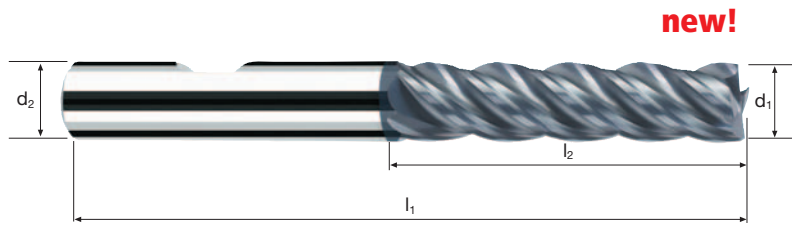


Zylindrische Fräser NF-NV

Glattschneidig, lange Ausführung



HM λ 40°
 γ 6°



Schruppen



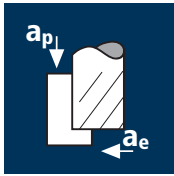
Schichten



Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless	Ti Titanium	GG(G) Tool Steel
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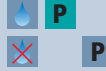
							POLYCHROM	
Beispiel: Bestell-Nr.							P45323	
							P45223	
\emptyset Code	d1 e8	d2 h6	l1	l2	45°	z		
.300	6	6	70	26	0.15	4	●	
.391	8	8	80	36	0.15	4	●	
.450	10	10	100	45	0.20	4	●	
.501	12	12	110	53	0.20	4	●	
.610	16	16	123	63	0.20	4	●	
.682	20	20	141	75	0.20	4	●	

Anwendung



Werkstoff

Stahl
< 850 N/mm²



Stahl
850 - 1100 N/mm²



Stahl
1100 - 1300 N/mm²



Nichtrostender Stahl
[Cr-Ni/1.4301]



Werkstoff

Gusseisen
GG(G)



Kaltarbeitsstahl
(12% Cr)
hoch legiert
[1.2379]



Titanlegierungen
>300 HB
[Ti6Al4V]



Hitzebeständiger Stahl
Duplex-Stahl
[1.4462]
[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]	Q [cm ³ /min]
6	4	130	0.045	15.0	0.6	6895	1240	11.0
8	4	130	0.060	20.0	0.8	5175	1240	20.0
10	4	130	0.075	25.0	1.0	4140	1240	31.0
12	4	130	0.090	30.0	1.2	3450	1240	44.5
16	4	130	0.115	40.0	1.6	2585	1190	76.0
20	4	130	0.145	50.0	2.0	2070	1200	120.0

6	4	120	0.040	15.0	0.6	6365	1020	9.0
8	4	120	0.050	20.0	0.8	4775	955	15.5
10	4	120	0.065	25.0	1.0	3820	995	25.0
12	4	120	0.080	30.0	1.2	3185	1020	36.5
16	4	120	0.100	40.0	1.6	2385	955	61.0
20	4	120	0.125	50.0	2.0	1910	955	95.5

6	4	100	0.035	15.0	0.6	5305	745	6.5
8	4	100	0.045	20.0	0.8	3980	715	11.5
10	4	100	0.060	25.0	1.0	3185	765	19.0
12	4	100	0.070	30.0	1.2	2655	745	27.0
16	4	100	0.090	40.0	1.6	1990	715	46.0
20	4	100	0.110	50.0	2.0	1590	700	70.0

6	4	80	0.025	15.0	0.45	4245	425	3.0
8	4	80	0.030	20.0	0.60	3185	380	4.5
10	4	80	0.040	25.0	0.75	2545	405	7.5
12	4	80	0.050	30.0	0.90	2120	425	11.5
16	4	80	0.060	40.0	1.20	1590	380	18.0
20	4	80	0.075	50.0	1.50	1275	385	29.0

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]
6	4	120	0.045	15.0	0.6	6365	1145	10.5
8	4	120	0.060	20.0	0.8	4775	1145	18.5
10	4	120	0.070	25.0	1.0	3820	1070	27.0
12	4	120	0.085	30.0	1.2	3185	1085	39.0
16	4	120	0.110	40.0	1.6	2385	1050	67.0
20	4	120	0.135	50.0	2.0	1910	1030	103.0

6	4	65	0.045	15.0	0.45	3450	550	5.0
8	4	65	0.060	20.0	0.60	2585	515	8.0
10	4	65	0.075	25.0	0.75	2070	540	13.5
12	4	65	0.090	30.0	0.90	1725	550	20.0
16	4	65	0.115	40.0	1.20	1295	520	33.5
20	4	65	0.145	50.0	1.50	1035	520	52.0

6	4	50	0.030	15.0	0.6	2655	320	3.0
8	4	50	0.035	20.0	0.8	1990	280	4.5
10	4	50	0.045	25.0	1.0	1590	285	7.0
12	4	50	0.055	30.0	1.2	1325	290	10.5
16	4	50	0.065	40.0	1.6	995	260	16.5
20	4	50	0.085	50.0	2.0	795	270	27.0

6	4	40	0.025	15.0	0.45	2120	210	1.5
8	4	40	0.030	20.0	0.60	1590	190	2.5
10	4	40	0.040	25.0	0.75	1275	205	4.0
12	4	40	0.050	30.0	0.90	1060	210	5.5
16	4	40	0.060	40.0	1.20	795	190	9.0
20	4	40	0.075	50.0	1.50	635	190	14.5