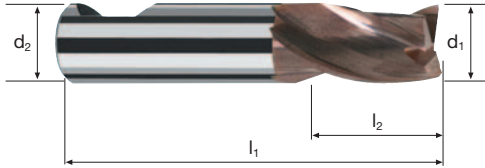


Zylindrische Fräser

Glattschneidig, kurze Schaftausführung

HM λ 30°
 γ 12°

90°



Schruppen



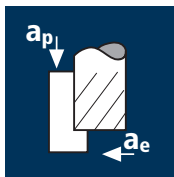
Schlichten



Rm < 850 Rm 850-1100 Rm 1100-1300 **Inox** Stainless Aluminium Copper Gold / Platinum

Ø Code	d1 e8	d2 h6	l1	l2	α	z	Beschichtung		
							Artikel-Nr.	α-Code	
Beispiel: Bestell-Nr. U 45336 .120								5336	U45336
								5236	
.120	1.5	6	38	3	11.5°	3	●	●	
.140	2.0	6	38	3	11.0°	3	●	●	
.160	2.5	6	38	3	10.0°	3	●	●	
.180	3.0	6	38	4	8.0°	3	●	●	
.200	3.5	6	38	4	7.0°	3	●	●	
.220	4.0	6	38	5	5.5°	3	●	●	
.240	4.5	6	38	5	4.5°	3	●	●	
.260	5.0	6	38	6	3.0°	3	●	●	
.300	6.0	6	38	7	0.0°	3	●	●	
.331	7.0	8	41	8	2.5°	3	●	●	
.391	8.0	8	41	9	0.0°	3	●	●	
.420	9.0	10	48	10	2.5°	3	●	●	
.450	10.0	10	48	11	0.0°	3	●	●	

Anwendung

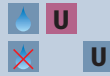


Werkstoff

Stahl
< 850 N/mm²



Stahl
850 - 1100 N/mm²



Gold



Nichtrostender Stahl
[Cr-Ni/1.4301]



d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
2	3	105	0.005	2	0.1	16710	250
3	3	105	0.010	3	0.2	11140	335
4	3	105	0.015	4	0.2	8355	375
5	3	105	0.015	5	0.3	6685	300
6	3	105	0.020	6	0.3	5570	335
7	3	105	0.025	7	0.4	4775	360
8	3	105	0.025	8	0.4	4180	315
9	3	105	0.030	9	0.5	3715	335
10	3	105	0.035	10	0.5	3340	350
2	3	65	0.005	2	0.1	10345	155
3	3	65	0.010	3	0.2	6895	205
4	3	65	0.015	4	0.2	5175	235
5	3	65	0.015	5	0.3	4140	185
6	3	65	0.020	6	0.3	3450	205
7	3	65	0.025	7	0.4	2955	220
8	3	65	0.025	8	0.4	2585	195
9	3	65	0.030	9	0.5	2300	205
10	3	65	0.035	10	0.5	2070	215
2	3	160	0.005	2	0.1	25465	380
3	3	160	0.010	3	0.2	16975	510
4	3	160	0.015	4	0.2	12735	575
5	3	160	0.015	5	0.3	10185	460
6	3	160	0.020	6	0.3	8490	510
7	3	160	0.025	7	0.4	7275	545
8	3	160	0.025	8	0.4	6365	475
9	3	160	0.030	9	0.5	5660	510
10	3	160	0.035	10	0.5	5095	535
2	3	65	0.005	2	0.1	10345	155
3	3	65	0.010	3	0.2	6895	205
4	3	65	0.015	4	0.2	5175	235
5	3	65	0.015	5	0.3	4140	185
6	3	65	0.020	6	0.3	3450	205
7	3	65	0.025	7	0.4	2955	220
8	3	65	0.025	8	0.4	2585	195
9	3	65	0.030	9	0.5	2300	205
10	3	65	0.035	10	0.5	2070	215

Anwendung

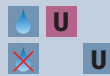


Werkstoff

Stahl
< 850 N/mm²



Stahl
850 - 1100 N/mm²



Gold



Nichtrostender Stahl
[Cr-Ni/1.4301]



d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]	Q [cm ³ /min]
2	3	75	0.005	0.8	2	11935	180	0.3
3	3	75	0.010	1.2	3	7960	240	0.9
4	3	75	0.010	1.6	4	5970	180	1.2
5	3	75	0.015	2.0	5	4775	215	2.2
6	3	75	0.015	2.4	6	3980	180	2.6
7	3	75	0.020	2.8	7	3410	205	4.0
8	3	75	0.020	3.2	8	2985	180	4.6
9	3	75	0.025	3.6	9	2655	200	6.5
10	3	75	0.030	4.0	10	2385	215	8.6
2	3	50	0.005	0.8	2	7960	120	0.2
3	3	50	0.010	1.2	3	5305	160	0.6
4	3	50	0.010	1.6	4	3980	120	0.8
5	3	50	0.015	2.0	5	3185	145	1.5
6	3	50	0.015	2.4	6	2655	120	1.7
7	3	50	0.020	2.8	7	2275	135	2.6
8	3	50	0.020	3.2	8	1990	120	3.1
9	3	50	0.025	3.6	9	1770	135	4.4
10	3	50	0.025	4.0	10	1590	120	4.8
2	3	140	0.005	0.8	2	22280	335	0.5
3	3	140	0.010	1.2	3	14855	445	1.6
4	3	140	0.010	1.6	4	11140	335	2.1
5	3	140	0.015	2.0	5	8915	400	4.0
6	3	140	0.020	2.4	6	7425	445	6.4
7	3	140	0.020	2.8	7	6365	380	7.4
8	3	140	0.025	3.2	8	5570	420	10.8
9	3	140	0.030	3.6	9	4950	445	14.4
10	3	140	0.030	4.0	10	4455	400	16.0
2	3	50	0.005	0.8	2	7960	120	0.2
3	3	50	0.010	1.2	3	5305	160	0.6
4	3	50	0.010	1.6	4	3980	120	0.8
5	3	50	0.015	2.0	5	3185	145	1.5
6	3	50	0.015	2.4	6	2655	120	1.7
7	3	50	0.020	2.8	7	2275	135	2.6
8	3	50	0.020	3.2	8	1990	120	3.1
9	3	50	0.025	3.6	9	1770	135	4.4
10	3	50	0.025	4.0	10	1590	120	4.8