

Cooling	 
Tolerance	f8
Coating	TiSiN- α

HA

HSC

HPC

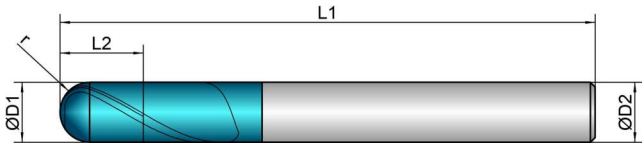




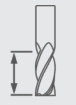
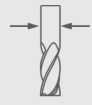
Expert

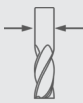


HA K203103



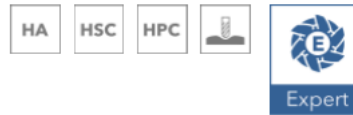
Steel			Hardened steel				Stainless steel (VA)	Castings	Non-ferrous materials				Inconel	Abrasive material		Titanium
< 850 N/mm	< 1100 N/mm	< 1400 N/mm	< 55 HRC	< 60 HRC	< 67 HRC	< 70 HRC			Al	Copper	Mg	Plastics		CFRP / GFRP	Graphite	
		210	180	160	110	85										

K203103	 mm ø	 mm	 mm	 mm ø	 #	 mm	 °
0,1/3	0.1	0.2	38.0	3.0	2	0.05	30
0,15/3	0.15	0.3	38.0	3.0	2	0.075	30
0,2/3	0.2	0.4	38.0	3.0	2	0.10	30
0,25/3	0.25	0.5	38.0	3.0	2	0.125	30
0,3/3	0.3	1.0	38.0	3.0	2	0.15	30
0,35/3	0.35	1.0	38.0	3.0	2	0.175	30
0,4/3	0.4	1.0	38.0	3.0	2	0.20	30
0,5/3	0.5	1.5	38.0	3.0	2	0.25	30
0,5/6	0.5	1.5	54.0	6.0	2	0.25	30
0,6/3	0.6	1.5	38.0	3.0	2	0.30	30
0,7/3	0.7	2.0	38.0	3.0	2	0.35	30
0,8/3	0.8	2.0	38.0	3.0	2	0.40	30
0,9/3	0.9	2.5	38.0	3.0	2	0.45	30
1/3	1.0	2.0	50.0	3.0	2	0.50	30

	D1  mm ø	L2  mm	L1  mm	D2  mm ø	z  #	r  mm	 °
K203103							
1/6	1.0	2.0	54.0	6.0	2	0.50	30
1,1/3	1.1	3.0	50.0	3.0	2	0.55	30
1,2/3	1.2	3.0	50.0	3.0	2	0.60	30
1,4/3	1.4	3.0	50.0	3.0	2	0.70	30
1,5/3	1.5	3.0	50.0	3.0	2	0.75	30
1,5/6	1.5	3.0	54.0	6.0	2	0.75	30
1,6/3	1.6	4.0	50.0	3.0	2	0.80	30
1,8/3	1.8	4.0	50.0	3.0	2	0.90	30
2/3	2.0	4.0	50.0	3.0	2	1.00	30
2/6	2.0	4.0	54.0	6.0	2	1.00	30
2,5/3	2.5	5.0	50.0	3.0	2	1.25	30
2,5/6	2.5	5.0	54.0	6.0	2	1.25	30
3/3	3.0	6.0	50.0	3.0	2	1.50	30
3/6	3.0	6.0	54.0	6.0	2	1.50	30
4/4	4.0	7.0	54.0	4.0	2	2.00	30
4/6	4.0	7.0	54.0	6.0	2	2.00	30
5/5	5.0	8.0	54.0	5.0	2	2.50	30
5/6	5.0	8.0	54.0	6.0	2	2.50	30
6/6	6.0	10.0	54.0	6.0	2	3.00	30
8/8	8.0	12.0	59.0	8.0	2	4.00	30
10/10	10.0	14.0	67.0	10.0	2	5.00	30
12/12	12.0	16.0	74.0	12.0	2	6.00	30
14/14	14.0	18.0	75.0	14.0	2	7.00	30
16/16	16.0	22.0	83.0	16.0	2	8.00	30
20/20	20.0	26.0	93.0	20.0	2	10.00	30

K203103 | VHM Vollradiusfräser
SC Full Radius Cutter

Kühlung	 
Toleranz	f8
Beschichtung	TiSiN- α



Werkstoff / Material	Festigkeit / strength (N/mm ²)	Vc m/min	Ø 0,1 - 2	Ø 3 - 4	Ø 5	Ø 6	Ø 8	Ø 10	Ø 12	Ø 16	Ø 20
											
			ae= 0,05xD	ae= 0,05xD	ae= 0,05xD	ae= 0,05xD	ae= 0,05xD	ae= 0,05xD	ae= 0,05xD	ae= 0,05xD	ae= 0,05xD
			ap= 0,05xD	ap= 0,05xD	ap= 0,05xD	ap= 0,05xD	ap= 0,05xD	ap= 0,05xD	ap= 0,05xD	ap= 0,05xD	ap= 0,05xD
			fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)	fz (mm/Z)
Stahl / Steel	< 850										
Stahl / Steel	< 1100										
Stahl / Steel	< 1400	210	0,007	0,015	0,03	0,045	0,06	0,07	0,08	0,09	0,1
Gehärteter Stahl / Hardness Steel	< 55HRC	180	0,006	0,025	0,05	0,055	0,07	0,08	0,09	0,1	0,11
Gehärteter Stahl / Hardness Steel	< 60HRC	160	0,006	0,025	0,05	0,055	0,07	0,08	0,09	0,1	0,11
Gehärteter Stahl / Hardness Steel	< 67HRC	110	0,006	0,025	0,05	0,055	0,07	0,08	0,09	0,1	0,11
Gehärteter Stahl / Hardness Steel	≤ 70HRC	85	0,003	0,02	0,04	0,045	0,06	0,065	0,07	0,075	0,08
INOX	< 700										
INOX	< 850										
Guss / Castings											
Aluminium / Al											
Kupfer / Cooper											
Kunststoffe / Plastics											
Inconel											
Titan / Titanium											
Grafit / Graphite											
GFK / CFK											

Bitte beachten, hierbei handelt es sich lediglich um Richtwerte! / Caution, these are only guide values!