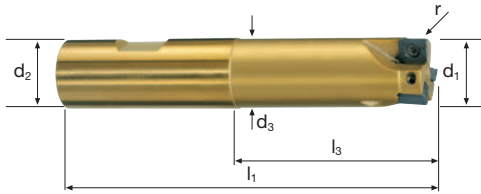


Eck-/Nutenfräser 90° SX

Wendeplatten 8mm, mit integriertem Luft-/Kühlkanal

| | |
|----|-----------------------------|
| HM | λ 8° γ 0° |
| | |
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|-------------|----------------|--|--|--|--|--|-------------------|----------------|-----------------------------|
| Rm < 850 | Rm 850-1100 | | | | | | Inox Stainless | Ti Titanium | Nickel-Alloys Tool Steel |
|-------------|----------------|--|--|--|--|--|-------------------|----------------|-----------------------------|

| Eck-/Nutenfräser 90° | | Lieferumfang: Fräserkörper inkl. Klemmschrauben für Wendeplatten montiert | | | | | | | | |
|----------------------|----|---|------|-----|-----|--------------------|---|-------|---|--|
| Bestell-Nr. | d1 | d2 h6 | d3 | l1 | l3 | ap _{max.} | z | L-Typ | | |
| W00100.162 | 16 | 16 | 15.4 | 75 | 25 | 7.5 | 2 | K | ● | |
| W00140.162 | 16 | 16 | 15.0 | 102 | 51 | 7.5 | 2 | M | ● | |
| W00180.162 | 16 | 16 | 15.0 | 129 | 78 | 7.5 | 2 | L | ● | |
| W00100.203 | 20 | 20 | 19.4 | 77 | 25 | 7.5 | 3 | K | ● | |
| W00140.203 | 20 | 20 | 19.4 | 110 | 57 | 7.5 | 3 | M | ● | |
| W00180.203 | 20 | 20 | 19.4 | 140 | 87 | 7.5 | 3 | L | ● | |
| W00100.254 | 25 | 25 | 24.0 | 90 | 32 | 7.5 | 4 | K | ● | |
| W00140.254 | 25 | 25 | 24.0 | 124 | 65 | 7.5 | 4 | M | ● | |
| W00180.254 | 25 | 25 | 24.0 | 158 | 99 | 7.5 | 4 | L | ● | |
| W00100.325 | 32 | 32 | 31.0 | 102 | 40 | 7.5 | 5 | K | ● | |
| W00140.325 | 32 | 32 | 31.0 | 144 | 81 | 7.5 | 5 | M | ● | |
| W00180.325 | 32 | 32 | 31.0 | 186 | 123 | 7.5 | 5 | L | ● | |

| SX Wendeplatten 8mm | | Lieferumfang: Verpackungseinheit 10 Stk. | | | | |
|---------------------|-----|--|-----|-----|--|---|
| Bestell-Nr. | H | B | D | r | | |
| W50310.008 | 8.4 | 6.4 | 3.4 | 0.6 | | ● |

| Zubehör | | Lieferumfang Klemmschrauben für Wendeplatten: Verpackungseinheit 10 Stk. | | |
|-------------|--|--|--|---|
| Bestell-Nr. | | | | |
| W90110.008 | Drehmoment-Schraubendreher 1.2 Nm mit Klinge Torx TX 08 | | | ● |
| W90111.008 | Wechselklinge zu Drehmoment-Schraubendreher Torx TX 08 | | | ● |
| W90100.008 | Schraubendreher Torx TX 08 | | | ● |
| W90500.008 | Klemmschrauben für Wendeplatten Torx TX 08 / M 2.5 x 5.0 | | | ● |



Werkstoff

Nichtrostender Stahl
[Cr-Ni/1.4301]

| L-Typ | 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] |
|-------|---------|---|------------------------|---------------------|---------------------|---------------------|------------------------|-------------------------|--------------------------|
| K | 16 | 2 | 150 | 0.050 | 3.0 | 12.8 | 2985 | 300 | 11.5 |
| | 20 | 3 | 150 | 0.050 | 3.0 | 16.0 | 2385 | 360 | 17.5 |
| | 25 | 4 | 150 | 0.050 | 3.0 | 20.0 | 1910 | 380 | 23.0 |
| | 32 | 5 | 150 | 0.050 | 3.0 | 25.6 | 1490 | 375 | 29.0 |
| M | 16 | 2 | 150 | 0.040 | 3.0 | 9.6 | 2985 | 240 | 7.0 |
| | 20 | 3 | 150 | 0.040 | 3.0 | 12.0 | 2385 | 285 | 10.5 |
| | 25 | 4 | 150 | 0.040 | 3.0 | 15.0 | 1910 | 305 | 13.5 |
| | 32 | 5 | 150 | 0.040 | 3.0 | 19.2 | 1490 | 300 | 17.5 |
| L | 16 | 2 | 150 | 0.050 | 3.0 | 6.4 | 2985 | 300 | 6.0 |
| | 20 | 3 | 150 | 0.050 | 3.0 | 8.0 | 2385 | 360 | 8.5 |
| | 25 | 4 | 150 | 0.050 | 3.0 | 10.0 | 1910 | 380 | 11.5 |
| | 32 | 5 | 150 | 0.050 | 3.0 | 12.8 | 1490 | 375 | 14.5 |

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

| | | | | | | | | | |
|---|----|---|-----|-------|-----|------|------|-----|------|
| K | 16 | 2 | 250 | 0.050 | 3.0 | 12.8 | 4975 | 500 | 19.0 |
| | 20 | 3 | 250 | 0.050 | 3.0 | 16.0 | 3980 | 595 | 28.5 |
| | 25 | 4 | 250 | 0.050 | 3.0 | 20.0 | 3185 | 635 | 38.0 |
| | 32 | 5 | 250 | 0.050 | 3.0 | 25.6 | 2485 | 620 | 47.5 |
| M | 16 | 2 | 250 | 0.040 | 3.0 | 9.6 | 4975 | 400 | 11.5 |
| | 20 | 3 | 250 | 0.040 | 3.0 | 12.0 | 3980 | 480 | 17.5 |
| | 25 | 4 | 250 | 0.040 | 3.0 | 15.0 | 3185 | 510 | 23.0 |
| | 32 | 5 | 250 | 0.040 | 3.0 | 19.2 | 2485 | 495 | 28.5 |
| L | 16 | 2 | 220 | 0.040 | 3.0 | 6.4 | 4375 | 350 | 6.5 |
| | 20 | 3 | 220 | 0.040 | 3.0 | 8.0 | 3500 | 420 | 10.0 |
| | 25 | 4 | 220 | 0.040 | 3.0 | 10.0 | 2800 | 450 | 13.5 |
| | 32 | 5 | 220 | 0.040 | 3.0 | 12.8 | 2190 | 440 | 17.0 |

Hitzebeständiger Stahl
[17-4 PH]

| | | | | | | | | | |
|---|----|---|-----|-------|-----|------|------|-----|------|
| K | 16 | 2 | 120 | 0.050 | 3.0 | 12.8 | 2385 | 240 | 9.0 |
| | 20 | 3 | 120 | 0.050 | 3.0 | 16.0 | 1910 | 285 | 13.5 |
| | 25 | 4 | 120 | 0.050 | 3.0 | 20.0 | 1530 | 305 | 18.5 |
| | 32 | 5 | 120 | 0.050 | 3.0 | 25.6 | 1195 | 300 | 23.0 |
| M | 16 | 2 | 120 | 0.040 | 3.0 | 9.6 | 2385 | 190 | 5.5 |
| | 20 | 3 | 120 | 0.040 | 3.0 | 12.0 | 1910 | 230 | 8.5 |
| | 25 | 4 | 120 | 0.040 | 3.0 | 15.0 | 1530 | 245 | 11.0 |
| | 32 | 5 | 120 | 0.040 | 3.0 | 19.2 | 1195 | 240 | 14.0 |
| L | 16 | 2 | 120 | 0.040 | 3.0 | 6.4 | 2385 | 190 | 3.5 |
| | 20 | 3 | 120 | 0.040 | 3.0 | 8.0 | 1910 | 230 | 5.5 |
| | 25 | 4 | 120 | 0.040 | 3.0 | 10.0 | 1530 | 245 | 7.5 |
| | 32 | 5 | 120 | 0.040 | 3.0 | 12.8 | 1195 | 240 | 9.0 |

Nickelbasislegierungen
[Inconel 718]

| | | | | | | | | | |
|---|----|---|----|-------|-----|-----|-----|----|-----|
| K | 16 | 2 | 20 | 0.030 | 3.0 | 4.8 | 400 | 25 | 0.5 |
| | 20 | 3 | 20 | 0.030 | 3.0 | 6.0 | 320 | 30 | 0.5 |
| | 25 | 4 | 20 | 0.030 | 3.0 | 7.5 | 255 | 30 | 0.5 |
| | 32 | 5 | 20 | 0.030 | 3.0 | 9.6 | 200 | 30 | 1.0 |
| M | 16 | 2 | 20 | 0.020 | 3.0 | 1.6 | 400 | 15 | 0.1 |
| | 20 | 3 | 20 | 0.020 | 3.0 | 2.0 | 320 | 20 | 0.1 |
| | 25 | 4 | 20 | 0.020 | 3.0 | 2.5 | 255 | 20 | 0.2 |
| | 32 | 5 | 20 | 0.020 | 3.0 | 3.2 | 200 | 20 | 0.2 |
| L | | | | | | | | | |
| | | | | | | | | | |



Werkstoff

Nichtrostender Stahl
[Cr-Ni/1.4301]

| L-Typ | 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] |
|-------|---------|---|------------------------|---------------------|---------------------|---------------------|------------------------|-------------------------|--------------------------|
| K | 16 | 2 | 120 | 0.050 | 2.4 | 16.0 | 2385 | 240 | 9.0 |
| | 20 | 3 | 120 | 0.050 | 2.4 | 20.0 | 1910 | 285 | 13.5 |
| | 25 | 4 | 120 | 0.050 | 2.4 | 25.0 | 1530 | 305 | 18.5 |
| | 32 | 5 | 120 | 0.050 | 2.4 | 32.0 | 1195 | 300 | 23.0 |
| M | 16 | 2 | 120 | 0.070 | 1.5 | 16.0 | 2385 | 335 | 8.0 |
| | 20 | 3 | 120 | 0.070 | 1.5 | 20.0 | 1910 | 400 | 12.0 |
| | 25 | 4 | 120 | 0.070 | 1.5 | 25.0 | 1530 | 430 | 16.0 |
| | 32 | 5 | 120 | 0.070 | 1.5 | 32.0 | 1195 | 420 | 20.0 |
| L | | | | | | | | | |
| | | | | | | | | | |

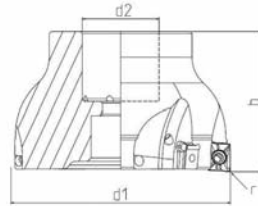
Hitzebeständiger Stahl
[17-4 PH]

| | | | | | | | | | |
|---|----|---|-----|-------|-----|------|------|-----|------|
| K | 16 | 2 | 100 | 0.050 | 2.4 | 16.0 | 1990 | 200 | 7.5 |
| | 20 | 3 | 100 | 0.050 | 2.4 | 20.0 | 1590 | 240 | 11.5 |
| | 25 | 4 | 100 | 0.050 | 2.4 | 25.0 | 1275 | 255 | 15.5 |
| | 32 | 5 | 100 | 0.050 | 2.4 | 32.0 | 995 | 250 | 19.0 |
| M | 16 | 2 | 100 | 0.070 | 1.5 | 16.0 | 1990 | 280 | 6.5 |
| | 20 | 3 | 100 | 0.070 | 1.5 | 20.0 | 1590 | 335 | 10.0 |
| | 25 | 4 | 100 | 0.070 | 1.5 | 25.0 | 1275 | 355 | 13.5 |
| | 32 | 5 | 100 | 0.070 | 1.5 | 32.0 | 995 | 350 | 17.0 |
| L | | | | | | | | | |
| | | | | | | | | | |

Eckfräser 90° SX

Wendeplatten 8mm, mit integriertem Luft-/Kühlkanal

| | |
|----|--------------|
| HM | λ 8° |
| | γ 0° |



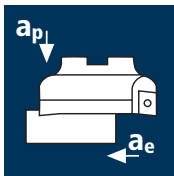
| | | | | | | | | | |
|-------------|----------------|--|--|--|--|--|-------------------|----------------|------------|
| Rm < 850 | Rm 850-1100 | | | | | | Inox Stainless | Ti Titanium | Tool Steel |
|-------------|----------------|--|--|--|--|--|-------------------|----------------|------------|

| Eckfräser 90° | | Lieferumfang: Fräserkörper inkl. Klemmschrauben für Wendeplatten montiert | | | | | |
|---------------|----|---|----|--------------------|----|---|--|
| Bestell-Nr. | d1 | d2 | b | ap _{max.} | z | | |
| W00400.405 | 40 | 16 | 40 | 7.5 | 5 | ● | |
| W00400.506 | 50 | 22 | 40 | 7.5 | 6 | ● | |
| W00400.637 | 63 | 22 | 40 | 7.5 | 7 | ● | |
| W00400.801 | 80 | 27 | 50 | 7.5 | 10 | ● | |
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| SX Wendeplatten 8mm | | Lieferumfang: Verpackungseinheit 10 Stk. | | | | |
|---------------------|-----|--|-----|-----|---|--|
| Bestell-Nr. | H | B | D | r | | |
| W50310.008 | 8.4 | 6.4 | 3.4 | 0.6 | ● | |

| Zubehör | | Lieferumfang Klemmschrauben für Wendeplatten: Verpackungseinheit 10 Stk. | | |
|-------------|--|--|--|---|
| Bestell-Nr. | | | | |
| W90110.008 | Drehmoment-Schraubendreher 1.2 Nm mit Klinge Torx TX 08 | | | ● |
| W90111.008 | Wechselklinge zu Drehmoment-Schraubendreher Torx TX 08 | | | ● |
| W90100.008 | Schraubendreher Torx TX 08 | | | ● |
| W90500.008 | Klemmschrauben für Wendeplatten Torx TX 08 / M 2.5 x 5.0 | | | ● |

Anwendung



Werkstoff

Nichtrostender Stahl
[Cr-Ni/1.4301]



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



Hitzebeständiger Stahl
[17-4 PH]



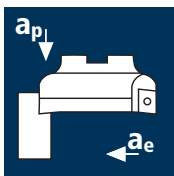
| d1 [mm] | z | v _c [m/min] | f _z [mm] | a _p [mm] | a _e [mm] | n [min ⁻¹] | v _f [mm/min] | Q [cm ³ /min] |
|------------|----|---------------------------|------------------------|------------------------|------------------------|---------------------------|----------------------------|-----------------------------|
| 40 | 5 | 120 | 0.080 | 1.5 | 30.0 | 955 | 380 | 17.0 |
| 50 | 6 | 120 | 0.080 | 1.5 | 37.5 | 765 | 365 | 20.5 |
| 63 | 7 | 100 | 0.080 | 1.5 | 47.3 | 505 | 285 | 20.0 |
| 80 | 10 | 100 | 0.080 | 1.5 | 50.0 | 400 | 320 | 24.0 |
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|----|----|-----|-------|-----|------|------|-----|------|
| 40 | 5 | 150 | 0.080 | 1.5 | 30.0 | 1195 | 480 | 21.5 |
| 50 | 6 | 150 | 0.080 | 1.5 | 37.5 | 955 | 460 | 26.0 |
| 63 | 7 | 120 | 0.080 | 1.5 | 47.3 | 605 | 340 | 24.0 |
| 80 | 10 | 120 | 0.080 | 1.5 | 50.0 | 475 | 380 | 28.5 |
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|----|----|-----|-------|-----|------|-----|-----|------|
| 40 | 5 | 100 | 0.080 | 1.5 | 30.0 | 795 | 320 | 14.5 |
| 50 | 6 | 100 | 0.080 | 1.5 | 37.5 | 635 | 305 | 17.0 |
| 63 | 7 | 70 | 0.080 | 1.5 | 47.3 | 355 | 200 | 14.0 |
| 80 | 10 | 70 | 0.080 | 1.5 | 50.0 | 280 | 225 | 17.0 |
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Anwendung



Werkstoff

Nichtrostender Stahl
[Cr-Ni/1.4301]



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



Hitzebeständiger Stahl
[17-4 PH]



| 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] |
|------------|----|---------------------------|------------------------|------------------------|------------------------|---------------------------|----------------------------|-----------------------------|
| 40 | 5 | 110 | 0.060 | 5 | 6 | 875 | 265 | 8.0 |
| 50 | 6 | 110 | 0.060 | 5 | 6 | 700 | 250 | 7.5 |
| 63 | 7 | 80 | 0.060 | 5 | 6 | 405 | 170 | 5.0 |
| 80 | 10 | 80 | 0.060 | 5 | 6 | 320 | 190 | 5.5 |
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|----|----|-----|-------|---|---|------|-----|------|
| 40 | 5 | 150 | 0.060 | 5 | 6 | 1195 | 360 | 11.0 |
| 50 | 6 | 150 | 0.060 | 5 | 6 | 955 | 345 | 10.5 |
| 63 | 7 | 120 | 0.060 | 5 | 6 | 605 | 255 | 7.5 |
| 80 | 10 | 120 | 0.060 | 5 | 6 | 475 | 285 | 8.5 |
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|----|----|-----|-------|---|---|-----|-----|-----|
| 40 | 5 | 100 | 0.060 | 5 | 6 | 795 | 240 | 7.0 |
| 50 | 6 | 100 | 0.060 | 5 | 6 | 635 | 230 | 7.0 |
| 63 | 7 | 70 | 0.060 | 5 | 6 | 355 | 150 | 4.5 |
| 80 | 10 | 70 | 0.060 | 5 | 6 | 280 | 170 | 5.0 |
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