

Schnittwerte Hartmetall-Schafffräser

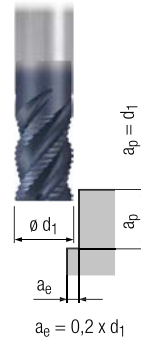
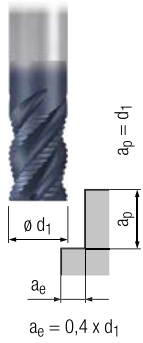
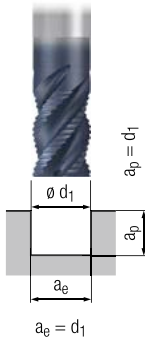
Kurze und lange Ausführung



NR

Gültig für

RG28-97A  
RG28-93A



		Standard		NR		Vc [m/min]	fz [mm]	MMS MOL	Machining Symbols
		Vc [m/min]	fz [mm]	Vc [m/min]	fz [mm]				
P	1.1	120	0,005 x d <sub>1</sub>	140	0,006 x d <sub>1</sub>	170	0,007 x d <sub>1</sub>		□ ■
	2.1	110	0,004 x d <sub>1</sub>	130	0,005 x d <sub>1</sub>	150	0,006 x d <sub>1</sub>		□ ■
	3.1	90	0,004 x d <sub>1</sub>	110	0,005 x d <sub>1</sub>	130	0,005 x d <sub>1</sub>	□ ■	■
	4.1	70	0,003 x d <sub>1</sub>	80	0,004 x d <sub>1</sub>	100	0,004 x d <sub>1</sub>	□ ■	
	5.1	60	0,003 x d <sub>1</sub>	70	0,003 x d <sub>1</sub>	80	0,004 x d <sub>1</sub>	□ ■	
M	1.1	60	0,003 x d <sub>1</sub>	70	0,004 x d <sub>1</sub>	80	0,004 x d <sub>1</sub>		■
	2.1	50	0,003 x d <sub>1</sub>	60	0,004 x d <sub>1</sub>	70	0,004 x d <sub>1</sub>		■
	3.1								
	4.1								
K	1.1	120	0,005 x d <sub>1</sub>	140	0,006 x d <sub>1</sub>	170	0,007 x d <sub>1</sub>	■ ■	
	1.2	120	0,005 x d <sub>1</sub>	140	0,006 x d <sub>1</sub>	170	0,007 x d <sub>1</sub>	■ ■	
	2.1	110	0,004 x d <sub>1</sub>	130	0,005 x d <sub>1</sub>	150	0,006 x d <sub>1</sub>	■ ■	
	2.2	110	0,004 x d <sub>1</sub>	130	0,005 x d <sub>1</sub>	150	0,006 x d <sub>1</sub>	■ ■	
	3.1	90	0,004 x d <sub>1</sub>	110	0,005 x d <sub>1</sub>	130	0,006 x d <sub>1</sub>	■ ■	
	3.2	90	0,004 x d <sub>1</sub>	110	0,005 x d <sub>1</sub>	130	0,006 x d <sub>1</sub>	■ ■	
	4.1	70	0,003 x d <sub>1</sub>	80	0,004 x d <sub>1</sub>	100	0,004 x d <sub>1</sub>	■ ■	
	4.2	60	0,003 x d <sub>1</sub>	70	0,004 x d <sub>1</sub>	80	0,004 x d <sub>1</sub>	■ ■	
N	1.1								
	1.2								
	1.3								
	1.4								
	1.5								
	1.6								
	2.1	110	0,005 x d <sub>1</sub>	130	0,006 x d <sub>1</sub>	150	0,007 x d <sub>1</sub>		■
	2.2	110	0,005 x d <sub>1</sub>	130	0,006 x d <sub>1</sub>	150	0,007 x d <sub>1</sub>		■
	2.3	110	0,005 x d <sub>1</sub>	130	0,006 x d <sub>1</sub>	150	0,007 x d <sub>1</sub>	□	■
	2.4	100	0,004 x d <sub>1</sub>	120	0,005 x d <sub>1</sub>	140	0,006 x d <sub>1</sub>		■
	2.5	100	0,004 x d <sub>1</sub>	120	0,005 x d <sub>1</sub>	140	0,006 x d <sub>1</sub>		■
	2.6	100	0,004 x d <sub>1</sub>	120	0,005 x d <sub>1</sub>	140	0,006 x d <sub>1</sub>	□	■
	2.7								
	2.8								
	3.1								
	3.2								
4.1	240	0,008 x d <sub>1</sub>	290	0,009 x d <sub>1</sub>	340	0,011 x d <sub>1</sub>		□ ■	
4.2									
4.3									
4.4									
5.1									
5.2	60	0,003 x d <sub>1</sub>	70	0,004 x d <sub>1</sub>	80	0,004 x d <sub>1</sub>		■	
5.3									
S	1.1	60	0,004 x d <sub>1</sub>	70	0,004 x d <sub>1</sub>	80	0,005 x d <sub>1</sub>		■
	1.2								
	1.3								
	2.1								
	2.2								
	2.3								
H	1.1	60	0,003 x d <sub>1</sub>	70	0,003 x d <sub>1</sub>	80	0,004 x d <sub>1</sub>	□ ■	
	1.2								
	1.3								
	1.4								
	1.5								

■ = sehr gut geeignet  
□ = gut geeignet

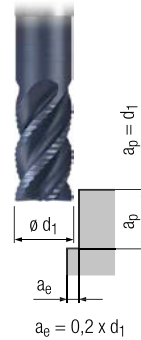
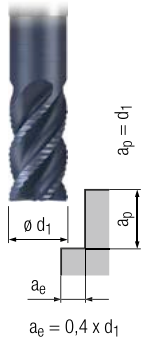
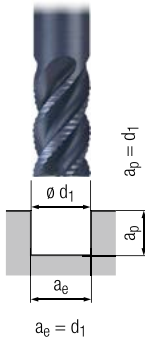
Schnittwerte Hartmetall-Schafffräser

Lange Ausführung mit kurzer Schneide



NR

Gültig für  
RG28-69AZ



		$v_c$	$f_z$	$v_c$	$f_z$	$v_c$	$f_z$			MMS MQL	
		[m/min]	[mm]	[m/min]	[mm]	[m/min]	[mm]				
P	1.1	160	$0,007 \times d_1$	180	$0,008 \times d_1$	200	$0,009 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.1	150	$0,006 \times d_1$	170	$0,007 \times d_1$	190	$0,008 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	3.1	140	$0,005 \times d_1$	160	$0,006 \times d_1$	180	$0,007 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	4.1	120	$0,004 \times d_1$	140	$0,005 \times d_1$	150	$0,005 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	5.1	100	$0,004 \times d_1$	120	$0,004 \times d_1$	130	$0,005 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
M	1.1	80	$0,004 \times d_1$	90	$0,005 \times d_1$	100	$0,005 \times d_1$				<input checked="" type="checkbox"/>
	2.1	60	$0,004 \times d_1$	70	$0,005 \times d_1$	80	$0,005 \times d_1$				<input checked="" type="checkbox"/>
	3.1										
	4.1										
K	1.1	160	$0,007 \times d_1$	180	$0,008 \times d_1$	200	$0,009 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	1.2	160	$0,007 \times d_1$	180	$0,008 \times d_1$	200	$0,009 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	2.1	140	$0,006 \times d_1$	160	$0,006 \times d_1$	180	$0,007 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	2.2	140	$0,006 \times d_1$	160	$0,006 \times d_1$	180	$0,007 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	3.1	120	$0,006 \times d_1$	140	$0,006 \times d_1$	150	$0,007 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	3.2	120	$0,006 \times d_1$	140	$0,006 \times d_1$	150	$0,007 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	4.1	100	$0,004 \times d_1$	120	$0,005 \times d_1$	130	$0,005 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	4.2	80	$0,004 \times d_1$	90	$0,005 \times d_1$	100	$0,005 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
N	1.1										
	1.2	480	$0,009 \times d_1$	550	$0,010 \times d_1$	600	$0,011 \times d_1$				<input checked="" type="checkbox"/>
	1.3	480	$0,009 \times d_1$	550	$0,010 \times d_1$	600	$0,012 \times d_1$				<input checked="" type="checkbox"/>
	1.4	320	$0,009 \times d_1$	370	$0,010 \times d_1$	400	$0,011 \times d_1$				<input checked="" type="checkbox"/>
	1.5										
	1.6										
	2.1	140	$0,007 \times d_1$	160	$0,008 \times d_1$	180	$0,009 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.2	140	$0,007 \times d_1$	160	$0,008 \times d_1$	180	$0,009 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.3	140	$0,007 \times d_1$	160	$0,008 \times d_1$	180	$0,009 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.4	130	$0,006 \times d_1$	150	$0,006 \times d_1$	160	$0,007 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.5	130	$0,006 \times d_1$	150	$0,006 \times d_1$	160	$0,007 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.6	130	$0,006 \times d_1$	150	$0,006 \times d_1$	160	$0,007 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.7	80	$0,004 \times d_1$	90	$0,005 \times d_1$	100	$0,005 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.8	80	$0,004 \times d_1$	90	$0,005 \times d_1$	100	$0,005 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	3.1										
	3.2										
4.1	320	$0,011 \times d_1$	370	$0,012 \times d_1$	400	$0,014 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>		<input checked="" type="checkbox"/>	
4.2											
4.3											
4.4											
5.1											
5.2	80	$0,004 \times d_1$	90	$0,005 \times d_1$	100	$0,005 \times d_1$				<input checked="" type="checkbox"/>	
5.3											
S	1.1	80	$0,005 \times d_1$	90	$0,006 \times d_1$	100	$0,006 \times d_1$				<input checked="" type="checkbox"/>
	1.2	60	$0,004 \times d_1$	70	$0,005 \times d_1$	80	$0,005 \times d_1$				<input checked="" type="checkbox"/>
	1.3	40	$0,004 \times d_1$	50	$0,004 \times d_1$	50	$0,005 \times d_1$				<input checked="" type="checkbox"/>
	2.1										
	2.2										
	2.3										
H	1.1	80	$0,004 \times d_1$	90	$0,004 \times d_1$	100	$0,005 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	1.2										
	1.3										
	1.4										
	1.5										

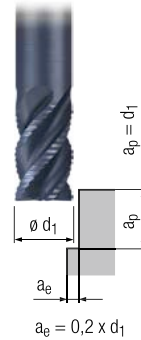
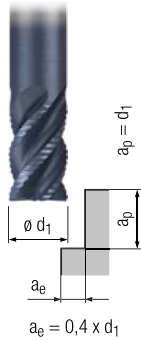
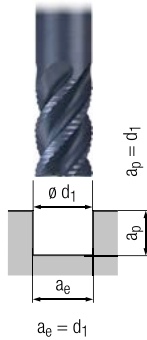
Schnittwerte Hartmetall-Schafffräser

Extra lange Ausführung mit kurzer Schneide

NR

Gültig für

RG28-75A



		$V_c$	$f_z$	$V_c$	$f_z$	$V_c$	$f_z$			MMS MQL	
		[m/min]	[mm]	[m/min]	[mm]	[m/min]	[mm]				
P	1.1	130	$0,005 \times d_1$	140	$0,005 \times d_1$	160	$0,006 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.1	120	$0,004 \times d_1$	130	$0,005 \times d_1$	140	$0,005 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	3.1	110	$0,004 \times d_1$	120	$0,004 \times d_1$	130	$0,005 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	4.1	90	$0,003 \times d_1$	100	$0,003 \times d_1$	110	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	5.1	80	$0,003 \times d_1$	90	$0,003 \times d_1$	100	$0,003 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
M	1.1										
	2.1										
	3.1										
	4.1										
K	1.1	130	$0,005 \times d_1$	140	$0,006 \times d_1$	160	$0,006 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	1.2	130	$0,005 \times d_1$	140	$0,006 \times d_1$	160	$0,006 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	2.1	120	$0,004 \times d_1$	130	$0,004 \times d_1$	140	$0,005 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	2.2	120	$0,004 \times d_1$	130	$0,004 \times d_1$	140	$0,005 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	3.1	100	$0,004 \times d_1$	110	$0,004 \times d_1$	120	$0,005 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	3.2	100	$0,004 \times d_1$	110	$0,004 \times d_1$	120	$0,005 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	4.1	80	$0,003 \times d_1$	90	$0,003 \times d_1$	100	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
4.2	70	$0,003 \times d_1$	80	$0,003 \times d_1$	80	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>			
N	1.1										
	1.2										
	1.3										
	1.4										
	1.5										
	1.6										
	2.1	120	$0,005 \times d_1$	130	$0,006 \times d_1$	140	$0,006 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.2	120	$0,005 \times d_1$	130	$0,006 \times d_1$	140	$0,006 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.3	120	$0,005 \times d_1$	130	$0,006 \times d_1$	140	$0,006 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.4	110	$0,004 \times d_1$	120	$0,004 \times d_1$	130	$0,005 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.5	110	$0,004 \times d_1$	120	$0,004 \times d_1$	130	$0,005 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.6	110	$0,004 \times d_1$	120	$0,004 \times d_1$	130	$0,005 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.7	70	$0,003 \times d_1$	80	$0,003 \times d_1$	80	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.8	70	$0,003 \times d_1$	80	$0,003 \times d_1$	80	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	3.1										
3.2											
4.1	270	$0,008 \times d_1$	300	$0,008 \times d_1$	320	$0,009 \times d_1$			<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
4.2											
4.3											
4.4											
5.1											
5.2	70	$0,003 \times d_1$	80	$0,003 \times d_1$	80	$0,004 \times d_1$					<input checked="" type="checkbox"/>
5.3											
S	1.1										
	1.2										
	1.3										
	2.1										
	2.2										
	2.6										
H	1.1	70	$0,003 \times d_1$	80	$0,003 \times d_1$	80	$0,003 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	1.2										
	1.3										
	1.4										
	1.5										

■ = sehr gut geeignet  
□ = gut geeignet

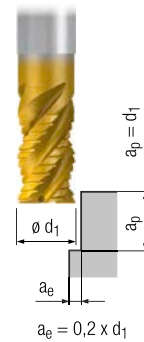
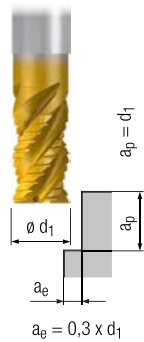
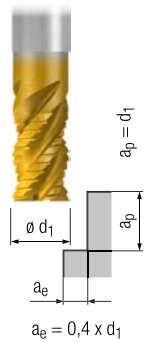
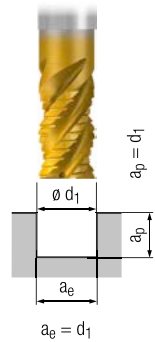
Schnittwerte Hartmetall-Schafffräser

Lange Ausführung mit kurzer Schneide

NF

Gültig für

RG26-49TZ



		Vc [m/min]		fz [mm]		Vc [m/min]		fz [mm]				MMS MQL	
		1	2	1	2	1	2	1	2				
P	1.1	120	0,005 x d <sub>1</sub>	140	0,006 x d <sub>1</sub>	170	0,007 x d <sub>1</sub>	190	0,008 x d <sub>1</sub>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.1	110	0,004 x d <sub>1</sub>	130	0,005 x d <sub>1</sub>	150	0,006 x d <sub>1</sub>	180	0,007 x d <sub>1</sub>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	3.1	90	0,004 x d <sub>1</sub>	110	0,005 x d <sub>1</sub>	130	0,005 x d <sub>1</sub>	140	0,006 x d <sub>1</sub>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	4.1	70	0,003 x d <sub>1</sub>	80	0,004 x d <sub>1</sub>	100	0,004 x d <sub>1</sub>	110	0,005 x d <sub>1</sub>	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	5.1	60	0,003 x d <sub>1</sub>	70	0,003 x d <sub>1</sub>	80	0,004 x d <sub>1</sub>	100	0,004 x d <sub>1</sub>	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
M	1.1	100	0,004 x d <sub>1</sub>	120	0,004 x d <sub>1</sub>	140	0,005 x d <sub>1</sub>	160	0,006 x d <sub>1</sub>				<input checked="" type="checkbox"/>
	2.1	80	0,004 x d <sub>1</sub>	100	0,004 x d <sub>1</sub>	110	0,005 x d <sub>1</sub>	130	0,006 x d <sub>1</sub>				<input checked="" type="checkbox"/>
	3.1	50	0,003 x d <sub>1</sub>	60	0,003 x d <sub>1</sub>	70	0,004 x d <sub>1</sub>	80	0,004 x d <sub>1</sub>				<input checked="" type="checkbox"/>
	4.1	40	0,003 x d <sub>1</sub>	50	0,003 x d <sub>1</sub>	60	0,004 x d <sub>1</sub>	60	0,004 x d <sub>1</sub>				<input checked="" type="checkbox"/>
K	1.1	120	0,005 x d <sub>1</sub>	140	0,006 x d <sub>1</sub>	170	0,007 x d <sub>1</sub>	190	0,008 x d <sub>1</sub>	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	1.2	120	0,005 x d <sub>1</sub>	140	0,006 x d <sub>1</sub>	170	0,007 x d <sub>1</sub>	190	0,008 x d <sub>1</sub>	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	2.1	110	0,004 x d <sub>1</sub>	130	0,005 x d <sub>1</sub>	150	0,006 x d <sub>1</sub>	180	0,006 x d <sub>1</sub>	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	2.2	110	0,004 x d <sub>1</sub>	130	0,005 x d <sub>1</sub>	150	0,006 x d <sub>1</sub>	180	0,006 x d <sub>1</sub>	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	3.1	90	0,004 x d <sub>1</sub>	110	0,005 x d <sub>1</sub>	130	0,006 x d <sub>1</sub>	140	0,006 x d <sub>1</sub>	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	3.2	90	0,004 x d <sub>1</sub>	110	0,005 x d <sub>1</sub>	130	0,006 x d <sub>1</sub>	140	0,006 x d <sub>1</sub>	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	4.1	70	0,003 x d <sub>1</sub>	80	0,004 x d <sub>1</sub>	100	0,004 x d <sub>1</sub>	110	0,005 x d <sub>1</sub>	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
4.2	60	0,003 x d <sub>1</sub>	70	0,004 x d <sub>1</sub>	80	0,004 x d <sub>1</sub>	100	0,005 x d <sub>1</sub>	<input type="checkbox"/>	<input checked="" type="checkbox"/>			
N	1.1												
	1.2												
	1.3												
	1.4												
	1.5												
	1.6												
	2.1	110	0,005 x d <sub>1</sub>	130	0,006 x d <sub>1</sub>	150	0,007 x d <sub>1</sub>	180	0,008 x d <sub>1</sub>			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.2	110	0,005 x d <sub>1</sub>	130	0,006 x d <sub>1</sub>	150	0,007 x d <sub>1</sub>	180	0,008 x d <sub>1</sub>			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.3	110	0,005 x d <sub>1</sub>	130	0,006 x d <sub>1</sub>	150	0,007 x d <sub>1</sub>	180	0,008 x d <sub>1</sub>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.4	100	0,004 x d <sub>1</sub>	120	0,005 x d <sub>1</sub>	140	0,006 x d <sub>1</sub>	160	0,006 x d <sub>1</sub>			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.5	100	0,004 x d <sub>1</sub>	120	0,005 x d <sub>1</sub>	140	0,006 x d <sub>1</sub>	160	0,006 x d <sub>1</sub>			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.6	100	0,004 x d <sub>1</sub>	120	0,005 x d <sub>1</sub>	140	0,006 x d <sub>1</sub>	160	0,006 x d <sub>1</sub>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.7	60	0,003 x d <sub>1</sub>	70	0,004 x d <sub>1</sub>	80	0,004 x d <sub>1</sub>	100	0,005 x d <sub>1</sub>		<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.8	60	0,003 x d <sub>1</sub>	70	0,004 x d <sub>1</sub>	80	0,004 x d <sub>1</sub>	100	0,005 x d <sub>1</sub>			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	3.1												
	3.2												
4.1													
4.2													
4.3													
4.4													
5.1													
5.2	60	0,003 x d <sub>1</sub>	70	0,004 x d <sub>1</sub>	80	0,004 x d <sub>1</sub>	100	0,005 x d <sub>1</sub>				<input checked="" type="checkbox"/>	
5.3													
S	1.1	70	0,005 x d <sub>1</sub>	80	0,005 x d <sub>1</sub>	100	0,006 x d <sub>1</sub>	110	0,007 x d <sub>1</sub>				<input checked="" type="checkbox"/>
	1.2	60	0,004 x d <sub>1</sub>	70	0,004 x d <sub>1</sub>	80	0,005 x d <sub>1</sub>	100	0,006 x d <sub>1</sub>				<input checked="" type="checkbox"/>
	1.3	30	0,003 x d <sub>1</sub>	40	0,003 x d <sub>1</sub>	40	0,004 x d <sub>1</sub>	50	0,004 x d <sub>1</sub>				<input checked="" type="checkbox"/>
	2.1	70	0,004 x d <sub>1</sub>	80	0,004 x d <sub>1</sub>	100	0,005 x d <sub>1</sub>	110	0,006 x d <sub>1</sub>				<input checked="" type="checkbox"/>
	2.2	20	0,003 x d <sub>1</sub>	20	0,004 x d <sub>1</sub>	25	0,004 x d <sub>1</sub>	30	0,005 x d <sub>1</sub>				<input checked="" type="checkbox"/>
	2.3	10	0,002 x d <sub>1</sub>	15	0,002 x d <sub>1</sub>	15	0,003 x d <sub>1</sub>	20	0,003 x d <sub>1</sub>				<input checked="" type="checkbox"/>
2.4	20	0,003 x d <sub>1</sub>	25	0,003 x d <sub>1</sub>	35	0,004 x d <sub>1</sub>	30	0,004 x d <sub>1</sub>				<input checked="" type="checkbox"/>	
2.5	10	0,002 x d <sub>1</sub>	10	0,002 x d <sub>1</sub>	10	0,003 x d <sub>1</sub>	20	0,003 x d <sub>1</sub>				<input checked="" type="checkbox"/>	
2.6	10	0,003 x d <sub>1</sub>	10	0,003 x d <sub>1</sub>	10	0,004 x d <sub>1</sub>	20	0,004 x d <sub>1</sub>				<input checked="" type="checkbox"/>	
H	1.1												
	1.2												
	1.3												
	1.4												
	1.5												

Schnittwerte Hartmetall-Schafffräser

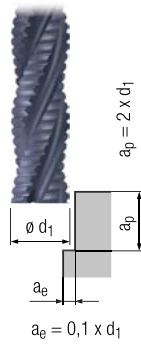
Extra lange Ausführung



NF

Gültig für

RG28-54A



		$v_c$ [m/min]	$f_z$ [mm]			MMS MOL		
P	1.1	100	$0,005 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
	2.1	90	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
	3.1	80	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
	4.1							
	5.1							
M	1.1	50	$0,003 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>	
	2.1	40	$0,003 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>	
	3.1							
	4.1							
K	1.1	100	$0,005 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>			
	1.2	100	$0,005 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>			
	2.1	90	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>			
	2.2	90	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>			
	3.1	80	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>			
	3.2	80	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>			
	4.1	60	$0,003 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>			
	4.2	50	$0,003 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>			
N	1.1						<input checked="" type="checkbox"/>	
	1.2						<input checked="" type="checkbox"/>	
	1.3						<input checked="" type="checkbox"/>	
	1.4						<input checked="" type="checkbox"/>	
	1.5						<input checked="" type="checkbox"/>	
	1.6						<input checked="" type="checkbox"/>	
	2.1					<input type="checkbox"/>	<input checked="" type="checkbox"/>	
	2.2	90	$0,005 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
	2.3					<input type="checkbox"/>	<input checked="" type="checkbox"/>	
	2.4					<input type="checkbox"/>	<input checked="" type="checkbox"/>	
	2.5					<input type="checkbox"/>	<input checked="" type="checkbox"/>	
	2.6	80	$0,004 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
	2.7					<input type="checkbox"/>	<input checked="" type="checkbox"/>	
	2.8					<input type="checkbox"/>	<input checked="" type="checkbox"/>	
	3.1				<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	3.2				<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
4.1					<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
4.2					<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
4.3					<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
4.4					<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
5.1								
5.2								
5.3								
S	1.1						<input checked="" type="checkbox"/>	
	1.2						<input checked="" type="checkbox"/>	
	1.3						<input checked="" type="checkbox"/>	
	2.1						<input checked="" type="checkbox"/>	
	2.2							
	2.3							
H	1.1							
	1.2							
	1.3							
	1.4							
	1.5							

■ = sehr gut geeignet  
□ = gut geeignet