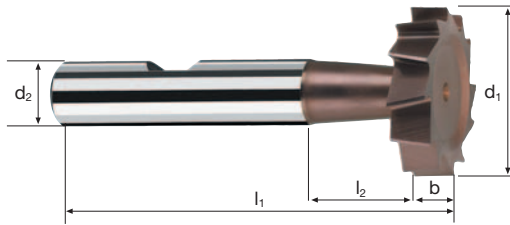


Schlitzfräser



HSS-E	λ 10°
Co8	γ 8°

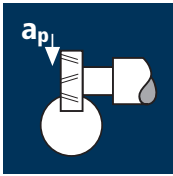


Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless	Ti Titanium	GG(G) Aluminium Copper
--------------------	-----------------------	------------------------	--	--	--	--	--------------------------	-----------------------	-------------------------------------

Beispiel: Bestell-Nr.								UNICUT-4X U0905	
Beschichtung Artikel-Nr. α-Code									
U 0905 .100									
∅ Code	d1 h11	d2 h6	l1	l2	b e8	z			
.100	4.5	6	50	12	1.0	8		●	
.150	7.5	6	50	11	1.5	8		●	
.160	7.5	6	50	10	2.0	8		●	
.200	10.5	6	50	11	2.0	8		●	
.210	10.5	6	50	10	2.5	8		●	
.220	10.5	6	50	9	3.0	8		●	
.310	13.5	10	56	13	2.5	8		●	
.320	13.5	10	56	12	3.0	8		●	
.330	13.5	10	56	11	4.0	8		●	
.360	16.5	10	56	12	3.0	8		●	
.370	16.5	10	56	11	4.0	8		●	
.380	16.5	10	56	10	5.0	8		●	
.410	19.5	10	63	18	3.0	10		●	
.420	19.5	10	63	17	4.0	10		●	
.430	19.5	10	63	16	5.0	10		●	
.440	19.5	10	63	15	6.0	10		●	
.500	22.5	10	63	17	4.0	10		●	
.510	22.5	10	63	16	5.0	10		●	
.520	22.5	10	63	15	6.0	10		●	
.540	22.5	10	63	14	8.0	10		●	
.600	25.5	10	63	16	5.0	12		●	
.610	25.5	10	63	15	6.0	12		●	



Anwendung



Werkstoff

Stahl
< 850 N/mm²



Stahl
850 - 1100 N/mm²



Stahl
1100 - 1300 N/mm²



Nichtrostender Stahl
[Cr-Ni/1.4301]



Werkstoff

Gusseisen
GG(G)



Reinkupfer



Titanlegierungen
bis 300 HB
[Ti5Al2.5Sn]



Al-Knetlegierung
Si < 6%



d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
7.5	8	55	0.005	2.0	2.0	2335	95
10.5	8	55	0.010	2.9	2.5	1665	135
13.5	8	55	0.010	3.8	3.0	1295	105
16.5	8	55	0.025	5.0	4.0	1060	210
19.5	10	55	0.035	5.5	5.0	900	315
22.5	10	55	0.040	6.6	6.0	780	310
25.5	12	55	0.045	7.5	6.0	685	370

d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
7.5	8	45	0.005	2.0	2.0	1910	75
10.5	8	45	0.010	2.9	2.5	1365	110
13.5	8	45	0.010	3.8	3.0	1060	85
16.5	8	45	0.025	5.0	4.0	870	175
19.5	10	45	0.035	5.5	5.0	735	255
22.5	10	45	0.040	6.6	6.0	635	255
25.5	12	45	0.045	7.5	6.0	560	300

d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
7.5	8	34	0.005	2.0	2.0	1445	60
10.5	8	34	0.010	2.9	2.5	1030	80
13.5	8	34	0.010	3.8	3.0	800	65
16.5	8	34	0.025	5.0	4.0	655	130
19.5	10	34	0.035	5.5	5.0	555	195
22.5	10	34	0.040	6.6	6.0	480	190
25.5	12	34	0.045	7.5	6.0	425	230

d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
7.5	8	21	0.005	2.0	2.0	890	35
10.5	8	21	0.010	2.9	2.5	635	50
13.5	8	21	0.010	3.8	3.0	495	40
16.5	8	21	0.025	5.0	4.0	405	80
19.5	10	21	0.035	5.5	5.0	345	120
22.5	10	21	0.040	6.6	6.0	295	120
25.5	12	21	0.045	7.5	6.0	260	140

d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
7.5	8	42	0.005	2.0	2.0	1785	70
10.5	8	42	0.010	2.9	2.5	1275	100
13.5	8	42	0.010	3.8	3.0	990	80
16.5	8	42	0.025	5.0	4.0	810	160
19.5	10	42	0.035	5.5	5.0	685	240
22.5	10	42	0.040	6.6	6.0	595	240
25.5	12	42	0.045	7.5	6.0	525	285

d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
7.5	8	65	0.005	2.0	2.0	2760	110
10.5	8	65	0.010	2.9	2.5	1970	160
13.5	8	65	0.010	3.8	3.0	1535	125
16.5	8	65	0.025	5.0	4.0	1255	250
19.5	10	65	0.035	5.5	5.0	1060	370
22.5	10	65	0.040	6.6	6.0	920	370
25.5	12	65	0.045	7.5	6.0	810	435

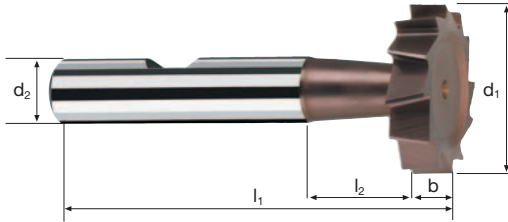
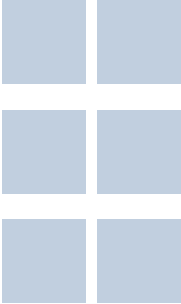
d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
7.5	8	23	0.005	2.0	2.0	975	40
10.5	8	23	0.010	2.9	2.5	695	55
13.5	8	23	0.010	3.8	3.0	540	45
16.5	8	23	0.025	5.0	4.0	445	90
19.5	10	23	0.035	5.5	5.0	375	130
22.5	10	23	0.040	6.6	6.0	325	130
25.5	12	23	0.045	7.5	6.0	285	155

d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
7.5	8	80	0.005	2.0	2.0	3395	135
10.5	8	80	0.010	2.9	2.5	2425	195
13.5	8	80	0.010	3.8	3.0	1885	150
16.5	8	80	0.025	5.0	4.0	1545	310
19.5	10	80	0.035	5.5	5.0	1305	455
22.5	10	80	0.040	6.6	6.0	1130	450
25.5	12	80	0.045	7.5	6.0	1000	540

Schlitzfräser



HSS-E λ 10°
Co8 γ 8°



Rm < 850	Rm 850-1100	Rm 1100-1300					Inox Stainless	Ti Titanium	GG(G) Aluminium Copper
--------------------	-----------------------	------------------------	--	--	--	--	--------------------------	-----------------------	-------------------------------------

Beispiel: Bestell-Nr.							UNICUT-4X	
							U0905	
\emptyset Code	d_1 h11	d_2 h6	l_1	l_2	b e8	z		
.650	28.5	10	63	14	6.0	12	●	
.660	28.5	10	63	13	8.0	12	●	
.700	28.5	12	71	14	10.0	12	●	
.750	32.5	12	71	18	6.0	12	●	
.760	32.5	12	71	17	7.0	12	●	
.770	32.5	12	71	16	8.0	12	●	
.800	32.5	12	71	15	10.0	12	●	
.900	45.5	12	71	14	10.0	14	●	





Werkstoff

Stahl
< 850 N/mm²

d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
28.5	12	55	0.050	8.2	8.0	615	370
32.5	12	55	0.060	9.8	10.0	540	390
45.5	14	55	0.080	12.0	10.0	385	430

Stahl
850 - 1100 N/mm²

28.5	12	45	0.050	8.2	8.0	505	305
32.5	12	45	0.060	9.8	10.0	440	315
45.5	14	45	0.080	12.0	10.0	315	355

Stahl
1100 - 1300 N/mm²

28.5	12	34	0.050	8.2	8.0	380	230
32.5	12	34	0.060	9.8	10.0	335	240
45.5	14	34	0.080	12.0	10.0	240	270

Nichtrostender Stahl
[Cr-Ni/1.4301]

28.5	12	21	0.050	8.2	8.0	235	140
32.5	12	21	0.060	9.8	10.0	205	150
45.5	14	21	0.080	12.0	10.0	145	160

Werkstoff

Gusseisen
GG(G)

d1 [mm]	z	v _c [m/min]	f _z [mm]	a _p [mm]	a _e [mm]	n [min ⁻¹]	v _f [mm/min]
28.5	12	42	0.050	8.2	8.0	470	280
32.5	12	42	0.060	9.8	10.0	410	295
45.5	14	42	0.080	12.0	10.0	295	330

Reinkupfer

28.5	12	65	0.050	8.2	8.0	725	435
32.5	12	65	0.060	9.8	10.0	635	455
45.5	14	65	0.080	12.0	10.0	455	510

Titanlegierungen
bis 300 HB
[Ti5Al2.5Sn]

28.5	12	23	0.050	8.2	8.0	255	155
32.5	12	23	0.060	9.8	10.0	225	160
45.5	14	23	0.080	12.0	10.0	160	180

Al-Knetlegierung
Si < 6%

28.5	12	80	0.050	8.2	8.0	895	535
32.5	12	80	0.060	9.8	10.0	785	565
45.5	14	80	0.080	12.0	10.0	560	625