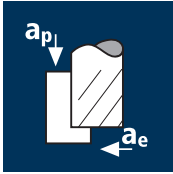


## Anwendung



## Werkstoff

Stahl  
< 850 N/mm<sup>2</sup>



Stahl  
850 - 1100 N/mm<sup>2</sup>



Titanlegierungen ausg.  
> 300 HB  
[Ti6Al4V]



Inox normal  
[Cr-Ni/1.4301]  
[Cr-Ni-Mo/1.4571]



Stahl  
< 850 N/mm<sup>2</sup>



Stahl  
850 - 1100 N/mm<sup>2</sup>



Titanlegierungen ausg.  
> 300 HB  
[Ti6Al4V]



Inox normal  
[Cr-Ni/1.4301]  
[Cr-Ni-Mo/1.4571]



d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>s</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>r</sub> [mm/min]	Q [cm <sup>3</sup> /min]
6.00	4	180	0.035	9.600	1.200	9550	1335	15.4
8.00	4	180	0.045	12.800	1.600	7160	1290	26.4
10.00	4	180	0.060	16.000	2.000	5730	1375	44.0
12.00	4	180	0.070	19.200	2.400	4775	1335	61.6
16.00	4	180	0.075	25.600	3.200	3580	1075	88.0
20.00	4	180	0.080	32.000	4.000	2865	915	117.3

6.00	4	130	0.035	9.600	1.200	6895	965	11.1
8.00	4	130	0.045	12.800	1.600	5175	930	19.1
10.00	4	130	0.060	16.000	2.000	4140	995	31.8
12.00	4	130	0.070	19.200	2.400	3450	965	44.5
16.00	4	130	0.075	25.600	3.200	2585	775	63.6
20.00	4	130	0.080	32.000	4.000	2070	660	84.7

6.00	4	45	0.025	9.600	1.200	2385	240	2.8
8.00	4	45	0.035	12.800	1.600	1790	250	5.1
10.00	4	45	0.045	16.000	2.000	1430	260	8.3
12.00	4	45	0.055	19.200	2.400	1195	265	12.1
16.00	4	45	0.060	25.600	3.200	895	215	17.6
20.00	4	45	0.065	32.000	4.000	715	185	23.8

6.00	4	60	0.025	9.600	1.200	3185	320	3.7
8.00	4	60	0.035	12.800	1.600	2385	335	6.8
10.00	4	60	0.045	16.000	2.000	1910	345	11.0
12.00	4	60	0.055	19.200	2.400	1590	350	16.1
16.00	4	60	0.060	25.600	3.200	1195	285	23.5
20.00	4	60	0.065	32.000	4.000	955	250	31.8

6.00	4	150	0.030	3.300	6.000	7960	955	18.9
8.00	4	150	0.040	4.400	8.000	5970	955	33.6
10.00	4	150	0.050	5.500	10.000	4775	955	52.5
12.00	4	150	0.055	6.600	12.000	3980	875	69.3
16.00	4	150	0.055	8.800	16.000	2985	655	92.4
20.00	4	150	0.060	11.000	20.000	2385	575	126.1

6.00	4	80	0.030	3.300	6.000	4245	510	10.1
8.00	4	80	0.040	4.400	8.000	3185	510	17.9
10.00	4	80	0.050	5.500	10.000	2545	510	28.0
12.00	4	80	0.055	6.600	12.000	2120	465	37.0
16.00	4	80	0.055	8.800	16.000	1590	350	49.3
20.00	4	80	0.060	11.000	20.000	1275	305	67.2

6.00	4	35	0.025	3.300	6.000	1855	185	3.7
8.00	4	35	0.030	4.400	8.000	1395	165	5.9
10.00	4	35	0.040	5.500	10.000	1115	180	9.8
12.00	4	35	0.045	6.600	12.000	930	165	13.2
16.00	4	35	0.045	8.800	16.000	695	125	17.6
20.00	4	35	0.050	11.000	20.000	555	110	24.5

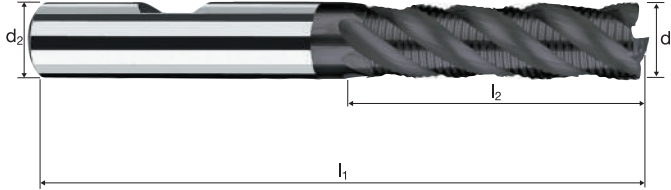
6.00	4	50	0.025	3.300	6.000	2655	265	5.3
8.00	4	50	0.030	4.400	8.000	1990	240	8.4
10.00	4	50	0.040	5.500	10.000	1590	255	14.0
12.00	4	50	0.045	6.600	12.000	1325	240	18.9
16.00	4	50	0.045	8.800	16.000	995	180	25.2
20.00	4	50	0.050	11.000	20.000	795	160	35.0

# Zylindrische Fräser SupraCarb®

Profiliert, mittellange Ausführung



**HM**  
**MG10**     $\lambda$  38°  
                   $\gamma$  0°



Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless	Ti Titanium	GG(G) Tool Steel
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Beispiel: Bestell-Nr.		Beschichtung		Artikel-Nr.		ø-Code				POLYCHROM
Ø Code		d <sub>1</sub> e <sub>8</sub>	d <sub>2</sub> h <sub>6</sub>	l <sub>1</sub>	l <sub>2</sub>	45°	z			
<b>300</b>	6.00	6.00	63	19.00	0.35	4				●
<b>391</b>	8.00	8.00	72	28.00	0.45	4				●
<b>450</b>	10.00	10.00	84	34.00	0.60	4				●
<b>501</b>	12.00	12.00	97	40.00	0.60	4				●
<b>610</b>	16.00	16.00	108	48.00	0.70	4				●
<b>682</b>	20.00	20.00	122	56.00	0.70	4				●