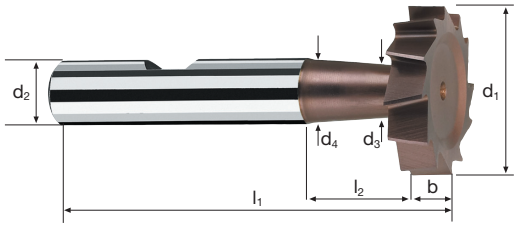
Schlitzfräser

HSS

HSS-E Co8	λ 10° γ 8°



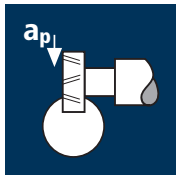
Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless	Ti Titanium	GG(G) Aluminium Copper

Beispiel: **Bestell-Nr.** Beschichtung **U** Artikel-Nr. **0905** ø-Code **100**

ø Code	d1 h11	d2 h6	d3	d4	l1	l2	b e8	z		UNICUT-4X U0905
100	4.5	6	1.8	5.5	50	12	1.0	8		●
150	7.5	6	2.8	5.5	50	11	1.5	8		●
160	7.5	6	3.2	5.5	50	10	2.0	8		●
200	10.5	6	4.0	5.5	50	11	2.0	8		●
210	10.5	6	4.0	5.5	50	10	2.5	8		●
220	10.5	6	4.2	5.5	50	9	3.0	8		●
310	13.5	10	4.6	9.5	56	13	2.5	8		●
320	13.5	10	4.6	9.5	56	12	3.0	8		●
330	13.5	10	4.6	9.5	56	11	4.0	8		●
360	16.5	10	4.6	9.5	56	12	3.0	8		●
370	16.5	10	4.6	9.5	56	11	4.0	8		●
380	16.5	10	5.0	9.5	56	10	5.0	8		●
410	19.5	10	5.6	9.5	63	18	3.0	10		●
420	19.5	10	5.6	9.5	63	17	4.0	10		●
430	19.5	10	6.0	9.5	63	16	5.0	10		●
440	19.5	10	6.5	9.5	63	15	6.0	10		●
500	22.5	10	6.0	9.5	63	17	4.0	10		●
510	22.5	10	6.0	9.5	63	16	5.0	10		●
520	22.5	10	6.5	9.5	63	15	6.0	10		●
540	22.5	10	6.5	9.5	63	14	8.0	10		●
600	25.5	10	7.5	9.5	63	16	5.0	12		●
610	25.5	10	7.5	9.5	63	15	6.0	12		●

VI

Anwendung



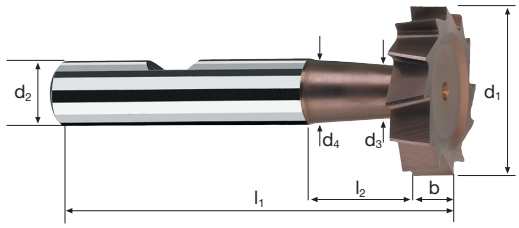
Werkstoff	d1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min⁻¹]	v_f [mm/min]
Stahl < 850 N/mm²	7.5	8	55	0.005	2.0	2.0	2335	95
	10.5	8	55	0.010	2.9	2.5	1665	135
	13.5	8	55	0.010	3.8	3.0	1295	105
	16.5	8	55	0.025	5.0	4.0	1060	210
	19.5	10	55	0.035	5.5	5.0	900	315
	22.5	10	55	0.040	6.6	6.0	780	310
	25.5	12	55	0.045	7.5	6.0	685	370
Stahl 850 - 1100 N/mm²	7.5	8	45	0.005	2.0	2.0	1910	75
	10.5	8	45	0.010	2.9	2.5	1365	110
	13.5	8	45	0.010	3.8	3.0	1060	85
	16.5	8	45	0.025	5.0	4.0	870	175
	19.5	10	45	0.035	5.5	5.0	735	255
	22.5	10	45	0.040	6.6	6.0	635	255
	25.5	12	45	0.045	7.5	6.0	560	300
Stahl 1100 - 1300 N/mm²	7.5	8	34	0.005	2.0	2.0	1445	60
	10.5	8	34	0.010	2.9	2.5	1030	80
	13.5	8	34	0.010	3.8	3.0	800	65
	16.5	8	34	0.025	5.0	4.0	655	130
	19.5	10	34	0.035	5.5	5.0	555	195
	22.5	10	34	0.040	6.6	6.0	480	190
	25.5	12	34	0.045	7.5	6.0	425	230
Nichtrostender Stahl [Cr-Ni/1.4301]	7.5	8	21	0.005	2.0	2.0	890	35
	10.5	8	21	0.010	2.9	2.5	635	50
	13.5	8	21	0.010	3.8	3.0	495	40
	16.5	8	21	0.025	5.0	4.0	405	80
	19.5	10	21	0.035	5.5	5.0	345	120
	22.5	10	21	0.040	6.6	6.0	295	120
	25.5	12	21	0.045	7.5	6.0	260	140

Werkstoff	d1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min⁻¹]	v_f [mm/min]
Gusseisen GG(G)	7.5	8	42	0.005	2.0	2.0	1785	70
	10.5	8	42	0.010	2.9	2.5	1275	100
	13.5	8	42	0.010	3.8	3.0	990	80
	16.5	8	42	0.025	5.0	4.0	810	160
	19.5	10	42	0.035	5.5	5.0	685	240
	22.5	10	42	0.040	6.6	6.0	595	240
	25.5	12	42	0.045	7.5	6.0	525	285
Reinkupfer	7.5	8	65	0.005	2.0	2.0	2760	110
	10.5	8	65	0.010	2.9	2.5	1970	160
	13.5	8	65	0.010	3.8	3.0	1535	125
	16.5	8	65	0.025	5.0	4.0	1255	250
	19.5	10	65	0.035	5.5	5.0	1060	370
	22.5	10	65	0.040	6.6	6.0	920	370
	25.5	12	65	0.045	7.5	6.0	810	435
Titanlegierungen bis 300 HB [Ti5Al2.5Sn]	7.5	8	23	0.005	2.0	2.0	975	40
	10.5	8	23	0.010	2.9	2.5	695	55
	13.5	8	23	0.010	3.8	3.0	540	45
	16.5	8	23	0.025	5.0	4.0	445	90
	19.5	10	23	0.035	5.5	5.0	375	130
	22.5	10	23	0.040	6.6	6.0	325	130
	25.5	12	23	0.045	7.5	6.0	285	155
Al-Knetlegierung Si < 6%	7.5	8	80	0.005	2.0	2.0	3395	135
	10.5	8	80	0.010	2.9	2.5	2425	195
	13.5	8	80	0.010	3.8	3.0	1885	150
	16.5	8	80	0.025	5.0	4.0	1545	310
	19.5	10	80	0.035	5.5	5.0	1305	455
	22.5	10	80	0.040	6.6	6.0	1130	450
	25.5	12	80	0.045	7.5	6.0	1000	540

Schlitzfräser

HSS

HSS-E Co8 | **λ 10° γ 8°**



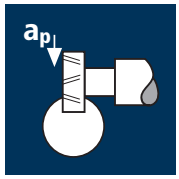
Rm < 850	**Rm** 850-1100	**Rm** 1100-1300					**Inox** Stainless	**Ti** Titanium	**GG(G) Aluminium Copper**

Beispiel: **Bestell-Nr.** Beschichtung **U** Artikel-Nr. **0905** ø-Code **650**

ø Code	d_1 h11	d_2 h6	d_3	d_4	l_1	l_2	b e8	z	UNICUT-4X U0905
650	28.5	10	8.5	9.5	63	14	6.0	12	●
660	28.5	10	8.5	9.5	63	13	8.0	12	●
700	28.5	12	9.3	11.5	71	14	10.0	12	●
750	32.5	12	8.5	11.5	71	18	6.0	12	●
760	32.5	12	8.5	11.5	71	17	7.0	12	●
770	32.5	12	8.5	11.5	71	16	8.0	12	●
800	32.5	12	9.3	11.5	71	15	10.0	12	●
900	45.5	12	11.0	11.5	71	14	10.0	14	●

VI

Anwendung



Werkstoff	d1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min⁻¹]	v_f [mm/min]
Stahl < 850 N/mm²	28.5	12	55	0.050	8.2	8.0	615	370
	32.5	12	55	0.060	9.8	10.0	540	390
	45.5	14	55	0.080	12.0	10.0	385	430
Stahl 850 - 1100 N/mm²	28.5	12	45	0.050	8.2	8.0	505	305
	32.5	12	45	0.060	9.8	10.0	440	315
	45.5	14	45	0.080	12.0	10.0	315	355
Stahl 1100 - 1300 N/mm²	28.5	12	34	0.050	8.2	8.0	380	230
	32.5	12	34	0.060	9.8	10.0	335	240
	45.5	14	34	0.080	12.0	10.0	240	270
Nichtrostender Stahl [Cr-Ni/1.4301]	28.5	12	21	0.050	8.2	8.0	235	140
	32.5	12	21	0.060	9.8	10.0	205	150
	45.5	14	21	0.080	12.0	10.0	145	160

Werkstoff	d1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min⁻¹]	v_f [mm/min]
Gusseisen GG(G)	28.5	12	42	0.050	8.2	8.0	470	280
	32.5	12	42	0.060	9.8	10.0	410	295
	45.5	14	42	0.080	12.0	10.0	295	330
Reinkupfer	28.5	12	65	0.050	8.2	8.0	725	435
	32.5	12	65	0.060	9.8	10.0	635	455
	45.5	14	65	0.080	12.0	10.0	455	510
Titanlegierungen bis 300 HB [Ti5Al2.5Sn]	28.5	12	23	0.050	8.2	8.0	255	155
	32.5	12	23	0.060	9.8	10.0	225	160
	45.5	14	23	0.080	12.0	10.0	160	180
Al-Knetlegierung Si < 6%	28.5	12	80	0.050	8.2	8.0	895	535
	32.5	12	80	0.060	9.8	10.0	785	565
	45.5	14	80	0.080	12.0	10.0	560	625