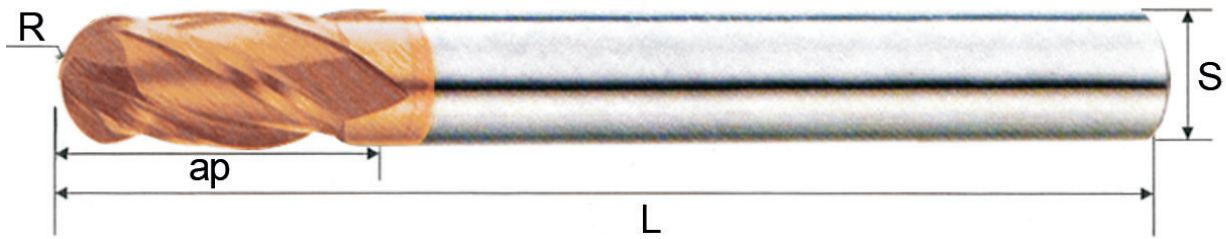


# Vollradiusfräser 4 Schneiden Typ P55+



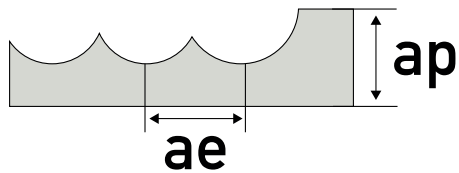
**P M K H**



Anwendung	
Schlichten	ja
Mittlere Bearbeitung	ja
Schruppen	nein

D	Toleranz
$\varnothing < 12$	0,02

Durchmesser (mm)	Schruppen mm/Z	Schlichten mm/Z
1	0,005-0,017	0,003-0,012
1,5	0,006-0,017	0,003-0,013
2	0,010-0,018	0,008-0,016
2,5	0,011-0,020	0,009-0,020
3	0,013-0,024	0,010-0,022
3,5	0,018-0,027	0,015-0,025
4	0,023-0,030	0,021-0,028
5	0,026-0,032	0,024-0,030
5,5	0,027-0,037	0,025-0,035
6	0,029-0,041	0,027-0,039
8	0,042-0,058	0,040-0,056
10	0,053-0,073	0,051-0,071
12	0,063-0,090	0,061-0,088
14	0,065-0,093	0,063-0,091
16	0,067-0,100	0,067-0,095
18	0,070-0,103	0,070-0,105
20	0,073-0,120	0,072-0,115
25	0,080-0,135	0,078-0,130



## Umfangsfräsen

$ae = 0,5xD$

$ap = 1,0xD$

## Vollnut-Fräsen

$ap = 1,0xD$

Material	unlegierte Vergütungsstähle	legierte Vergütungsstähle	Nitrierstähle	Werkzeugstähle	Gusseisen (GGG/GT)	Harte Werkstoffe
Zugfestigkeit / Härte in N/mm <sup>2</sup>	850-1000	1000-1200	1000-1200	850-1000	<300 HB	48-60 HRC
Vc (m/min) beschichtet	190	240	210	190	235	80

Bezeichnung	Materialhärte	Durchmesser (D)	Zustelltiefe (ap)	Schaft-durchmesser (S)	Gesamtlänge (L)
P55+D1R0,5ap2F0S4L50Z4	P55+	1	2	4	50
P55+D1R0,5ap2F0S6L50Z4	P55+	1	2	6	50
P55+D1,5R0,75ap3F0S4L50Z4	P55+	1,5	3	4	50
P55+D1,5R0,75ap3F0S6L50Z4	P55+	1,5	3	6	50
P55+D2R1ap4F0S4L50Z4	P55+	2	4	4	50
P55+D2R1ap4F0S6L50Z4	P55+	2	4	6	50
P55+D2,5R1,25ap5F0S4L50Z4	P55+	2,5	5	4	50
P55+D3R1,5ap6F0S3L50Z4	P55+	3	6	3	50
P55+D3R1,5ap6F0S4L50Z4	P55+	3	6	4	50
P55+D3R1,5ap6F0S6L50Z4	P55+	3	6	6	50
P55+D3,5R1,75ap7F0S4L50Z4	P55+	3,5	7	4	50
P55+D4R2ap8F0S4L50Z4	P55+	4	8	4	50
P55+D4R2ap8F0S6L50Z4	P55+	4	8	6	50
P55+D5R2,5ap10F0S5L50Z4	P55+	5	10	5	50
P55+D5R2,5ap10F0S6L50Z4	P55+	5	10	6	50
P55+D5,5R2,75ap11F0S6L50Z4	P55+	5,5	11	6	50
P55+D6R3ap12F0S6L50Z4	P55+	6	12	6	50
P55+D8R4ap16F0S8L60Z4	P55+	8	16	8	60
P55+D3R1,5ap6F0S3L75Z4	P55+	3	6	3	75
P55+D4R2ap8F0S4L75Z4	P55+	4	8	4	75
P55+D5R2,5ap10F0S5L75Z4	P55+	5	10	5	75
P55+D6R3ap12F0S6L75Z4	P55+	6	12	6	75
P55+D8R4ap16F0S8L75Z4	P55+	8	16	8	75
P55+D10R5ap20F0S10L75Z4	P55+	10	20	10	75
P55+D12R6ap24F0S12L75Z4	P55+	12	24	12	75
P55+D14R7ap28F0S14L80Z4	P55+	14	28	14	80
P55+D3R1,5ap6F0S3L100Z4	P55+	3	6	3	100
P55+D4R2ap8F0S4L100Z4	P55+	4	8	4	100
P55+D5R2,5ap10F0S5L100Z4	P55+	5	10	5	100
P55+D6R3ap12F0S6L100Z4	P55+	6	12	6	100
P55+D8R4ap16F0S8L100Z4	P55+	8	16	8	100
P55+D10R5ap20F0S10L100Z4	P55+	10	20	10	100
P55+D12R6ap24F0S12L100Z4	P55+	12	24	12	100
P55+D14R7ap28F0S14L100Z4	P55+	14	28	14	100
P55+D16R8ap32F0S16L100Z4	P55+	16	32	16	100
P55+D18R9ap36F0S18L100Z4	P55+	18	36	18	100
P55+D20R10ap40F0S20L100Z4	P55+	20	40	20	100
P55+D25R12,5ap50F0S25L100Z4	P55+	25	50	25	100
P55+D6R3ap12F0S6L150Z4	P55+	6	12	6	150
P55+D8R4ap16F0S8L150Z4	P55+	8	16	8	150
P55+D10R5ap20F0S10L150Z4	P55+	10	20	10	150
P55+D12R6ap24F0S12L150Z4	P55+	12	24	12	150
P55+D14R7ap28F0S14L150Z4	P55+	14	28	14	150
P55+D16R8ap32F0S16L150Z4	P55+	16	32	16	150
P55+D18R9ap36F0S18L150Z4	P55+	18	36	18	150
P55+D20R10ap40F0S20L150Z4	P55+	20	40	20	150
P55+D25R12,5ap50F0S25L150Z4	P55+	25	50	25	150