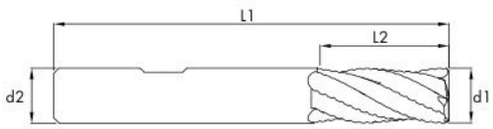
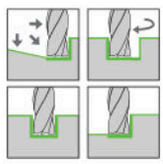
SOLID CARBIDE ROUGHING END MILLS

VOLLHARTMETALL SCHRUPPFRASER

KARBÜR KABA TALAŞ FREZE STABLE





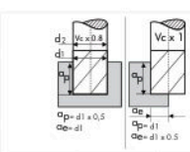


STABLE

<52 HRC



$d_1(e_8)$	L_2	L_1	$d_2(h_6)$	x45°	Z	Uncoated Code	Coated Code
6	13	57	6	0,30	4	4006110	4006120
7	16	60	7	0,35	4	4006130	4006140
8	19	63	8	0,40	4	4006150	4006160
9	19	67	9	0,45	4	4006170	4006180
10	22	72	10	0,50	4	4006190	4006200
12	26	83	12	0,60	4	4006210	4006220
14	26	83	14	0,70	4	4006230	4006240
16	32	92	16	0,80	4	4006250	4006260
18	32	92	18	0,90	4	4006270	4006280
20	38	104	20	1,00	4	4006290	4006300
6	24	68	6	0,30	4	4006310	4006320
8	38	88	8	0,40	4	4006330	4006340
10	45	100	10	0,50	4	4006350	4006360
12	53	110	12	0,60	4	4006370	4006380
14	53	110	14	0,70	4	4006390	4006400
16	63	110	16	0,80	4	4006410	4006420
18	63	110	18	0,90	4	4006430	4006440
20	75	141	20	1,00	4	4006450	4006460



	P (20-30 Hrc)			P (30-40 Hrc)			M			GG			AL			CU			Titan			< 52 HRC		
	1.0050-2 1.0060-2 1.0070-2			1.5864 1.6580 1.7225			1.4405 1.4460 1.4505			0.6035 0.7080 0.8055			3.2151 3.2373 3.2382			2.1247 2.0580 2.0598			3.7035 3.7055 3.7065			1.3255 1.3265 1.3333		
	Vc= 70 m/dk.			Vc = 50 m/dk.			Vc = 35 m/dk.			Vc= 100 m/dk.			Vc = 260 m/dk.			Vc = 180 m/dk.			Vc = 30 m/dk.			Vc = 30 m/dk.		
dl	ap	ae	fz	n	Vf	fz	n	Vf	fz	n	Vf	fz	n	Vf	fz	n	Vf	fz	n	Vf	fz	n	Vf	fz	n	Vf
6	3,0	3,0	0,070	3715	260xZ	0,070	2654	185xZ	0,054	1858	100xZ	0,034	5308	180xZ	0,079	13800	1100xZ	0,048	9554	460xZ	0,031	1592	50 xZ	0,025	1592	24 xZ
7	3,5	3,5	0,081	3185	260xZ	0,081	2275	185xZ	0,063	1592	100xZ	0,040	4500	180xZ	0,093	11828	1100xZ	0,056	8189	460xZ	0,037	1365	50 xZ	0,029	1365	40xZ
8	4,0	4,0	0,093	2787	260xZ	0,093	1190	185xZ	0,072	1393	100xZ	0,045	3981	180xZ	0,106	10350	1100xZ	0,064	7166	460xZ	0,042	1194	50 xZ	0,034	1194	40xZ
9	4,5	4,5	0,105	2477	260xZ	0,105	1769	185xZ	0,081	1238	100xZ	0,051	3538	180xZ	0,119	9200	1100xZ	0,072	6370	460xZ	0,047	1062	50 xZ	0,038	1062	40xZ
10	5,0	5,0	0,116	2229	260xZ	0,116	1592	185xZ	0,090	1115	100xZ	0,056	3185	180xZ	0,133	8280	1100xZ	0,080	5732	460xZ	0,052	955	50 xZ	0,042	955	40xZ
12	6,0	6,0	0,140	1858	260xZ	0,140	1327	185xZ	0,107	929	100xZ	0,068	2654	180xZ	0,159	6900	1100xZ	0,096	4777	460xZ	0,063	796	50 xZ	0,050	796	40xZ
14	7,0	7,0	0,163	1592	260xZ	0,163	1137	185xZ	0,125	796	100xZ	0,079	2275	180xZ	0,186	5914	1100xZ	0,112	4095	460xZ	0,073	682	50 xZ	0,058	682	40xZ
16	8,0	8,0	0,187	1393	260xZ	0,187	995	185xZ	0,143	697	100xZ	0,090	1990	180xZ	0,212	5175	1100xZ	0,128	3583	460xZ	0,084	597	50 xZ	0,067	597	40xZ
18	9,0	9,0	0,210	1238	260xZ	0,210	885	185xZ	0,161	619	100xZ	0,102	1769	180xZ	0,239	4600	1100xZ	0,144	3185	460xZ	0,094	531	50 xZ	0,075	531	40xZ
20	10,0	10,0	0,233	1115	260xZ	0,233	796	185xZ	0,179	557	100xZ	0,113	1592	180xZ	0,266	4140	1100xZ	0,161	2866	460xZ	0,105	478	50 xZ	0,084	478	40xZ
22	11,0	11,0	0,257	1013	260xZ	0,257	724	185xZ	0,197	507	100xZ	0,124	1448	180xZ	0,292	3766	1100xZ	0,176	2606	460xZ	0,115	434	50 xZ	0,092	434	40xZ
25	12,5	12,5	0,291	892	260xZ	0,291	637	185xZ	0,224	446	100xZ	0,141	1274	180xZ	0,332	3312	1100xZ	0,201	2293	460xZ	0,131	382	50 xZ	0,105	382	40xZ
28	14,0	14,0	0,327	796	260xZ	0,327	569	185xZ	0,251	398	100xZ	0,158	1137	180xZ	0,372	2957	1100xZ	0,225	2047	460xZ	0,147	341	50 xZ	0,117	341	40xZ