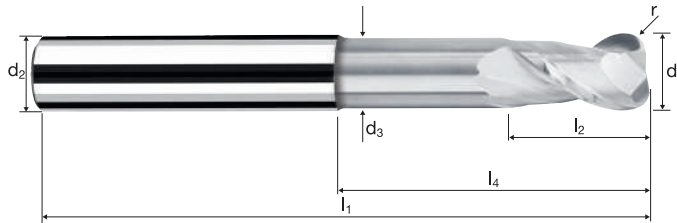
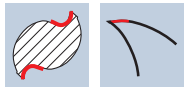
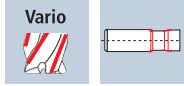


Eckradiusfräser AX

Glattschneidig, Ausführung 4xd, Hals



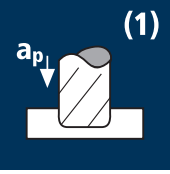

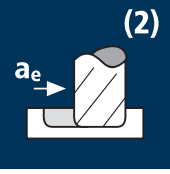

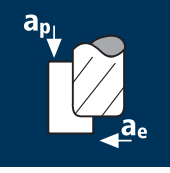

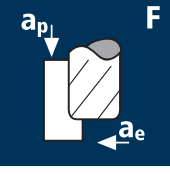



HM
MG10 λ 40°
 γ 20°

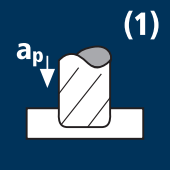

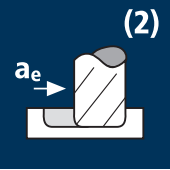

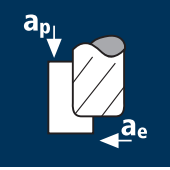

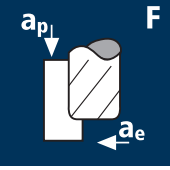





ToolSchool 15575 / C15575

Al Aluminium > 99% Al Aluminium Alloy Al Aluminium Cast Cu Copper Plastic Thermoplast

											CELERO	
Beispiel: Bestell-Nr. C 15574 302											15574	C15574
\emptyset Code	d_1 e8	d_2 h6	d_3	l_1	l_2	l_3	l_4	r 0/+0.03	z			
302	6.00	6.00	5.50	60	7.00	22.15	24.00	1.000	2	●	●	
391	8.00	8.00	7.40	68	9.00	29.63	32.00	1.000	2	●	●	
450	10.00	10.00	9.20	84	11.00	36.99	40.00	1.000	2	●	●	
501	12.00	12.00	11.00	97	13.00	44.29	48.00	1.000	2	●	●	
608	16.00	16.00	15.00	115	18.00	59.73	64.00	1.000	2	●	●	
680	20.00	20.00	19.00	130	22.00	75.23	80.00	1.000	2	●	●	
770	25.00	25.00	24.00	157	27.00	94.68	100.00	1.000	2	●	●	
453	10.00	10.00	9.20	84	11.00	36.99	40.00	1.500	2	●	-	
503	12.00	12.00	11.00	97	13.00	44.29	48.00	1.500	2	●	-	
611	16.00	16.00	15.00	115	18.00	59.73	64.00	2.000	2	●	-	
683	20.00	20.00	19.00	130	22.00	75.23	80.00	2.000	2	●	-	
307	6.00	6.00	5.50	60	7.00	22.15	24.00	2.500	2	●	●	
397	8.00	8.00	7.40	68	9.00	29.63	32.00	2.500	2	●	●	
457	10.00	10.00	9.20	84	11.00	36.99	40.00	2.500	2	●	●	
506	12.00	12.00	11.00	97	13.00	44.29	48.00	2.500	2	●	●	
612	16.00	16.00	15.00	115	18.00	59.73	64.00	2.500	2	●	●	
684	20.00	20.00	19.00	130	22.00	75.23	80.00	2.500	2	●	●	
774	25.00	25.00	24.00	157	27.00	94.68	100.00	2.500	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 	6.00	2	0.090	3.500	6.000	1800	2700	3600	5400
		8.00	2	0.120	4.500	8.000	2400	3600	4800	7200
		10.00	2	0.150	5.000	10.000	3000	4500	6000	9000
		12.00	2	0.180	5.500	12.000	3600	5400	7200	10800
		16.00	2	0.190	6.000	16.000	3800	5700	7600	11400
		20.00	2	0.205	6.500	20.000	4100	6150	8200	12300
 <p>(2)</p>	Al-Knetlegierung Al-Integralbau 	6.00	2	0.090	3.500	3.600	1800	2700	3600	5400
		8.00	2	0.120	4.500	4.800	2400	3600	4800	7200
		10.00	2	0.150	5.000	6.000	3000	4500	6000	9000
		12.00	2	0.180	5.500	7.200	3600	5400	7200	10800
		16.00	2	0.190	6.000	9.600	3800	5700	7600	11400
		20.00	2	0.205	6.500	12.000	4100	6150	8200	12300
	Al-Knetlegierung Al-Integralbau 	6.00	2	0.090	5.300	3.600	1800	2700	3600	5400
		8.00	2	0.120	6.800	4.800	2400	3600	4800	7200
		10.00	2	0.150	7.500	6.000	3000	4500	6000	9000
		12.00	2	0.180	8.300	7.200	3600	5400	7200	10800
		16.00	2	0.190	9.000	9.600	3800	5700	7600	11400
		20.00	2	0.205	9.800	12.000	4100	6150	8200	12300
 <p>F</p>	Al-Knetlegierung Al-Integralbau 	6.00	2	0.025	5.300	0.200	500	750	1000	1500
		8.00	2	0.035	6.800	0.250	700	1050	1400	2100
		10.00	2	0.045	7.500	0.300	900	1350	1800	2700
		12.00	2	0.055	8.300	0.350	1100	1650	2200	3300
		16.00	2	0.055	9.000	0.500	1100	1650	2200	3300
		20.00	2	0.060	9.800	0.600	1200	1800	2400	3600
	Al-Knetlegierung Al-Integralbau 	6.00	2	0.200	0.400	0.400	4000	6000	8000	12000
		8.00	2	0.265	0.450	0.450	5300	7950	10600	15900
		10.00	2	0.330	0.500	0.500	6600	9900	13200	19800
		12.00	2	0.395	0.600	0.600	7900	11850	15800	23700
		16.00	2	0.420	0.750	0.750	8400	12600	16800	25200
		20.00	2	0.450	1.000	1.000	9000	13500	18000	27000
		25.00	2	0.475	1.200	1.200	9500	14250	19000	28500

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 	10.00	2	0.150	5.000	10.000	3000	4500	6000	9000
		12.00	2	0.180	5.500	12.000	3600	5400	7200	10800
		16.00	2	0.190	6.000	16.000	3800	5700	7600	11400
		20.00	2	0.205	6.500	20.000	4100	6150	8200	12300
		25.00	2	0.215	6.500	25.000	4300	6450	8600	12900
 <p>(2)</p>	Al-Knetlegierung Al-Integralbau 	10.00	2	0.150	5.000	6.000	3000	4500	6000	9000
		12.00	2	0.180	5.500	7.200	3600	5400	7200	10800
		16.00	2	0.190	6.000	9.600	3800	5700	7600	11400
		20.00	2	0.205	6.500	12.000	4100	6150	8200	12300
		25.00	2	0.215	6.500	15.000	4300	6450	8600	12900
	Al-Knetlegierung Al-Integralbau 	10.00	2	0.150	7.500	6.000	3000	4500	6000	9000
		12.00	2	0.180	8.300	7.200	3600	5400	7200	10800
		16.00	2	0.190	9.000	9.600	3800	5700	7600	11400
		20.00	2	0.205	9.800	12.000	4100	6150	8200	12300
		25.00	2	0.215	9.800	15.000	4300	6450	8600	12900
 <p>F</p>	Al-Knetlegierung Al-Integralbau 	10.00	2	0.045	7.500	0.300	900	1350	1800	2700
		12.00	2	0.055	8.300	0.350	1100	1650	2200	3300
		16.00	2	0.055	9.000	0.500	1100	1650	2200	3300
		20.00	2	0.060	9.800	0.600	1200	1800	2400	3600
		25.00	2	0.065	9.800	0.750	1300	1950	2600	3900
	Al-Knetlegierung Al-Integralbau 	10.00	2	0.330	0.500	0.500	6600	9900	13200	19800
		12.00	2	0.395	0.600	0.600	7900	11850	15800	23700
		16.00	2	0.420	0.750	0.750	8400	12600	16800	25200
		20.00	2	0.450	1.000	1.000	9000	13500	18000	27000
		25.00	2	0.475	1.200	1.200	9500	14250	19000	28500