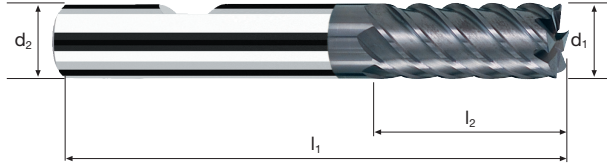


# Zylindrische Fräser Multicut N

Schichten, normale Ausführung



**HM**  
**MG10**     $\lambda$  **45°**  
                     $\gamma$  **8°**



Schuppen



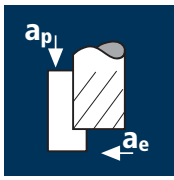
Schichten



	<b>Rm</b> 850-1100	<b>Rm</b> 1100-1300	<b>Rm</b> 1300-1500					<b>Ti</b> Titanium	<b>GG(G)</b> Copper
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							<b>POLYCHROM</b>	
							<b>P5360</b>	
							<b>P5260</b>	
$\emptyset$ Code	d1 e8	d2 h6	l1	l2	45°	z		
<b>300</b>	6	6	57	13	0.15	6	●	
<b>391</b>	8	8	63	19	0.15	6	●	
<b>450</b>	10	10	72	22	0.20	6	●	
<b>501</b>	12	12	83	26	0.20	6	●	
<b>610</b>	16	16	92	32	0.20	8	●	
<b>682</b>	20	20	104	38	0.20	10	●	

## Anwendung



## Werkstoff

Stahl  
850 - 1100 N/mm<sup>2</sup>

Stahl  
1100 - 1300 N/mm<sup>2</sup>

Stahl  
1300 - 1500 N/mm<sup>2</sup>

Gusseisen  
GG(G)

d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>f</sub> [mm/min]
6	6	140	0.015	9	0.1	7425	670
8	6	140	0.025	12	0.1	5570	835
10	6	140	0.030	15	0.1	4455	800
12	6	140	0.035	18	0.1	3715	780
16	8	140	0.045	24	0.2	2785	1005
20	10	140	0.055	30	0.2	2230	1225

6	6	120	0.015	9	0.1	6365	575
8	6	120	0.025	12	0.1	4775	715
10	6	120	0.030	15	0.1	3820	690
12	6	120	0.035	18	0.1	3185	670
16	8	120	0.045	24	0.2	2385	860
20	10	120	0.055	30	0.2	1910	1050

6	6	80	0.016	9	0.1	4245	410
8	6	80	0.020	12	0.1	3185	380
10	6	80	0.026	15	0.1	2545	395
12	6	80	0.030	18	0.1	2120	380
16	8	80	0.040	24	0.2	1590	510
20	10	80	0.050	30	0.2	1275	640

6	6	140	0.015	9	0.1	7425	670
8	6	140	0.025	12	0.1	5570	835
10	6	140	0.030	15	0.1	4455	800
12	6	140	0.035	18	0.1	3715	780
16	8	140	0.045	24	0.2	2785	1005
20	10	140	0.055	30	0.2	2230	1225

## Werkstoff

Titanlegierungen ausg.  
>300 HB  
[Ti6Al4V]

Reinkupfer

d1 [mm]	z	v <sub>c</sub> [m/min]	f <sub>z</sub> [mm]	a <sub>p</sub> [mm]	a <sub>e</sub> [mm]	n [min <sup>-1</sup> ]	v <sub>f</sub> [mm/min]
6	6	60	0.015	9	0.1	3185	285
8	6	60	0.025	12	0.1	2385	360
10	6	60	0.030	15	0.1	1910	345
12	6	60	0.035	18	0.1	1590	335
16	8	60	0.045	24	0.2	1195	430
20	10	60	0.055	30	0.2	955	525

6	6	200	0.015	9	0.1	10610	955
8	6	200	0.025	12	0.1	7960	1195
10	6	200	0.030	15	0.1	6365	1145
12	6	200	0.035	18	0.1	5305	1115
16	8	200	0.045	24	0.2	3980	1435
20	10	200	0.055	30	0.2	3185	1750

