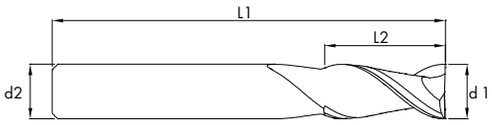
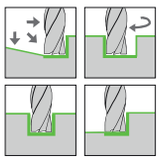
SOLID CARBIDE END MILLS

VOLLHARTMETALLFRÄSER

KARBÜR FREZE ALUMAX







ALUMAX



TYPE



QUALITY



DIAMETER



NORM


2 FLUTES



SHAFT TYPE



HELICAL



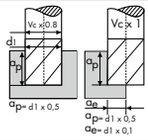
CHAMFER



COATED

d1(e8)	L2	L1	d2(h6)	Z	Uncoated Code	Coated Code
3	8	40	3	2	4032690	4032700
4	11	50	4	2	4032710	4032720
5	13	50	5	2	4032730	4032740
6	13	57	6	2	4032750	4032760
8	19	63	8	2	4032770	4032780
10	22	72	10	2	4032790	4032800
12	26	83	12	2	4032810	4032820
14	26	83	14	2	4032830	4032840
16	32	92	16	2	4032850	4032860
18	32	92	18	2	4032870	4032880
20	38	104	20	2	4032890	4032900
3	16	65	3	2	4032910	4032920
4	18	65	4	2	4032930	4032940
5	20	65	5	2	4032950	4032960
6	24	68	6	2	4032970	4032980
8	38	88	8	2	4032990	4033000
10	45	100	10	2	4033010	4033020
12	53	110	12	2	4033030	4033040
14	53	110	14	2	4033050	4033060
16	63	110	16	2	4033070	4033080
18	63	110	18	2	4033090	4033100
20	75	141	20	2	4033110	4033120

d1(e8)	L2	L1	d2(h6)	Z	Uncoated Code	Coated Code
3	8	40	3	3	4033130	4033140
4	11	50	4	3	4033150	4033160
5	13	50	5	3	4033170	4033180
6	13	57	6	3	4033190	4033200
8	19	63	8	3	4033210	4033220
10	22	72	10	3	4033230	4033240
12	26	83	12	3	4033250	4033260
14	26	83	14	3	4033270	4033280
16	32	92	16	3	4033290	4033300
18	32	92	18	3	4033310	4033320
20	38	104	20	3	4033330	4033340
3	16	65	3	3	4033350	4033360
4	18	65	4	3	4033370	4033380
5	20	65	5	3	4033390	4033400
6	24	68	6	3	4033410	4033420
8	38	88	8	3	4033430	4033440
10	45	100	10	3	4033450	4033460
12	53	110	12	3	4033470	4033480
14	53	110	14	3	4033490	4033500
16	63	110	16	3	4033510	4033520
18	63	110	18	3	4033530	4033540
20	75	141	20	3	4033550	4033560



	AL			CU			Graphit		
	3.2151 3.2373 3.2382			2.1247 2.0580 2.0598					
	Vc = 300 m/dk.			Vc = 220 m/dk.			Vc = 400 m/dk.		
d1	ap	ae	fz	n	Vf	fz	n	Vf	fz	n	Vf
3	1,5	0,60	0,020	31847	637xZ	0,010	23355	234 xZ	0,020	42463	849xZ
4	2,0	0,70	0,090	23885	2150xZ	0,080	17516	1401 xZ	0,090	31847	2866xZ
5	2,5	0,80	0,100	19108	1911xZ	0,090	14013	1261 xZ	0,100	25478	2548xZ
6	3,0	0,90	0,120	15924	1911xZ	0,100	11677	1168 xZ	0,120	21231	2548xZ
8	4,0	1,00	0,150	11943	1791 xZ	0,120	8758	1051 xZ	0,150	15924	2389xZ
10	5,0	1,20	0,180	9554	1720xZ	0,140	7006	981 xZ	0,180	12739	2293xZ
12	6,0	1,40	0,200	7962	1592xZ	0,160	5839	934 xZ	0,200	10616	2123xZ
14	7,0	1,60	0,220	6824	1501xZ	0,180	5005	901 xZ	0,220	9099	2002xZ
16	8,0	1,80	0,250	5971	1493xZ	0,200	4379	876 xZ	0,250	7962	1990xZ
18	9,0	2,00	0,280	5308	1486xZ	0,220	3892	856 xZ	0,280	7077	1982xZ
20	10,0	2,20	0,300	4777	1433xZ	0,240	3503	841 xZ	0,300	6369	1911xZ