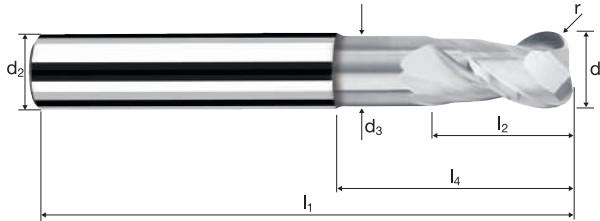
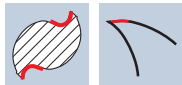
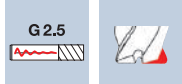


Eckradiusfräser AX (AX-RV2)

Glattschneidig, Ausführung 3xd mit Hals

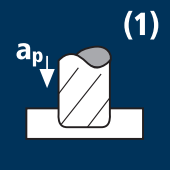

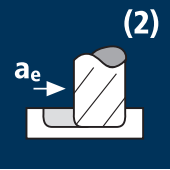

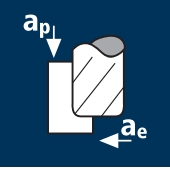

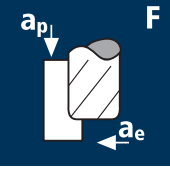





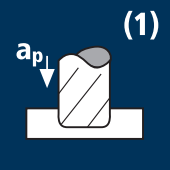

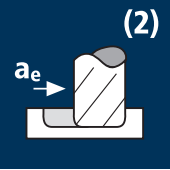

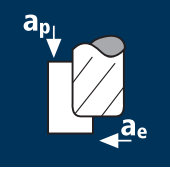

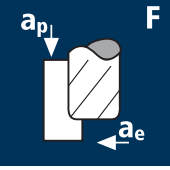



HM
MG10 λ 40°
 γ 20°



		Al Aluminium > 99%	Al Aluminium Alloy	Al Aluminium Cast		Cu Copper	Plastic Thermoplast	
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Beispiel: Bestell-Nr. C 15573 180												CELERO	
												15573	C15573
\emptyset Code	d_1 e8	d_2 h6	d_3	l_1	l_2	l_3	l_4	r 0/+0.03	α	z			
180	3.00	6.00	2.80	54	4.00	9.00	15.37	0.500	5.9°	2	●	●	
220	4.00	6.00	3.70	54	5.00	12.00	16.82	0.500	3.7°	2	●	●	
260	5.00	6.00	4.60	54	6.00	15.00	18.27	0.500	1.7°	2	●	●	
300	6.00	6.00	5.50	54	7.00	16.15	18.00	0.500	0.0°	2	●	●	
302	6.00	6.00	5.50	54	7.00	16.15	18.00	1.000	0.0°	2	●	●	
391	8.00	8.00	7.40	63	9.00	21.63	24.00	1.000	0.0°	2	●	●	
450	10.00	10.00	9.20	72	11.00	26.99	30.00	1.000	0.0°	2	●	●	
501	12.00	12.00	11.00	83	13.00	32.29	36.00	1.000	0.0°	2	●	●	
608	16.00	16.00	15.00	97	18.00	43.73	48.00	1.000	0.0°	2	●	●	
680	20.00	20.00	19.00	111	22.00	55.23	60.00	1.000	0.0°	2	●	●	
770	25.00	25.00	24.00	132	27.00	69.68	75.00	1.000	0.0°	2	●	●	
453	10.00	10.00	9.20	72	11.00	26.99	30.00	1.500	0.0°	2	●	-	
503	12.00	12.00	11.00	83	13.00	32.29	36.00	1.500	0.0°	2	●	-	
611	16.00	16.00	15.00	97	18.00	43.73	48.00	2.000	0.0°	2	●	-	
683	20.00	20.00	19.00	111	22.00	55.23	60.00	2.000	0.0°	2	●	-	

Anwendung	Werkstoff	d1 [mm]	z	f _z [mm]	a _p [mm]	a _e [mm]	n=10000 min ⁻¹ vf [mm/min]	n=15000 min ⁻¹ vf [mm/min]	n=20000 min ⁻¹ vf [mm/min]	n=30000 min ⁻¹ vf [mm/min]
 <p>(1)</p>	Al-Knetlegierung Al-Integralbau 	3.00	2	0.050	2.000	3.000	1000	1500	2000	3000
		4.00	2	0.065	3.000	4.000	1300	1950	2600	3900
		6.00	2	0.100	4.000	6.000	2000	3000	4000	6000
		8.00	2	0.130	5.000	8.000	2600	3900	5200	7800
		10.00	2	0.165	5.500	10.000	3300	4950	6600	9900
		12.00	2	0.195	6.000	12.000	3900	5850	7800	11700
		16.00	2	0.210	6.500	16.000	4200	6300	8400	12600
20.00	2	0.220	7.000	20.000	4400	6600	8800	13200		
25.00	2	0.230	7.000	25.000	4600	6900	9200	13800		
 <p>(2)</p>	Al-Knetlegierung Al-Integralbau 	3.00	2	0.050	2.000	2.400	1000	1500	2000	3000
		4.00	2	0.065	3.000	3.200	1300	1950	2600	3900
		6.00	2	0.100	4.000	4.800	2000	3000	4000	6000
		8.00	2	0.130	5.000	6.400	2600	3900	5200	7800
		10.00	2	0.165	5.500	8.000	3300	4950	6600	9900
		12.00	2	0.195	6.000	9.600	3900	5850	7800	11700
		16.00	2	0.210	6.500	12.800	4200	6300	8400	12600
20.00	2	0.220	7.000	16.000	4400	6600	8800	13200		
25.00	2	0.230	7.000	20.000	4600	6900	9200	13800		
	Al-Knetlegierung Al-Integralbau 	3.00	2	0.050	3.000	1.800	1000	1500	2000	3000
		4.00	2	0.065	4.500	2.400	1300	1950	2600	3900
		6.00	2	0.100	6.000	3.600	2000	3000	4000	6000
		8.00	2	0.130	7.500	4.800	2600	3900	5200	7800
		10.00	2	0.165	8.300	6.000	3300	4950	6600	9900
		12.00	2	0.195	9.000	7.200	3900	5850	7800	11700
		16.00	2	0.210	9.800	9.600	4200	6300	8400	12600
20.00	2	0.220	10.500	12.000	4400	6600	8800	13200		
25.00	2	0.230	10.500	15.000	4600	6900	9200	13800		
 <p>F</p>	Al-Knetlegierung Al-Integralbau 	3.00	2	0.015	3.000	0.100	300	450	600	900
		4.00	2	0.020	4.500	0.100	400	600	800	1200
		6.00	2	0.030	6.000	0.200	600	900	1200	1800
		8.00	2	0.040	7.500	0.250	800	1200	1600	2400
		10.00	2	0.050	8.300	0.300	1000	1500	2000	3000
		12.00	2	0.060	9.000	0.350	1200	1800	2400	3600
		16.00	2	0.065	9.800	0.500	1300	1950	2600	3900
20.00	2	0.065	10.500	0.600	1300	1950	2600	3900		
25.00	2	0.070	10.500	0.750	1400	2100	2800	4200		
	Al-Knetlegierung Al-Integralbau 	3.00	2	0.110	0.300	0.300	2200	3300	4400	6600
		4.00	2	0.145	0.350	0.350	2900	4350	5800	8700
		6.00	2	0.220	0.400	0.400	4400	6600	8800	13200
		8.00	2	0.285	0.450	0.450	5700	8550	11400	17100
		10.00	2	0.365	0.500	0.500	7300	10950	14600	21900
		12.00	2	0.430	0.600	0.600	8600	12900	17200	25800
		16.00	2	0.460	0.750	0.750	9200	13800	18400	27600
20.00	2	0.485	1.000	1.000	9700	14550	19400	29100		
25.00	2	0.505	1.200	1.200	10100	15150	20200	30300		

Anwendung	Werkstoff	d1 [mm]	z	f _z [mm]	a _p [mm]	a _e [mm]	n=10000 min ⁻¹ vf [mm/min]	n=15000 min ⁻¹ vf [mm/min]	n=20000 min ⁻¹ vf [mm/min]	n=30000 min ⁻¹ vf [mm/min]
 <p>(1)</p>	Al-Knetlegierung Al-Integralbau 	6.00	2	0.100	4.000	6.000	2000	3000	4000	6000
		8.00	2	0.130	5.000	8.000	2600	3900	5200	7800
		10.00	2	0.165	5.500	10.000	3300	4950	6600	9900
		12.00	2	0.195	6.000	12.000	3900	5850	7800	11700
		16.00	2	0.210	6.500	16.000	4200	6300	8400	12600
		20.00	2	0.220	7.000	20.000	4400	6600	8800	13200
25.00	2	0.230	7.000	25.000	4600	6900	9200	13800		
 <p>(2)</p>	Al-Knetlegierung Al-Integralbau 	6.00	2	0.100	4.000	4.800	2000	3000	4000	6000
		8.00	2	0.130	5.000	6.400	2600	3900	5200	7800
		10.00	2	0.165	5.500	8.000	3300	4950	6600	9900
		12.00	2	0.195	6.000	9.600	3900	5850	7800	11700
		16.00	2	0.210	6.500	12.800	4200	6300	8400	12600
		20.00	2	0.220	7.000	16.000	4400	6600	8800	13200
25.00	2	0.230	7.000	20.000	4600	6900	9200	13800		
	Al-Knetlegierung Al-Integralbau 	6.00	2	0.100	6.000	3.600	2000	3000	4000	6000
		8.00	2	0.130	7.500	4.800	2600	3900	5200	7800
		10.00	2	0.165	8.300	6.000	3300	4950	6600	9900
		12.00	2	0.195	9.000	7.200	3900	5850	7800	11700
		16.00	2	0.210	9.800	9.600	4200	6300	8400	12600
		20.00	2	0.220	10.500	12.000	4400	6600	8800	13200
25.00	2	0.230	10.500	15.000	4600	6900	9200	13800		
 <p>F</p>	Al-Knetlegierung Al-Integralbau 	6.00	2	0.030	6.000	0.200	600	900	1200	1800
		8.00	2	0.040	7.500	0.250	800	1200	1600	2400
		10.00	2	0.050	8.300	0.300	1000	1500	2000	3000
		12.00	2	0.060	9.000	0.350	1200	1800	2400	3600
		16.00	2	0.065	9.800	0.500	1300	1950	2600	3900
		20.00	2	0.065	10.500	0.600	1300	1950	2600	3900
25.00	2	0.070	10.500	0.750	1400	2100	2800	4200		
	Al-Knetlegierung Al-Integralbau 	6.00	2	0.220	0.400	0.400	4400	6600	8800	13200
		8.00	2	0.285	0.450	0.450	5700	8550	11400	17100
		10.00	2	0.365	0.500	0.500	7300	10950	14600	21900
		12.00	2	0.430	0.600	0.600	8600	12900	17200	25800
		16.00	2	0.460	0.750	0.750	9200	13800	18400	27600
		20.00	2	0.485	1.000	1.000	9700	14550	19400	29100
25.00	2	0.505	1.200	1.200	10100	15150	20200	30300		