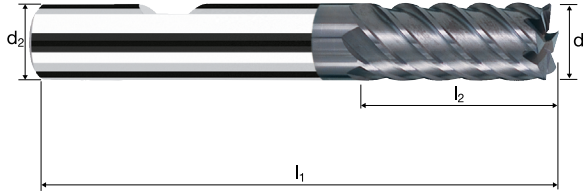


Zylindrische Fräser Multicut N

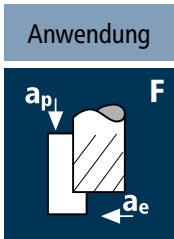
Schichten, normale Ausführung

| | |
|-------------|---------------|
| HM | λ 45° |
| MG10 | γ 8° |



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|-----------------------|------------------------|------------------------|--|--|--|-----------------------|------------------------|
| Rm 850-1100 | Rm 1100-1300 | Rm 1300-1500 | | | | Ti Titanium | GG(G) Copper |
|-----------------------|------------------------|------------------------|--|--|--|-----------------------|------------------------|

| | | | | | | | | POLYCHROM | |
|---------------------------------|----------------------------------|----------------------------------|----------------|----------------|------|------------|--|------------------|--------------|
| Beispiel: Bestell-Nr. | | Beschichtung | | Artikel-Nr. | | ø-Code | | | |
| | | P | | 5360 | | 300 | | | P5360 |
| | | | | | | | | | P5260 |
| Ø Code | d ₁ e ₈ | d ₂ h ₆ | l ₁ | l ₂ | 45° | z | | | |
| 300 | 6.00 | 6.00 | 57 | 13.00 | 0.15 | 6 | | | ● |
| 391 | 8.00 | 8.00 | 63 | 19.00 | 0.15 | 6 | | | ● |
| 450 | 10.00 | 10.00 | 72 | 22.00 | 0.20 | 6 | | | ● |
| 501 | 12.00 | 12.00 | 83 | 26.00 | 0.20 | 6 | | | ● |
| 610 | 16.00 | 16.00 | 92 | 32.00 | 0.20 | 8 | | | ● |
| 682 | 20.00 | 20.00 | 104 | 38.00 | 0.20 | 10 | | | ● |
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Werkstoff

Stahl
850 - 1100 N/mm²

Stahl
1100 - 1300 N/mm²

Stahl
1300 - 1500 N/mm²

Gusseisen
GG(G)

Titanlegierungen ausg.
> 300 HB
[Ti6Al4V]

Reinkupfer

| d1 [mm] | z | v _c [m/min] | f _i [mm] | a _p [mm] | a _e [mm] | n [min ⁻¹] | v _r [mm/min] |
|---------|----|------------------------|---------------------|---------------------|---------------------|------------------------|-------------------------|
| 6.00 | 6 | 140 | 0.015 | 9.000 | 0.100 | 7425 | 670 |
| 8.00 | 6 | 140 | 0.025 | 12.000 | 0.100 | 5570 | 835 |
| 10.00 | 6 | 140 | 0.030 | 15.000 | 0.100 | 4455 | 800 |
| 12.00 | 6 | 140 | 0.035 | 18.000 | 0.100 | 3715 | 780 |
| 16.00 | 8 | 140 | 0.045 | 24.000 | 0.200 | 2785 | 1005 |
| 20.00 | 10 | 140 | 0.055 | 30.000 | 0.200 | 2230 | 1225 |

| | | | | | | | |
|-------|----|-----|-------|--------|-------|------|------|
| 6.00 | 6 | 120 | 0.015 | 9.000 | 0.100 | 6365 | 575 |
| 8.00 | 6 | 120 | 0.025 | 12.000 | 0.100 | 4775 | 715 |
| 10.00 | 6 | 120 | 0.030 | 15.000 | 0.100 | 3820 | 690 |
| 12.00 | 6 | 120 | 0.035 | 18.000 | 0.100 | 3185 | 670 |
| 16.00 | 8 | 120 | 0.045 | 24.000 | 0.200 | 2385 | 860 |
| 20.00 | 10 | 120 | 0.055 | 30.000 | 0.200 | 1910 | 1050 |

| | | | | | | | |
|-------|----|----|-------|--------|-------|------|-----|
| 6.00 | 6 | 80 | 0.016 | 9.000 | 0.100 | 4245 | 405 |
| 8.00 | 6 | 80 | 0.020 | 12.000 | 0.100 | 3185 | 380 |
| 10.00 | 6 | 80 | 0.026 | 15.000 | 0.100 | 2545 | 395 |
| 12.00 | 6 | 80 | 0.030 | 18.000 | 0.100 | 2120 | 380 |
| 16.00 | 8 | 80 | 0.040 | 24.000 | 0.200 | 1590 | 510 |
| 20.00 | 10 | 80 | 0.050 | 30.000 | 0.200 | 1275 | 635 |

| | | | | | | | |
|-------|----|-----|-------|--------|-------|------|------|
| 6.00 | 6 | 140 | 0.015 | 9.000 | 0.100 | 7425 | 670 |
| 8.00 | 6 | 140 | 0.025 | 12.000 | 0.100 | 5570 | 835 |
| 10.00 | 6 | 140 | 0.030 | 15.000 | 0.100 | 4455 | 800 |
| 12.00 | 6 | 140 | 0.035 | 18.000 | 0.100 | 3715 | 780 |
| 16.00 | 8 | 140 | 0.045 | 24.000 | 0.200 | 2785 | 1005 |
| 20.00 | 10 | 140 | 0.055 | 30.000 | 0.200 | 2230 | 1225 |

| | | | | | | | |
|-------|----|----|-------|--------|-------|------|-----|
| 6.00 | 6 | 60 | 0.015 | 9.000 | 0.100 | 3185 | 285 |
| 8.00 | 6 | 60 | 0.025 | 12.000 | 0.100 | 2385 | 360 |
| 10.00 | 6 | 60 | 0.030 | 15.000 | 0.100 | 1910 | 345 |
| 12.00 | 6 | 60 | 0.035 | 18.000 | 0.100 | 1590 | 335 |
| 16.00 | 8 | 60 | 0.045 | 24.000 | 0.200 | 1195 | 430 |
| 20.00 | 10 | 60 | 0.055 | 30.000 | 0.200 | 955 | 525 |

| | | | | | | | |
|-------|----|-----|-------|--------|-------|-------|------|
| 6.00 | 6 | 200 | 0.015 | 9.000 | 0.100 | 10610 | 955 |
| 8.00 | 6 | 200 | 0.025 | 12.000 | 0.100 | 7960 | 1195 |
| 10.00 | 6 | 200 | 0.030 | 15.000 | 0.100 | 6365 | 1145 |
| 12.00 | 6 | 200 | 0.035 | 18.000 | 0.100 | 5305 | 1115 |
| 16.00 | 8 | 200 | 0.045 | 24.000 | 0.200 | 3980 | 1430 |
| 20.00 | 10 | 200 | 0.055 | 30.000 | 0.200 | 3185 | 1750 |