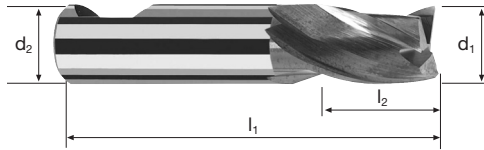
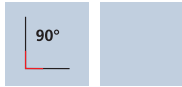


# Zylindrische Fräser Cut-X

Glattschneidig, kurze Schaftausführung

**HM**  
**MG10**      $\lambda$  **30°**  
                   $\gamma$  **12°**



Schuppen



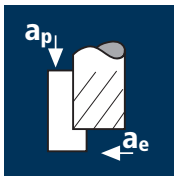
Schichten



<b>Rm</b> < 850	<b>Rm</b> 850-1100	<b>Rm</b> 1100-1300				<b>Inox</b> Stainless	<b>Ti</b> Titanium	<b>GG(G)</b> Nickel-Alloys
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		Beschichtung		Artikel-Nr.		ø-Code				<b>POLYCHROM</b>	<b>TRIBO</b>
Beispiel: Bestell-Nr.		<b>P</b>		<b>5336</b>		<b>120</b>				<b>P5336</b>	<b>T5336</b>
ø Code	d1 e8	d2 h6	l1	l2	α	z					
<b>120</b>	1.5	6	38	3	11.5°	3			●	●	
<b>140</b>	2.0	6	38	3	11.0°	3			●	●	
<b>160</b>	2.5	6	38	3	10.0°	3			●	●	
<b>180</b>	3.0	6	38	4	8.0°	3			●	●	
<b>200</b>	3.5	6	38	4	7.0°	3			●	●	
<b>220</b>	4.0	6	38	5	5.5°	3			●	●	
<b>240</b>	4.5	6	38	5	4.5°	3			●	●	
<b>260</b>	5.0	6	38	6	3.0°	3			●	●	
<b>300</b>	6.0	6	38	7	0.0°	3			●	●	
<b>331</b>	7.0	8	41	8	2.5°	3			●	●	
<b>391</b>	8.0	8	41	9	0.0°	3			●	●	
<b>420</b>	9.0	10	48	10	2.5°	3			●	●	
<b>450</b>	10.0	10	48	11	0.0°	3			●	●	

## Anwendung



## Werkstoff

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



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



Titanlegierungen  
bis 300 HB  
[Ti5Al2.5Sn]



Nichtrostender Stahl  
[Cr-Ni/1.4301]



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]
2	3	115	0.005	2	0.2	18305	275
3	3	115	0.010	3	0.3	12200	365
4	3	115	0.015	4	0.4	9150	410
5	3	115	0.015	5	0.5	7320	330
6	3	115	0.020	6	0.6	6100	365
8	3	115	0.025	8	0.8	4575	345
10	3	115	0.035	10	1.0	3660	385

2	3	75	0.005	2	0.2	11935	180
3	3	75	0.010	3	0.3	7960	240
4	3	75	0.015	4	0.4	5970	270
5	3	75	0.015	5	0.5	4775	215
6	3	75	0.020	6	0.6	3980	240
8	3	75	0.025	8	0.8	2985	225
10	3	75	0.035	10	1.0	2385	250

2	3	40	0.005	2	0.2	6365	95
3	3	40	0.010	3	0.3	4245	125
4	3	40	0.015	4	0.4	3185	145
5	3	40	0.015	5	0.5	2545	115
6	3	40	0.020	6	0.6	2120	125
8	3	40	0.025	8	0.8	1590	120
10	3	40	0.035	10	1.0	1275	135

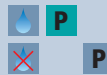
2	3	80	0.005	2	0.2	12735	190
3	3	80	0.010	3	0.3	8490	255
4	3	80	0.015	4	0.4	6365	285
5	3	80	0.015	5	0.5	5095	230
6	3	80	0.020	6	0.6	4245	255
8	3	80	0.025	8	0.8	3185	240
10	3	80	0.035	10	1.0	2545	265

## Anwendung



## Werkstoff

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



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



Titanlegierungen  
bis 300 HB  
[Ti5Al2.5Sn]



Nichtrostender Stahl  
[Cr-Ni/1.4301]



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]	Q [cm <sup>3</sup> /min]
2	3	85	0.005	1.0	2	13530	205	0.4
3	3	85	0.010	1.5	3	9020	270	1.2
4	3	85	0.010	2.0	4	6765	205	1.6
5	3	85	0.015	2.5	5	5410	245	3.1
6	3	85	0.015	3.0	6	4510	205	3.7
8	3	85	0.020	4.0	8	3380	205	6.6
10	3	85	0.030	5.0	10	2705	245	12.3

2	3	60	0.005	1.0	2	9550	145	0.3
3	3	60	0.010	1.5	3	6365	190	0.9
4	3	60	0.010	2.0	4	4775	145	1.2
5	3	60	0.015	2.5	5	3820	170	2.1
6	3	60	0.015	3.0	6	3185	145	2.6
8	3	60	0.020	4.0	8	2385	145	4.6
10	3	60	0.025	5.0	10	1910	145	7.3

2	3	30	0.005	1.0	2	4775	70	0.1
3	3	30	0.010	1.5	3	3185	95	0.4
4	3	30	0.010	2.0	4	2385	70	0.6
5	3	30	0.015	2.5	5	1910	85	1.1
6	3	30	0.015	3.0	6	1590	70	1.3
8	3	30	0.020	4.0	8	1195	70	2.2
10	3	30	0.025	5.0	10	955	70	3.5

2	3	55	0.005	1.0	2	8755	130	0.3
3	3	55	0.010	1.5	3	5835	175	0.8
4	3	55	0.010	2.0	4	4375	130	1.0
5	3	55	0.015	2.5	5	3500	160	2.0
6	3	55	0.015	3.0	6	2920	130	2.3
8	3	55	0.020	4.0	8	2190	130	4.2
10	3	55	0.025	5.0	10	1750	130	6.5