

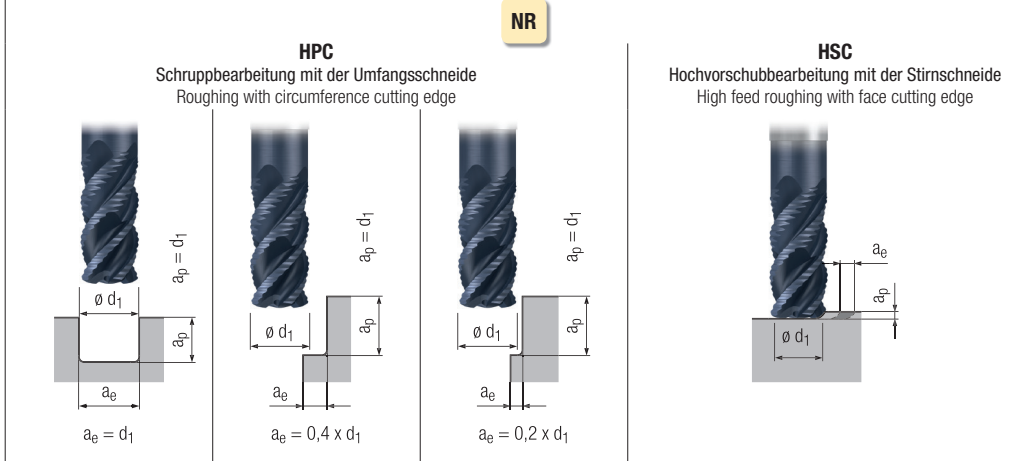
- Product Finder
- NR
- NF
- N
- H
- WR
- WF
- W
- $v_c / f_z$**



### Hartmetall-Schafffräser „DUPLEX“ – lange und extra lange Ausführung

Solid carbide end mills “DUPLEX” – long and extra long design

**Gültig für · Valid for**  
 2614AT 2615AZ 2616AZ  
 2614AZ 2616AT 2617AZ



	$v_c$ [m/min]	$f_z$ [mm]	$v_c$ [m/min]	$f_z$ [mm]	$v_c$ [m/min]	$f_z$ [mm]	$v_c$ [m/min]	$f_z$ [mm]	$a_p$ [mm]	$a_e$ [mm]					
<b>P</b>	1.1	170	$0,005 \times d_1$	190	$0,006 \times d_1$	200	$0,007 \times d_1$	220	$0,038 \times d_1$	$0,05 \times d_1$	0,5 $\times d_1$	□	■	□	■
	2.1	150	$0,005 \times d_1$	170	$0,005 \times d_1$	180	$0,006 \times d_1$	200	$0,034 \times d_1$	$0,05 \times d_1$	0,5 $\times d_1$	□	■		■
	3.1	130	$0,004 \times d_1$	140	$0,005 \times d_1$	160	$0,005 \times d_1$	170	$0,030 \times d_1$	$0,04 \times d_1$	0,4 $\times d_1$	□	■		□
	4.1	120	$0,003 \times d_1$	130	$0,004 \times d_1$	140	$0,004 \times d_1$	160	$0,024 \times d_1$	$0,03 \times d_1$	0,3 $\times d_1$	□	■		□
	5.1	110	$0,003 \times d_1$	120	$0,003 \times d_1$	130	$0,004 \times d_1$	140	$0,022 \times d_1$	$0,03 \times d_1$	0,3 $\times d_1$	□	■		□
<b>M</b>	1.1														
	2.1														
	3.1														
	4.1														
<b>K</b>	1.1	170	$0,006 \times d_1$	190	$0,006 \times d_1$	200	$0,007 \times d_1$	220	$0,040 \times d_1$	$0,06 \times d_1$	0,6 $\times d_1$	□	■		□
	1.2	170	$0,006 \times d_1$	190	$0,006 \times d_1$	200	$0,007 \times d_1$	220	$0,040 \times d_1$	$0,06 \times d_1$	0,6 $\times d_1$	□	■		□
	2.1	150	$0,005 \times d_1$	170	$0,005 \times d_1$	180	$0,006 \times d_1$	200	$0,032 \times d_1$	$0,05 \times d_1$	0,5 $\times d_1$	□	■		□
	2.2	150	$0,005 \times d_1$	170	$0,005 \times d_1$	180	$0,006 \times d_1$	200	$0,032 \times d_1$	$0,05 \times d_1$	0,5 $\times d_1$	□	■		□
	3.1	130	$0,005 \times d_1$	140	$0,005 \times d_1$	160	$0,006 \times d_1$	170	$0,032 \times d_1$	$0,05 \times d_1$	0,5 $\times d_1$	□	■		□
	3.2	130	$0,005 \times d_1$	140	$0,005 \times d_1$	160	$0,006 \times d_1$	170	$0,032 \times d_1$	$0,05 \times d_1$	0,5 $\times d_1$	□	■		□
	4.1	100	$0,003 \times d_1$	110	$0,004 \times d_1$	120	$0,004 \times d_1$	130	$0,024 \times d_1$	$0,03 \times d_1$	0,3 $\times d_1$	□	■		□
	4.2	80	$0,003 \times d_1$	90	$0,004 \times d_1$	100	$0,004 \times d_1$	100	$0,024 \times d_1$	$0,03 \times d_1$	0,3 $\times d_1$	□	■		□
<b>N</b>	1.1														
	1.2														
	1.3														
	1.4														
	1.5														
	1.6														
	2.1														
	2.2														
	2.3	150	$0,006 \times d_1$	170	$0,006 \times d_1$	180	$0,007 \times d_1$	200	$0,040 \times d_1$	$0,06 \times d_1$	0,6 $\times d_1$		□		■
	2.4														
	2.5														
	2.6	130	$0,005 \times d_1$	140	$0,005 \times d_1$	160	$0,006 \times d_1$	170	$0,032 \times d_1$	$0,05 \times d_1$	0,5 $\times d_1$		□		■
	2.7														
	2.8														
	3.1														
	3.2														
4.1															
4.2															
4.3															
4.4															
5.1															
5.2	80	$0,003 \times d_1$	90	$0,004 \times d_1$	100	$0,004 \times d_1$	100	$0,024 \times d_1$	$0,03 \times d_1$	0,3 $\times d_1$		□		■	
5.3															
<b>S</b>	1.1														
	1.2														
	1.3														
	2.1														
	2.2														
	2.3														
	2.4														
2.5															
2.6															
<b>H</b>	1.1	80	$0,003 \times d_1$	90	$0,003 \times d_1$	100	$0,004 \times d_1$	100	$0,022 \times d_1$	$0,03 \times d_1$	0,3 $\times d_1$	□	■		
	1.2	80	$0,003 \times d_1$	90	$0,003 \times d_1$	100	$0,004 \times d_1$	100	$0,020 \times d_1$	$0,03 \times d_1$	0,3 $\times d_1$	□	■		
	1.3														
	1.4														
	1.5														