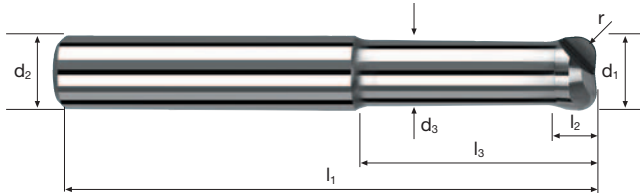
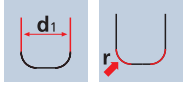


Eckradiusfräser XSpeed-CBN

Zylindrischer Hals, 3xd



CBN λ **0°**
 γ **0°**



HRC 48-56
HRC 56-60
HRC > 60
HSS

Beispiel: Bestell-Nr.											
	Beschichtung		Artikel-Nr.		α-Code						
			31410		.220						31410
Ø Code	d1 0/-0.01	d2 h5	d3	l1	l2	l3	r 0/+0.015	α	z		
.220	4	6	3.7	80	1.9	12	1.00	3.8°	2	●	
.260	5	6	4.6	80	2.5	15	1.25	1.8°	2	●	
.300	6	6	5.5	80	3.0	20	1.50	0.0°	2	●	
.391	8	8	7.4	100	4.0	26	2.00	0.0°	2	●	
.450	10	10	9.2	100	5.0	31	2.50	0.0°	2	●	
.501	12	12	11.0	120	6.0	37	3.00	0.0°	2	●	



Werkstoff

Werkzeugstahl gehärtet
52 - 56 HRC

d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	d _{eff} [mm]	n [min ⁻¹]	v _f [mm/min]	r [mm]
4	2	650	0.020	0.020	0.040	2.40	60000	2400	r=1.00
5	2	650	0.025	0.026	0.050	3.01	60000	3000	r=1.25
6	2	650	0.030	0.030	0.060	3.60	57475	3450	r=1.50
8	2	650	0.040	0.040	0.080	4.80	43105	3450	r=2.00
10	2	650	0.050	0.030	0.100	5.77	35860	3585	r=2.50
12	2	650	0.060	0.036	0.120	6.93	29855	3585	r=3.00

Werkzeugstahl gehärtet
56 - 60 HRC

4	2	620	0.020	0.020	0.040	2.40	60000	2400	r=1.00
5	2	620	0.025	0.026	0.050	3.01	60000	3000	r=1.25
6	2	620	0.030	0.030	0.060	3.60	54820	3290	r=1.50
8	2	620	0.040	0.040	0.080	4.80	41115	3290	r=2.00
10	2	620	0.050	0.030	0.100	5.77	34205	3420	r=2.50
12	2	620	0.060	0.036	0.120	6.93	28480	3420	r=3.00

Werkzeugstahl gehärtet
> 60 HRC

4	2	580	0.020	0.020	0.040	2.40	60000	2400	r=1.00
5	2	580	0.025	0.026	0.050	3.01	60000	3000	r=1.25
6	2	580	0.030	0.030	0.060	3.60	51285	3075	r=1.50
8	2	580	0.040	0.040	0.080	4.80	38465	3075	r=2.00
10	2	580	0.050	0.030	0.100	5.77	31995	3200	r=2.50
12	2	580	0.060	0.036	0.120	6.93	26640	3195	r=3.00



Werkstoff

Werkzeugstahl gehärtet
52 - 56 HRC

d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	d _{eff} [mm]	n [min ⁻¹]	v _f [mm/min]	β [°]
4	2	700	0.020	0.016	0.016	3.64	60000	2400	45°
5	2	700	0.025	0.020	0.020	4.55	48970	2450	45°
6	2	700	0.030	0.022	0.022	5.45	40885	2455	45°
8	2	700	0.040	0.024	0.024	7.23	30820	2465	45°
10	2	700	0.050	0.026	0.026	9.01	24730	2475	45°
12	2	700	0.060	0.032	0.032	10.82	20595	2470	45°

Werkzeugstahl gehärtet
56 - 60 HRC

4	2	650	0.020	0.016	0.016	3.64	56845	2275	45°
5	2	650	0.025	0.020	0.020	4.55	45475	2275	45°
6	2	650	0.030	0.022	0.022	5.45	37965	2280	45°
8	2	650	0.040	0.024	0.024	7.23	28620	2290	45°
10	2	650	0.050	0.026	0.026	9.01	22965	2295	45°
12	2	650	0.060	0.032	0.032	10.82	19125	2295	45°

Werkzeugstahl gehärtet
> 60 HRC

4	2	600	0.020	0.016	0.016	3.64	52470	2100	45°
5	2	600	0.025	0.020	0.020	4.55	41975	2100	45°
6	2	600	0.030	0.022	0.022	5.45	35045	2105	45°
8	2	600	0.040	0.024	0.024	7.23	26415	2115	45°
10	2	600	0.050	0.026	0.026	9.01	21200	2120	45°
12	2	600	0.060	0.032	0.032	10.82	17650	2120	45°