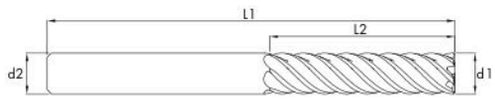
SOLID CARBIDE FINISHING END MILLS

VOLLHARTMETALL SCHLICHTFRASER LANG

KARBÜR ÇOK AĞIZLI FINISH FREZE UZUN DURAFIN LONG







DURAFIN LONG

<52 HRC



TYPE



QUALITY



DIAMETER



NORM

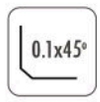

6 FLUTES



SHAFT TYPE



HELICAL

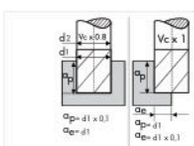


CHAMFER



COATED

$d_1(e_8)$	L_2	L_1	$d_2(h_6)$	Z	Uncoated Code	Coated Code
6	24	68	6	6	4007160	4007170
8	38	88	8	6	4007180	4007190
10	45	100	10	6	4007200	4007210
12	53	110	12	6	4007220	4007230
16	63	110	16	6	4007240	4007250
20	75	141	20	8	4007260	4007270
25	90	165	25	10	4007280	4007290



			P (20-30 Hrc)			P (30-40 Hrc)			GG			< 52 HRC		
			1.0050-2 1.0060-2 1.0070-2			1.5864 1.6580 1.7225			0.6035 0.7080 0.8055			1.3255 1.3265 1.3333		
			Vc= 130 m/dk.			Vc = 100 m/dk.			Vc= 120 m/dk.			Vc = 60 m/dk.		
dl	ap	ae	fz	n	Vf	fz	n	Vf	fz	n	Vf	fz	n	Vf
6	6	6	0,015	6900	100 xZ	0,015	5308	80xZ	0,020	6370	130xZ	0,009	3185	30xZ
8	8	8	0,019	5175	100 xZ	0,020	3981	80xZ	0,027	4777	130xZ	0,013	2390	30xZ
10	10	10	0,024	4140	100 xZ	0,025	3185	80xZ	0,034	3822	130xZ	0,016	1910	30xZ
12	12	12	0,029	3450	100 xZ	0,030	2654	80xZ	0,041	3185	130xZ	0,019	1592	30xZ
14	14	14	0,034	2957	100 xZ	0,035	2275	80xZ	0,048	2730	130xZ	0,022	1365	30xZ
16	16	16	0,038	2588	100 xZ	0,040	1990	80xZ	0,054	2390	130xZ	0,025	1194	30xZ
18	18	18	0,043	2300	100 xZ	0,045	1770	80xZ	0,061	2123	130xZ	0,028	1062	30xZ
20	20	20	0,048	2070	100 xZ	0,050	1592	80xZ	0,068	1911	130xZ	0,031	955	30xZ
25	25	25	0,060	1656	100 xZ	0,063	1274	80xZ	0,085	1530	130xZ	0,039	765	30xZ