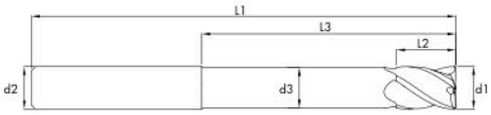
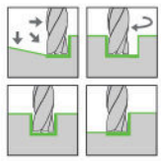
# SOLID CARBIDE END MILLS

VOLLHARTMETALLFRÄSER LANG

KARBÜR FREZE UZUN MOLDWAY LONG





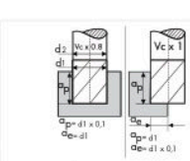



## MOLDWAY LONG

<52 HRC




| $d_1(e_8)$ | $L_2$ | $d_3$ | $L_3$ | $L_1$ | $d_2(h_6)$ | Z | Coated Code |
|---|---|---|---|---|---|---|---|
| 4 | 6 | 3,8 | 32 | 65 | 4 | 4 | 4027800 |
| 5 | 7 | 4,8 | 48 | 80 | 5 | 4 | 4027810 |
| 6 | 8 | 5,7 | 48 | 80 | 6 | 4 | 4027820 |
| 8 | 10 | 7,6 | 54 | 88 | 8 | 4 | 4027830 |
| 4 | 6 | 3,8 | 60 | 100 | 4 | 4 | 4027840 |
| 5 | 7 | 4,8 | 60 | 100 | 5 | 4 | 4027850 |
| 6 | 8 | 5,7 | 60 | 100 | 6 | 4 | 4027860 |
| 8 | 10 | 7,6 | 60 | 100 | 8 | 4 | 4027870 |
| 10 | 14 | 9,5 | 60 | 100 | 10 | 4 | 4027880 |
| 12 | 16 | 11,5 | 60 | 100 | 12 | 4 | 4027890 |
| 14 | 18 | 13,5 | 60 | 100 | 14 | 4 | 4027900 |
| 16 | 20 | 15,5 | 60 | 100 | 16 | 4 | 4027910 |
| 18 | 22 | 17,5 | 60 | 100 | 18 | 4 | 4027920 |
| | | | | | | | |
| 10 | 14 | 9,5 | 120 | 165 | 10 | 4 | 4027930 |
| 12 | 16 | 11,5 | 120 | 165 | 12 | 4 | 4027940 |
| 14 | 18 | 13,5 | 120 | 165 | 14 | 4 | 4027950 |
| 16 | 20 | 15,5 | 120 | 165 | 16 | 4 | 4027960 |
| 18 | 22 | 17,5 | 120 | 165 | 18 | 4 | 4027970 |
| 20 | 24 | 19,5 | 120 | 165 | 20 | 4 | 4027980 |




| | | | P (< 20 HRC) | | | P (< 25 HRC) | | | P (< 30 HRC) | | | P (< 35 HRC) | | | < 40 HRC | | | < 45 HRC | | | < 50 HRC | | | < 52 HRC | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | 1.7131-1.7139<br>1.7149-1.7262 | | | 1.4112 - 1.4116<br>1.4117 - 1.4125 | | | 1.7039 - 1.7225<br>1.7220 - 1.7226 | | | 1.5864 - 1.7707<br>1.6580 - 1.4542 | | | 1.7139 - 1.7262<br>1.7311 - 1.7323 | | | 1.8509 - 1.2713<br>1.2714 - 1.2718 | | | 1.2718 - 1.2726<br>1.2343 - 1.2344 | | | 1.2360 - 1.2782<br>1.2884 - 1.2365 | | |
| | | | Vc = 125 m/dk. | | | Vc = 115 m/dk. | | | Vc = 105 m/dk. | | | Vc = 95 m/dk. | | | Vc = 85 m/dk. | | | Vc = 75 m/dk. | | | Vc = 65 m/dk. | | | Vc = 55 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 |
| 4 | 0,4 | 0,4 | 0,020 | 9952 | 200xZ | 0,020 | 9155 | 180xZ | 0,020 | 8360 | 170xZ | 0,020 | 7562 | 150xZ | 0,020 | 6767 | 135xZ | 0,020 | 5971 | 120xZ | 0,020 | 5175 | 100xZ | 0,020 | 4379 | 90xZ |
| 5 | 0,5 | 0,5 | 0,025 | 7962 | 200xZ | 0,025 | 7324 | 180xZ | 0,025 | 6688 | 170xZ | 0,025 | 6050 | 150xZ | 0,025 | 5414 | 135xZ | 0,025 | 4777 | 120xZ | 0,024 | 4140 | 100xZ | 0,025 | 3503 | 90xZ |
| 6 | 0,6 | 0,6 | 0,030 | 6635 | 200xZ | 0,030 | 6103 | 180xZ | 0,034 | 5573 | 170xZ | 0,030 | 5041 | 150xZ | 0,030 | 4512 | 135xZ | 0,030 | 3981 | 120xZ | 0,029 | 3450 | 100xZ | 0,031 | 2919 | 90xZ |
| 8 | 0,8 | 0,8 | 0,040 | 4976 | 200xZ | 0,040 | 4577 | 180xZ | 0,045 | 4180 | 170xZ | 0,040 | 3781 | 150xZ | 0,040 | 3384 | 135xZ | 0,040 | 2986 | 120xZ | 0,039 | 2587 | 100xZ | 0,041 | 2190 | 90xZ |
| 10 | 1,0 | 1,0 | 0,050 | 3981 | 200xZ | 0,050 | 3662 | 180xZ | 0,050 | 3344 | 170xZ | 0,050 | 3025 | 150xZ | 0,050 | 2707 | 135xZ | 0,050 | 2388 | 120xZ | 0,049 | 2070 | 100xZ | 0,051 | 1752 | 90xZ |
| 12 | 1,2 | 1,2 | 0,060 | 3317 | 200xZ | 0,060 | 3052 | 180xZ | 0,061 | 2787 | 170xZ | 0,060 | 2521 | 150xZ | 0,060 | 2256 | 135xZ | 0,060 | 1990 | 120xZ | 0,059 | 1725 | 100xZ | 0,061 | 1460 | 90xZ |
| 14 | 1,4 | 1,4 | 0,070 | 2844 | 200xZ | 0,070 | 2616 | 180xZ | 0,071 | 2388 | 170xZ | 0,070 | 2160 | 150xZ | 0,070 | 1934 | 135xZ | 0,070 | 1706 | 120xZ | 0,069 | 1478 | 100xZ | 0,071 | 1251 | 90xZ |
| 16 | 1,6 | 1,6 | 0,080 | 2488 | 200xZ | 0,080 | 2289 | 180xZ | 0,081 | 2090 | 170xZ | 0,080 | 1890 | 150xZ | 0,080 | 1692 | 135xZ | 0,080 | 1493 | 120xZ | 0,079 | 1294 | 100xZ | 0,081 | 1095 | 90xZ |
| 18 | 1,8 | 1,8 | 0,090 | 2212 | 200xZ | 0,090 | 2034 | 180xZ | 0,091 | 1858 | 170xZ | 0,090 | 1680 | 150xZ | 0,090 | 1504 | 135xZ | 0,090 | 1327 | 120xZ | 0,089 | 1150 | 100xZ | 0,091 | 973 | 90xZ |
| 20 | 2,0 | 2,0 | 0,100 | 1990 | 200xZ | 0,100 | 1831 | 180xZ | 0,110 | 1672 | 170xZ | 0,100 | 1512 | 150xZ | 0,100 | 1354 | 135xZ | 0,100 | 1194 | 120xZ | 0,100 | 1035 | 100xZ | 0,110 | 876 | 90xZ |