

Zylindrische Fräser CVD

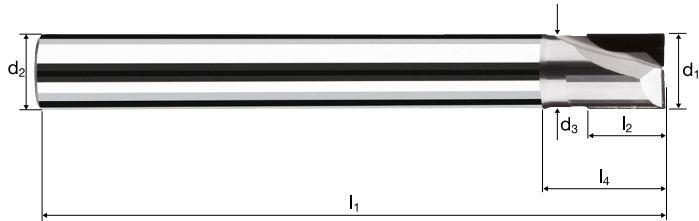
Mittellange Ausführung mit Kurzhals, gerade Schneide



CVD λ 0°
 γ 0°

45°

d_1



Verschleissresistenz



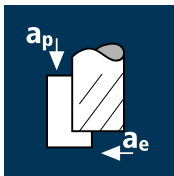
Al Aluminium Cast	Cu Copper	CuZn Brass		C Graphite	CFK GFK I	CFK GFK II	CFK GFK II	CFK/AL	
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Beispiel: Bestell-Nr. Beschichtung Artikel-Nr. ø-Code												
											25000	
Ø Code	d_1 h7	d_2 h6	d_3	l_1	l_2	l_3	l_4	45°	α	z		
220	4.00	6.00	3.80	60	8.00	10.00	13.20	0.10	4.1°	2	●	
222	4.00	6.00	3.80	60	15.00	20.00	23.20	0.10	2.4°	2	●	
300	6.00	6.00	5.80	65	10.00	15.00	15.50	0.10	0.0°	2	●	
304	6.00	6.00	5.80	65	20.00	25.00	25.50	0.10	0.0°	2	●	
391	8.00	8.00	7.60	70	10.00	15.00	15.90	0.10	0.0°	2	●	
395	8.00	8.00	7.60	70	20.00	30.00	30.90	0.10	0.0°	2	●	
450	10.00	10.00	9.60	85	10.00	15.00	15.90	0.10	0.0°	2	●	
455	10.00	10.00	9.60	85	20.00	30.00	30.90	0.10	0.0°	2	●	
501	12.00	12.00	11.60	92	10.00	15.00	15.90	0.10	0.0°	2	●	
505	12.00	12.00	11.60	92	20.00	30.00	30.90	0.10	0.0°	2	●	



Anwendung

Werkstoff



CFK






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]
4.00	2	0.045	6.000	1.000	900	1350	1800	2700
6.00	2	0.070	8.000	1.500	1400	2100	2800	4200
8.00	2	0.095	9.000	2.000	1900	2850	3800	5700
10.00	2	0.120	9.000	2.500	2400	3600	4800	7200
12.00	2	0.135	9.000	3.000	2700	4050	5400	8100

GFK




4.00	2	0.040	6.000	1.000	800	1200	1600	2400
6.00	2	0.060	8.000	1.500	1200	1800	2400	3600
8.00	2	0.080	9.000	2.000	1600	2400	3200	4800
10.00	2	0.100	9.000	2.500	2000	3000	4000	6000
12.00	2	0.115	9.000	3.000	2300	3450	4600	6900

**Aluminium
Si > 6%**

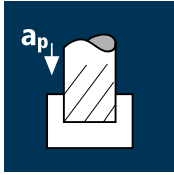



4.00	2	0.035	4.000	1.000	700	1050	1400	2100
6.00	2	0.055	6.000	1.500	1100	1650	2200	3300
8.00	2	0.070	7.000	2.000	1400	2100	2800	4200
10.00	2	0.090	7.000	2.500	1800	2700	3600	5400
12.00	2	0.105	7.000	3.000	2100	3150	4200	6300



Grafit



4.00	2	0.040	6.000	1.000	800	1200	1600	2400
6.00	2	0.060	8.000	1.500	1200	1800	2400	3600
8.00	2	0.080	9.000	2.000	1600	2400	3200	4800
10.00	2	0.100	9.000	2.500	2000	3000	4000	6000
12.00	2	0.115	9.000	3.000	2300	3450	4600	6900



CFK



4.00	2	0.035	2.400	4.000	700	1050	1400	2100
6.00	2	0.055	3.600	6.000	1100	1650	2200	3300
8.00	2	0.075	4.800	8.000	1500	2250	3000	4500
10.00	2	0.095	6.000	10.000	1900	2850	3800	5700
12.00	2	0.110	7.200	12.000	2200	3300	4400	6600

GFK



4.00	2	0.030	2.400	4.000	600	900	1200	1800
6.00	2	0.050	3.600	6.000	1000	1500	2000	3000
8.00	2	0.065	4.800	8.000	1300	1950	2600	3900
10.00	2	0.080	6.000	10.000	1600	2400	3200	4800
12.00	2	0.090	7.200	12.000	1800	2700	3600	5400

**Aluminium
Si > 6%**

4.00	2	0.030	2.000	4.000	600	900	1200	1800
6.00	2	0.045	3.000	6.000	900	1350	1800	2700
8.00	2	0.055	4.000	8.000	1100	1650	2200	3300
10.00	2	0.070	5.000	10.000	1400	2100	2800	4200
12.00	2	0.085	6.000	12.000	1700	2550	3400	5100

Grafit



4.00	2	0.030	2.400	4.000	600	900	1200	1800
6.00	2	0.050	3.600	6.000	1000	1500	2000	3000
8.00	2	0.065	4.800	8.000	1300	1950	2600	3900
10.00	2	0.080	6.000	10.000	1600	2400	3200	4800
12.00	2	0.090	7.200	12.000	1800	2700	3600	5400