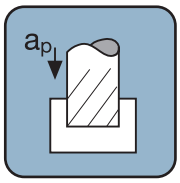
Schnittwertempfehlungen,
Recommended cutting data,
Parametres de coupe

KOMPETENZ IN PRÄZISION

Katalog-Nr. 527 114



Baustähle, Einsatzstähle, Vergütungsstähle, Stahlguss, Gusswerkstoffe (GG, GGG)						HRC <20
Werkstoffgruppen 1.1 / 1.2 / 1.3 / 2						
Nutenfräsen						
d_1	z	a_p max.	a_e max.	f_z	n	v_f
[mm]	[-]	[mm]	[mm]	[mm]	[min^{-1}]	[mm/min]
3,0	2	3,0	-	0,007	6.690	95
4,0	2	4,0	-	0,012	5.020	125
5,0	2	5,0	-	0,017	4.020	135
6,0	2	6,0	-	0,020	3.350	135
8,0	2	8,0	-	0,034	2.510	170
10,0	2	10,0	-	0,040	2.010	165
12,0	2	12,0	-	0,060	1.680	205
14,0	2	14,0	-	0,070	1.440	205
16,0	2	16,0	-	0,080	1.260	205
18,0	2	18,0	-	0,090	1.120	205
20,0	2	20,0	-	0,100	1.010	205

Baustähle, Einsatzstähle, Vergütungsstähle, Gusswerkstoffe (GG, GGG)						HRC 20~30
Werkstoffgruppen 1.4 / 1.5 / 2						
Nutenfräsen						
d_1	z	a_p max.	a_e max.	f_z	n	v_f
[mm]	[-]	[mm]	[mm]	[mm]	[min^{-1}]	[mm/min]
3,0	2	3,0	-	0,006	5.730	75
4,0	2	4,0	-	0,011	4.300	95
5,0	2	5,0	-	0,015	3.440	105
6,0	2	6,0	-	0,018	2.870	105
8,0	2	8,0	-	0,030	2.150	135
10,0	2	10,0	-	0,036	1.720	125
12,0	2	12,0	-	0,054	1.440	160
14,0	2	14,0	-	0,063	1.230	155
16,0	2	16,0	-	0,072	1.080	160
18,0	2	18,0	-	0,081	960	160
20,0	2	20,0	-	0,090	860	155

Werkzeugstähle, Vergütungsstähle, verschleissfeste Stähle						HRC 30~38
Werkstoffgruppen 1.4 / 1.5						
Nutenfräsen						
d_1	z	a_p max.	a_e max.	f_z	n	v_f
[mm]	[-]	[mm]	[mm]	[mm]	[min^{-1}]	[mm/min]
3,0	2	2,5	-	0,006	4.250	50
4,0	2	3,0	-	0,010	3.190	65
5,0	2	4,0	-	0,013	2.550	70
6,0	2	4,5	-	0,016	2.130	70
8,0	2	6,0	-	0,027	1.600	90
10,0	2	7,5	-	0,032	1.280	85
12,0	2	9,0	-	0,048	1.070	105
14,0	2	10,5	-	0,056	910	105
16,0	2	12,0	-	0,064	800	105
18,0	2	13,5	-	0,072	710	105
20,0	2	15,0	-	0,080	640	105

Werkzeugstähle, verschleissfeste Stähle						HRC 38~45
Werkstoffgruppen 1.4 / 1.5						
Nutenfräsen						
d_1	z	a_p max.	a_e max.	f_z	n	v_f
[mm]	[-]	[mm]	[mm]	[mm]	[min^{-1}]	[mm/min]
3,0	2	1,5	-	0,005	2.980	30
4,0	2	2,0	-	0,008	2.230	40
5,0	2	2,5	-	0,012	1.790	45
6,0	2	3,0	-	0,014	1.490	45
8,0	2	4,0	-	0,024	1.120	55
10,0	2	5,0	-	0,028	900	55
12,0	2	6,0	-	0,042	750	65
14,0	2	7,0	-	0,049	640	65
16,0	2	8,0	-	0,056	560	65
18,0	2	9,0	-	0,063	500	65
20,0	2	10,0	-	0,070	450	65

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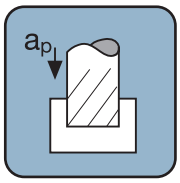

Rost- u. säurebeständige Stähle, 1.4301; 1.4571; 1.4057						HRC <25
Werkstoffgruppen 1.6.1 / 1.6.2						
Nutenfräsen						
d_1	z	a_p max.	a_e max.	f_z	n	v_f
[mm]	[-]	[mm]	[mm]	[mm]	[min^{-1}]	[mm/min]
3,0	2	1,5	-	0,006	3.400	40
4,0	2	2,0	-	0,010	2.550	50
5,0	2	2,5	-	0,013	2.040	55
6,0	2	3,0	-	0,016	1.700	55
8,0	2	4,0	-	0,027	1.280	70
10,0	2	5,0	-	0,032	1.020	70
12,0	2	6,0	-	0,048	850	85
14,0	2	7,0	-	0,056	730	85
16,0	2	8,0	-	0,064	640	85
18,0	2	9,0	-	0,072	570	85
20,0	2	10,0	-	0,080	510	85

Titan u. Titan-Legierungen 3.7115; 3.7124; 3.7164; 3.7174						HRC <45
Werkstoffgruppen 5.1 / 5.2 / 5.3						
Nutenfräsen						
d_1	z	a_p max.	a_e max.	f_z	n	v_f
[mm]	[-]	[mm]	[mm]	[mm]	[min^{-1}]	[mm/min]
3,0	2	1,2	-	0,005	1.910	20
4,0	2	1,6	-	0,009	1.440	30
5,0	2	2,0	-	0,012	1.150	30
6,0	2	2,4	-	0,015	960	30
8,0	2	3,2	-	0,025	720	40
10,0	2	4,0	-	0,030	580	35
12,0	2	4,8	-	0,045	480	45
14,0	2	5,6	-	0,053	410	45
16,0	2	6,4	-	0,060	360	45
18,0	2	7,2	-	0,068	320	45
20,0	2	8,0	-	0,075	290	45

Nickel u. Nickel-Legierungen 2.4812; 2.4876; 2.4668						HRC <45
Werkstoffgruppen 6.1 / 6.2 / 6.3						
Nutenfräsen						
d_1	z	a_p max.	a_e max.	f_z	n	v_f
[mm]	[-]	[mm]	[mm]	[mm]	[min^{-1}]	[mm/min]
3,0	2	0,8	-	0,004	1.490	15
4,0	2	1,0	-	0,007	1.120	20
5,0	2	1,3	-	0,010	900	20
6,0	2	1,5	-	0,012	750	20
8,0	2	2,0	-	0,020	560	25
10,0	2	2,5	-	0,024	450	25
12,0	2	3,0	-	0,036	380	30
14,0	2	3,5	-	0,042	320	30
16,0	2	4,0	-	0,048	280	30
18,0	2	4,5	-	0,054	250	30
20,0	2	5,0	-	0,060	230	30