

Zylindrische Fräser MulticutXA

Schichten, mittellange Ausführung



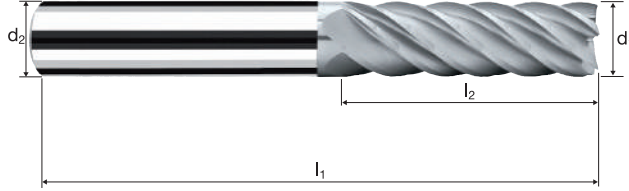
HM
MG10

λ 40°
 γ 20°

r

G 2,5

Vario

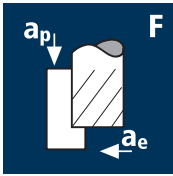


Schruppen Schichten

Al Aluminium > 99% Al Aluminium Alloy Al Aluminium Cast Cu Copper Plastic Thermoplast

								CELERO	
Beispiel: Bestell-Nr. Beschichtung Artikel-Nr. ø-Code									
								15590	C15590
Ø Code	d ₁ e8	d ₂ h6	l ₁	l ₂	r	z			
300	6.00	6.00	63	18.00	0.150	6	●	●	
391	8.00	8.00	72	24.00	0.150	6	●	●	
450	10.00	10.00	84	30.00	0.200	6	●	●	
501	12.00	12.00	97	36.00	0.200	6	●	●	
610	16.00	16.00	108	48.00	0.200	6	●	●	
682	20.00	20.00	122	60.00	0.200	6	●	●	

Anwendung



Werkstoff

Al-Knetlegierung
Al-Integralbau



Reinkupfer



Thermoplaste



Al-Gusslegierung



d1 [mm]	z	f _z [mm]	a _p [mm]	a _e [mm]	n=10000 min ⁻¹ vf [mm/min]	n=15000 min ⁻¹ vf [mm/min]	n=20000 min ⁻¹ vf [mm/min]	n=30000 min ⁻¹ vf [mm/min]
6.00	6	0.020	18.000	0.100	1200	1800	2400	3600
8.00	6	0.020	24.000	0.100	1200	1800	2400	3600
10.00	6	0.025	30.000	0.150	1500	2250	3000	4500
12.00	6	0.025	36.000	0.200	1500	2250	3000	4500
16.00	6	0.030	48.000	0.250	1800	2700	3600	5400
20.00	6	0.030	60.000	0.300	1800	2700	3600	5400
6.00	6	0.020	18.000	0.100	1200	1800	2400	3600
8.00	6	0.020	24.000	0.100	1200	1800	2400	3600
10.00	6	0.025	30.000	0.150	1500	2250	3000	4500
12.00	6	0.025	36.000	0.200	1500	2250	3000	4500
16.00	6	0.030	48.000	0.250	1800	2700	3600	5400
20.00	6	0.030	60.000	0.300	1800	2700	3600	5400
6.00	6	0.020	18.000	0.100	1200	1800	2400	3600
8.00	6	0.020	24.000	0.100	1200	1800	2400	3600
10.00	6	0.025	30.000	0.150	1500	2250	3000	4500
12.00	6	0.025	36.000	0.200	1500	2250	3000	4500
16.00	6	0.030	48.000	0.250	1800	2700	3600	5400
20.00	6	0.030	60.000	0.300	1800	2700	3600	5400