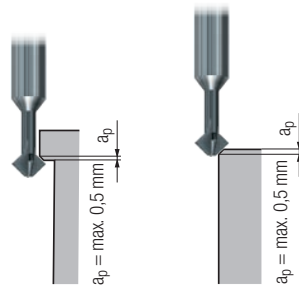


Hartmetall-NC-Entgratfräser – lange Ausführung
Solid carbide NC deburring end mills – long design

N



Gültig für · Valid for
1700L

	$l_3 = 10 \text{ mm} / 15 \text{ mm}$		$l_3 = 20 \text{ mm} / 25 \text{ mm}$		$l_3 = 30 \text{ mm} / 35 \text{ mm}$						
	V_c [m/min]	f_z [mm]	V_c [m/min]	f_z [mm]	V_c [m/min]	f_z [mm]					
P	1.1	80	$0,004 \times d_1$	72	$0,004 \times d_1$	64	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.1	70	$0,004 \times d_1$	63	$0,004 \times d_1$	56	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	3.1	60	$0,003 \times d_1$	54	$0,003 \times d_1$	48	$0,003 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	4.1	50	$0,003 \times d_1$	45	$0,003 \times d_1$	40	$0,003 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	5.1	40	$0,002 \times d_1$	36	$0,002 \times d_1$	32	$0,002 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
M	1.1	60	$0,002 \times d_1$	54	$0,002 \times d_1$	48	$0,002 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.1	50	$0,002 \times d_1$	45	$0,002 \times d_1$	40	$0,002 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	3.1	40	$0,002 \times d_1$	36	$0,002 \times d_1$	32	$0,002 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	4.1	30	$0,002 \times d_1$	27	$0,002 \times d_1$	24	$0,002 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
K	1.1	70	$0,004 \times d_1$	63	$0,004 \times d_1$	56	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	1.2	70	$0,004 \times d_1$	63	$0,004 \times d_1$	56	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	2.1	60	$0,003 \times d_1$	54	$0,003 \times d_1$	48	$0,003 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	2.2	60	$0,003 \times d_1$	54	$0,003 \times d_1$	48	$0,003 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	3.1	50	$0,002 \times d_1$	45	$0,002 \times d_1$	40	$0,002 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	3.2	50	$0,002 \times d_1$	45	$0,002 \times d_1$	40	$0,002 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	4.1	40	$0,002 \times d_1$	36	$0,002 \times d_1$	32	$0,002 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	4.2	30	$0,002 \times d_1$	27	$0,002 \times d_1$	24	$0,002 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
N	1.1	120	$0,005 \times d_1$	108	$0,005 \times d_1$	96	$0,005 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	1.2	120	$0,005 \times d_1$	108	$0,005 \times d_1$	96	$0,005 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	1.3	120	$0,005 \times d_1$	108	$0,005 \times d_1$	96	$0,005 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	1.4	80	$0,004 \times d_1$	72	$0,004 \times d_1$	64	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	1.5	70	$0,004 \times d_1$	63	$0,004 \times d_1$	56	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	1.6	60	$0,004 \times d_1$	54	$0,004 \times d_1$	48	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.1	70	$0,004 \times d_1$	63	$0,004 \times d_1$	56	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.2	60	$0,004 \times d_1$	54	$0,004 \times d_1$	48	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.3	70	$0,004 \times d_1$	63	$0,004 \times d_1$	56	$0,004 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.4	60	$0,004 \times d_1$	54	$0,004 \times d_1$	48	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.5	60	$0,004 \times d_1$	54	$0,004 \times d_1$	48	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.6	70	$0,004 \times d_1$	63	$0,004 \times d_1$	56	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.7	50	$0,003 \times d_1$	45	$0,003 \times d_1$	40	$0,003 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.8	40	$0,003 \times d_1$	36	$0,003 \times d_1$	32	$0,003 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	3.1	120	$0,004 \times d_1$	108	$0,004 \times d_1$	96	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	3.2	80	$0,003 \times d_1$	72	$0,003 \times d_1$	64	$0,003 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
4.1	150	$0,004 \times d_1$	135	$0,004 \times d_1$	120	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>	
4.2	100	$0,004 \times d_1$	90	$0,004 \times d_1$	80	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>	
4.3	80	$0,004 \times d_1$	72	$0,004 \times d_1$	64	$0,004 \times d_1$	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>		<input type="checkbox"/>	
4.4	60	$0,004 \times d_1$	54	$0,004 \times d_1$	48	$0,004 \times d_1$	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>		<input type="checkbox"/>	
5.1	120	$0,005 \times d_1$	108	$0,005 \times d_1$	96	$0,005 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
5.2	60	$0,003 \times d_1$	54	$0,003 \times d_1$	48	$0,003 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>	
5.3											
S	1.1	50	$0,003 \times d_1$	45	$0,003 \times d_1$	40	$0,003 \times d_1$				<input checked="" type="checkbox"/>
	1.2	40	$0,002 \times d_1$	36	$0,002 \times d_1$	32	$0,002 \times d_1$				<input checked="" type="checkbox"/>
	1.3	30	$0,002 \times d_1$	27	$0,002 \times d_1$	24	$0,002 \times d_1$				<input checked="" type="checkbox"/>
	2.1	50	$0,003 \times d_1$	45	$0,003 \times d_1$	40	$0,003 \times d_1$				<input checked="" type="checkbox"/>
	2.2	30	$0,002 \times d_1$	27	$0,002 \times d_1$	24	$0,002 \times d_1$				<input checked="" type="checkbox"/>
	2.3	20	$0,002 \times d_1$	18	$0,002 \times d_1$	16	$0,002 \times d_1$				<input checked="" type="checkbox"/>
	2.4	30	$0,002 \times d_1$	27	$0,002 \times d_1$	24	$0,002 \times d_1$				<input checked="" type="checkbox"/>
	2.5	20	$0,002 \times d_1$	18	$0,002 \times d_1$	16	$0,002 \times d_1$				<input checked="" type="checkbox"/>
2.6	30	$0,002 \times d_1$	27	$0,002 \times d_1$	24	$0,002 \times d_1$				<input checked="" type="checkbox"/>	
H	1.1										
	1.2										
	1.3										
	1.4										
	1.5										

■ = sehr gut geeignet · very suitable
□ = gut geeignet · suitable

v_c = Schnittgeschwindigkeit · Cutting speed
 f_z = Vorschub pro Zahn · Feed per tooth