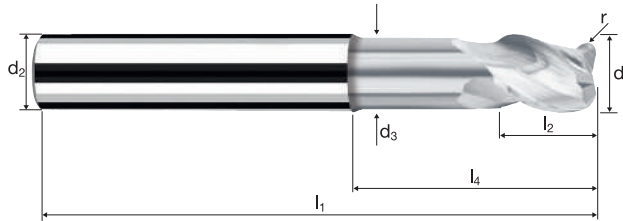
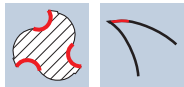
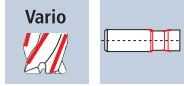


Eckradiusfräser AX

Glattschneidig, Ausführung 3xd, Hals

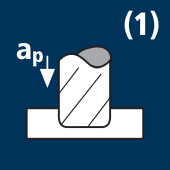

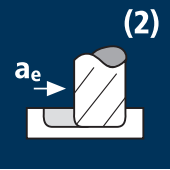

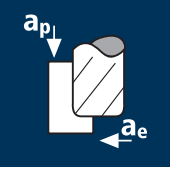

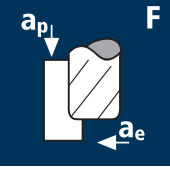

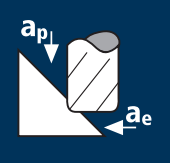



HM
MG10 λ 40°
 γ 20°



		Al Aluminium > 99%	Al Aluminium Alloy	Al Aluminium Cast		Cu Copper	Plastic Thermoplast	
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												CELERO	
Beispiel: Bestell-Nr. C 15583 180												15583	C15583
\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°	3	●	●	
220	4.00	6.00	3.70	54	5.00	12.00	16.82	0.500	3.7°	3	●	●	
260	5.00	6.00	4.60	54	6.00	15.00	18.27	0.500	1.7°	3	●	●	
300	6.00	6.00	5.50	54	7.00	16.15	18.00	0.500	0.0°	3	●	●	
302	6.00	6.00	5.50	54	7.00	16.15	18.00	1.000	0.0°	3	●	●	
391	8.00	8.00	7.40	63	9.00	21.63	24.00	1.000	0.0°	3	●	●	
450	10.00	10.00	9.20	72	11.00	26.99	30.00	1.000	0.0°	3	●	●	
501	12.00	12.00	11.00	83	13.00	32.29	36.00	1.000	0.0°	3	●	●	
608	16.00	16.00	15.00	97	18.00	43.73	48.00	1.000	0.0°	3	●	●	
680	20.00	20.00	19.00	111	22.00	55.23	60.00	1.000	0.0°	3	●	●	
770	25.00	25.00	24.00	132	27.00	69.68	75.00	1.000	0.0°	3	●	●	
453	10.00	10.00	9.20	72	11.00	26.99	30.00	1.500	0.0°	3	●	-	
503	12.00	12.00	11.00	83	13.00	32.29	36.00	1.500	0.0°	3	●	-	
611	16.00	16.00	15.00	97	18.00	43.73	48.00	2.000	0.0°	3	●	-	
683	20.00	20.00	19.00	111	22.00	55.23	60.00	2.000	0.0°	3	●	-	

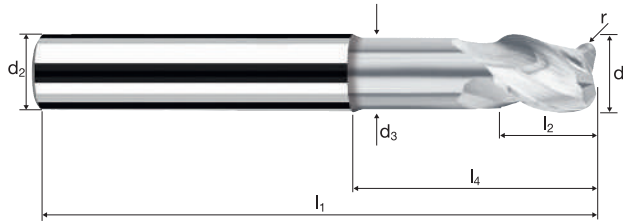
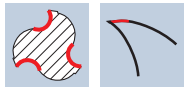
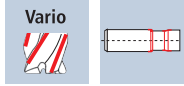
Anwendung	Werkstoff	d1 [mm]	z	f _z [mm]	a _p [mm]	a _e [mm]	n=10000 min ⁻¹ vf [mm/min]	n=15000 min ⁻¹ vf [mm/min]	n=20000 min ⁻¹ vf [mm/min]	n=30000 min ⁻¹ vf [mm/min]
 <p>(1)</p>	Al-Knetlegierung Al-Integralbau 	3.00	3	0.030	2.000	3.000	900	1350	1800	2700
		4.00	3	0.040	3.000	4.000	1200	1800	2400	3600
		6.00	3	0.060	4.000	6.000	1800	2700	3600	5400
		8.00	3	0.085	5.000	8.000	2550	3825	5100	7650
		10.00	3	0.105	5.500	10.000	3150	4725	6300	9450
		12.00	3	0.125	6.000	12.000	3750	5625	7500	11250
		16.00	3	0.135	6.500	16.000	4050	6075	8100	12150
20.00	3	0.140	7.000	20.000	4200	6300	8400	12600		
25.00	3	0.150	7.000	25.000	4500	6750	9000	13500		
 <p>(2)</p>	Al-Knetlegierung Al-Integralbau 	3.00	3	0.030	2.000	2.400	900	1350	1800	2700
		4.00	3	0.040	3.000	3.200	1200	1800	2400	3600
		6.00	3	0.060	4.000	4.800	1800	2700	3600	5400
		8.00	3	0.085	5.000	6.400	2550	3825	5100	7650
		10.00	3	0.105	5.500	8.000	3150	4725	6300	9450
		12.00	3	0.125	6.000	9.600	3750	5625	7500	11250
		16.00	3	0.135	6.500	12.800	4050	6075	8100	12150
20.00	3	0.140	7.000	16.000	4200	6300	8400	12600		
25.00	3	0.150	7.000	20.000	4500	6750	9000	13500		
	Al-Knetlegierung Al-Integralbau 	3.00	3	0.030	3.000	1.800	900	1350	1800	2700
		4.00	3	0.040	4.500	2.400	1200	1800	2400	3600
		6.00	3	0.060	6.000	3.600	1800	2700	3600	5400
		8.00	3	0.085	7.500	4.800	2550	3825	5100	7650
		10.00	3	0.105	8.300	6.000	3150	4725	6300	9450
		12.00	3	0.125	9.000	7.200	3750	5625	7500	11250
		16.00	3	0.135	9.800	9.600	4050	6075	8100	12150
20.00	3	0.140	10.500	12.000	4200	6300	8400	12600		
25.00	3	0.150	10.500	15.000	4500	6750	9000	13500		
 <p>F</p>	Al-Knetlegierung Al-Integralbau 	3.00	3	0.010	3.000	0.100	300	450	600	900
		4.00	3	0.010	4.500	0.100	300	450	600	900
		6.00	3	0.020	6.000	0.200	600	900	1200	1800
		8.00	3	0.025	7.500	0.250	750	1125	1500	2250
		10.00	3	0.030	8.300	0.300	900	1350	1800	2700
		12.00	3	0.040	9.000	0.350	1200	1800	2400	3600
		16.00	3	0.040	9.800	0.500	1200	1800	2400	3600
20.00	3	0.040	10.500	0.600	1200	1800	2400	3600		
25.00	3	0.045	10.500	0.750	1350	2025	2700	4050		
	Al-Knetlegierung Al-Integralbau 	3.00	3	0.065	0.400	0.400	1950	2925	3900	5850
		4.00	3	0.090	0.450	0.450	2700	4050	5400	8100
		6.00	3	0.130	0.400	0.400	3900	5850	7800	11700
		8.00	3	0.185	0.450	0.450	5550	8325	11100	16650
		10.00	3	0.230	0.500	0.500	6900	10350	13800	20700
		12.00	3	0.275	0.600	0.600	8250	12375	16500	24750
		16.00	3	0.295	0.750	0.750	8850	13275	17700	26550
20.00	3	0.310	1.000	1.000	9300	13950	18600	27900		
25.00	3	0.330	1.200	1.200	9900	14850	19800	29700		

Eckradiusfräser AX

Glattschneidig, Ausführung 3xd, Hals

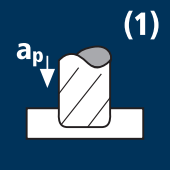

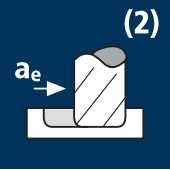

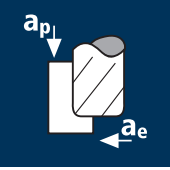

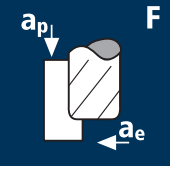





HM
MG10 λ 40°
 γ 20°



		Al Aluminium > 99%	Al Aluminium Alloy	Al Aluminium Cast		Cu Copper	Plastic Thermoplast	
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											CELERO	
Beispiel: Bestell-Nr. C 15583 307											15583	C15583
\emptyset Code	d_1 e8	d_2 h6	d_3	l_1	l_2	l_3	l_4	r 0/+0.03	α	z		
307	6.00	6.00	5.50	54	7.00	16.15	18.00	2.500	0.0°	3	●	●
397	8.00	8.00	7.40	63	9.00	21.63	24.00	2.500	0.0°	3	●	●
457	10.00	10.00	9.20	72	11.00	26.99	30.00	2.500	0.0°	3	●	●
506	12.00	12.00	11.00	83	13.00	32.29	36.00	2.500	0.0°	3	●	●
612	16.00	16.00	15.00	97	18.00	43.73	48.00	2.500	0.0°	3	●	●
684	20.00	20.00	19.00	111	22.00	55.23	60.00	2.500	0.0°	3	●	●
774	25.00	25.00	24.00	132	27.00	69.68	75.00	2.500	0.0°	3	●	●
459	10.00	10.00	9.20	72	11.00	26.99	30.00	4.000	0.0°	3	●	●
508	12.00	12.00	11.00	83	13.00	32.29	36.00	4.000	0.0°	3	●	●
614	16.00	16.00	15.00	97	18.00	43.73	48.00	4.000	0.0°	3	●	●
686	20.00	20.00	19.00	111	22.00	55.23	60.00	4.000	0.0°	3	●	●
776	25.00	25.00	24.00	132	27.00	69.68	75.00	4.000	0.0°	3	●	●

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	3	0.060	4.000	6.000	1800	2700	3600	5400
		8.00	3	0.085	5.000	8.000	2550	3825	5100	7650
		10.00	3	0.105	5.500	10.000	3150	4725	6300	9450
		12.00	3	0.125	6.000	12.000	3750	5625	7500	11250
		16.00	3	0.135	6.500	16.000	4050	6075	8100	12150
		20.00	3	0.140	7.000	20.000	4200	6300	8400	12600
		25.00	3	0.150	7.000	25.000	4500	6750	9000	13500
 <p>(2)</p>	Al-Knetlegierung Al-Integralbau 	6.00	3	0.060	4.000	4.800	1800	2700	3600	5400
		8.00	3	0.085	5.000	6.400	2550	3825	5100	7650
		10.00	3	0.105	5.500	8.000	3150	4725	6300	9450
		12.00	3	0.125	6.000	9.600	3750	5625	7500	11250
		16.00	3	0.135	6.500	12.800	4050	6075	8100	12150
		20.00	3	0.140	7.000	16.000	4200	6300	8400	12600
		25.00	3	0.150	7.000	20.000	4500	6750	9000	13500
	Al-Knetlegierung Al-Integralbau 	6.00	3	0.060	6.000	3.600	1800	2700	3600	5400
		8.00	3	0.085	7.500	4.800	2550	3825	5100	7650
		10.00	3	0.105	8.300	6.000	3150	4725	6300	9450
		12.00	3	0.125	9.000	7.200	3750	5625	7500	11250
		16.00	3	0.135	9.800	9.600	4050	6075	8100	12150
		20.00	3	0.140	10.500	12.000	4200	6300	8400	12600
		25.00	3	0.150	10.500	15.000	4500	6750	9000	13500
 <p>F</p>	Al-Knetlegierung Al-Integralbau 	6.00	3	0.020	6.000	0.200	600	900	1200	1800
		8.00	3	0.025	7.500	0.250	750	1125	1500	2250
		10.00	3	0.030	8.300	0.300	900	1350	1800	2700
		12.00	3	0.040	9.000	0.350	1200	1800	2400	3600
		16.00	3	0.040	9.800	0.500	1200	1800	2400	3600
		20.00	3	0.040	10.500	0.600	1200	1800	2400	3600
		25.00	3	0.045	10.500	0.750	1350	2025	2700	4050
	Al-Knetlegierung Al-Integralbau 	6.00	3	0.130	0.400	0.400	3900	5850	7800	11700
		8.00	3	0.185	0.450	0.450	5550	8325	11100	16650
		10.00	3	0.230	0.500	0.500	6900	10350	13800	20700
		12.00	3	0.275	0.600	0.600	8250	12375	16500	24750
		16.00	3	0.295	0.750	0.750	8850	13275	17700	26550
		20.00	3	0.310	1.000	1.000	9300	13950	18600	27900
		25.00	3	0.330	1.200	1.200	9900	14850	19800	29700