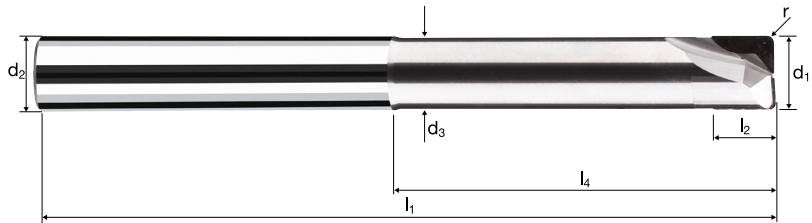
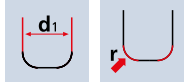


# Eckradiusfräser CVD

Lange Ausführung mit Hals, gerade Schneide



CVD  $\lambda$  0°  
 $\gamma$  0°



Verschleissresistenz



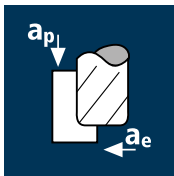
Al Aluminium Cast	Cu Copper	CuZn Brass		C Graphite	CFK GFK I	CFK GFK II	CFK GFK II	CFK/AL	
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Ø Code	d <sub>1</sub> h7	d <sub>2</sub> h6	d <sub>3</sub>	l <sub>1</sub>	l <sub>2</sub>	l <sub>3</sub>	l <sub>4</sub>	r ±0.01	α	z	Beispiel:	
											Bestell-Nr.	25404
											Beschichtung	Artikel-Nr.
												ø-Code
												25404
												138
138	2.00	6.00	1.90	55	2.50	10.00	17.80	0.200	6.6°	2	●	
178	3.00	6.00	2.80	75	2.50	20.00	26.10	0.200	3.3°	2	●	
218	4.00	6.00	3.80	75	2.50	30.00	34.20	0.200	1.7°	2	●	
300	6.00	6.00	5.60	100	6.00	40.00	40.90	0.500	0.0°	2	●	
388	8.00	8.00	7.60	100	7.00	40.00	40.90	0.500	0.0°	2	●	
448	10.00	10.00	9.60	100	8.00	50.00	50.90	0.500	0.0°	2	●	
498	12.00	12.00	11.60	107	9.00	60.00	60.90	0.500	0.0°	2	●	
302	6.00	6.00	5.60	100	6.00	40.00	40.90	1.000	0.0°	2	●	
391	8.00	8.00	7.60	100	7.00	40.00	40.90	1.000	0.0°	2	●	
450	10.00	10.00	9.60	100	8.00	50.00	50.90	1.000	0.0°	2	●	
501	12.00	12.00	11.60	107	9.00	60.00	60.90	1.000	0.0°	2	●	





# Anwendung

# Werkstoff



**CFK**



d1 [mm]	z	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n=10000 min <sup>-1</sup> vf [mm/min]	n=15000 min <sup>-1</sup> vf [mm/min]	n=20000 min <sup>-1</sup> vf [mm/min]	n=30000 min <sup>-1</sup> vf [mm/min]
2.00	2	0.020	1.200	1.000	400	600	800	1200
3.00	2	0.030	1.800	1.500	600	900	1200	1800
4.00	2	0.040	2.400	2.000	800	1200	1600	2400
6.00	2	0.065	3.600	3.000	1300	1950	2600	3900
8.00	2	0.085	4.800	4.000	1700	2550	3400	5100
10.00	2	0.105	6.000	5.000	2100	3150	4200	6300
12.00	2	0.120	7.200	6.000	2400	3600	4800	7200

**GFK**




2.00	2	0.015	1.200	1.000	300	450	600	900
3.00	2	0.025	1.800	1.500	500	750	1000	1500
4.00	2	0.035	2.400	2.000	700	1050	1400	2100
6.00	2	0.055	3.600	3.000	1100	1650	2200	3300
8.00	2	0.070	4.800	4.000	1400	2100	2800	4200
10.00	2	0.090	6.000	5.000	1800	2700	3600	5400
12.00	2	0.100	7.200	6.000	2000	3000	4000	6000

**Aluminium  
Si > 6%**

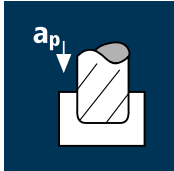



2.00	2	0.015	1.000	1.000	300	450	600	900
3.00	2	0.025	1.500	1.500	500	750	1000	1500
4.00	2	0.030	2.000	2.000	600	900	1200	1800
6.00	2	0.050	3.000	3.000	1000	1500	2000	3000
8.00	2	0.065	4.000	4.000	1300	1950	2600	3900
10.00	2	0.080	5.000	5.000	1600	2400	3200	4800
12.00	2	0.090	6.000	6.000	1800	2700	3600	5400


**Grafit**



2.00	2	0.015	1.200	1.000	300	450	600	900
3.00	2	0.025	1.800	1.500	500	750	1000	1500
4.00	2	0.035	2.400	2.000	700	1050	1400	2100
6.00	2	0.055	3.600	3.000	1100	1650	2200	3300
8.00	2	0.070	4.800	4.000	1400	2100	2800	4200
10.00	2	0.090	6.000	5.000	1800	2700	3600	5400
12.00	2	0.100	7.200	6.000	2000	3000	4000	6000



**CFK**






2.00	2	0.015	1.200	2.000	300	450	600	900
3.00	2	0.020	1.800	3.000	400	600	800	1200
4.00	2	0.030	2.400	4.000	600	900	1200	1800
6.00	2	0.045	3.600	6.000	900	1350	1800	2700
8.00	2	0.060	4.800	8.000	1200	1800	2400	3600
10.00	2	0.075	6.000	10.000	1500	2250	3000	4500
12.00	2	0.085	7.200	12.000	1700	2550	3400	5100

**GFK**




2.00	2	0.010	1.200	2.000	200	300	400	600
3.00	2	0.020	1.800	3.000	400	600	800	1200
4.00	2	0.025	2.400	4.000	500	750	1000	1500
6.00	2	0.040	3.600	6.000	800	1200	1600	2400
8.00	2	0.050	4.800	8.000	1000	1500	2000	3000
10.00	2	0.065	6.000	10.000	1300	1950	2600	3900
12.00	2	0.070	7.200	12.000	1400	2100	2800	4200

**Aluminium  
Si > 6%**

2.00	2	0.010	1.000	2.000	200	300	400	600
3.00	2	0.020	1.500	3.000	400	600	800	1200
4.00	2	0.020	2.000	4.000	400	600	800	1200
6.00	2	0.035	3.000	6.000	700	1050	1400	2100
8.00	2	0.045	4.000	8.000	900	1350	1800	2700
10.00	2	0.055	5.000	10.000	1100	1650	2200	3300
12.00	2	0.065	6.000	12.000	1300	1950	2600	3900

**Grafit**



2.00	2	0.010	1.200	2.000	200	300	400	600
3.00	2	0.020	1.800	3.000	400	600	800	1200
4.00	2	0.025	2.400	4.000	500	750	1000	1500
6.00	2	0.040	3.600	6.000	800	1200	1600	2400
8.00	2	0.050	4.800	8.000	1000	1500	2000	3000
10.00	2	0.065	6.000	10.000	1300	1950	2600	3900
12.00	2	0.070	7.200	12.000	1400	2100	2800	4200