

Langlochfräser (Bohrnutenfräser)

Fortsetzung

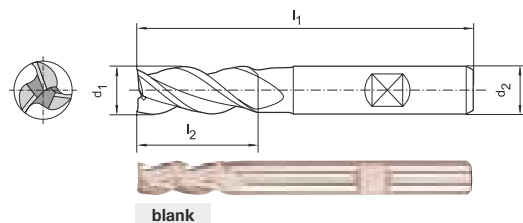
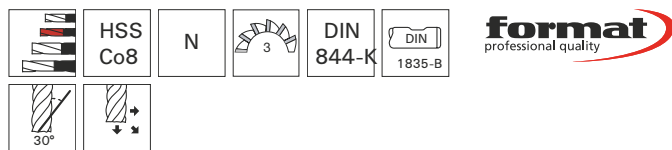
| Ø d ₁ = e8 mm | Schneidenlänge l ₂ mm | Gesamtlänge l ₁ mm | Schaft-Ø d ₂ = h6 mm | format | | Bestell-Nr. |
|-----------------------------|-------------------------------------|----------------------------------|------------------------------------|-----------------------------------|---------------|-------------|
| | | | | STAHL < 1400 N/mm ² | 2155 TiAIN | |
| 6 | 13 | 57 | 6 | 0,02 | 21,00 | ...0600 |
| 6,5 | 16 | 66 | 10 | 0,02 | 31,60 | ...0650 |
| 7 | 16 | 66 | 10 | 0,02 | 31,60 | ...0700 |
| 8 | 19 | 69 | 10 | 0,03 | 30,90 | ...0800 |
| 8,5 | 19 | 69 | 10 | 0,03 | 32,00 | ...0850 |
| 9 | 19 | 69 | 10 | 0,03 | 32,70 | ...0900 |
| 10 | 22 | 72 | 10 | 0,042 | 32,70 | ...1000 |
| 11 | 22 | 79 | 12 | 0,042 | 43,50 | ...1100 |
| 12 | 26 | 83 | 12 | 0,049 | 42,40 | ...1200 |
| 13 | 26 | 83 | 12 | 0,049 | 48,30 | ...1300 |
| 14 | 26 | 83 | 12 | 0,053 | 48,30 | ...1400 |
| 15 | 26 | 83 | 12 | 0,053 | 57,50 | ...1500 |
| 16 | 32 | 92 | 16 | 0,061 | 57,50 | ...1600 |
| 18 | 32 | 92 | 16 | 0,062 | 70,20 | ...1800 |
| 20 | 38 | 104 | 20 | 0,068 | 91,20 | ...2000 |
| 25 | 45 | 121 | 25 | 0,108 | 135,00 | ...2500 |

(W208)

Schaftfräser, Alu

Ausführung: Mit spezieller Schneidengeometrie. Zum Bohren geeignet.

Anwendung: Einsetzbar zum Umfangs- und Bohrfräsen von weichen bis zu zähen, langspanenden Werkstoffen.



| Einsatz | STAHL | | | INOX | | | GUSS | | SOND.-LEG. | NE-METALLE | | | | GEHÄRTETER STAHL | | | Bestell-Nr. |
|------------------------|-------------------------|--------------------------|--------------------------|------------------|--------------|--------|--------|-----|-------------------------------|-------------|-------------|--------------------|-------------------------|------------------|----------|----------|-------------|
| | < 700 N/mm ² | < 1000 N/mm ² | < 1400 N/mm ² | ferrit./martens. | austenitisch | Duplex | GG/GTS | GGG | Titan > 850 N/mm ² | Alu < 8% Si | Alu > 8% Si | Kupfer/Kupfer-Leg. | Graphit/GFK/CFK/Duropl. | < 55 HRC | < 60 HRC | > 60 HRC | |
| V _c [m/min] | 30 | 25 | 15 | - | - | - | - | - | - | 100 | - | - | - | - | - | - | 2160 |

| Ø d ₁ = e8 mm | Schneidenlänge l ₂ mm | Gesamtlänge l ₁ mm | Schaft-Ø d ₂ = h6 mm | format | | Bestell-Nr. |
|-----------------------------|-------------------------------------|----------------------------------|------------------------------------|----------------|---------------|-------------|
| | | | | ALU < 8% Si | 2160 blank | |
| 3 | 8 | 52 | 6 | 0,005 | 14,35 | ...0300 |
| 4 | 11 | 55 | 6 | 0,008 | 14,70 | ...0400 |
| 5 | 13 | 57 | 6 | 0,011 | 14,70 | ...0500 |
| 6 | 13 | 57 | 6 | 0,012 | 14,70 | ...0600 |
| 8 | 19 | 69 | 10 | 0,021 | 19,70 | ...0800 |
| 10 | 22 | 72 | 10 | 0,029 | 19,70 | ...1000 |
| 12 | 26 | 83 | 12 | 0,034 | 26,40 | ...1200 |
| 16 | 32 | 92 | 16 | 0,04 | 35,30 | ...1600 |
| 20 | 38 | 104 | 20 | 0,047 | 52,30 | ...2000 |
| 25 | 45 | 121 | 25 | 0,053 | 81,90 | ...2500 |

(W209)