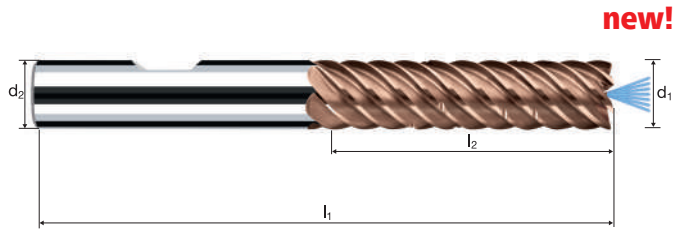
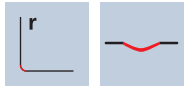


Zylindrische Fräser SX

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

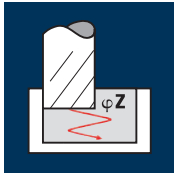


HM
MG10 λ **55°**
γ **10°**



Ø Code	d ₁ e8	d ₂ h6	l ₁	l ₂	r	z	Beispiel: Bestell-Nr.	
							Beschichtung S	Artikel-Nr. 8618
300	6.00	6.00	63	22.00	0.100	6		DURO-XI S8618
391	8.00	8.00	72	31.00	0.150	6		S8518
450	10.00	10.00	84	39.00	0.200	7		●
501	12.00	12.00	97	46.00	0.200	7		●
610	16.00	16.00	108	53.00	0.200	8		●
682	20.00	20.00	122	63.00	0.250	8		●

Anwendung



Werkstoff

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

S

d_1 [mm]	z	v_c [m/min]	f_z [mm]	a_p [mm]	a_e [mm]	n [min ⁻¹]	v_f [mm/min]	φ_Z [°]
6.00	6	70	0.019	22.000	5.400	3715	424	4
8.00	6	70	0.026	31.000	7.200	2785	435	4
10.00	7	70	0.028	39.000	9.000	2230	437	4
12.00	7	70	0.033	46.000	10.800	1855	429	4
16.00	8	70	0.035	53.000	14.400	1395	391	4
20.00	8	70	0.043	63.000	18.000	1115	384	4

Inox medium
[Cr-Ni-Mo+/1.4539]
Duplex Stahl
[17-4 PH]

S

6.00	6	55	0.019	22.000	5.400	2920	333	4
8.00	6	55	0.026	31.000	7.200	2190	342	4
10.00	7	55	0.028	39.000	9.000	1750	343	4
12.00	7	55	0.033	46.000	10.800	1460	337	4
16.00	8	55	0.035	53.000	14.400	1095	307	4
20.00	8	55	0.043	63.000	18.000	875	301	4

Inox difficult
[Cr-Ni-Mo+/1.4529]
Hitzebeständiger Stahl
[1.4841]

S

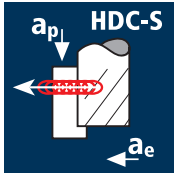
6.00	6	40	0.017	22.000	5.400	2120	216	4
8.00	6	40	0.023	31.000	7.200	1590	219	4
10.00	7	40	0.025	39.000	9.000	1275	223	4
12.00	7	40	0.029	46.000	10.800	1060	215	4
16.00	8	40	0.030	53.000	14.400	795	191	4
20.00	8	40	0.037	63.000	18.000	635	188	4

Nickelbasislegierungen
ausgelagert
Rm > 1000 N/mm²
[Inconel 718]

S

6.00	6	20	0.009	22.000	5.400	1060	57	2
8.00	6	20	0.012	31.000	7.200	795	57	2
10.00	7	20	0.012	39.000	9.000	635	53	2
12.00	7	20	0.015	46.000	10.800	530	56	2
16.00	8	20	0.016	53.000	14.400	400	51	2
20.00	8	20	0.017	63.000	18.000	320	44	2

Anwendung



Werkstoff

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

S

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 [cm ³ /min]
6.00	6	141	0.047	22.000	0.450	7470	2098	20.8
8.00	6	141	0.065	31.000	0.600	5600	2167	40.3
10.00	7	133	0.068	39.000	0.750	4220	2003	58.6
12.00	7	133	0.081	46.000	0.900	3520	2003	82.9
16.00	8	126	0.095	53.000	1.200	2510	1906	121.2
20.00	8	126	0.104	63.000	1.500	2005	1663	157.2

Inox medium
[Cr-Ni-Mo+/1.4539]
Duplex Stahl
[17-4 PH]

S

6.00	6	103	0.047	22.000	0.450	5470	1536	15.2
8.00	6	103	0.065	31.000	0.600	4105	1589	29.5
10.00	7	97	0.068	39.000	0.750	3075	1459	42.7
12.00	7	97	0.081	46.000	0.900	2560	1457	60.3
16.00	8	92	0.095	53.000	1.200	1825	1386	88.1
20.00	8	92	0.104	63.000	1.500	1460	1211	114.5

Inox difficult
[Cr-Ni-Mo+/1.4529]
Hitzebeständiger Stahl
[1.4841]

S

6.00	6	82	0.042	22.000	0.450	4345	1105	10.9
8.00	6	82	0.058	31.000	0.600	3255	1137	21.1
10.00	7	79	0.060	39.000	0.750	2500	1047	30.6
12.00	7	79	0.072	46.000	0.900	2085	1051	43.5
16.00	8	74	0.086	53.000	1.200	1465	1008	64.1
20.00	8	74	0.095	63.000	1.500	1175	897	84.7

Nickelbasislegierungen
ausgelagert
Rm > 1000 N/mm²
[Inconel 718]

S

6.00	6	43	0.053	22.000	0.150	2305	739	2.4
8.00	6	43	0.071	31.000	0.200	1730	739	4.6
10.00	7	41	0.077	39.000	0.250	1310	704	6.9
12.00	7	41	0.089	46.000	0.300	1090	675	9.3
16.00	8	39	0.105	53.000	0.400	775	649	13.7
20.00	8	39	0.111	63.000	0.500	620	552	17.4