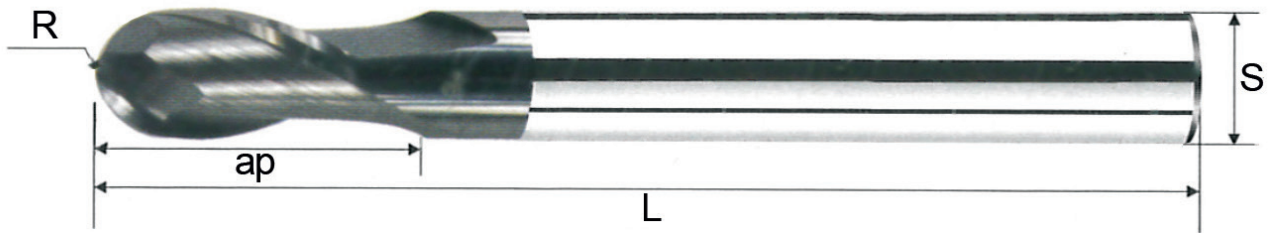
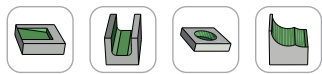


Vollradiusfräser 2 Schneiden Typ P45+



P M K S

UMG 0,4µm ARCO R 30° HRC 65



Anwendung	
Schlichten	ja
Mittlere Bearbeitung	ja
Schruppen	ja

D	Toleranz
$\varnothing \leq 12$	0 - 0,01
$\varnothing > 12$	0 - 0,015

Durchmesser (mm)	Schruppen mm/Z	Schlichten mm/Z
1	0,005-0,016	0,005-0,010
1,5	0,006-0,018	0,005-0,012
2	0,007-0,019	0,005-0,014
2,5	0,007-0,019	0,005-0,014
3	0,012-0,024	0,010-0,019
3,5	0,016-0,021	0,014-0,023
4	0,020-0,030	0,018-0,025
5	0,022-0,033	0,020-0,028
5,5	0,024-0,038	0,022-0,033
6	0,026-0,044	0,024-0,039
8	0,034-0,058	0,032-0,053
10	0,040-0,070	0,038-0,065
12	0,047-0,077	0,045-0,072
14	0,054-0,093	0,052-0,088
16	0,056-0,100	0,054-0,095
18	0,060-0,105	0,058-0,100
20	0,068-0,115	0,066-0,110
25	0,080-0,135	0,078-0,130

Material	allemeine Baustähle	unlegierte Vergütungsstähle	legierte Vergütungsstähle	Nitrierstähle
Zugfestigkeit / Härte in N/mm ²	500-850	850-1000	1000-1200	1000-1200
Vc (m/min) Schlichten	95	80	100	90
Vc (m/min) Schrappen	155	130	165	150

Material	Werkzeugstähle	rostfreie Stähle	Gusseisen (GGG/.GT)	Sonder-/ Titanlegierungen
Zugfestigkeit / Härte in N/mm ²	850-1000	850	<300 HB	850-1200
Vc (m/min) Schlichten	80	65	95	-
Vc (m/min) Schrappen	125	90	160	30

Bezeichnung	Materialhärte	Durchmesser (D)	Zustelltiefe (ap)	Schaft-durchmesser (S)	Gesamtlänge (L)
P45+D1R0,5ap2F0S4L50Z2	P45+	1	2	4	50
P45+D1,5R0,75ap3F0S4L50Z2	P45+	1,5	3	4	50
P45+D2R1ap4F0S4L50Z2	P45+	2	4	4	50
P45+D2R1ap4F0S6L50Z2	P45+	2	4	6	50
P45+D2,5R1,25ap5F0S4L50Z2	P45+	2,5	5	4	50
P45+D3R1,5ap6F0S3L50Z2	P45+	3	6	3	50
P45+D3R1,5ap6F0S4L50Z2	P45+	3	6	4	50
P45+D3,5R1,75ap7F0S4L50Z2	P45+	3,5	7	4	50
P45+D4R2ap8F0S4L50Z2	P45+	4	8	4	50
P45+D5R2,5ap10F0S5L50Z2	P45+	5	10	5	50
P45+D5R2,5ap10F0S6L50Z2	P45+	5	10	6	50
P45+D5,5R2,75ap11F0S6L50Z2	P45+	5,5	11	6	50
P45+D6R3ap12F0S6L50Z2	P45+	6	12	6	50
P45+D8R4ap16F0S8L60Z2	P45+	8	16	8	60
P45+D3R1,5ap6F0S3L75Z2	P45+	3	6	3	75
P45+D4R2ap8F0S4L75Z2	P45+	4	8	4	75
P45+D5R2,5ap10F0S5L75Z2	P45+	5	10	5	75
P45+D6R3ap12F0S6L75Z2	P45+	6	12	6	75
P45+D8R4ap16F0S8L75Z2	P45+	8	16	8	75
P45+D10R5ap20F0S10L75Z2	P45+	10	20	10	75
P45+D12R6ap24F0S12L75Z2	P45+	12	24	12	75
P45+D14R7ap28F0S14L80Z2	P45+	14	28	14	80
P45+D3R1,5ap6F0S3L100Z2	P45+	3	6	3	100
P45+D4R2ap8F0S4L100Z2	P45+	4	8	4	100
P45+D5R2,5ap10F0S5L100Z2	P45+	5	10	5	100
P45+D6R3ap12F0S6L100Z2	P45+	6	12	6	100
P45+D8R4ap16F0S8L100Z2	P45+	8	16	8	100
P45+D10R5ap20F0S10L100Z2	P45+	10	20	10	100
P45+D12R6ap24F0S12L100Z2	P45+	12	24	12	100
P45+D14R7ap28F0S14L100Z2	P45+	14	28	14	100
P45+D16R8ap32F0S16L100Z2	P45+	16	32	16	100
P45+D18R9ap36F0S18L100Z2	P45+	18	36	18	100
P45+D20R10ap40F0S20L100Z2	P45+	20	40	20	100
P45+D25R12,5ap50F0S25L100Z2	P45+	25	50	25	100
P45+D6R3ap12F0S6L150Z2	P45+	6	12	6	150
P45+D8R4ap16F0S8L150Z2	P45+	8	16	8	150
P45+D10R5ap20F0S10L150Z2	P45+	10	20	10	150
P45+D12R6ap24F0S12L150Z2	P45+	12	24	12	150
P45+D14R7ap28F0S14L150Z2	P45+	14	28	14	150
P45+D16R8ap32F0S16L150Z2	P45+	16	32	16	150
P45+D18R9ap36F0S18L150Z2	P45+	18	36	18	150
P45+D20R10ap40F0S20L150Z2	P45+	20	40	20	150
P45+D25R12,5ap50F0S25L150Z2	P45+	25	50	25	150