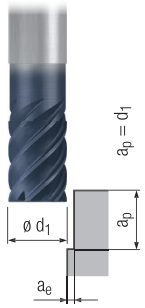
Hartmetall-Schaftfräser – kurze, lange und extra lange Ausführung
Solid carbide end mills – short, long and extra long design

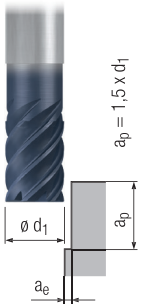
H

Gültig für · Valid for

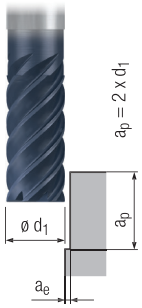
1825A	1927A	2816A
1827A	1928A	2817A
1828A	2812A	
1925A	2813A	



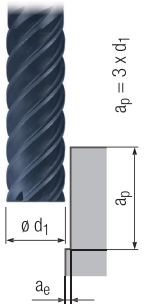
$a_e = 0{,}05 \times d_1$



$a_e = 0{,}05 \times d_1$



$a_e = 0{,}02 \times d_1$



$a_e = 0{,}02 \times d_1$

		v_c [m/min]	f_z [mm]	v_c [m/min]	f_z [mm]	v_c [m/min]	f_z [mm]	v_c [m/min]	f_z [mm]			MMS MQL	
P	1.1	210	0,005 x d_1	170	0,004 x d_1	240	0,005 x d_1	150	0,005 x d_1	□	■		□
	2.1	190	0,004 x d_1	150	0,004 x d_1	220	0,005 x d_1	130	0,004 x d_1	□	■		□
	3.1	170	0,004 x d_1	140	0,003 x d_1	200	0,004 x d_1	120	0,004 x d_1	□	■		□
	4.1	150	0,003 x d_1	120	0,003 x d_1	170	0,003 x d_1	110	0,003 x d_1	□	■		
	5.1	130	0,003 x d_1	100	0,003 x d_1	150	0,003 x d_1	90	0,003 x d_1	□	■		
M	1.1												
	2.1												
	3.1												
	4.1												
K	1.1	210	0,005 x d_1	170	0,005 x d_1	240	0,006 x d_1	150	0,005 x d_1	□	■		
	1.2	210	0,005 x d_1	170	0,005 x d_1	240	0,006 x d_1	150	0,005 x d_1	□	■		
	2.1	180	0,004 x d_1	140	0,004 x d_1	210	0,004 x d_1	130	0,004 x d_1	□	■		
	2.2	180	0,004 x d_1	140	0,004 x d_1	210	0,004 x d_1	130	0,004 x d_1	□	■		
	3.1	160	0,004 x d_1	130	0,004 x d_1	180	0,004 x d_1	110	0,004 x d_1	□	■		
	3.2	160	0,004 x d_1	130	0,004 x d_1	180	0,004 x d_1	110	0,004 x d_1	□	■		
	4.1	130	0,003 x d_1	100	0,003 x d_1	150	0,003 x d_1	90	0,003 x d_1	□	■		
	4.2	110	0,003 x d_1	90	0,003 x d_1	130	0,003 x d_1	80	0,003 x d_1	□	■		
N	1.1												
	1.2												
	1.3												
	1.4												
	1.5												
	1.6												
	2.1												
	2.2												
	2.3												
	2.4												
	2.5												
	2.6												
	2.7												
	2.8												
	3.1												
	3.2												
	4.1												
	4.2												
	4.3												
	4.4												
	5.1												
	5.2												
	5.3												
S	1.1												
	1.2												
	1.3												
	2.1												
	2.2												
	2.3												
	2.4												
	2.5												
	2.6												
H	1.1	130	0,004 x d_1	100	0,003 x d_1	150	0,004 x d_1	90	0,004 x d_1	□	■		
	1.2	110	0,003 x d_1	90	0,003 x d_1	130	0,003 x d_1	80	0,003 x d_1	□	■		
	1.3	90	0,003 x d_1	70	0,002 x d_1	100	0,003 x d_1	60	0,003 x d_1	□	■		
	1.4	80	0,002 x d_1	60	0,002 x d_1	90	0,002 x d_1	60	0,002 x d_1	□	■		
	1.5	70	0,002 x d_1	60	0,001 x d_1	80	0,002 x d_1	50	0,002 x d_1	□	■		

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