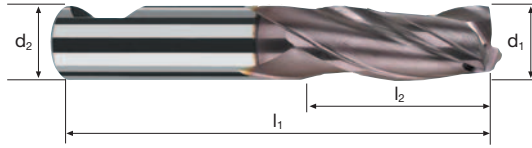
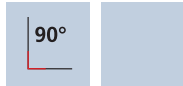


Zylindrische Fräser

Glattschneidig, kurze Schaftausführung



HSS-E
Co8 λ **30°**
 γ **15°**



Schruppen



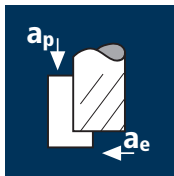
Schichten



Rm < 850 **Rm** 850-1100 **Inox** Stainless **Copper**

Beispiel: Bestell-Nr.		Beschichtung U	Artikel-Nr. 0410	α -Code .140			UNICUT-4X U0410
\emptyset Code	d1 f8	d2 h6	l1	l2	α	z	
.140	2.0	6	38	7	8.5°	3	●
.160	2.5	6	39	8	7.0°	3	●
.180	3.0	6	39	8	6.0°	3	●
.200	3.5	6	41	10	4.5°	3	●
.220	4.0	6	42	11	3.5°	3	●
.240	4.5	6	42	11	2.5°	3	●
.260	5.0	6	44	13	1.5°	3	●
.280	5.5	6	44	13	1.0°	3	●
.300	6.0	6	44	13	0.0°	3	●
.311	6.5	8	48	16	2.0°	3	●
.331	7.0	8	48	16	1.5°	3	●
.351	7.5	8	48	16	1.0°	3	●
.391	8.0	8	51	19	0.0°	3	●
.410	8.5	10	56	19	2.0°	3	●
.420	9.0	10	56	19	1.5°	3	●
.430	9.5	10	56	19	1.0°	3	●
.450	10.0	10	59	22	0.0°	3	●
.501*	12.0	12	83	26	0.0°	3	●
.610*	16.0	16	92	32	0.0°	3	●
.682*	20.0	20	104	38	0.0°	3	●
* normale Schaftausführung							

Anwendung



Werkstoff

Stahl
< 850 N/mm²

Stahl
850 - 1100 N/mm²

Nichtrostender Stahl
[Cr-Ni/1.4301]

Nichtrostender Stahl
[Cr-Ni-Mo-.../1.4571]

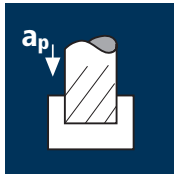
d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
2	3	60	0.005	3	0.2	9550	145
3	3	60	0.010	5	0.3	6365	190
5	3	60	0.015	8	0.5	3820	170
6	3	60	0.020	9	0.6	3185	190
8	3	60	0.025	12	0.8	2385	180
10	3	60	0.035	15	1.0	1910	200
12	3	60	0.040	18	1.2	1590	190
16	3	60	0.055	24	1.6	1195	195
20	3	60	0.065	30	2.0	955	185

2	3	48	0.005	3	0.2	7640	115
3	3	48	0.010	5	0.3	5095	155
5	3	48	0.015	8	0.5	3055	135
6	3	48	0.020	9	0.6	2545	155
8	3	48	0.025	12	0.8	1910	145
10	3	48	0.035	15	1.0	1530	160
12	3	48	0.040	18	1.2	1275	155
16	3	48	0.055	24	1.6	955	160
20	3	48	0.065	30	2.0	765	150

2	3	25	0.005	3	0.2	3980	60
3	3	25	0.010	5	0.3	2655	80
5	3	25	0.015	8	0.5	1590	70
6	3	25	0.020	9	0.6	1325	80
8	3	25	0.025	12	0.8	995	75
10	3	25	0.035	15	1.0	795	85
12	3	25	0.040	18	1.2	665	80
16	3	25	0.055	24	1.6	495	80
20	3	25	0.065	30	2.0	400	80

2	3	22	0.005	3	0.2	3500	55
3	3	22	0.010	5	0.3	2335	70
5	3	22	0.015	8	0.5	1400	65
6	3	22	0.020	9	0.6	1165	70
8	3	22	0.025	12	0.8	875	65
10	3	22	0.035	15	1.0	700	75
12	3	22	0.040	18	1.2	585	70
16	3	22	0.055	24	1.6	440	75
20	3	22	0.065	30	2.0	350	70

Anwendung



Werkstoff

Stahl
< 850 N/mm²

Stahl
850 - 1100 N/mm²

Nichtrostender Stahl
[Cr-Ni/1.4301]

Nichtrostender Stahl
[Cr-Ni-Mo-.../1.4571]

d1 [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]
2	3	55	0.005	1.0	2	8755	130	0.5
3	3	55	0.010	1.5	3	5835	175	1.0
5	3	55	0.015	2.5	5	3500	160	2.0
6	3	55	0.015	3.0	6	2920	130	2.5
8	3	55	0.025	4.0	8	2190	165	5.5
10	3	55	0.030	5.0	10	1750	160	8.0
12	3	55	0.035	6.0	12	1460	155	11.0
16	3	55	0.045	8.0	16	1095	150	19.0
20	3	55	0.055	10.0	20	875	145	29.0

2	3	45	0.005	1.0	2	7160	105	0.2
3	3	45	0.010	1.5	3	4775	145	0.5
5	3	45	0.015	2.5	5	2865	130	1.5
6	3	45	0.015	3.0	6	2385	105	2.0
8	3	45	0.025	4.0	8	1790	135	4.5
10	3	45	0.030	5.0	10	1430	130	6.5
12	3	45	0.035	6.0	12	1195	125	9.0
16	3	45	0.045	8.0	16	895	120	15.5
20	3	45	0.055	10.0	20	715	120	24.0

2	3	22	0.005	1.0	2	3500	55	0.1
3	3	22	0.010	1.5	3	2335	70	0.5
5	3	22	0.015	2.5	5	1400	65	1.0
6	3	22	0.015	3.0	6	1165	50	1.0
8	3	22	0.025	4.0	8	875	65	2.0
10	3	22	0.030	5.0	10	700	65	3.5
12	3	22	0.035	6.0	12	585	60	4.5
16	3	22	0.045	8.0	16	440	60	7.5
20	3	22	0.055	10.0	20	350	60	12.0

2	3	20	0.005	1.0	2	3185	50	0.1
3	3	20	0.010	1.5	3	2120	65	0.5
5	3	20	0.015	2.5	5	1275	55	0.5
6	3	20	0.015	3.0	6	1060	50	1.0
8	3	20	0.025	4.0	8	795	60	2.0
10	3	20	0.030	5.0	10	635	55	3.0
12	3	20	0.035	6.0	12	530	55	4.0
16	3	20	0.045	8.0	16	400	55	7.0
20	3	20	0.055	10.0	20	320	55	11.0