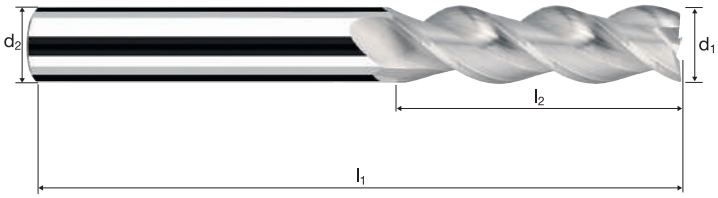
Zylindrische Fräser AX

Glattschneidig, lange Ausführung

X-Generation

HM MG10	λ 40° γ 20°
90°	
Vario	



Schruppen

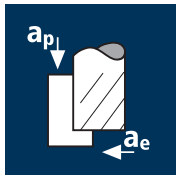
Schlichten

Rm < 850			Al Aluminium > 99%	Al Aluminium Alloy	Al Aluminium Cast		Cu Copper	Plastic Thermoplast	

Beispiel: **Bestell-Nr.** Beschichtung **C** Artikel-Nr. **15561** ø-Code **300**

						CELERO	
						15661	C15661
						15561	C15561
Ø Code	d_1 e8	d_2 h6	l_1	l_2	z		
300	6.00	6.00	70	26.00	3	●	●
391	8.00	8.00	80	36.00	3	●	●
450	10.00	10.00	100	45.00	3	●	●
501	12.00	12.00	110	53.00	3	●	●
610	16.00	16.00	123	63.00	3	●	●
682	20.00	20.00	141	75.00	3	●	●

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]	Q [cm^3/min]
Al-Knetlegierung Al-Integralbau	6.00	3	350	0.065	18.000	0.900	18570	3620	58.7
	8.00	3	350	0.080	24.000	1.200	13925	3340	96.3
	10.00	3	350	0.100	30.000	1.500	11140	3340	150.4
	12.00	3	350	0.120	36.000	1.800	9285	3340	216.6
	16.00	3	350	0.130	48.000	2.400	6965	2715	312.8
	20.00	3	350	0.150	60.000	3.000	5570	2505	451.2
Reinkupfer	6.00	3	220	0.050	18.000	0.900	11670	1750	28.4
	8.00	3	220	0.065	24.000	1.200	8755	1705	49.2
	10.00	3	220	0.080	30.000	1.500	7005	1680	75.6
	12.00	3	220	0.095	36.000	1.800	5835	1665	107.8
	16.00	3	220	0.105	48.000	2.400	4375	1380	158.8
	20.00	3	220	0.120	60.000	3.000	3500	1260	226.9
Thermoplaste	6.00	3	600	0.065	18.000	0.900	31830	6205	100.6
	8.00	3	600	0.080	24.000	1.200	23875	5730	165.0
	10.00	3	600	0.100	30.000	1.500	19100	5730	257.8
	12.00	3	600	0.120	36.000	1.800	15915	5730	371.3
	16.00	3	600	0.130	48.000	2.400	11935	4655	536.3
	20.00	3	600	0.150	60.000	3.000	9550	4295	773.5
Al-Gusslegierung	6.00	3	280	0.065	18.000	0.900	14855	2895	46.9
	8.00	3	280	0.080	24.000	1.200	11140	2675	77.0
	10.00	3	280	0.100	30.000	1.500	8915	2675	120.3
	12.00	3	280	0.120	36.000	1.800	7425	2675	173.3
	16.00	3	280	0.130	48.000	2.400	5570	2170	250.3
	20.00	3	280	0.150	60.000	3.000	4455	2005	361.0