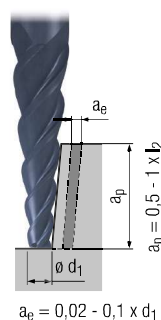
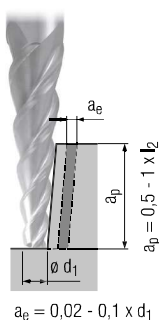


Konische Hartmetallfräser
 Tapered solid carbide end mills

N

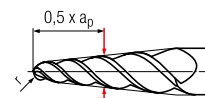


Gültig für · Valid for

RG39-000	RG39-000A
RG39-001	RG39-001A
RG39-002	RG39-002A
RG39-003	RG39-003A
RG39-004	RG39-004A
RG39-005	RG39-005A

Für die Berechnung der Drehzahl n muss mit dem mittleren Durchmesser d_m (Messpunkt bei $0,5 \times a_p$) gerechnet werden.

For the calculation of rpm (n), use the average diameter d_m (measuring point at $0,5 \times a_p$).



$$n = \frac{v_c \times 1000}{d_m \times \pi} \text{ [min}^{-1}\text{]}$$



		Unbeschichtet · Uncoated		TiAlN					
		v_c [m/min]	f_z [mm]	v_c [m/min]	f_z [mm]				
P	1.1	110	$0,005 \times d_1$	140	$0,005 \times d_1$	☐	☒	☐	☒
	2.1	100	$0,005 \times d_1$	120	$0,005 \times d_1$	☐	☒	☐	☒
	3.1			100	$0,004 \times d_1$	☐	☒	☐	
	4.1			80	$0,004 \times d_1$	☐	☒	☐	
	5.1			70	$0,003 \times d_1$	☐	☒	☐	
M	1.1			70	$0,003 \times d_1$			☐	☒
	2.1			50	$0,003 \times d_1$			☐	☒
	3.1								
	4.1								
K	1.1			140	$0,005 \times d_1$	☒	☒		
	1.2			140	$0,005 \times d_1$	☒	☒		
	2.1			120	$0,004 \times d_1$	☒	☒		
	2.2			120	$0,004 \times d_1$	☒	☒		
	3.1			100	$0,004 \times d_1$	☒	☒		
	3.2			100	$0,004 \times d_1$	☒	☒		
	4.1			80	$0,003 \times d_1$	☒	☒		
	4.2			70	$0,003 \times d_1$	☒	☒		
N	1.1	500	$0,008 \times d_1$	600	$0,008 \times d_1$			☐	☒
	1.2	500	$0,007 \times d_1$	600	$0,007 \times d_1$			☐	☒
	1.3	500	$0,006 \times d_1$	600	$0,006 \times d_1$			☐	☒
	1.4			350	$0,007 \times d_1$			☐	☒
	1.5			300	$0,006 \times d_1$			☐	☒
	1.6								
	2.1	100	$0,005 \times d_1$	120	$0,005 \times d_1$			☐	☒
	2.2	100	$0,005 \times d_1$	120	$0,005 \times d_1$			☐	☒
	2.3	100	$0,005 \times d_1$	120	$0,005 \times d_1$	☐	☐	☐	☒
	2.4			100	$0,004 \times d_1$			☐	☒
	2.5			100	$0,004 \times d_1$			☐	☒
	2.6			100	$0,004 \times d_1$	☐	☐	☐	☒
	2.7			60	$0,003 \times d_1$			☐	☒
	2.8			60	$0,003 \times d_1$			☐	☒
	3.1			260	$0,009 \times d_1$			☐	☒
	3.2			260	$0,007 \times d_1$			☐	☒
	4.1	180	$0,008 \times d_1$	200	$0,008 \times d_1$			☐	☒
	4.2	240	$0,008 \times d_1$	280	$0,008 \times d_1$			☐	☒
	4.3			130	$0,006 \times d_1$			☐	☒
	4.4			80	$0,006 \times d_1$			☐	☒
	5.1								
	5.2			70	$0,003 \times d_1$			☐	☒
	5.3			140	$0,006 \times d_1$	☐	☒		☒
S	1.1			70	$0,004 \times d_1$			☐	☒
	1.2			60	$0,003 \times d_1$			☐	☒
	1.3			40	$0,003 \times d_1$			☐	☒
	2.1			50	$0,003 \times d_1$			☐	☒
	2.2			30	$0,003 \times d_1$			☐	☒
	2.3			20	$0,002 \times d_1$			☐	☒
	2.4			20	$0,002 \times d_1$			☐	☒
	2.5			15	$0,002 \times d_1$			☐	☒
	2.6			20	$0,002 \times d_1$			☐	☒
H	1.1			70	$0,003 \times d_1$	☐	☒		
	1.2			60	$0,003 \times d_1$	☐	☒		
	1.3								
	1.4								
	1.5								

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

v_c = Schnittgeschwindigkeit · Cutting speed
 f_z = Vorschub pro Zahn · Feed per tooth