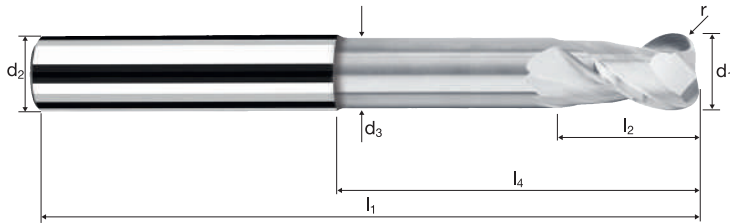
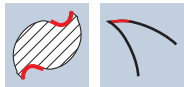
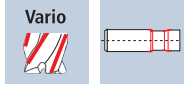


# Eckradiusfräser AX

Glattschneidig, Ausführung 5xd, Hals



HM  
MG10  $\lambda$  40°  
 $\gamma$  20°



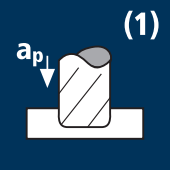

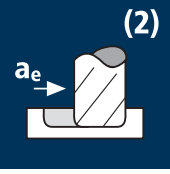

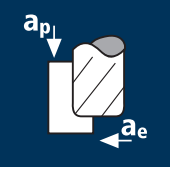

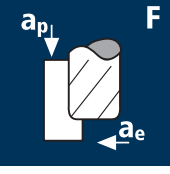



Schruppen

Schichten



			Al Aluminium > 99%	Al Aluminium Alloy	Al Aluminium Cast		Cu Copper	Plastic Thermoplast	
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Beispiel: Bestell-Nr. <b>C 15575 302</b>											CELERO	
											15575	C15575
Ø Code	d <sub>1</sub> e8	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/+0.03	z			
302	6.00	6.00	5.50	66	7.00	28.15	30.00	1.000	2	●	●	-
391	8.00	8.00	7.40	76	9.00	37.63	40.00	1.000	2	●	●	-
450	10.00	10.00	9.20	91	11.00	46.99	50.00	1.000	2	●	●	●
501	12.00	12.00	11.00	106	13.00	56.29	60.00	1.000	2	●	●	●
608	16.00	16.00	15.00	129	18.00	75.73	80.00	1.000	2	●	●	●
680	20.00	20.00	19.00	151	22.00	95.23	100.00	1.000	2	●	●	●
770	25.00	25.00	24.00	182	27.00	119.68	125.00	1.000	2	●	●	●
307	6.00	6.00	5.50	66	7.00	28.15	30.00	2.500	2	●	●	●
397	8.00	8.00	7.40	76	9.00	37.63	40.00	2.500	2	●	●	●
457	10.00	10.00	9.20	91	11.00	46.99	50.00	2.500	2	●	●	●
506	12.00	12.00	11.00	106	13.00	56.29	60.00	2.500	2	●	●	●
612	16.00	16.00	15.00	129	18.00	75.73	80.00	2.500	2	●	●	●
684	20.00	20.00	19.00	151	22.00	95.23	100.00	2.500	2	●	●	●
774	25.00	25.00	24.00	182	27.00	119.68	125.00	2.500	2	●	●	●
459	10.00	10.00	9.20	91	11.00	46.99	50.00	4.000	2	●	●	●
508	12.00	12.00	11.00	106	13.00	56.29	60.00	4.000	2	●	●	●
614	16.00	16.00	15.00	129	18.00	75.73	80.00	4.000	2	●	●	●
686	20.00	20.00	19.00	151	22.00	95.23	100.00	4.000	2	●	●	●
776	25.00	25.00	24.00	182	27.00	119.68	125.00	4.000	2	●	●	●

Anwendung	Werkstoff	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 <sup>3</sup> /min]	n=15000 min <sup>-1</sup> vf [mm <sup>3</sup> /min]	n=20000 min <sup>-1</sup> vf [mm <sup>3</sup> /min]	n=30000 min <sup>-1</sup> vf [mm <sup>3</sup> /min]
 <p>(1)</p>	Al-Knetlegierung Al-Integralbau 	6.00	2	0.065	4.000	6.000	1300	1950	2600	3900
		8.00	2	0.085	4.500	8.000	1700	2550	3400	5100
		10.00	2	0.110	5.000	10.000	2200	3300	4400	6600
		12.00	2	0.120	5.000	12.000	2400	3600	4800	7200
		16.00	2	0.150	5.000	16.000	3000	4500	6000	9000
		20.00	2	0.180	5.000	20.000	3600	5400	7200	10800
25.00	2	0.200	5.000	25.000	4000	6000	8000	12000		
 <p>(2)</p>	Al-Knetlegierung Al-Integralbau 	6.00	2	0.065	4.000	3.600	1300	1950	2600	3900
		8.00	2	0.085	4.500	4.800	1700	2550	3400	5100
		10.00	2	0.110	5.000	6.000	2200	3300	4400	6600
		12.00	2	0.120	5.000	7.200	2400	3600	4800	7200
		16.00	2	0.150	5.000	9.600	3000	4500	6000	9000
		20.00	2	0.180	5.000	12.000	3600	5400	7200	10800
25.00	2	0.200	5.000	15.000	4000	6000	8000	12000		
	Al-Knetlegierung Al-Integralbau 	6.00	2	0.065	6.000	3.600	1300	1950	2600	3900
		8.00	2	0.085	6.800	4.800	1700	2550	3400	5100
		10.00	2	0.110	7.500	6.000	2200	3300	4400	6600
		12.00	2	0.120	7.500	7.200	2400	3600	4800	7200
		16.00	2	0.150	7.500	9.600	3000	4500	6000	9000
		20.00	2	0.180	7.500	12.000	3600	5400	7200	10800
25.00	2	0.200	7.500	15.000	4000	6000	8000	12000		
 <p>F</p>	Al-Knetlegierung Al-Integralbau 	6.00	2	0.020	6.000	0.200	400	600	800	1200
		8.00	2	0.025	6.800	0.250	500	750	1000	1500
		10.00	2	0.035	7.500	0.300	700	1050	1400	2100
		12.00	2	0.035	7.500	0.350	700	1050	1400	2100
		16.00	2	0.045	7.500	0.500	900	1350	1800	2700
		20.00	2	0.055	7.500	0.600	1100	1650	2200	3300
25.00	2	0.060	7.500	0.750	1200	1800	2400	3600		
	Al-Knetlegierung Al-Integralbau 	6.00	2	0.145	0.350	0.350	2900	4350	5800	8700
		8.00	2	0.185	0.400	0.400	3700	5550	7400	11100
		10.00	2	0.240	0.450	0.450	4800	7200	9600	14400
		12.00	2	0.265	0.500	0.500	5300	7950	10600	15900
		16.00	2	0.330	0.600	0.600	6600	9900	13200	19800
		20.00	2	0.395	0.750	0.750	7900	11850	15800	23700
25.00	2	0.440	0.800	0.800	8800	13200	17600	26400		