

Cooling	   
Tolerance	0-0,01
Coating	TiSiN- α

HA

HSC

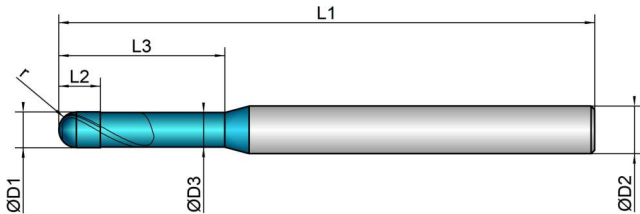




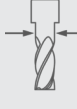
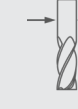
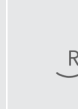
Expert

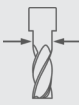
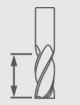
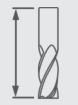
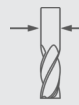


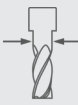
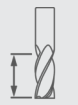
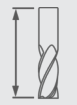
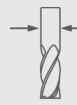
HA K203206



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	
220	210	195	125	75	60	45	100			150						

K203206	D1  mm ø	D3  mm ø	L2  mm	L3  mm	L1  mm	D2  mm ø	z  #	r  mm	 °
0,2X0,3	0.2	0.17	0.16	0.3	45.0	4.0	2	0.10	30
0,2X0,5	0.2	0.17	0.16	0.5	45.0	4.0	2	0.10	30
0,2X0,75	0.2	0.17	0.16	0.75	45.0	4.0	2	0.10	30
0,2X1	0.2	0.17	0.16	1.0	45.0	4.0	2	0.10	30
0,2X1,25	0.2	0.17	0.16	1.25	45.0	4.0	2	0.10	30
0,2X1,5	0.2	0.17	0.16	1.5	45.0	4.0	2	0.10	30
0,2X1,75	0.2	0.17	0.16	1.75	45.0	4.0	2	0.10	30
0,2X2	0.2	0.17	0.16	2.0	45.0	4.0	2	0.10	30
0,2X2,5	0.2	0.17	0.16	2.5	45.0	4.0	2	0.10	30
0,2X3	0.2	0.17	0.16	3.0	45.0	4.0	2	0.10	30
0,3X0,5	0.3	0.27	0.24	0.5	45.0	4.0	2	0.15	30
0,3X0,75	0.3	0.27	0.24	0.75	45.0	4.0	2	0.15	30
0,3X1	0.3	0.27	0.24	1.0	45.0	4.0	2	0.15	30
0,3X1,25	0.3	0.27	0.24	1.25	45.0	4.0	2	0.15	30
0,3X1,5	0.3	0.27	0.24	1.5	45.0	4.0	2	0.15	30
0,4X0,5	0.4	0.34	0.32	0.5	45.0	4.0	2	0.20	30
0,4X0,75	0.4	0.34	0.32	0.75	45.0	4.0	2	0.20	30
0,4X1	0.4	0.34	0.32	1.0	45.0	4.0	2	0.20	30

									
K203206	mm ø	mm ø	mm	mm	mm	mm ø	#	mm	°
0,4X1,5	0.4	0.34	0.32	1.5	45.0	4.0	2	0.20	30
0,4X2	0.4	0.34	0.32	2.0	45.0	4.0	2	0.20	30
0,4X2,5	0.4	0.34	0.32	2.5	45.0	4.0	2	0.20	30
0,4X3	0.4	0.34	0.32	3.0	45.0	4.0	2	0.20	30
0,4X3,5	0.4	0.34	0.32	3.5	45.0	4.0	2	0.20	30
0,4X4	0.4	0.34	0.32	4.0	45.0	4.0	2	0.20	30
0,4X4,5	0.4	0.34	0.32	4.5	45.0	4.0	2	0.20	30
0,4X5	0.4	0.34	0.32	5.0	45.0	4.0	2	0.20	30
0,4X5,5	0.4	0.34	0.32	5.5	45.0	4.0	2	0.20	30
0,4X6	0.4	0.34	0.32	6.0	45.0	4.0	2	0.20	30
0,5X1	0.5	0.47	0.4	1.0	45.0	4.0	2	0.25	30
0,5X1,5	0.5	0.47	0.4	1.5	45.0	4.0	2	0.25	30
0,5X2	0.5	0.47	0.4	2.0	45.0	4.0	2	0.25	30
0,5X2,5	0.5	0.47	0.4	2.5	45.0	4.0	2	0.25	30
0,5X3	0.5	0.47	0.4	3.0	45.0	4.0	2	0.25	30
0,5X3,5	0.5	0.47	0.4	3.5	45.0	4.0	2	0.25	30
0,5X4	0.5	0.47	0.4	4.0	45.0	4.0	2	0.25	30
0,5X4,5	0.5	0.47	0.4	4.5	45.0	4.0	2	0.25	30
0,5X5	0.5	0.47	0.4	5.0	45.0	4.0	2	0.25	30
0,5X5,5	0.5	0.47	0.4	5.5	45.0	4.0	2	0.25	30
0,5X6	0.5	0.47	0.4	6.0	45.0	4.0	2	0.25	30
0,5X7	0.5	0.47	0.4	7.0	45.0	4.0	2	0.25	30
0,5X8	0.5	0.47	0.4	8.0	45.0	4.0	2	0.25	30
0,5X9	0.5	0.47	0.4	9.0	45.0	4.0	2	0.25	30
0,6X1	0.6	0.57	0.48	1.0	45.0	4.0	2	0.30	30
0,6X2	0.6	0.57	0.48	2.0	45.0	4.0	2	0.30	30
0,6X3	0.6	0.57	0.48	3.0	45.0	4.0	2	0.30	30
0,6X4	0.6	0.57	0.48	4.0	45.0	4.0	2	0.30	30
0,6X5	0.6	0.57	0.48	5.0	45.0	4.0	2	0.30	30
0,6X6	0.6	0.57	0.48	6.0	45.0	4.0	2	0.30	30
0,6X8	0.6	0.57	0.48	8.0	45.0	4.0	2	0.30	30
0,8X2	0.8	0.77	0.64	2.0	45.0	4.0	2	0.40	30
0,8X3	0.8	0.77	0.64	3.0	45.0	4.0	2	0.40	30
0,8X4	0.8	0.77	0.64	4.0	45.0	4.0	2	0.40	30
0,8X5	0.8	0.77	0.64	5.0	45.0	4.0	2	0.40	30
0,8X6	0.8	0.77	0.64	6.0	45.0	4.0	2	0.40	30
0,8X7	0.8	0.77	0.64	7.0	45.0	4.0	2	0.40	30
0,8X8	0.8	0.77	0.64	8.0	45.0	4.0	2	0.40	30
0,8X9	0.8	0.77	0.64	9.0	45.0	4.0	2	0.40	30
1X2,5	1.0	0.96	0.8	2.5	45.0	4.0	2	0.50	30

K203206									
	mm ø	mm ø	mm	mm	mm	mm ø	#	mm	°
1X3	1.0	0.96	0.8	3.0	45.0	4.0	2	0.50	30
1X4	1.0	0.96	0.8	4.0	45.0	4.0	2	0.50	30
1X5	1.0	0.96	0.8	5.0	45.0	4.0	2	0.50	30
1X6	1.0	0.96	0.8	6.0	45.0	4.0	2	0.50	30
1X7	1.0	0.96	0.8	7.0	45.0	4.0	2	0.50	30
1X8	1.0	0.96	0.8	8.0	45.0	4.0	2	0.50	30
1X9	1.0	0.96	0.8	9.0	45.0	4.0	2	0.50	30
1X10	1.0	0.96	0.8	10.0	45.0	4.0	2	0.50	30
1X12	1.0	0.96	0.8	12.0	45.0	4.0	2	0.50	30
1,2X6	1.2	1.16	0.96	6.0	45.0	4.0	2	0.60	30
1,2X8	1.2	1.16	0.96	8.0	45.0	4.0	2	0.60	30
1,2X10	1.2	1.16	0.96	10.0	45.0	4.0	2	0.60	30
1,2X12	1.2	1.16	0.96	12.0	45.0	4.0	2	0.60	30
1,4X8	1.4	1.34	1.12	8.0	45.0	4.0	2	0.70	30
1,4X12	1.4	1.34	1.12	12.0	45.0	4.0	2	0.70	30
1,5X3	1.5	1.44	1.2	3.0	45.0	4.0	2	0.75	30
1,5X4	1.5	1.44	1.2	4.0	45.0	4.0	2	0.75	30
1,5X6	1.5	1.44	1.2	6.0	45.0	4.0	2	0.75	30
1,5X8	1.5	1.44	1.2	8.0	45.0	4.0	2	0.75	30
1,5X10	1.5	1.44	1.2	10.0	45.0	4.0	2	0.75	30
1,5X12	1.5	1.44	1.2	12.0	45.0	4.0	2	0.75	30
1,6X8	1.6	1.54	1.28	8.0	45.0	4.0	2	0.80	30
1,6X12	1.6	1.54	1.28	12.0	45.0	4.0	2	0.80	30
1,8X8	1.8	1.74	1.44	8.0	45.0	4.0	2	0.90	30
1,8X12	1.8	1.74	1.44	12.0	45.0	4.0	2	0.90	30
2X3	2.0	1.94	1.6	3.0	45.0	4.0	2	1.00	30
2X4	2.0	1.94	1.6	4.0	45.0	4.0	2	1.00	30
2X6	2.0	1.94	1.6	6.0	45.0	4.0	2	1.00	30
2X8	2.0	1.94	1.6	8.0	45.0	4.0	2	1.00	30
2X10	2.0	1.94	1.6	10.0	45.0	4.0	2	1.00	30
2X12	2.0	1.94	1.6	12.0	45.0	4.0	2	1.00	30
2,5X10	2.5	2.41	2.0	10.0	45.0	4.0	2	1.25	30
3X8	3.0	2.92	3.5	8.0	45.0	4.0	2	1.50	30
3X10	3.0	2.92	3.5	10.0	45.0	4.0	2	1.50	30
3X12	3.0	2.92	3.5	12.0	45.0	4.0	2	1.50	30
3X16	3.0	2.92	3.5	16.0	45.0	4.0	2	1.50	30

K203206 | VHM Micro Vollradiusfräser SC Micro Full Radius Cutter

Kühlung				
Toleranz	0-0,01			
Beschichtung	TiSiN- α			



Werkstoff / Material	Festigkeit / strength (N/mm ²)	Vc m/min	Ø 0,1 - 0,3		Ø 0,4 - 0,8		Ø 0,9 - 1,2		Ø 1,3 - 1,5		Ø 1,6 - 1,9		Ø 2 - 2,3		Ø 2,4 - 2,7		Ø 2,8 - 3,0			
			ae= 0,15xD	ae= 0,1xD	ae= 0,15xD	ae= 0,1xD	ae= 0,15xD	ae= 0,1xD	ae= 0,15xD	ae= 0,1xD	ae= 0,15xD	ae= 0,1xD	ae= 0,15xD	ae= 0,1xD	ae= 0,15xD	ae= 0,1xD	ae= 0,15xD	ae= 0,1xD		
			ap= L ₂ max	ap= 0,1xD	ap= L ₂ max	ap= 0,1xD	ap= L ₂ max	ap= 0,1xD	ap= L ₂ max	ap= 0,1xD	ap= L ₂ max	ap= 0,1xD	ap= L ₂ max	ap= 0,1xD	ap= L ₂ max	ap= 0,1xD	ap= L ₂ max	ap= 0,1xD		
			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)	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	195		0,012		0,017		0,021		0,023		0,025		0,028		0,031		0,033		
Gehärteter Stahl / Hardness Steel	< 55HRC	125		0,012		0,017		0,021		0,023		0,025		0,028		0,031		0,033		
Gehärteter Stahl / Hardness Steel	< 60HRC	75		0,011		0,016		0,02		0,022		0,024		0,027		0,03		0,032		
Gehärteter Stahl / Hardness Steel	< 67HRC	60		0,01		0,015		0,019		0,021		0,023		0,026		0,029		0,031		
Gehärteter Stahl / Hardness Steel	≤ 70HRC	45		0,009		0,014		0,018		0,02		0,022		0,025		0,028		0,03		
INOX	< 700	100		0,012		0,017		0,021		0,023		0,025		0,028		0,031		0,033		
INOX	< 850	95		0,011		0,016		0,02		0,022		0,024		0,027		0,03		0,032		
Guss / Castings																				
Aluminium / Al																				
Kupfer / Cooper		150		0,012		0,017		0,021		0,023		0,025		0,028		0,031		0,033		
Kunststoffe / Plastics																				
Inconel																				
Titan / Titanium																				
Grafit / Graphite																				
GFK / CFK																				

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

Hinweis:

Fz Angaben Tabelle ist für kurze Auskraglänge (L3), je länger, dementsprechen Fz prozentual verringern

Fz information at the table is for a short projection length (L3), the longer, accordingly reduce Fz as a percentage

