

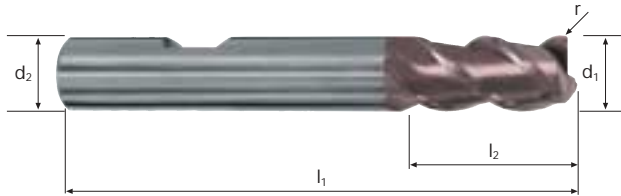
# Eckradiusfräser

Glattschneidig, normale Ausführung



HM  
MG10

$\lambda$  45°  
 $\gamma$  15°



Schruppen



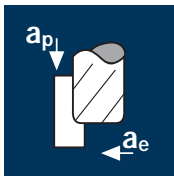
Schichten



Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless		GG(G) Copper
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Ø Code	d1 e8	d2 h6	l1	l2	r 0/+0,03	$\alpha$	Z	UNICUT-4X	
								U5334	U5234
Beispiel: Bestell-Nr. <span style="margin-left: 20px;">Beschichtung</span> <span style="margin-left: 20px;">Artikel-Nr.</span> <span style="margin-left: 20px;">α-Code</span> <span style="margin-left: 20px;">U</span> <span style="margin-left: 20px;">5334</span> <span style="margin-left: 20px;">.178</span>									
.178	3	6	57	7	0.2	6.0°	3	●	
.218	4	6	57	8	0.2	4.0°	3	●	
.258	5	6	57	10	0.2	2.0°	3	●	
.297	6	6	57	10	0.2	0.0°	3	●	
.388	8	8	63	16	0.2	0.0°	3	●	
.445	10	10	72	19	0.2	0.0°	3	●	
.496	12	12	83	22	0.2	0.0°	3	●	
.180	3	6	57	7	0.5	6.0°	3	●	
.220	4	6	57	8	0.5	4.0°	3	●	
.260	5	6	57	10	0.5	2.0°	3	●	
.300	6	6	57	10	0.5	0.0°	3	●	
.391	8	8	63	16	0.5	0.0°	3	●	
.450	10	10	72	19	0.5	0.0°	3	●	
.501	12	12	83	22	0.5	0.0°	3	●	

## Anwendung



## Werkstoff

Stahl  
< 850 N/mm<sup>2</sup>

Stahl  
850 - 1100 N/mm<sup>2</sup>

Guss Eisen  
GG(G)

Nichtrostender Stahl  
[Cr-Ni/1.4301]

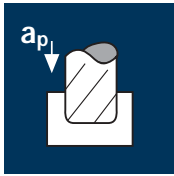
d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>f</sub> [mm/min]	Q [cm <sup>3</sup> /min]
3	3	120	0.010	4.5	0.3	12735	380	0.5
4	3	120	0.015	6.0	0.4	9550	430	1.0
5	3	120	0.015	7.5	0.5	7640	345	1.5
6	3	120	0.020	9.0	0.6	6365	380	2.0
8	3	120	0.025	12.0	0.8	4775	360	3.5
10	3	120	0.035	15.0	1.0	3820	400	6.0
12	3	120	0.040	18.0	1.2	3185	380	8.0

3	3	80	0.010	4.5	0.3	8490	255	0.5
4	3	80	0.015	6.0	0.4	6365	285	0.5
5	3	80	0.015	7.5	0.5	5095	230	1.0
6	3	80	0.020	9.0	0.6	4245	255	1.5
8	3	80	0.025	12.0	0.8	3185	240	2.5
10	3	80	0.035	15.0	1.0	2545	265	4.0
12	3	80	0.040	18.0	1.2	2120	255	5.5

3	3	160	0.010	4.5	0.3	16975	510	0.5
4	3	160	0.015	6.0	0.4	12735	575	1.5
5	3	160	0.015	7.5	0.5	10185	460	1.5
6	3	160	0.020	9.0	0.6	8490	510	3.0
8	3	160	0.025	12.0	0.8	6365	475	4.5
10	3	160	0.035	15.0	1.0	5095	535	8.0
12	3	160	0.040	18.0	1.2	4245	510	11.0

3	3	50	0.010	4.5	0.3	5305	160	0.2
4	3	50	0.015	6.0	0.4	3980	180	0.5
5	3	50	0.015	7.5	0.5	3185	145	0.5
6	3	50	0.020	9.0	0.6	2655	160	1.0
8	3	50	0.025	12.0	0.8	1990	150	1.5
10	3	50	0.035	15.0	1.0	1590	165	2.5
12	3	50	0.040	18.0	1.2	1325	160	3.5

## Anwendung



## Werkstoff

Stahl  
< 850 N/mm<sup>2</sup>

Stahl  
850 - 1100 N/mm<sup>2</sup>

Guss Eisen  
GG(G)

Nichtrostender Stahl  
[Cr-Ni/1.4301]

d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>f</sub> [mm/min]	Q [cm <sup>3</sup> /min]
3	3	100	0.010	1.5	3	10610	320	1.5
4	3	100	0.010	2.0	4	7960	240	2.0
5	3	100	0.015	2.5	5	6365	285	3.5
6	3	100	0.015	3.0	6	5305	240	4.5
8	3	100	0.020	4.0	8	3980	240	7.5
10	3	100	0.030	5.0	10	3185	285	14.5
12	3	100	0.035	6.0	12	2655	280	20.0

3	3	70	0.010	1.5	3	7425	225	1.0
4	3	70	0.010	2.0	4	5570	165	1.5
5	3	70	0.015	2.5	5	4455	200	2.5
6	3	70	0.015	3.0	6	3715	165	3.0
8	3	70	0.020	4.0	8	2785	165	5.5
10	3	70	0.025	5.0	10	2230	165	8.5
12	3	70	0.030	6.0	12	1855	165	12.0

3	3	120	0.010	1.5	3	12735	380	1.5
4	3	120	0.010	2.0	4	9550	285	2.5
5	3	120	0.015	2.5	5	7640	345	4.5
6	3	120	0.020	3.0	6	6365	380	7.0
8	3	120	0.025	4.0	8	4775	360	11.5
10	3	120	0.030	5.0	10	3820	345	17.5
12	3	120	0.035	6.0	12	3185	335	24.0

3	3	35	0.010	1.5	3	3715	110	0.5
4	3	35	0.010	2.0	4	2785	85	0.5
5	3	35	0.015	2.5	5	2230	100	1.5
6	3	35	0.015	3.0	6	1855	85	1.5
8	3	35	0.020	4.0	8	1395	85	2.5
10	3	35	0.025	5.0	10	1115	85	4.5
12	3	35	0.030	6.0	12	930	85	6.0