

Cooling	 
Tolerance	f8
Coating	TiSiN- α

HA

HSC

HPC

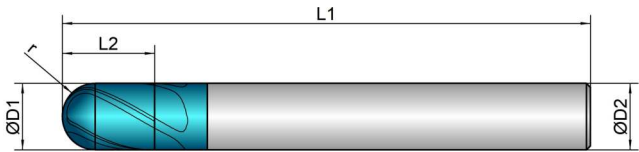




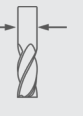
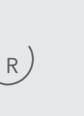
Expert



HA K203343

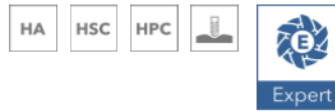


Steel			Hardened steel				Stainless steel (VA)	Castings	Non-ferrous materials				Inconel	Abrasive material		Titanium
< 850 N/mm	< 1100 N/mm	< 1400 N/mm	< 55 HRC	< 60 HRC	< 67 HRC	< 70 HRC			Al	Copper	Mg	Plastics		CFRP / GFRP	Graphite	
		200	175	155	110	85										

K203343	 D1 mm ø	 L2 mm	 L1 mm	 D2 mm ø	 z #	 r mm	 °
2/3	2.0	4.0	75.0	3.0	4	1.00	30
2/6	2.0	4.0	80.0	6.0	4	1.00	30
2,5/6	2.5	5.0	80.0	6.0	4	1.25	30
3/3	3.0	5.0	75.0	3.0	4	1.50	30
3/6	3.0	5.0	80.0	6.0	4	1.50	30
4/4	4.0	8.0	75.0	4.0	4	2.00	30
4/6	4.0	8.0	80.0	6.0	4	2.00	30
5/5	5.0	9.0	75.0	5.0	4	2.50	30
5/6	5.0	9.0	100.0	6.0	4	2.50	30
6/6	6.0	10.0	100.0	6.0	4	3.00	30
8/8	8.0	12.0	100.0	8.0	4	4.00	30
10/10	10.0	14.0	100.0	10.0	4	5.00	30
12/12	12.0	16.0	100.0	12.0	4	6.00	30
14/14	14.0	18.0	100.0	14.0	4	7.00	30
16/16	16.0	22.0	150.0	16.0	4	8.00	30
20/20	20.0	26.0	150.0	20.0	4	10.00	30

K203343 | 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	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!