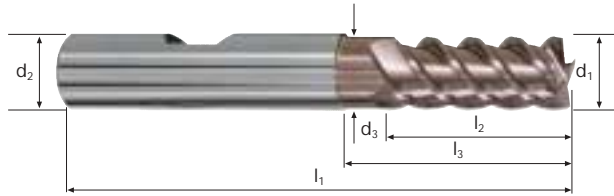


Zylindrische Fräser

Glattschneidig, normale Ausführung mit Kurzhals



HM
MG10 λ 55°
 γ 15°



Schuppen



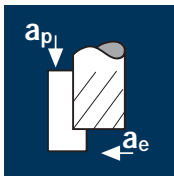
Schichten



Rm < 850 **Rm** 850-1100 **Rm** 1100-1300 **Inox** Stainless **Ti** Titanium **GG(G)** Gold / Platinum

										UNICUT-4X	TRIBO
Beispiel: Bestell-Nr. Beschichtung Artikel-Nr. α-Code										U5355	T5355
										U5255	
Ø Code	d1 e8	d2 h6	d3	l1	l2	l3	45°	α	z		
.300	6	6	5.5	57	13	20	0.15	0.0°	4	●	●
.331*	7	8	-	63	16	-	0.15	1.5°	4	●	●
.391	8	8	7.4	63	19	26	0.15	0.0°	4	●	●
.420*	9	10	-	72	19	-	0.20	1.5°	4	●	●
.450	10	10	9.2	72	22	31	0.20	0.0°	4	●	●
.470*	11	12	-	83	26	-	0.20	1.0°	4	●	●
.501	12	12	11.0	83	26	37	0.20	0.0°	4	●	●
.570	14	14	13.0	83	26	37	0.20	0.0°	4	●	●
.610	16	16	15.0	92	32	43	0.20	0.0°	4	●	●
.640	18	18	17.9	92	32	43	0.20	0.0°	4	●	●
.682	20	20	19.0	104	38	53	0.20	0.0°	4	●	●
* nur ohne Kurzhals											

Anwendung

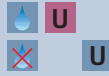


Werkstoff

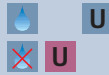
Stahl
< 850 N/mm²



Stahl
850 - 1100 N/mm²



Stahl
1100 - 1300 N/mm²



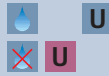
Kaltarbeitsstahl (12% Cr)
hoch legiert [1.2379]
Nichtrostender Stahl
[Cr-Ni/1.4301]



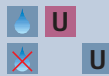
d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
6	4	170	0.020	9.0	1.5	9020	720
7	4	170	0.025	10.5	1.8	7730	775
8	4	170	0.025	12.0	2.0	6765	675
10	4	170	0.035	15.0	2.5	5410	755
12	4	170	0.040	18.0	3.0	4510	720
14	4	170	0.045	21.0	3.5	3865	695
16	4	170	0.055	24.0	4.0	3380	745
18	4	170	0.060	27.0	4.5	3005	720
20	4	170	0.065	30.0	5.0	2705	705
6	4	110	0.020	9.0	1.5	5835	465
7	4	110	0.025	10.5	1.8	5000	500
8	4	110	0.025	12.0	2.0	4375	440
10	4	110	0.035	15.0	2.5	3500	490
12	4	110	0.040	18.0	3.0	2920	465
14	4	110	0.045	21.0	3.5	2500	450
16	4	110	0.055	24.0	4.0	2190	480
18	4	110	0.060	27.0	4.5	1945	465
20	4	110	0.065	30.0	5.0	1750	455
6	4	80	0.020	9.0	0.6	4245	340
7	4	80	0.025	10.5	0.7	3640	365
8	4	80	0.025	12.0	0.8	3185	320
10	4	80	0.035	15.0	1.0	2545	355
12	4	80	0.040	18.0	1.2	2120	340
14	4	80	0.045	21.0	1.4	1820	330
16	4	80	0.055	24.0	1.6	1590	350
18	4	80	0.060	27.0	1.8	1415	340
20	4	80	0.065	30.0	2.0	1275	330
6	4	70	0.020	9.0	1.5	3715	295
7	4	70	0.025	10.5	1.8	3185	320
8	4	70	0.025	12.0	2.0	2785	280
10	4	70	0.035	15.0	2.5	2230	310
12	4	70	0.040	18.0	3.0	1855	295
14	4	70	0.045	21.0	3.5	1590	285
16	4	70	0.055	24.0	4.0	1395	305
18	4	70	0.060	27.0	4.5	1240	300
20	4	70	0.065	30.0	5.0	1115	290

Werkstoff

Gusseisen
GG(G)



Reinkupfer



Titanlegierungen
bis 300 HB
[Ti5Al2.5Sn]



Hitzebeständiger Stahl
[17-4 PH]



d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
6	4	130	0.020	9.0	1.5	6895	550
7	4	130	0.025	10.5	1.8	5910	590
8	4	130	0.025	12.0	2.0	5175	520
10	4	130	0.035	15.0	2.5	4140	580
12	4	130	0.040	18.0	3.0	3450	550
14	4	130	0.045	21.0	3.5	2955	530
16	4	130	0.055	24.0	4.0	2585	570
18	4	130	0.060	27.0	4.5	2300	550
20	4	130	0.065	30.0	5.0	2070	540
6	4	230	0.020	9.0	1.5	12200	975
7	4	230	0.025	10.5	1.8	10460	1045
8	4	230	0.025	12.0	2.0	9150	915
10	4	230	0.035	15.0	2.5	7320	1025
12	4	230	0.040	18.0	3.0	6100	975
14	4	230	0.045	21.0	3.5	5230	940
16	4	230	0.055	24.0	4.0	4575	1005
18	4	230	0.060	27.0	4.5	4065	975
20	4	230	0.065	30.0	5.0	3660	950
6	4	80	0.020	9.0	1.5	4245	340
7	4	80	0.025	10.5	1.8	3640	365
8	4	80	0.025	12.0	2.0	3185	320
10	4	80	0.035	15.0	2.5	2545	355
12	4	80	0.040	18.0	3.0	2120	340
14	4	80	0.045	21.0	3.5	1820	330
16	4	80	0.055	24.0	4.0	1590	350
18	4	80	0.060	27.0	4.5	1415	340
20	4	80	0.065	30.0	5.0	1275	330
6	4	40	0.020	9.0	1.5	2120	170
7	4	40	0.025	10.5	1.8	1820	180
8	4	40	0.025	12.0	2.0	1590	160
10	4	40	0.035	15.0	2.5	1275	180
12	4	40	0.040	18.0	3.0	1060	170
14	4	40	0.045	21.0	3.5	910	165
16	4	40	0.055	24.0	4.0	795	175
18	4	40	0.060	27.0	4.5	705	170
20	4	40	0.065	30.0	5.0	635	165