

Hartmetall-Kreissegment-Fräser mit Tropfenform – VR
 Solid carbide circle segment end mills with oval form – VR

N


 Aufmaß · Allowance
 0,05 - 0,1 mm

 Aufmaß · Allowance
 0,1 - 0,2 mm

 Gültig für · Valid for
 RG390L-KSF

 Für die Berechnung der Drehzahl n muss mit dem Durchmesser d_1 gerechnet werden.

 In order to calculate the rotational speed n , the diameter d_1 has to be used.

		V_c [m/min]	f_z [mm]	V_c [m/min]	f_z [mm]				
P	1.1	420	$0,003 \times d_1$	420	$0,002 \times d_1$	□	■	□	■
	2.1	375	$0,003 \times d_1$	375	$0,002 \times d_1$	□	■	□	■
	3.1	315	$0,002 \times d_1$	315	$0,002 \times d_1$	□	■	□	■
	4.1	300	$0,002 \times d_1$	300	$0,001 \times d_1$	□	■		
	5.1	270	$0,002 \times d_1$	270	$0,001 \times d_1$	□	■		
M	1.1	150	$0,003 \times d_1$	150	$0,002 \times d_1$			□	■
	2.1	120	$0,003 \times d_1$	120	$0,002 \times d_1$			□	■
	3.1	90	$0,002 \times d_1$	90	$0,001 \times d_1$			□	■
	4.1	60	$0,002 \times d_1$	60	$0,001 \times d_1$			□	■
K	1.1	280	$0,004 \times d_1$	280	$0,003 \times d_1$	□	■		
	1.2	280	$0,004 \times d_1$	280	$0,003 \times d_1$	□	■		
	2.1	250	$0,003 \times d_1$	250	$0,002 \times d_1$	□	■		
	2.2	250	$0,003 \times d_1$	250	$0,002 \times d_1$	□	■		
	3.1	210	$0,003 \times d_1$	210	$0,002 \times d_1$	□	■		
	3.2	210	$0,003 \times d_1$	210	$0,002 \times d_1$	□	■		
	4.1	180	$0,002 \times d_1$	180	$0,001 \times d_1$	□	■		
	4.2	140	$0,002 \times d_1$	140	$0,001 \times d_1$	□	■		
N	1.1	600	$0,003 \times d_1$	600	$0,002 \times d_1$			□	■
	1.2	600	$0,003 \times d_1$	600	$0,002 \times d_1$			□	■
	1.3	600	$0,002 \times d_1$	600	$0,001 \times d_1$			□	■
	1.4	410	$0,003 \times d_1$	410	$0,002 \times d_1$			□	■
	1.5								
	1.6								
	2.1	270	$0,004 \times d_1$	270	$0,003 \times d_1$			□	■
	2.2	270	$0,004 \times d_1$	270	$0,003 \times d_1$			□	■
	2.3	270	$0,004 \times d_1$	270	$0,003 \times d_1$		□	□	■
	2.4	255	$0,003 \times d_1$	255	$0,002 \times d_1$			□	■
	2.5	255	$0,003 \times d_1$	255	$0,002 \times d_1$			□	■
	2.6	255	$0,003 \times d_1$	255	$0,002 \times d_1$		□	□	■
	2.7	150	$0,002 \times d_1$	150	$0,001 \times d_1$			□	■
	2.8	150	$0,002 \times d_1$	150	$0,001 \times d_1$			□	■
	3.1	410	$0,004 \times d_1$	410	$0,003 \times d_1$			□	■
	3.2	410	$0,004 \times d_1$	410	$0,003 \times d_1$			□	■
	4.1	410	$0,004 \times d_1$	410	$0,003 \times d_1$		□	□	■
	4.2	600	$0,004 \times d_1$	600	$0,003 \times d_1$			□	■
	4.3								
	4.4								
	5.1								
	5.2	150	$0,003 \times d_1$	150	$0,002 \times d_1$				■
	5.3								
S	1.1	100	$0,005 \times d_1$	100	$0,004 \times d_1$				■
	1.2	80	$0,004 \times d_1$	80	$0,003 \times d_1$				■
	1.3	60	$0,004 \times d_1$	60	$0,003 \times d_1$				■
	2.1	80	$0,003 \times d_1$	80	$0,002 \times d_1$				■
	2.2	30	$0,003 \times d_1$	30	$0,002 \times d_1$				■
	2.3	30	$0,003 \times d_1$	30	$0,002 \times d_1$				■
	2.4	30	$0,003 \times d_1$	30	$0,002 \times d_1$				■
	2.5	30	$0,003 \times d_1$	30	$0,002 \times d_1$				■
	2.6	30	$0,003 \times d_1$	30	$0,002 \times d_1$				■
	2.7	30	$0,003 \times d_1$	30	$0,002 \times d_1$				■
H	1.1	130	$0,004 \times d_1$	130	$0,003 \times d_1$	□	■		
	1.2	100	$0,004 \times d_1$	100	$0,003 \times d_1$	□	■		
	1.3	80	$0,003 \times d_1$	80	$0,002 \times d_1$	□	■		
	1.4								
	1.5								

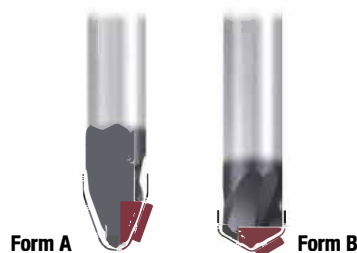
 V_c = Schnittgeschwindigkeit · Cutting speed
 f_z = Vorschub pro Zahn · Feed per tooth

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


Hartmetall-Kreissegment-Fräser mit Kegelform – VR
 Solid carbide circle segment end mills with taper form – VR

N

 Gültig für · Valid for
 RG400L-KSF

 Aufmaß · Allowance
 0,05 - 0,1 mm

 Aufmaß · Allowance
 0,1 - 0,2 mm

 Für die Berechnung der Drehzahl n
 muss mit dem Durchmesser d_1
 gerechnet werden.

 In order to calculate the rotational
 speed n , the diameter d_1 has to
 be used.


		V_c [m/min]	f_z [mm]	V_c [m/min]	f_z [mm]				
P	1.1	420	$0,004 \times d_1$	420	$0,003 \times d_1$	□	■	□	■
	2.1	375	$0,004 \times d_1$	375	$0,003 \times d_1$	□	■	□	■
	3.1	315	$0,003 \times d_1$	315	$0,003 \times d_1$	□	■	□	■
	4.1	300	$0,003 \times d_1$	300	$0,002 \times d_1$	□	■		
	5.1	270	$0,003 \times d_1$	270	$0,002 \times d_1$	□	■		
M	1.1	150	$0,004 \times d_1$	150	$0,003 \times d_1$			□	■
	2.1	120	$0,004 \times d_1$	120	$0,003 \times d_1$			□	■
	3.1	90	$0,003 \times d_1$	90	$0,002 \times d_1$			□	■
	4.1	60	$0,003 \times d_1$	60	$0,002 \times d_1$			□	■
K	1.1	280	$0,007 \times d_1$	280	$0,004 \times d_1$	□	■		
	1.2	280	$0,007 \times d_1$	280	$0,004 \times d_1$	□	■		
	2.1	250	$0,006 \times d_1$	250	$0,003 \times d_1$	□	■		
	2.2	250	$0,006 \times d_1$	250	$0,003 \times d_1$	□	■		
	3.1	210	$0,006 \times d_1$	210	$0,003 \times d_1$	□	■		
	3.2	210	$0,006 \times d_1$	210	$0,003 \times d_1$	□	■		
	4.1	180	$0,004 \times d_1$	180	$0,002 \times d_1$	□	■		
	4.2	140	$0,003 \times d_1$	140	$0,002 \times d_1$	□	■		
N	1.1	600	$0,004 \times d_1$	600	$0,003 \times d_1$			□	■
	1.2	600	$0,004 \times d_1$	600	$0,003 \times d_1$			□	■
	1.3	600	$0,003 \times d_1$	600	$0,002 \times d_1$			□	■
	1.4	410	$0,004 \times d_1$	410	$0,003 \times d_1$			□	■
	1.5								
	1.6								
	2.1	270	$0,005 \times d_1$	270	$0,004 \times d_1$			□	■
	2.2	270	$0,005 \times d_1$	270	$0,004 \times d_1$			□	■
	2.3	270	$0,005 \times d_1$	270	$0,004 \times d_1$		□	□	■
	2.4	255	$0,004 \times d_1$	255	$0,003 \times d_1$			□	■
	2.5	255	$0,004 \times d_1$	255	$0,003 \times d_1$			□	■
	2.6	255	$0,004 \times d_1$	255	$0,003 \times d_1$		□	□	■
	2.7	150	$0,003 \times d_1$	150	$0,002 \times d_1$			□	■
	2.8	150	$0,003 \times d_1$	150	$0,002 \times d_1$			□	■
	3.1	410	$0,005 \times d_1$	410	$0,004 \times d_1$			□	■
	3.2	410	$0,005 \times d_1$	410	$0,004 \times d_1$			□	■
	4.1	410	$0,005 \times d_1$	410	$0,004 \times d_1$		□	□	■
	4.2	600	$0,005 \times d_1$	600	$0,004 \times d_1$			□	■
	4.3								
	4.4								
	5.1								
	5.2	150	$0,004 \times d_1$	150	$0,003 \times d_1$				■
	5.3								
S	1.1	100	$0,005 \times d_1$	100	$0,004 \times d_1$				■
	1.2	80	$0,004 \times d_1$	80	$0,003 \times d_1$				■
	1.3	60	$0,004 \times d_1$	60	$0,003 \times d_1$				■
	2.1	80	$0,003 \times d_1$	80	$0,002 \times d_1$				■
	2.2	30	$0,003 \times d_1$	30	$0,002 \times d_1$				■
	2.3	30	$0,003 \times d_1$	30	$0,002 \times d_1$				■
	2.4	30	$0,003 \times d_1$	30	$0,002 \times d_1$				■
	2.5	30	$0,003 \times d_1$	30	$0,002 \times d_1$				■
H	1.1	130	$0,005 \times d_1$	130	$0,003 \times d_1$	□	■		
	1.2	100	$0,005 \times d_1$	100	$0,003 \times d_1$	□	■		
	1.3								
	1.4								
	1.5								

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

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