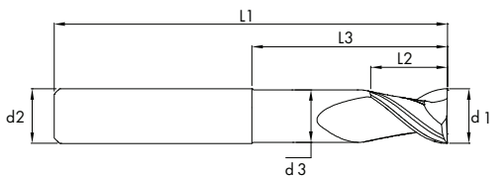
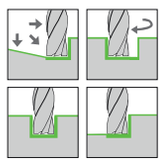
SOLID CARBIDE END MILLS

VOLLHARTMETALLFRÄSER

KARBÜR FREZE ALUCAST







ALUCAST



TYPE



QUALITY



DIAMETER



NORM


2 FLUTES



SHAFT TYPE



HELICAL

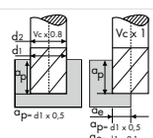


CHAMFER



COATED

$d_1(e_8)$	L_2	d_3	L_3	L_1	$d_2(h_6)$	Z	Uncoated Code	Coated Code
4	6	3,8	25	50	4	2	4033570	4033580
5	7	4,8	25	50	5	2	4033590	4033600
6	8	5,7	28	57	6	2	4033610	4033620
8	10	7,6	32	63	8	2	4033630	4033640
10	14	9,5	36	72	10	2	4033650	4033660
12	16	11,5	42	83	12	2	4033670	4033680
14	18	13,5	42	83	14	2	4033690	4033700
16	20	15,5	46	92	16	2	4033710	4033720
18	22	17,5	46	92	18	2	4033730	4033740
20	24	19,5	52	104	20	2	4033750	4033760
4	6	3,8	25	50	4	3	4033770	4033780
5	7	4,8	25	50	5	3	4033790	4033800
6	8	5,7	28	57	6	3	4033810	4033820
8	10	7,6	32	63	8	3	4033830	4033840
10	14	9,5	36	72	10	3	4033850	4033860
12	16	11,5	42	83	12	3	4033870	4033880
14	18	13,5	42	83	14	3	4033890	4033900
16	20	15,5	46	92	16	3	4033910	4033920
18	22	17,5	46	92	18	3	4033930	4033940
20	24	19,5	52	104	20	3	4033950	4033960



			AL			CU			Graphit		
			1.7139 - 1.7262 1.7311 - 1.7323			1.8509 - 1.2713 1.2714 - 1.2718					
			Vc = 350 m/dk.			Vc = 300 m/dk.			Vc = 500 m/dk.		
d1	ap	ae	fz	n	Vf	fz	n	Vf	fz	n	Vf
4	2,0	0,40	0,050	27866	2787	0,040	23885	1911	0,050	39809	3981
5	2,5	0,50	0,060	22293	2675	0,050	19108	1911	0,060	31847	3822
6	3,0	0,60	0,070	18577	2601	0,065	15924	2070	0,070	26539	3715
8	4,0	0,80	0,100	13933	2787	0,080	11943	1911	0,100	19904	3981
10	5,0	1,00	0,120	11146	2675	0,110	9554	2102	0,120	15924	3822
12	6,0	1,20	0,120	9289	2229	0,110	7962	1752	0,120	13270	3185
14	7,0	1,40	0,140	7962	2229	0,120	6824	1638	0,140	11374	3185
16	8,0	1,60	0,160	6967	2229	0,140	5971	1672	0,160	9952	3185
18	9,0	1,80	0,180	6192	2229	0,160	5308	1699	0,180	8846	3185
20	0,0	2,00	0,200	5573	2229	0,180	4777	1720	0,200	7962	3185