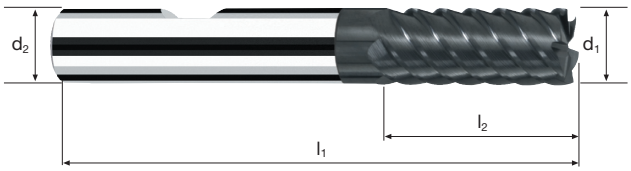
Zylindrische Fräser Multicut HX-H

Schlichten, normale Ausführung

X-Generation

HM XA | **λ 55° γ-10°**

45°



Schruppen

Schlichten

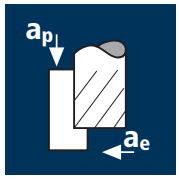
ToolSchool

HRC 48-56 | **HRC** 56-60 | **HRC** > 60 | **HSS GG(G)**

Beispiel: **Bestell-Nr.** — Beschichtung **D** | Artikel-Nr. **5366** | ø-Code **180**

ø Code	d1 e8	d2 h6	l1	l2	45°	α	z	DURO-S D5366	DURO-S D5266
180	3	6	57	8	0.10	6.0°	4		●
220	4	6	57	11	0.10	4.0°	4		●
260	5	6	57	13	0.15	2.0°	5		●
300	6	6	57	13	0.15	0.0°	6		●
391	8	8	63	19	0.15	0.0°	6		●
450	10	10	72	22	0.20	0.0°	6		●
501	12	12	83	26	0.20	0.0°	6		●
610	16	16	92	32	0.20	0.0°	6		●
682	20	20	104	38	0.20	0.0°	8		●

Anwendung



Werkstoff	d1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min⁻¹]	v_f [mm/min]
Werkzeugstahl gehärtet 48 - 52 HRC	3	4	150	0.008	4.5	0.1	15915	510
	4	4	150	0.010	6.0	0.1	11935	475
	5	5	150	0.014	7.5	0.1	9550	670
	6	6	150	0.016	9.0	0.1	7960	765
	8	6	150	0.022	12.0	0.1	5970	790
	10	6	150	0.028	15.0	0.1	4775	800
	12	6	150	0.032	18.0	0.1	3980	765
	16	6	150	0.044	24.0	0.2	2985	790
	20	8	150	0.054	30.0	0.2	2385	1030
Werkzeugstahl gehärtet 52 - 56 HRC	3	4	120	0.008	4.5	0.1	12735	410
	4	4	120	0.010	6.0	0.1	9550	380
	5	5	120	0.014	7.5	0.1	7640	535
	6	6	120	0.016	9.0	0.1	6365	610
	8	6	120	0.022	12.0	0.1	4775	630
	10	6	120	0.028	15.0	0.1	3820	640
	12	6	120	0.032	18.0	0.1	3185	610
	16	6	120	0.044	24.0	0.2	2385	630
	20	8	120	0.054	30.0	0.2	1910	825
Werkzeugstahl gehärtet 56 - 60 HRC	3	4	100	0.008	4.5	0.1	10610	340
	4	4	100	0.010	6.0	0.1	7960	320
	5	5	100	0.014	7.5	0.1	6365	445
	6	6	100	0.016	9.0	0.1	5305	510
	8	6	100	0.022	12.0	0.1	3980	525
	10	6	100	0.028	15.0	0.1	3185	535
	12	6	100	0.032	18.0	0.1	2655	510
	16	6	100	0.044	24.0	0.2	1990	525
	20	8	100	0.054	30.0	0.2	1590	685
Werkzeugstahl gehärtet > 60 HRC	3	4	80	0.008	4.5	0.1	8490	270
	4	4	80	0.010	6.0	0.1	6365	255
	5	5	80	0.012	7.5	0.1	5095	305
	6	6	80	0.016	9.0	0.1	4245	410
	8	6	80	0.020	12.0	0.1	3185	380
	10	6	80	0.026	15.0	0.1	2545	395
	12	6	80	0.030	18.0	0.1	2120	380
	16	6	80	0.040	24.0	0.2	1590	380
	20	8	80	0.050	30.0	0.2	1275	510

Werkstoff	d1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min⁻¹]	v_f [mm/min]
Schnellarbeitsstahl gehärtet	3	4	50	0.008	4.5	0.1	5305	170
	4	4	50	0.010	6.0	0.1	3980	160
	5	5	50	0.012	7.5	0.1	3185	190
	6	6	50	0.016	9.0	0.1	2655	255
	8	6	50	0.020	12.0	0.1	1990	240
	10	6	50	0.026	15.0	0.1	1590	250
	12	6	50	0.030	18.0	0.1	1325	240
	16	6	50	0.040	24.0	0.2	995	240
	20	8	50	0.050	30.0	0.2	795	320
Gusseisen GG(G)	3	4	220	0.008	4.5	0.1	23345	745
	4	4	220	0.010	6.0	0.1	17510	700
	5	5	220	0.014	7.5	0.1	14005	980
	6	6	220	0.016	9.0	0.1	11670	1120
	8	6	220	0.022	12.0	0.1	8755	1155
	10	6	220	0.028	15.0	0.1	7005	1175
	12	6	220	0.032	18.0	0.1	5835	1120
	16	6	220	0.044	24.0	0.2	4375	1155
	20	8	220	0.054	30.0	0.2	3500	1510