Ni/1.4301]



Werkstoff

Gusseisen
GG(G)



Reinkupfer



Titanlegierungen
bis 300 HB
[Ti5Al2.5Sn]



Al-Knetlegierung
Si < 6%



d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
8	7	55	0.005	2.5	1.5	2190	75
12	8	55	0.010	3.0	2.0	1460	115
16	10	55	0.015	4.0	2.2	1095	165
20	12	55	0.018	6.0	2.4	875	190
25	14	55	0.020	8.0	2.6	700	195
32	16	55	0.025	10.0	3.0	545	220

8	7	45	0.005	2.5	1.5	1790	65
12	8	45	0.010	3.0	2.0	1195	95
16	10	45	0.015	4.0	2.2	895	135
20	12	45	0.018	6.0	2.4	715	155
25	14	45	0.020	8.0	2.6	575	160
32	16	45	0.025	10.0	3.0	450	180

8	7	34	0.005	2.5	1.5	1355	45
12	8	34	0.010	3.0	2.0	900	70
16	10	34	0.015	4.0	2.2	675	100
20	12	34	0.018	6.0	2.4	540	115
25	14	34	0.020	8.0	2.6	435	120
32	16	34	0.025	10.0	3.0	340	135

8	7	21	0.005	2.5	1.5	835	30
12	8	21	0.010	3.0	2.0	555	45
16	10	21	0.015	4.0	2.2	420	65
20	12	21	0.018	6.0	2.4	335	70
25	14	21	0.020	8.0	2.6	265	75
32	16	21	0.025	10.0	3.0	210	85

d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
8	7	42	0.005	2.5	1.5	1670	60
12	8	42	0.010	3.0	2.0	1115	90
16	10	42	0.015	4.0	2.2	835	125
20	12	42	0.018	6.0	2.4	670	145
25	14	42	0.020	8.0	2.6	535	150
32	16	42	0.025	10.0	3.0	420	170

8	7	65	0.005	2.5	1.5	2585	90
12	8	65	0.010	3.0	2.0	1725	140
16	10	65	0.015	4.0	2.2	1295	195
20	12	65	0.018	6.0	2.4	1035	225
25	14	65	0.020	8.0	2.6	830	230
32	16	65	0.025	10.0	3.0	645	260

8	7	23	0.005	2.5	1.5	915	30
12	8	23	0.010	3.0	2.0	610	50
16	10	23	0.015	4.0	2.2	460	70
20	12	23	0.018	6.0	2.4	365	80
25	14	23	0.020	8.0	2.6	295	85
32	16	23	0.025	10.0	3.0	230	90

8	7	80	0.005	2.5	1.5	3185	110
12	8	80	0.010	3.0	2.0	2120	170
16	10	80	0.015	4.0	2.2	1590	240
20	12	80	0.018	6.0	2.4	1275	275
25	14	80	0.020	8.0	2.6	1020	285
32	16	80	0.025	10.0	3.0	795	320