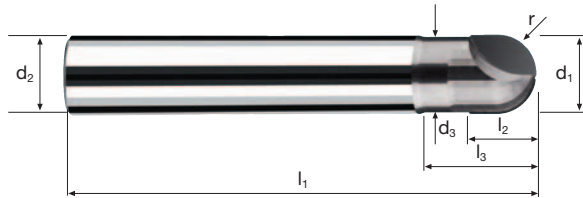
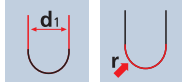


# Kugelpkopfräser CVD

Kurze Ausführung, gerade Schneide



<b>CVD</b>	$\lambda$ 0°
	$\gamma$ 0°



Verschleissresistenz

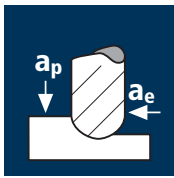


Al Aluminium Cast	Cu Copper	CuZn Brass		C Graphite	CFK GFK I	CFK GFK II	CFK III	CFK/Al	
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Beispiel: Bestell-Nr.		Beschichtung		Artikel-Nr.		ø-Code					
				<b>25700</b>		<b>.140</b>					<b>25700</b>
ø Code	d1 h7	d2 h6	d3	l1	l2	l3	r ±0.005	α	z		
<b>.140</b>	2	6	1.9	50	2.5	4	1.0	10.6°	2	●	
<b>.180</b>	3	6	2.8	50	2.5	4	1.5	9.9°	2	●	
<b>.220</b>	4	6	3.8	50	2.5	6	2.0	6.9°	2	●	
<b>.300</b>	6	6	5.6	50	6.0	9	3.0	0.0°	2	●	
<b>.391</b>	8	8	7.6	60	7.0	12	4.0	0.0°	2	●	
<b>.450</b>	10	10	9.6	60	8.0	14	5.0	0.0°	2	●	
<b>.501</b>	12	12	11.6	65	9.0	14	6.0	0.0°	2	●	



V

## Anwendung



## Werkstoff



CFK


GFK



Aluminium  
Si > 6%

Graphit



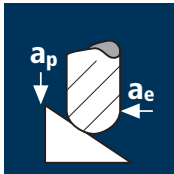
d1 [mm]	z	fz [mm]	ap [mm]	ae [mm]	n=10000 min <sup>-1</sup> vf [mm/min]	n=15000 min <sup>-1</sup> vf [mm/min]	n=20000 min <sup>-1</sup> vf [mm/min]	n=30000 min <sup>-1</sup> vf [mm/min]
2	2	0.025	1.2	0.90	500	750	1000	1500
3	2	0.035	1.8	1.35	700	1050	1400	2100
4	2	0.045	2.4	1.80	900	1350	1800	2700
6	2	0.070	3.6	2.70	1400	2100	2800	4200
8	2	0.095	4.8	3.60	1900	2850	3800	5700
10	2	0.120	6.0	4.50	2400	3600	4800	7200
12	2	0.135	7.2	5.40	2700	4050	5400	

2	2	0.020	1.2	0.90	400	600	800	1200
3	2	0.030	1.8	1.35	600	900	1200	1800
4	2	0.040	2.4	1.80	800	1200	1600	2400
6	2	0.060	3.6	2.70	1200	1800	2400	3600
8	2	0.080	4.8	3.60	1600	2400	3200	4800
10	2	0.100	6.0	4.50	2000	3000	4000	6000
12	2	0.115	7.2	5.40	2300	3450	4600	

2	2	0.020	1.2	0.90	400	600	800	1200
3	2	0.025	1.8	1.35	500	750	1000	1500
4	2	0.035	2.4	1.80	700	1050	1400	2100
6	2	0.055	3.6	2.70	1100	1650	2200	3300
8	2	0.070	4.8	3.60	1400	2100	2800	4200
10	2	0.090	6.0	4.50	1800	2700	3600	5400
12	2	0.105	7.2	5.40	2100	3150	4200	


2	2	0.020	1.2	0.90	400	600	800	1200
3	2	0.030	1.8	1.35	600	900	1200	1800
4	2	0.040	2.4	1.80	800	1200	1600	2400
6	2	0.060	3.6	2.70	1200	1800	2400	3600
8	2	0.080	4.8	3.60	1600	2400	3200	4800
10	2	0.100	6.0	4.50	2000	3000	4000	6000
12	2	0.115	7.2	5.40	2300	3450	4600	

## Anwendung



## Werkstoff



CFK


GFK



Aluminium  
Si > 6%

Graphit



d1 [mm]	z	fz [mm]	ap [mm]	ae [mm]	n=10000 min <sup>-1</sup> vf [mm/min]	n=15000 min <sup>-1</sup> vf [mm/min]	n=20000 min <sup>-1</sup> vf [mm/min]	n=30000 min <sup>-1</sup> vf [mm/min]
2	2	0.025	0.20	0.20	500	750	1000	1500
3	2	0.035	0.30	0.30	700	1050	1400	2100
4	2	0.045	0.40	0.40	900	1350	1800	2700
6	2	0.070	0.60	0.60	1400	2100	2800	4200
8	2	0.095	0.80	0.80	1900	2850	3800	5700
10	2	0.120	1.00	1.00	2400	3600	4800	7200
12	2	0.135	1.20	1.20	2700	4050	5400	

2	2	0.020	0.20	0.20	400	600	800	1200
3	2	0.030	0.30	0.30	600	900	1200	1800
4	2	0.040	0.40	0.40	800	1200	1600	2400
6	2	0.060	0.60	0.60	1200	1800	2400	3600
8	2	0.080	0.80	0.80	1600	2400	3200	4800
10	2	0.100	1.00	1.00	2000	3000	4000	6000
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2	2	0.020	0.20	0.20	400	600	800	1200
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4	2	0.040	0.40	0.40	800	1200	1600	2400
6	2	0.060	0.60	0.60	1200	1800	2400	3600
8	2	0.080	0.80	0.80	1600	2400	3200	4800
10	2	0.100	1.00	1.00	2000	3000	4000	6000
12	2	0.115	1.20	1.20	2300	3450	4600	