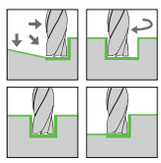
SOLID CARBIDE END MILLS

VOLLHARTMETALLFRÄSER

KARBÜR FREZE FLEXI







FLEXI



TYPE



QUALITY



DIAMETER



NORM

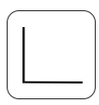

1 FLUTES



SHAFT TYPE



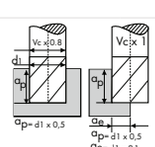
HELICAL


CHAMFER



COATED

$d_{1(e8)}$	L_2	L_1	$d_{2(h6)}$	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 3.2373 3.2382			2.1247 2.0580 2.0598								
			Vc = 300 m/dk.			Vc = 220 m/dk.			Vc = 500 m/dk.			Vc = 500 m/dk.		
d1	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