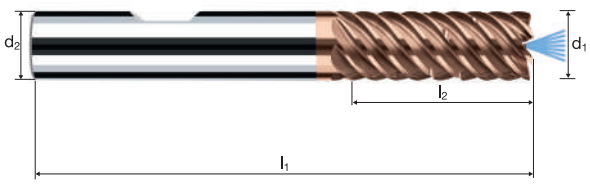
Zylindrische Fräser SX

Glattschneidig, Spanteiler, normale Ausführung
Hochleistungs-Eintauchstirn, zentraler Luft-/Kühlkanal

HM
MG10

λ 55°
γ 10°

r



new!

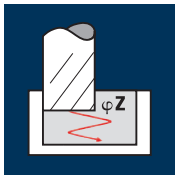
Schruppen HPC | Schruppen HDC | Schlichten

Inox Stainless | Ti Titanium | Nickel-Alloys

Beispiel:
Bestell-Nr. Beschichtung **S** Artikel-Nr. **8608** ø-Code **300**

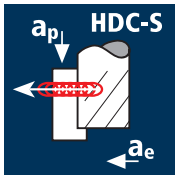
Ø Code	d_1 e8	d_2 h6	l_1	l_2	r	z	DURO-XI S8608	DURO-XI S8508
300	6.00	6.00	57	16.00	0.100	6		●
391	8.00	8.00	63	21.00	0.150	6		●
450	10.00	10.00	72	25.00	0.200	7		●
501	12.00	12.00	83	31.00	0.200	7		●
610	16.00	16.00	92	36.00	0.200	8		●
682	20.00	20.00	104	46.00	0.250	8		●

Anwendung



Werkstoff	d_1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min⁻¹]	v_f [mm/min]	φZ [°]
Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571] S	6.00	6	80	0.022	16.000	5.400	4245	560	5
	8.00	6	80	0.029	21.000	7.200	3185	554	5
	10.00	7	80	0.031	25.000	9.000	2545	552	5
	12.00	7	80	0.037	31.000	10.800	2120	549	5
	16.00	8	80	0.038	36.000	14.400	1590	483	5
	20.00	8	80	0.048	46.000	18.000	1275	490	5
Inox medium [Cr-Ni-Mo+/1.4539] Duplex Stahl [17-4 PH] S	6.00	6	60	0.022	16.000	5.400	3185	420	5
	8.00	6	60	0.029	21.000	7.200	2385	415	5
	10.00	7	60	0.031	25.000	9.000	1910	415	5
	12.00	7	60	0.037	31.000	10.800	1590	412	5
	16.00	8	60	0.038	36.000	14.400	1195	363	5
	20.00	8	60	0.048	46.000	18.000	955	367	5
Inox difficult [Cr-Ni-Mo++/1.4529] Hitzebeständiger Stahl [1.4841] S	6.00	6	45	0.019	16.000	5.400	2385	272	5
	8.00	6	45	0.026	21.000	7.200	1790	279	5
	10.00	7	45	0.027	25.000	9.000	1430	270	5
	12.00	7	45	0.033	31.000	10.800	1195	276	5
	16.00	8	45	0.034	36.000	14.400	895	243	5
	20.00	8	45	0.042	46.000	18.000	715	240	5
Nickelbasislegierungen ausgelagert Rm > 1000 N/mm² [Inconel 718] S	6.00	6	15	0.010	16.000	5.400	795	48	3
	8.00	6	15	0.013	21.000	7.200	595	46	3
	10.00	7	15	0.014	25.000	9.000	475	47	3
	12.00	7	15	0.016	31.000	10.800	400	45	3
	16.00	8	15	0.017	36.000	14.400	300	41	3
	20.00	8	15	0.019	46.000	18.000	240	37	3

Anwendung



Werkstoff	d_1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min⁻¹]	v_f [mm/min]	Q [cm³/min]
Inox normal [Cr-Ni/1.4301] [Cr-Ni-Mo/1.4571] S	6.00	6	129	0.055	16.000	0.600	6845	2275	21.8
	8.00	6	129	0.082	21.000	0.800	5135	2523	42.4
	10.00	7	122	0.091	25.000	1.000	3870	2463	61.6
	12.00	7	122	0.104	31.000	1.200	3225	2346	87.3
	16.00	8	116	0.120	36.000	1.600	2300	2210	127.3
	20.00	8	116	0.122	46.000	2.000	1840	1800	165.6
Inox medium [Cr-Ni-Mo+/1.4539] Duplex Stahl [17-4 PH] S	6.00	6	95	0.055	16.000	0.600	5015	1667	16.0
	8.00	6	95	0.082	21.000	0.800	3760	1848	31.0
	10.00	7	89	0.091	25.000	1.000	2815	1791	44.8
	12.00	7	89	0.104	31.000	1.200	2350	1709	63.6
	16.00	8	84	0.120	36.000	1.600	1670	1605	92.4
	20.00	8	84	0.122	46.000	2.000	1335	1306	120.2
Inox difficult [Cr-Ni-Mo++/1.4529] Hitzebeständiger Stahl [1.4841] S	6.00	6	75	0.050	16.000	0.600	3980	1194	11.5
	8.00	6	75	0.074	21.000	0.800	2985	1327	22.3
	10.00	7	72	0.080	25.000	1.000	2290	1289	32.2
	12.00	7	72	0.092	31.000	1.200	1910	1227	45.7
	16.00	8	68	0.109	36.000	1.600	1345	1173	67.6
	20.00	8	68	0.113	46.000	2.000	1075	968	89.1
Nickelbasislegierungen ausgelagert Rm > 1000 N/mm² [Inconel 718] S	6.00	6	35	0.048	16.000	0.300	1865	539	2.6
	8.00	6	35	0.069	21.000	0.400	1400	576	4.8
	10.00	7	33	0.078	25.000	0.500	1060	582	7.3
	12.00	7	33	0.086	31.000	0.600	885	531	9.9
	16.00	8	31	0.101	36.000	0.800	625	504	14.5
	20.00	8	31	0.100	46.000	1.000	500	399	18.4