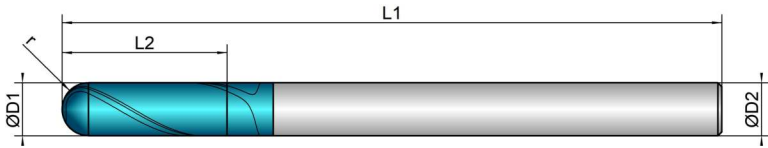


Cooling	 
Tolerance	f8
Coating	TiSiN- α



HA K203143

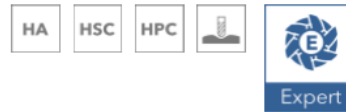


Steel			Hardened steel				Stainless steel (VA)	Castings	Non-ferrous materials				Inconel	Abrasive material		Titanium
< 850 N/mm	< 1100 N/mm	< 1400 N/mm	< 55 HRC	< 60 HRC	< 67 HRC	< 70 HRC			Al	Copper	Mg	Plastics		CFRP / GFRP	Graphite	
		200	175	155	95	80										

	D1  mm ø	L2  mm	L1  mm	D2  mm ø	z  #	r  mm	 °
K203143							
0,5/3	0.5	1.5	75.0	3.0	2	0.25	30
0,5/6	0.5	1.5	80.0	6.0	2	0.25	30
1/3	1.0	3.0	75.0	3.0	2	0.50	30
1/6	1.0	3.0	80.0	6.0	2	0.50	30
1,5/3	1.5	4.0	75.0	3.0	2	0.75	30
1,5/6	1.5	4.0	80.0	6.0	2	0.75	30
2/3	2.0	6.0	75.0	3.0	2	1.00	30
2/6	2.0	6.0	80.0	6.0	2	1.00	30
2,5/3	2.5	8.0	75.0	3.0	2	1.25	30
2,5/6	2.5	8.0	80.0	6.0	2	1.25	30
3/3	3.0	10.0	75.0	3.0	2	1.50	30
3/6	3.0	10.0	80.0	6.0	2	1.50	30
4/4	4.0	13.0	75.0	4.0	2	2.00	30
4/6	4.0	13.0	80.0	6.0	2	2.00	30
5/5	5.0	14.0	75.0	5.0	2	2.50	30
5/6	5.0	14.0	100.0	6.0	2	2.50	30
6/6	6.0	16.0	100.0	6.0	2	3.00	30
8/8	8.0	22.0	100.0	8.0	2	4.00	30
10/10	10.0	25.0	100.0	10.0	2	5.00	30
12/12	12.0	26.0	100.0	12.0	2	6.00	30
14/14	14.0	26.0	100.0	14.0	2	7.00	30
16/16	16.0	30.0	150.0	16.0	2	8.00	30
20/20	20.0	40.0	150.0	20.0	2	10.00	30

K203143 | 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		200	0,007	0,015	0,03	0,045	0,06	0,07	0,08	0,09	0,1
Gehärteter Stahl / Hardness Steel	< 55HRC		175	0,006	0,025	0,05	0,055	0,07	0,08	0,09	0,1	0,11
Gehärteter Stahl / Hardness Steel	< 60HRC		155	0,006	0,025	0,05	0,055	0,07	0,08	0,09	0,1	0,11
Gehärteter Stahl / Hardness Steel	< 67HRC		95	0,006	0,025	0,05	0,055	0,07	0,08	0,09	0,1	0,11
Gehärteter Stahl / Hardness Steel	≤ 70HRC		80	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!