

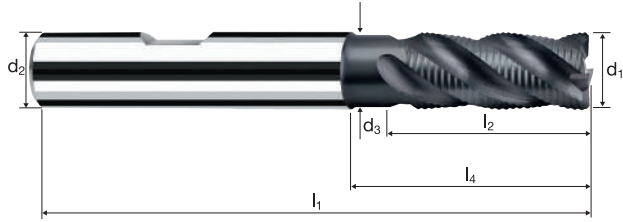
Zylindrische Fräser SupraCarb®

Profiliert, normale Ausführung mit Kurzhals



HM λ **38°**
MG10 γ **0°**

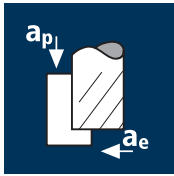
45°



Rm < 850 Rm 850-1100 Rm 1100-1300 Inox Stainless Ti Titanium GG(G) Tool Steel

| Ø Code | d ₁ e8 | d ₂ h6 | d ₃ | l ₁ | l ₂ | l ₃ | l ₄ | 45° | α | z | POLYCHROM | |
|-----------|----------------------|----------------------|----------------|----------------|----------------|----------------|----------------|------|------|---|-------------|-------------|
| | | | | | | | | | | | Bestell-Nr. | Artikel-Nr. |
| 180 | 3.00 | 6.00 | 2.80 | 57 | 8.00 | 14.00 | 20.63 | 0.25 | 4.5° | 3 | | ● |
| 220 | 4.00 | 6.00 | 3.70 | 57 | 11.00 | 16.00 | 20.95 | 0.30 | 3.0° | 3 | | ● |
| 260 | 5.00 | 6.00 | 4.60 | 57 | 13.00 | 18.00 | 21.27 | 0.35 | 1.5° | 4 | | ● |
| 300 | 6.00 | 6.00 | 5.50 | 57 | 13.00 | 19.34 | 20.00 | 0.35 | 0.0° | 4 | | ● |
| 391 | 8.00 | 8.00 | 7.40 | 63 | 19.00 | 25.29 | 26.00 | 0.45 | 0.0° | 4 | | ● |
| 450 | 10.00 | 10.00 | 9.20 | 72 | 22.00 | 30.20 | 31.00 | 0.60 | 0.0° | 4 | | ● |
| 501 | 12.00 | 12.00 | 11.00 | 83 | 26.00 | 36.13 | 37.00 | 0.60 | 0.0° | 4 | | ● |
| 570 | 14.00 | 14.00 | 13.00 | 83 | 26.00 | 36.13 | 37.00 | 0.60 | 0.0° | 4 | | ● |
| 610 | 16.00 | 16.00 | 15.00 | 92 | 32.00 | 42.13 | 43.00 | 0.70 | 0.0° | 4 | | ● |
| 612 | 16.00 | 16.00 | 15.00 | 92 | 32.00 | 42.13 | 43.00 | 0.70 | 0.0° | 6 | | ● |
| 640 | 18.00 | 18.00 | 17.00 | 92 | 32.00 | 42.13 | 43.00 | 0.70 | 0.0° | 4 | | ● |
| 682 | 20.00 | 20.00 | 19.00 | 104 | 38.00 | 52.13 | 53.00 | 0.70 | 0.0° | 4 | | ● |
| 684 | 20.00 | 20.00 | 19.00 | 104 | 38.00 | 52.13 | 53.00 | 0.70 | 0.0° | 6 | | ● |

Anwendung



Werkstoff

Stahl
< 850 N/mm²



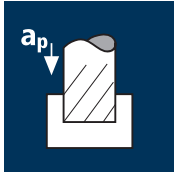
Stahl
850 - 1100 N/mm²



Titanlegierungen ausg.
> 300 HB
[Ti6Al4V]



Inox normal
[Cr-Ni/1.4301]
[Cr-Ni-Mo/1.4571]



Stahl
< 850 N/mm²



Stahl
850 - 1100 N/mm²



Titanlegierungen ausg.
> 300 HB
[Ti6Al4V]



Inox normal
[Cr-Ni/1.4301]
[Cr-Ni-Mo/1.4571]



| d1 [mm] | z | v _c [m/min] | f _s [mm] | a _p [mm] | a _e [mm] | n [min ⁻¹] | v _r [mm/min] | Q [cm ³ /min] |
|------------|---|---------------------------|------------------------|------------------------|------------------------|---------------------------|----------------------------|-----------------------------|
| 3.00 | 3 | 180 | 0.015 | 3.600 | 1.800 | 19100 | 860 | 5.6 |
| 4.00 | 3 | 180 | 0.020 | 4.800 | 2.400 | 14325 | 860 | 9.9 |
| 5.00 | 4 | 180 | 0.025 | 6.000 | 3.000 | 11460 | 1145 | 20.6 |
| 6.00 | 4 | 180 | 0.030 | 7.200 | 3.600 | 9550 | 1145 | 29.7 |
| 8.00 | 4 | 180 | 0.040 | 9.600 | 4.800 | 7160 | 1145 | 52.8 |
| 10.00 | 4 | 180 | 0.050 | 12.000 | 6.000 | 5730 | 1145 | 82.5 |
| 12.00 | 4 | 180 | 0.055 | 14.400 | 7.200 | 4775 | 1050 | 108.9 |
| 16.00 | 4 | 180 | 0.055 | 19.200 | 9.600 | 3580 | 790 | 145.2 |
| 20.00 | 4 | 180 | 0.060 | 24.000 | 12.000 | 2865 | 690 | 198.0 |
| 3.00 | 3 | 130 | 0.015 | 3.600 | 1.800 | 13795 | 620 | 4.0 |
| 4.00 | 3 | 130 | 0.020 | 4.800 | 2.400 | 10345 | 620 | 7.2 |
| 5.00 | 4 | 130 | 0.025 | 6.000 | 3.000 | 8275 | 830 | 14.9 |
| 6.00 | 4 | 130 | 0.030 | 7.200 | 3.600 | 6895 | 830 | 21.5 |
| 8.00 | 4 | 130 | 0.040 | 9.600 | 4.800 | 5175 | 830 | 38.1 |
| 10.00 | 4 | 130 | 0.050 | 12.000 | 6.000 | 4140 | 830 | 59.6 |
| 12.00 | 4 | 130 | 0.055 | 14.400 | 7.200 | 3450 | 760 | 78.7 |
| 16.00 | 4 | 130 | 0.055 | 19.200 | 9.600 | 2585 | 570 | 104.9 |
| 20.00 | 4 | 130 | 0.060 | 24.000 | 12.000 | 2070 | 495 | 143.0 |
| 3.00 | 3 | 45 | 0.010 | 3.600 | 1.800 | 4775 | 145 | 0.9 |
| 4.00 | 3 | 45 | 0.015 | 4.800 | 2.400 | 3580 | 160 | 1.9 |
| 5.00 | 4 | 45 | 0.020 | 6.000 | 3.000 | 2865 | 230 | 4.1 |
| 6.00 | 4 | 45 | 0.025 | 7.200 | 3.600 | 2385 | 240 | 6.2 |
| 8.00 | 4 | 45 | 0.030 | 9.600 | 4.800 | 1790 | 215 | 9.9 |
| 10.00 | 4 | 45 | 0.040 | 12.000 | 6.000 | 1430 | 230 | 16.5 |
| 12.00 | 4 | 45 | 0.045 | 14.400 | 7.200 | 1195 | 215 | 22.3 |
| 16.00 | 4 | 45 | 0.045 | 19.200 | 9.600 | 895 | 160 | 29.7 |
| 20.00 | 4 | 45 | 0.050 | 24.000 | 12.000 | 715 | 145 | 41.3 |
| 3.00 | 3 | 60 | 0.010 | 3.600 | 1.800 | 6365 | 190 | 1.2 |
| 4.00 | 3 | 60 | 0.015 | 4.800 | 2.400 | 4775 | 215 | 2.5 |
| 5.00 | 4 | 60 | 0.020 | 6.000 | 3.000 | 3820 | 305 | 5.5 |
| 6.00 | 4 | 60 | 0.025 | 7.200 | 3.600 | 3185 | 320 | 8.3 |
| 8.00 | 4 | 60 | 0.030 | 9.600 | 4.800 | 2385 | 285 | 13.2 |
| 10.00 | 4 | 60 | 0.040 | 12.000 | 6.000 | 1910 | 305 | 22.0 |
| 12.00 | 4 | 60 | 0.045 | 14.400 | 7.200 | 1590 | 285 | 29.7 |
| 16.00 | 4 | 60 | 0.045 | 16.800 | 8.400 | 1195 | 215 | 30.3 |
| 20.00 | 4 | 60 | 0.050 | 24.000 | 12.000 | 955 | 190 | 55.0 |
| 3.00 | 3 | 150 | 0.015 | 3.000 | 3.000 | 15915 | 715 | 6.4 |
| 4.00 | 3 | 150 | 0.020 | 4.000 | 4.000 | 11935 | 715 | 11.5 |
| 5.00 | 4 | 150 | 0.025 | 5.000 | 5.000 | 9550 | 955 | 23.9 |
| 6.00 | 4 | 150 | 0.030 | 6.000 | 6.000 | 7960 | 955 | 34.4 |
| 8.00 | 4 | 150 | 0.040 | 8.000 | 8.000 | 5970 | 955 | 61.1 |
| 10.00 | 4 | 150 | 0.050 | 10.000 | 10.000 | 4775 | 955 | 95.5 |
| 12.00 | 4 | 150 | 0.055 | 12.000 | 12.000 | 3980 | 875 | 126.1 |
| 16.00 | 4 | 150 | 0.055 | 16.000 | 16.000 | 2985 | 655 | 168.1 |
| 20.00 | 4 | 150 | 0.060 | 20.000 | 20.000 | 2385 | 575 | 229.2 |
| 3.00 | 3 | 80 | 0.015 | 3.000 | 3.000 | 8490 | 380 | 3.4 |
| 4.00 | 3 | 80 | 0.020 | 4.000 | 4.000 | 6365 | 380 | 6.1 |
| 5.00 | 4 | 80 | 0.025 | 5.000 | 5.000 | 5095 | 510 | 12.7 |
| 6.00 | 4 | 80 | 0.030 | 6.000 | 6.000 | 4245 | 510 | 18.3 |
| 8.00 | 4 | 80 | 0.040 | 8.000 | 8.000 | 3185 | 510 | 32.6 |
| 10.00 | 4 | 80 | 0.050 | 10.000 | 10.000 | 2545 | 510 | 50.9 |
| 12.00 | 4 | 80 | 0.055 | 12.000 | 12.000 | 2120 | 465 | 67.2 |
| 16.00 | 4 | 80 | 0.055 | 16.000 | 16.000 | 1590 | 350 | 89.6 |
| 20.00 | 4 | 80 | 0.060 | 20.000 | 20.000 | 1275 | 305 | 122.2 |
| 3.00 | 3 | 35 | 0.010 | 3.000 | 3.000 | 3715 | 110 | 1.0 |
| 4.00 | 3 | 35 | 0.015 | 4.000 | 4.000 | 2785 | 125 | 2.0 |
| 5.00 | 4 | 35 | 0.020 | 5.000 | 5.000 | 2230 | 180 | 4.5 |
| 6.00 | 4 | 35 | 0.025 | 6.000 | 6.000 | 1855 | 185 | 6.7 |
| 8.00 | 4 | 35 | 0.030 | 8.000 | 8.000 | 1395 | 165 | 10.7 |
| 10.00 | 4 | 35 | 0.040 | 10.000 | 10.000 | 1115 | 180 | 17.8 |
| 12.00 | 4 | 35 | 0.045 | 12.000 | 12.000 | 930 | 165 | 24.1 |
| 16.00 | 4 | 35 | 0.045 | 16.000 | 16.000 | 695 | 125 | 32.1 |
| 20.00 | 4 | 35 | 0.050 | 20.000 | 20.000 | 555 | 110 | 44.6 |
| 3.00 | 3 | 50 | 0.010 | 3.000 | 3.000 | 5305 | 160 | 1.4 |
| 4.00 | 3 | 50 | 0.015 | 4.000 | 4.000 | 3980 | 180 | 2.9 |
| 5.00 | 4 | 50 | 0.020 | 5.000 | 5.000 | 3185 | 255 | 6.4 |
| 6.00 | 4 | 50 | 0.025 | 6.000 | 6.000 | 2655 | 265 | 9.5 |
| 8.00 | 4 | 50 | 0.030 | 8.000 | 8.000 | 1990 | 240 | 15.3 |
| 10.00 | 4 | 50 | 0.040 | 10.000 | 10.000 | 1590 | 255 | 25.5 |
| 12.00 | 4 | 50 | 0.045 | 12.000 | 12.000 | 1325 | 240 | 34.4 |
| 16.00 | 4 | 50 | 0.045 | 16.000 | 16.000 | 995 | 180 | 45.8 |
| 20.00 | 4 | 50 | 0.050 | 20.000 | 20.000 | 795 | 160 | 63.7 |