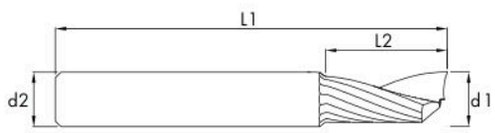
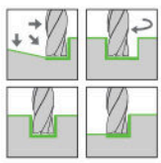
# SOLID CARBIDE END MILLS

VOLLHARTMETALLFRÄSER

KARBÜR FREZE FLEXI





## FLEXI



TYPE



QUALITY



DIAMETER



NORM


1 FLUTES



SHAFT TYPE



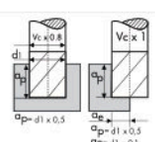
HELICAL


CHAMFER



COATED

| $d_1(e_8)$ | $L_2$ | $L_1$ | $d_2(h_6)$ | Z | Uncoated Code | Coated Code |
|---|---|---|---|---|---|---|
| 1 | 4 | 40 | 3 | 1 | 4032120 | 4032130 |
| 2 | 6 | 40 | 3 | 1 | 4032140 | 4032150 |
| 3 | 14 | 40 | 3 | 1 | 4032160 | 4032170 |
| 4 | 15 | 50 | 4 | 1 | 4032180 | 4032190 |
| 5 | 16 | 50 | 5 | 1 | 4032200 | 4032210 |
| 6 | 18 | 57 | 6 | 1 | 4032220 | 4032230 |
| 8 | 20 | 63 | 8 | 1 | 4032240 | 4032250 |
| 10 | 22 | 72 | 10 | 1 | 4032260 | 4032270 |
| 12 | 26 | 83 | 12 | 1 | 4032280 | 4032290 |
| | | | | | | |
| 3 | 16 | 65 | 3 | 1 | 4032300 | 4032310 |
| 4 | 18 | 65 | 4 | 1 | 4032320 | 4032330 |
| 5 | 20 | 65 | 5 | 1 | 4032340 | 4032350 |
| 6 | 24 | 68 | 6 | 1 | 4032360 | 4032370 |
| 8 | 38 | 88 | 8 | 1 | 4032380 | 4032390 |
| 10 | 45 | 100 | 10 | 1 | 4032400 | 4032410 |
| 12 | 53 | 110 | 12 | 1 | 4032420 | 4032430 |




| | | | AL | | | CU | | | Graphit | | | Flex | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | 3.2151<br>3.2373<br>3.2382 | | | 2.1247<br>2.0580<br>2.0598 | | | | | | | | |
| | | | Vc = 300 m/dk. | | | Vc = 220 m/dk. | | | Vc = 500 m/dk. | | | Vc = 500 m/dk. | | |
| dl | ap | ae | fz | n | Vf | fz | n | Vf | fz | n | Vf | fz | n | Vf |
| 3 | 1,5 | 0,30 | 0,030 | 31847 | 955 | 0,030 | 23355 | 701 | 0,030 | 53079 | 1592 | 0,030 | 53079 | 1592 |
| 4 | 2,0 | 0,40 | 0,040 | 23885 | 955 | 0,040 | 17516 | 701 | 0,040 | 39809 | 1592 | 0,040 | 39809 | 1592 |
| 5 | 2,5 | 0,50 | 0,050 | 19108 | 955 | 0,050 | 14013 | 701 | 0,050 | 31847 | 1592 | 0,050 | 31847 | 1592 |
| 6 | 3,0 | 0,60 | 0,060 | 15924 | 955 | 0,060 | 11677 | 701 | 0,060 | 26539 | 1592 | 0,060 | 26539 | 1592 |
| 8 | 4,0 | 0,80 | 0,070 | 11943 | 836 | 0,070 | 8758 | 613 | 0,070 | 19904 | 1393 | 0,070 | 19904 | 1393 |
| 10 | 5,0 | 1,00 | 0,080 | 9554 | 764 | 0,080 | 7006 | 561 | 0,080 | 15924 | 1274 | 0,080 | 15924 | 1274 |
| 12 | 6,0 | 1,20 | 0,090 | 7962 | 717 | 0,090 | 5839 | 525 | 0,090 | 13270 | 1194 | 0,090 | 13270 | 1194 |