

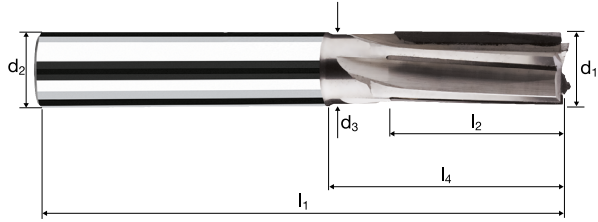
Zylindrische Fräser CVD

Normale Ausführung mit Kurzhals, gerade Schneide



CVD λ 4°
 γ 0°

45°



Verschleissresistenz

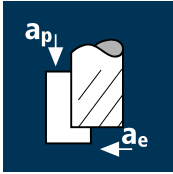
Al Aluminium Cast	Cu Copper	CuZn Brass	C Graphite	CFK GFK I	CFK GFK II	CFK GFK II	CFK/AL
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Ø Code	d ₁ h8	d ₂ h6	d ₃	l ₁	l ₂	l ₃	l ₄	45°	z	Beispiel:	
										Bestell-Nr.	25010
391	8.00	8.00	7.40	55	10.00	18.00	19.00	0.10	5	●	
395	8.00	8.00	7.40	65	20.00	28.00	29.00	0.10	5	●	
450	10.00	10.00	9.40	62	12.00	21.00	22.00	0.10	5	●	
455	10.00	10.00	9.40	72	22.00	31.00	32.00	0.10	5	●	
501	12.00	12.00	11.40	70	15.00	24.00	25.00	0.10	7	●	
505	12.00	12.00	11.40	80	24.00	34.00	35.00	0.10	7	●	



V

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]
8.00	5	0.075	8.000	4.000	3750	5625	7500	11250
10.00	5	0.095	10.000	5.000	4750	7125	9500	14250
12.00	7	0.110	12.000	6.000	7700	11550	15400	23100

GFK



8.00	5	0.065	8.000	4.000	3250	4875	6500	9750
10.00	5	0.080	10.000	5.000	4000	6000	8000	12000
12.00	7	0.095	12.000	6.000	6650	9975	13300	19950

**Aluminium
Si > 6%**

8.00	5	0.060	6.400	4.000	3000	4500	6000	9000
10.00	5	0.070	8.000	5.000	3500	5250	7000	10500
12.00	7	0.085	9.600	6.000	5950	8925	11900	17850



Grafit



8.00	5	0.065	8.000	4.000	3250	4875	6500	9750
10.00	5	0.080	10.000	5.000	4000	6000	8000	12000
12.00	7	0.095	12.000	6.000	6650	9975	13300	19950



CFK



8.00	5	0.045	8.000	8.000	2250	3375	4500	6750
10.00	5	0.055	10.000	10.000	2750	4125	5500	8250
12.00	7	0.065	12.000	12.000	4550	6825	9100	13650

GFK



8.00	5	0.040	8.000	8.000	2000	3000	4000	6000
10.00	5	0.050	10.000	10.000	2500	3750	5000	7500
12.00	7	0.055	12.000	12.000	3850	5775	7700	11550

**Aluminium
Si > 6%**

8.00	5	0.035	6.400	8.000	1750	2625	3500	5250
10.00	5	0.040	8.000	10.000	2000	3000	4000	6000
12.00	7	0.050	9.600	12.000	3500	5250	7000	10500

Grafit



8.00	5	0.040	8.000	8.000	2000	3000	4000	6000
10.00	5	0.050	10.000	10.000	2500	3750	5000	7500
12.00	7	0.055	12.000	12.000	3850	5775	7700	11550