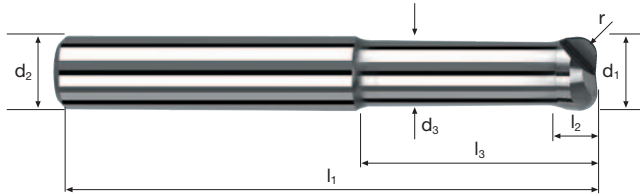
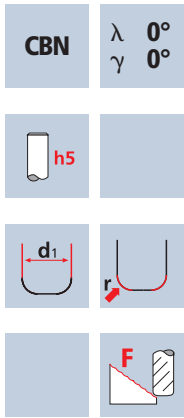


Eckradiusfräser XSpeed-CBN

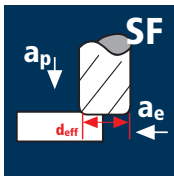
Zylindrischer Hals, 3xd



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

| Ø Code | d1 0/-0.01 | d2 h5 | d3 | l1 | l2 | l3 | r 0/+0.015 | α | z | Beispiel: Bestell-Nr. | |
|-------------|---------------|----------|------|-----|-----|----|---------------|------|---|--------------------------|--------------|
| | | | | | | | | | | Beschichtung | Artikel-Nr. |
| | | | | | | | | | | | |
| | | | | | | | | | | | 31420 |
| .220 | 4 | 6 | 3.7 | 80 | 1.9 | 12 | 0.5 | 3.7° | 2 | ● | |
| .260 | 5 | 6 | 4.6 | 80 | 2.5 | 15 | 0.5 | 1.7° | 2 | ● | |
| .300 | 6 | 6 | 5.5 | 80 | 3.0 | 20 | 0.5 | 0.0° | 2 | ● | |
| .391 | 8 | 8 | 7.4 | 100 | 4.0 | 26 | 0.5 | 0.0° | 2 | ● | |
| .450 | 10 | 10 | 9.2 | 100 | 5.0 | 31 | 0.5 | 0.0° | 2 | ● | |
| .501 | 12 | 12 | 11.0 | 120 | 6.0 | 37 | 0.5 | 0.0° | 2 | ● | |
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Anwendung



Werkstoff

Werkzeugstahl gehärtet
52 - 56 HRC



Werkzeugstahl gehärtet
56 - 60 HRC



Werkzeugstahl gehärtet
> 60 HRC

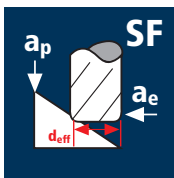


| d1 [mm] | z | v _c [m/min] | f _z [mm] | a _p [mm] | a _e [mm] | d _{eff} [mm] | n [min ⁻¹] | v _f [mm/min] | r [mm] |
|---------|---|------------------------|---------------------|---------------------|---------------------|-----------------------|------------------------|-------------------------|--------|
| 4 | 2 | 650 | 0.020 | 0.020 | 0.040 | 3.28 | 60000 | 2400 | r=0.5 |
| 5 | 2 | 650 | 0.025 | 0.026 | 0.050 | 4.32 | 47895 | 2395 | r=0.5 |
| 6 | 2 | 650 | 0.030 | 0.030 | 0.060 | 5.34 | 38745 | 2325 | r=0.5 |
| 8 | 2 | 650 | 0.040 | 0.040 | 0.080 | 7.39 | 28000 | 2240 | r=0.5 |
| 10 | 2 | 650 | 0.050 | 0.030 | 0.100 | 9.34 | 22155 | 2215 | r=0.5 |
| 12 | 2 | 650 | 0.060 | 0.036 | 0.120 | 11.37 | 18200 | 2185 | r=0.5 |

| | | | | | | | | | |
|----|---|-----|-------|-------|-------|-------|-------|------|-------|
| 4 | 2 | 620 | 0.020 | 0.020 | 0.040 | 3.28 | 60000 | 2400 | r=0.5 |
| 5 | 2 | 620 | 0.025 | 0.026 | 0.050 | 4.32 | 45685 | 2285 | r=0.5 |
| 6 | 2 | 620 | 0.030 | 0.030 | 0.060 | 5.34 | 36960 | 2220 | r=0.5 |
| 8 | 2 | 620 | 0.040 | 0.040 | 0.080 | 7.39 | 26705 | 2135 | r=0.5 |
| 10 | 2 | 620 | 0.050 | 0.030 | 0.100 | 9.34 | 21130 | 2115 | r=0.5 |
| 12 | 2 | 620 | 0.060 | 0.036 | 0.120 | 11.37 | 17360 | 2085 | r=0.5 |

| | | | | | | | | | |
|----|---|-----|-------|-------|-------|-------|-------|------|-------|
| 4 | 2 | 580 | 0.020 | 0.020 | 0.040 | 3.28 | 56290 | 2250 | r=0.5 |
| 5 | 2 | 580 | 0.025 | 0.026 | 0.050 | 4.32 | 42735 | 2135 | r=0.5 |
| 6 | 2 | 580 | 0.030 | 0.030 | 0.060 | 5.34 | 34575 | 2075 | r=0.5 |
| 8 | 2 | 580 | 0.040 | 0.040 | 0.080 | 7.39 | 24985 | 2000 | r=0.5 |
| 10 | 2 | 580 | 0.050 | 0.030 | 0.100 | 9.34 | 19765 | 1975 | r=0.5 |
| 12 | 2 | 580 | 0.060 | 0.036 | 0.120 | 11.37 | 16240 | 1950 | r=0.5 |

Anwendung



Werkstoff

Werkzeugstahl gehärtet
52 - 56 HRC



Werkzeugstahl gehärtet
56 - 60 HRC



Werkzeugstahl gehärtet
> 60 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 | 3.86 | 57725 | 2310 | 45° |
| 5 | 2 | 700 | 0.025 | 0.020 | 0.020 | 4.88 | 45660 | 2285 | 45° |
| 6 | 2 | 700 | 0.030 | 0.022 | 0.022 | 5.88 | 37895 | 2275 | 45° |
| 8 | 2 | 700 | 0.040 | 0.024 | 0.024 | 7.89 | 28240 | 2260 | 45° |
| 10 | 2 | 700 | 0.050 | 0.026 | 0.026 | 9.90 | 22505 | 2250 | 45° |
| 12 | 2 | 700 | 0.060 | 0.032 | 0.032 | 11.91 | 18710 | 2245 | 45° |

| | | | | | | | | | |
|----|---|-----|-------|-------|-------|-------|-------|------|-----|
| 4 | 2 | 650 | 0.020 | 0.016 | 0.016 | 3.86 | 53605 | 2145 | 45° |
| 5 | 2 | 650 | 0.025 | 0.020 | 0.020 | 4.88 | 42400 | 2120 | 45° |
| 6 | 2 | 650 | 0.030 | 0.022 | 0.022 | 5.88 | 35190 | 2110 | 45° |
| 8 | 2 | 650 | 0.040 | 0.024 | 0.024 | 7.89 | 26225 | 2100 | 45° |
| 10 | 2 | 650 | 0.050 | 0.026 | 0.026 | 9.90 | 20900 | 2090 | 45° |
| 12 | 2 | 650 | 0.060 | 0.032 | 0.032 | 11.91 | 17375 | 2085 | 45° |

| | | | | | | | | | |
|----|---|-----|-------|-------|-------|-------|-------|------|-----|
| 4 | 2 | 600 | 0.020 | 0.016 | 0.016 | 3.86 | 49480 | 1980 | 45° |
| 5 | 2 | 600 | 0.025 | 0.020 | 0.020 | 4.88 | 39140 | 1955 | 45° |
| 6 | 2 | 600 | 0.030 | 0.022 | 0.022 | 5.88 | 32480 | 1950 | 45° |
| 8 | 2 | 600 | 0.040 | 0.024 | 0.024 | 7.89 | 24205 | 1935 | 45° |
| 10 | 2 | 600 | 0.050 | 0.026 | 0.026 | 9.90 | 19290 | 1930 | 45° |
| 12 | 2 | 600 | 0.060 | 0.032 | 0.032 | 11.91 | 16035 | 1925 | 45° |