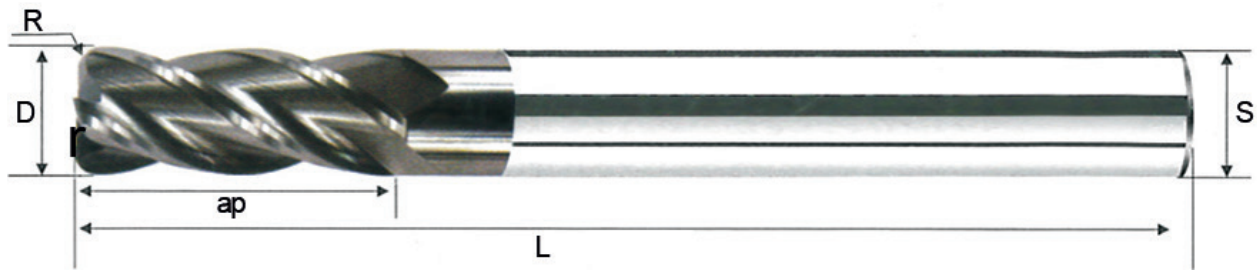


# Schaftfräser 4 Schneiden mit Eckradius Typ P45+

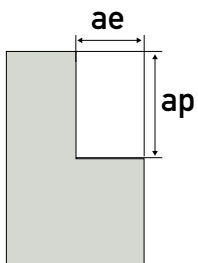


**P M S**

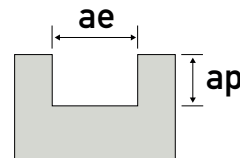


Anwendung	
Schichten	ja
Mittlere Bearbeitung	ja
Schruppen	nein

d	Toleranz
$\varnothing < 3$	0 - 0,03
$3 \geq \varnothing \leq 10$	0 - 0,04
$\varnothing > 10$	0 - 0,05



**Umfangsfräsen**  
 $ap = 1,5 \times D$



**Vollnut-Fräsen**  
 $ae = 0,5 \times D$   
 $ap = 2,0 \times D$

Material	Stahl	Rostfrei	Gusseisen (GGG/GT)	Super-/ Titanlegierung
Zugfestigkeit / Härte	< 850 N/mm <sup>2</sup>	< 700 N/mm <sup>2</sup>	> 260 HB	> 1200 N/mm <sup>2</sup>
Vc (m/min) Schichten	200	70	110	50
Vc (m/min) Schruppen	180	50	90	40

Durchmesser	Schruppen	Schichten
3	0,007 - 0,031	0,007 - 0,027
4	0,011 - 0,039	0,010 - 0,033
5	0,016 - 0,039	0,015 - 0,033
6	0,026 - 0,044	0,025 - 0,038
8	0,032 - 0,055	0,029 - 0,048
10	0,042 - 0,077	0,039 - 0,067
12	0,063 - 0,099	0,059 - 0,086
14	0,084 - 0,121	0,078 - 0,105
16	0,095 - 0,143	0,088 - 0,124
18	0,126 - 0,165	0,118 - 0,143
20	0,137 - 0,187	0,127 - 0,162
25	0,152 - 0,192	0,150 - 0,190
14	0,074 - 0,121	0,069 - 0,105
16	0,095 - 0,143	0,088 - 0,124
18	0,116 - 0,165	0,091 - 0,128
20	0,137 - 0,187	0,127 - 0,162
25	0,158 - 0,209	0,150 - 0,190

Bezeichnung	Materialhärte	Durchmesser (D)	Radius (R)	Zustelltiefe (ap)	Schaftdurchmesser (S)	Gesamtlänge (L)
P45+D3R0,5ap8F0S3L50Z4	P45+	3	0,5	8	3	50
P45+D3R1ap8F0S3L50Z4	P45+	3	1	8	3	50
P45+D3R0,5ap8F0S4L50Z4	P45+	3	0,5	8	4	50
P45+D3R1ap8F0S4L50Z4	P45+	3	1	8	4	50
P45+D4R0,5ap10F0S4L50Z4	P45+	4	0,5	10	4	50
P45+D4R1ap10F0S4L50Z4	P45+	4	1	10	4	50
P45+D5R0,5ap13F0S5L50Z4	P45+	5	0,5	13	5	50
P45+D5R1ap13F0S5L50Z4	P45+	5	1	13	5	50
P45+D5R0,5ap13F0S6L50Z4	P45+	5	0,5	13	6	50
P45+D5R1ap13F0S6L50Z4	P45+	5	1	13	6	50
P45+D6R0,5ap15F0S6L50Z4	P45+	6	0,5	15	6	50
P45+D6R1ap15F0S6L50Z4	P45+	6	1	15	6	50
P45+D8R0,5ap20F0S8L60Z4	P45+	8	0,5	20	8	60
P45+D8R1ap20F0S8L60Z4	P45+	8	1	20	8	60
P45+D3R0,5ap12F0S3L75Z4	P45+	3	0,5	12	3	75
P45+D3R1ap12F0S3L75Z4	P45+	3	1	12	3	75
P45+D4R0,5ap15F0S4L75Z4	P45+	4	0,5	15	4	75
P45+D4R1ap15F0S4L75Z4	P45+	4	1	15	4	75
P45+D5R0,5ap20F0S5L75Z4	P45+	5	0,5	20	5	75
P45+D5R1ap20F0S5L75Z4	P45+	5	1	20	5	75
P45+D6R0,5ap20F0S6L75Z4	P45+	6	0,5	20	6	75
P45+D6R1ap20F0S6L75Z4	P45+	6	1	20	6	75
P45+D8R0,5ap25F0S8L75Z4	P45+	8	0,5	25	8	75
P45+D8R1ap25F0S8L75Z4	P45+	8	1	25	8	75
P45+D10R0,5ap25F0S10L75Z4	P45+	10	0,5	25	10	75
P45+D10R1ap25F0S10L75Z4	P45+	10	1	25	10	75
P45+D12R0,5ap30F0S12L75Z4	P45+	12	0,5	30	12	75
P45+D12R1ap30F0S12L75Z4	P45+	12	1	30	12	75
P45+D14R0,5ap32F0S14L80Z4	P45+	14	0,5	32	14	80
P45+D14R1ap32F0S14L80Z4	P45+	14	1	32	14	80
P45+D3R0,5ap12F0S3L100Z4	P45+	3	0,5	12	3	100
P45+D3R1ap12F0S3L100Z4	P45+	3	1	12	3	100
P45+D4R0,5ap16F0S4L100Z4	P45+	4	0,5	16	4	100
P45+D4R1ap16F0S4L100Z4	P45+	4	1	16	4	100
P45+D5R0,5ap20F0S5L100Z4	P45+	5	0,5	20	5	100
P45+D5R1ap20F0S5L100Z4	P45+	5	1	20	5	100
P45+D6R0,5ap25F0S6L100Z4	P45+	6	0,5	25	6	100
P45+D6R1ap25F0S6L100Z4	P45+	6	1	25	6	100
P45+D8R0,5ap35F0S8L100Z4	P45+	8	0,5	35	8	100
P45+D8R1ap35F0S8L100Z4	P45+	8	1	35	8	100
P45+D10R0,5ap40F0S10L100Z4	P45+	10	0,5	40	10	100
P45+D10R1ap40F0S10L100Z4	P45+	10	1	40	10	100
P45+D12R0,5ap45F0S12L100Z4	P45+	12	0,5	45	12	100
P45+D12R1ap45F0S12L100Z4	P45+	12	1	45	12	100
P45+D14R0,5ap45F0S14L100Z4	P45+	14	0,5	45	14	100
P45+D14R1ap45F0S14L100Z4	P45+	14	1	45	14	100

Bezeichnung	Materialhärte	Durchmesser (D)	Radius (R)	Zustelltiefe (ap)	Schaftdurchmesser (S)	Gesamtlänge (L)
P45+D16R0,5ap45F0S16L100Z4	P45+	16	0,5	45	16	100
P45+D16R1ap45F0S16L100Z4	P45+	16	1	45	16	100
P45+D18R0,5ap45F0S18L100Z4	P45+	18	0,5	45	18	100
P45+D18R1ap45F0S18L100Z4	P45+	18	1	45	18	100
P45+D20R0,5ap45F0S20L100Z4	P45+	20	0,5	45	20	100
P45+D20R1ap45F0S20L100Z4	P45+	20	1	45	20	100
P45+D25R0,5ap45F0S25L100Z4	P45+	25	0,5	45	25	100
P45+D25R1ap45F0S25L100Z4	P45+	25	1	45	25	100
P45+D6R0,5ap25F0S6L150Z4	P45+	6	0,5	25	6	150
P45+D6R1ap25F0S6L150Z4	P45+	6	1	25	6	150
P45+D8R0,5ap35F0S8L150Z4	P45+	8	0,5	35	8	150
P45+D8R1ap35F0S8L150Z4	P45+	8	1	35	8	150
P45+D10R0,5ap45F0S10L150Z4	P45+	10	0,5	45	10	150
P45+D10R1ap45F0S10L150Z4	P45+	10	1	45	10	150
P45+D12R0,5ap45F0S12L150Z4	P45+	12	0,5	45	12	150
P45+D12R1ap45F0S12L150Z4	P45+	12	1	45	12	150
P45+D14R0,5ap45F0S14L150Z4	P45+	14	0,5	45	14	150
P45+D14R1ap45F0S14L150Z4	P45+	14	1	45	14	150
P45+D16R0,5ap50F0S16L150Z4	P45+	16	0,5	50	16	150
P45+D16R1ap50F0S16L150Z4	P45+	16	1	50	16	150
P45+D18R0,5ap50F0S18L150Z4	P45+	18	0,5	50	18	150
P45+D18R1ap50F0S18L150Z4	P45+	18	1	50	18	150
P45+D20R0,5ap55F0S20L150Z4	P45+	20	0,5	55	20	150
P45+D20R1ap55F0S20L150Z4	P45+	20	1	55	20	150
P45+D25R0,5ap60F0S25L150Z4	P45+	25	0,5	60	25	150
P45+D25R1ap60F0S25L150Z4	P45+	25	1	60	25	150