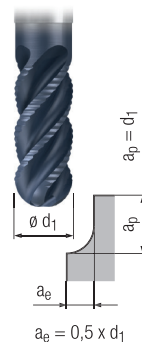
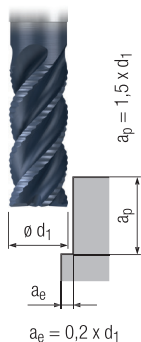
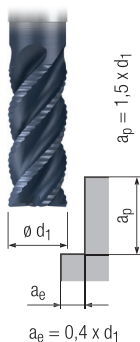
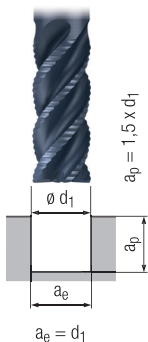


Hartmetall-Schaft- und Kugelfräser – lange Ausführung
Solid carbide end mills and ball nose end mills – long design

NR

Gültig für · Valid for
MED-RO4IK
MED-RRD4



		1		2		3		4		Coolant	MMS MQL	Water
		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]			
P	1.1	140	$0,006 \times d_1$	160	$0,007 \times d_1$	180	$0,008 \times d_1$	140	$0,004 \times d_1$	□	□	■
	2.1	130	$0,006 \times d_1$	150	$0,006 \times d_1$	170	$0,007 \times d_1$	130	$0,003 \times d_1$	□	□	■
	3.1	120	$0,005 \times d_1$	140	$0,005 \times d_1$	160	$0,006 \times d_1$	110	$0,003 \times d_1$	□	■	■
	4.1	110	$0,004 \times d_1$	130	$0,004 \times d_1$	140	$0,005 \times d_1$	90	$0,002 \times d_1$	□	■	
	5.1	100	$0,004 \times d_1$	120	$0,004 \times d_1$	130	$0,004 \times d_1$	70	$0,002 \times d_1$	□	■	
M	1.1	70	$0,004 \times d_1$	80	$0,004 \times d_1$	90	$0,005 \times d_1$					■
	2.1	60	$0,004 \times d_1$	70	$0,004 \times d_1$	80	$0,005 \times d_1$					■
	3.1											
	4.1											
K	1.1	140	$0,007 \times d_1$	160	$0,007 \times d_1$	180	$0,008 \times d_1$	140	$0,004 \times d_1$	□	■	
	1.2	140	$0,007 \times d_1$	160	$0,007 \times d_1$	180	$0,008 \times d_1$	140	$0,004 \times d_1$	□	■	
	2.1	120	$0,005 \times d_1$	140	$0,006 \times d_1$	160	$0,007 \times d_1$	130	$0,003 \times d_1$	□	■	
	2.2	120	$0,005 \times d_1$	140	$0,006 \times d_1$	160	$0,007 \times d_1$	130	$0,003 \times d_1$	□	■	
	3.1	110	$0,005 \times d_1$	130	$0,006 \times d_1$	140	$0,007 \times d_1$	110	$0,003 \times d_1$	□	■	
	3.2	110	$0,005 \times d_1$	130	$0,006 \times d_1$	140	$0,007 \times d_1$	110	$0,003 \times d_1$	□	■	
	4.1	80	$0,004 \times d_1$	90	$0,004 \times d_1$	100	$0,005 \times d_1$	90	$0,002 \times d_1$	□	■	
	4.2	70	$0,004 \times d_1$	80	$0,004 \times d_1$	90	$0,005 \times d_1$	70	$0,002 \times d_1$	□	■	
N	1.1											
	1.2	420	$0,008 \times d_1$	480	$0,009 \times d_1$	550	$0,010 \times d_1$					■
	1.3	420	$0,008 \times d_1$	480	$0,009 \times d_1$	550	$0,011 \times d_1$					■
	1.4	280	$0,008 \times d_1$	320	$0,009 \times d_1$	360	$0,010 \times d_1$					■
	1.5											
	1.6											
	2.1	120	$0,007 \times d_1$	140	$0,007 \times d_1$	160	$0,008 \times d_1$	130	$0,004 \times d_1$		□	■
	2.2	120	$0,007 \times d_1$	140	$0,007 \times d_1$	160	$0,008 \times d_1$	130	$0,004 \times d_1$		□	■
	2.3	120	$0,007 \times d_1$	140	$0,007 \times d_1$	160	$0,008 \times d_1$	130	$0,004 \times d_1$	□	□	■
	2.4	110	$0,005 \times d_1$	130	$0,006 \times d_1$	140	$0,007 \times d_1$	120	$0,003 \times d_1$	□	□	■
	2.5	110	$0,005 \times d_1$	130	$0,006 \times d_1$	140	$0,007 \times d_1$	120	$0,003 \times d_1$	□	□	■
	2.6	110	$0,005 \times d_1$	130	$0,006 \times d_1$	140	$0,007 \times d_1$	120	$0,003 \times d_1$	□	□	■
	2.7	70	$0,004 \times d_1$	80	$0,004 \times d_1$	90	$0,005 \times d_1$	70	$0,002 \times d_1$	□	□	■
	2.8	70	$0,004 \times d_1$	80	$0,004 \times d_1$	90	$0,005 \times d_1$	70	$0,002 \times d_1$	□	□	■
	3.1											
	3.2											
4.1	280	$0,010 \times d_1$	320	$0,011 \times d_1$	360	$0,012 \times d_1$	290	$0,006 \times d_1$	□	□	■	
4.2												
4.3												
4.4												
5.1												
5.2	70	$0,004 \times d_1$	80	$0,004 \times d_1$	90	$0,005 \times d_1$	70	$0,002 \times d_1$			■	
5.3												
S	1.1	70	$0,005 \times d_1$	80	$0,005 \times d_1$	90	$0,006 \times d_1$	70	$0,003 \times d_1$			■
	1.2	60	$0,004 \times d_1$	70	$0,004 \times d_1$	80	$0,005 \times d_1$	60	$0,002 \times d_1$			■
	1.3	40	$0,003 \times d_1$	50	$0,004 \times d_1$	50	$0,004 \times d_1$	40	$0,002 \times d_1$			■
	2.1											
	2.2											
	2.6											
H	1.1	70	$0,004 \times d_1$	80	$0,004 \times d_1$	90	$0,004 \times d_1$	70	$0,002 \times d_1$	□	■	
	1.2											
	1.3											
	1.4											
	1.5											