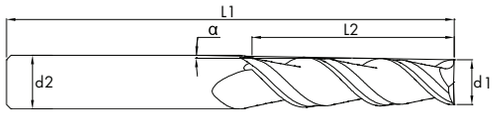
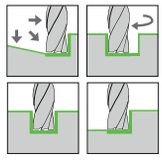
SOLID CARBIDE END MILLS

VOLLHARTMETALLFRÄSER LANG

KARBÜR FREZE UZUN ALUCAST LONG







ALUCAST LONG



TYPE



QUALITY



DIAMETER



NORM


2 FLUTES



SHAFT TYPE



HELICAL



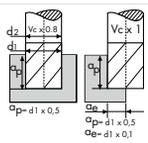
CHAMFER



COATED

$d_{1(e8)}$	L_2	d_3	L_3	L_1	$d_{2(h6)}$	Z	Uncoated Code	Coated Code
4	6	3,8	32	65	4	2	4033970	4033980
5	7	4,8	40	80	5	2	4033990	4034000
6	8	5,7	40	80	6	2	4034010	4034020
8	10	7,6	44	88	8	2	4034030	4034040
4	6	3,8	60	100	4	2	4034050	4034060
5	7	4,8	60	100	5	2	4034070	4034080
6	8	5,7	60	100	6	2	4034090	4034100
8	10	7,6	60	100	8	2	4034110	4034120
10	14	9,5	60	100	10	2	4034130	4034140
12	16	11,5	60	100	12	2	4034150	4034160
14	18	13,5	60	100	14	2	4034170	4034180
16	20	15,5	60	100	16	2	4034190	4034200
18	22	17,5	60	100	18	2	4034210	4034220
10	14	9,5	120	165	10	2	4034230	4034240
12	16	11,5	120	165	12	2	4034250	4034260
14	18	13,5	120	165	14	2	4034270	4034280
16	20	15,5	120	165	16	2	4034290	4034300
18	22	17,5	120	165	18	2	4034310	4034320
20	24	19,5	120	165	20	2	4034330	4034340

$d_{1(e8)}$	L_2	d_3	L_3	L_1	$d_{2(h6)}$	Z	Uncoated Code	Coated Code
4	6	3,8	32	65	4	3	4034350	4034360
5	7	4,8	40	80	5	3	4034370	4034380
6	8	5,7	40	80	6	3	4034390	4034400
8	10	7,6	44	88	8	3	4034410	4034420
4	6	3,8	60	100	4	3	4034430	4034440
5	7	4,8	60	100	5	3	4034450	4034460
6	8	5,7	60	100	6	3	4034470	4034480
8	10	7,6	60	100	8	3	4034490	4034500
10	14	9,5	60	100	10	3	4034510	4034520
12	16	11,5	60	100	12	3	4034530	4034540
14	18	13,5	60	100	14	3	4034550	4034560
16	20	15,5	60	100	16	3	4034570	4034580
18	22	17,5	60	100	18	3	4034590	4034600
10	14	9,5	120	165	10	3	4034610	4034620
12	16	11,5	120	165	12	3	4034630	4034640
14	18	13,5	120	165	14	3	4034650	4034660
16	20	15,5	120	165	16	3	4034670	4034680
18	22	17,5	120	165	18	3	4034690	4034700
20	24	19,5	120	165	20	3	4034710	4034720



	AL			CU			Graphit		
	1.7139 - 1.7262 1.7311 - 1.7323			1.8509 - 1.2713 1.2714 - 1.2718					
	Vc = 300 m/dk.			Vc = 250 m/dk.			Vc = 450 m/dk.		
d1	ap	ae	fz	n	Vf	fz	n	Vf	fz	n	Vf
4	2,0	0,40	0,050	23885	2389	0,040	19904	1592	0,050	35828	3583
5	2,5	0,50	0,060	19108	2293	0,050	15924	1592	0,060	28662	3439
6	3,0	0,60	0,070	15924	2229	0,050	13270	1327	0,070	23885	3344
8	4,0	0,80	0,100	11943	2389	0,080	9952	1592	0,100	17914	3583
10	5,0	1,00	0,120	9554	2293	0,110	7962	1752	0,120	14331	3439
12	6,0	1,20	0,120	7962	1911	0,110	6635	1460	0,120	11943	2866
14	7,0	1,40	0,140	6824	1911	0,120	5687	1365	0,140	10237	2866
16	8,0	1,60	0,160	5971	1911	0,140	4976	1393	0,160	8957	2866
18	9,0	1,80	0,180	5308	1911	0,160	4423	1415	0,180	7962	2866
20	10,0	2,00	0,200	4777	1911	0,180	3981	1433	0,200	7166	2866