

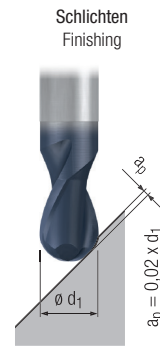
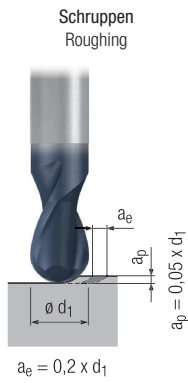


Hartmetall-Kugelfräser – extra kurze, lange und extra lange Ausführung
 Solid carbide ball nose end mills – extra short, long and extra long design

N

Gültig für · Valid for

1820A 1967A 2504A
 1867A 2502A



		Schruppen		Schlichten				MMS MQL	
		V_c [m/min]	f_z [mm]	V_c [m/min]	f_z [mm]				
P	1.1	200	$0,014 \times d_1$	270	$0,010 \times d_1$	□	■	□	■
	2.1	170	$0,013 \times d_1$	230	$0,009 \times d_1$	□	■	□	■
	3.1	140	$0,011 \times d_1$	200	$0,008 \times d_1$	□	■	□	■
	4.1	110	$0,010 \times d_1$	160	$0,007 \times d_1$	□	■	□	■
	5.1	100	$0,008 \times d_1$	130	$0,006 \times d_1$	□	■	□	■
M	1.1	100	$0,008 \times d_1$	130	$0,006 \times d_1$			□	■
	2.1	80	$0,008 \times d_1$	110	$0,006 \times d_1$			□	■
	3.1	60	$0,006 \times d_1$	80	$0,005 \times d_1$			□	■
	4.1	40	$0,006 \times d_1$	60	$0,005 \times d_1$			□	■
K	1.1	200	$0,014 \times d_1$	270	$0,010 \times d_1$	□	■	□	■
	1.2	200	$0,014 \times d_1$	270	$0,010 \times d_1$	□	■	□	■
	2.1	180	$0,011 \times d_1$	230	$0,008 \times d_1$	□	■	□	■
	2.2	180	$0,011 \times d_1$	230	$0,008 \times d_1$	□	■	□	■
	3.1	140	$0,011 \times d_1$	200	$0,008 \times d_1$	□	■	□	■
	3.2	140	$0,011 \times d_1$	200	$0,008 \times d_1$	□	■	□	■
	4.1	110	$0,008 \times d_1$	160	$0,006 \times d_1$	□	■	□	■
	4.2	100	$0,008 \times d_1$	130	$0,006 \times d_1$	□	■	□	■
N	1.1								
	1.2								
	1.3								
	1.4								
	1.5								
	1.6								
	2.1	180	$0,014 \times d_1$	230	$0,010 \times d_1$			□	■
	2.2	180	$0,014 \times d_1$	230	$0,010 \times d_1$			□	■
	2.3	180	$0,014 \times d_1$	230	$0,010 \times d_1$	□	□	□	■
	2.4	140	$0,011 \times d_1$	200	$0,008 \times d_1$			□	■
	2.5	140	$0,011 \times d_1$	200	$0,008 \times d_1$			□	■
	2.6	140	$0,011 \times d_1$	200	$0,008 \times d_1$	□	□	□	■
	2.7	90	$0,008 \times d_1$	120	$0,006 \times d_1$			□	■
	2.8	90	$0,008 \times d_1$	120	$0,006 \times d_1$			□	■
	3.1	400	$0,025 \times d_1$	500	$0,018 \times d_1$	□	□	□	■
	3.2	400	$0,020 \times d_1$	500	$0,014 \times d_1$	□	□	□	■
4.1	290	$0,020 \times d_1$	400	$0,015 \times d_1$			□	■	
4.2	430	$0,020 \times d_1$	580	$0,015 \times d_1$			□	■	
4.3									
4.4									
5.1									
5.2	100	$0,008 \times d_1$	130	$0,006 \times d_1$			□	■	
5.3	180	$0,017 \times d_1$	270	$0,012 \times d_1$	□	■		■	
S	1.1	100	$0,010 \times d_1$	130	$0,007 \times d_1$			□	■
	1.2	80	$0,008 \times d_1$	110	$0,006 \times d_1$			□	■
	1.3	40	$0,007 \times d_1$	60	$0,005 \times d_1$			□	■
	2.1	70	$0,008 \times d_1$	100	$0,006 \times d_1$			□	■
	2.2	25	$0,006 \times d_1$	40	$0,004 \times d_1$			□	■
	2.3	25	$0,006 \times d_1$	30	$0,004 \times d_1$			□	■
	2.4	25	$0,006 \times d_1$	30	$0,004 \times d_1$			□	■
2.5	15	$0,006 \times d_1$	25	$0,004 \times d_1$			□	■	
2.6	25	$0,006 \times d_1$	30	$0,004 \times d_1$			□	■	
H	1.1								
	1.2								
	1.3								
	1.4								
	1.5								

■ = sehr gut geeignet · very suitable
 □ = gut geeignet · suitable

