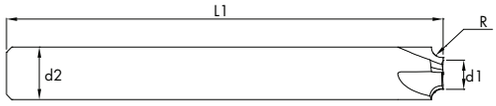
SOLID CARBIDE CORNER ROUNDING CUTTERS

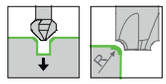
heikenei.com

VOLLHARTMETALL VIERTELKREISFRASER

KARBÜR DIŞ KÖŞE FREZE CORNER ROUNDING







CORNER ROUNDING



TYPE



QUALITY



DIAMETER



NORM

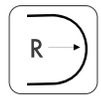

4 FLUTES



SHAFT TYPE



HELICAL

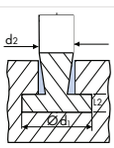


RADIUS



COATED

R	d1	L1	d2	Z	R	Uncoated Code	Coated Code
0,5	7	63	8	4	0,5	4043780	4043790
1,0	6	63	8	4	1,0	4043800	4043810
1,5	7	72	10	4	1,5	4043820	4043830
2,0	6	83	10	4	2,0	4043840	4043850
2,5	7	83	12	4	2,5	4043860	4043870
3,0	6	83	12	4	3,0	4043880	4043890
3,5	9	92	16	4	3,5	4043900	4043910
4,0	8	92	16	4	4,0	4043920	4043930
4,5	7	92	16	4	4,5	4043940	4043950
5,0	10	104	20	4	5,0	4043960	4043970
6,0	8	104	20	4	6,0	4043980	4043990



	P (20-30 Hrc)			P (30-40 Hrc)			M			GG			AL			CU			Titan			< 52 HRC		
	1.0050-2 1.0060-2 1.0070-2			1.5864 1.6580 1.7225			1.4405 1.4460 1.4505			0.6035 0.7080 0.8055			3.2151 3.2373 3.2382			2.1247 2.0580 2.0598			3.7035 3.7055 3.7065			1.3255 1.3265 1.3333		
	Vc= 12 m/dk.			Vc = 10 m/dk.			Vc = 9 m/dk.			Vc= 15 m/dk.			Vc = 25 m/dk.			Vc = 25 m/dk.			Vc = 8 m/dk.			Vc = 7 m/dk.		
d1	fz	n	Vf	fz	n	Vf	fz	n	Vf	fz	n	Vf	fz	n	Vf	fz	n	Vf	fz	n	Vf	fz	n	Vf
9	0,040	425	17xZ	0,030	350	11xZ	0,020	320	7xZ	0,040	530	21xZ	0,05	885	44xZ	0,05	885	44xZ	0,010	280	3xZ	0,008	250	2xZ
11	0,045	350	16xZ	0,035	290	10xZ	0,025	260	7xZ	0,045	435	20xZ	0,08	725	58xZ	0,08	725	58xZ	0,012	230	3xZ	0,010	200	2xZ
13	0,050	295	15xZ	0,040	245	10xZ	0,030	220	7xZ	0,050	370	19xZ	0,10	610	61xZ	0,10	610	61xZ	0,015	195	3xZ	0,012	170	2xZ
17	0,055	225	12xZ	0,045	190	9xZ	0,035	170	6xZ	0,055	280	16xZ	0,12	470	57xZ	0,12	470	57xZ	0,017	150	3xZ	0,014	130	2xZ
21	0,060	180	11xZ	0,050	150	8xZ	0,040	140	6xZ	0,060	230	14xZ	0,15	380	57xZ	0,15	380	57xZ	0,020	120	3xZ	0,015	105	2xZ