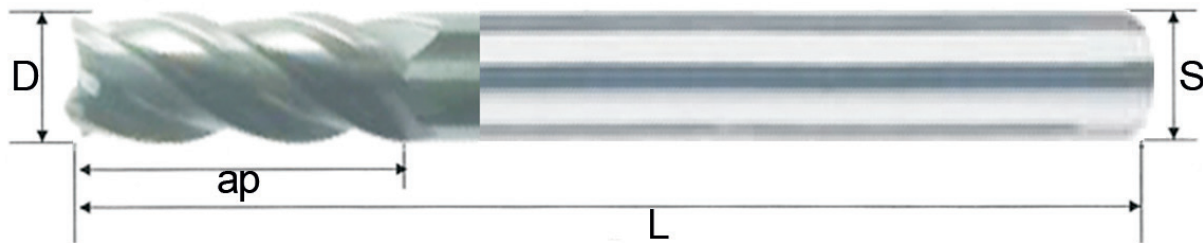
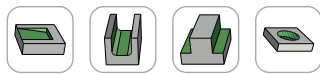


Schaftfräser 4 Schneiden Typ SM+

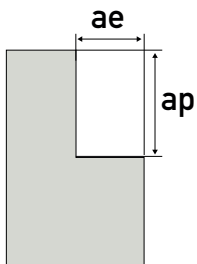


P M S

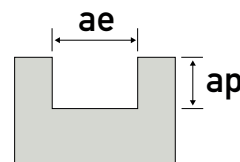


Anwendung	
Schichten	ja
Mittlere Bearbeitung	ja
Schruppen	nein

D	Toleranz
$\varnothing \leq 12$	0 - 0,02
$\varnothing > 12$	0 - 0,03



Umfangsfräsen
$ae = 0,5 \times D$
$ap = 1,5 \times D$



Vollnut-Fräsen
$ap = 1,0 \times D$

Material	Stahl	Rostfrei	Rostfrei	Gusseisen (GGG(GT))	Super-/Titanlegierung
Zugfestigkeit / Härte	< 850 N/mm ²	< 700 N/mm ²	< 1100 N/mm ²	> 260 HB	> 1200 N/mm ²
Vc (m/min) Schichten	200	100	90	80	60
Vc (m/min) Schruppen	180	90	80	60	50

Durchmesser	Schruppen	Schichten
3	0,0105 - 0,0170	0,0098 - 0,0140
4	0,0147 - 0,0220	0,0137 - 0,0190
5	0,0189 - 0,0260	0,0176 - 0,0230
6	0,0210 - 0,0310	0,0196 - 0,0270
8	0,0315 - 0,0420	0,0294 - 0,0360
10	0,0420 - 0,0550	0,0392 - 0,0480
12	0,0473 - 0,0610	0,0441 - 0,0520
14	0,0525 - 0,0660	0,0490 - 0,0570
16	0,0735 - 0,0880	0,0686 - 0,0760
20	0,0735 - 0,0990	0,0686 - 0,0860
25	0,0840 - 0,1210	0,0780 - 0,1050

Bezeichnung	Materialhärte	Durchmesser (D)	Zustelltiefe (ap)	Schaftdurchmesser (S)	Gesamtlänge (L)
SM+D1R0ap3F0S4L50Z4	SM+	1	3	4	50
SM+D1,5R0ap4F0S4L50Z4	SM+	1,5	4	4	50
SM+D2R0ap6F0S4L50Z4	SM+	2	6	4	50
SM+D2,5R0ap8F0S4L50Z4	SM+	2,50	8	4	50
SM+D3R0ap8F0S3L50Z4	SM+	3	8	3	50
SM+D3R0ap8F0S4L50Z4	SM+	3	8	4	50
SM+D3,5R0ap8F0S4L50Z4	SM+	3,5	8	4	50
SM+D4R0ap10F0S4L50Z4	SM+	4	10	4	50
SM+D5R0ap13F0S5L50Z4	SM+	5	13	5	50
SM+D5R0ap13F0S6L50Z4	SM+	5	13	6	50
SM+D5,5R0ap15F0S6L50Z4	SM+	5,5	15	6	50
SM+D6R0ap15F0S6L50Z4	SM+	6	15	6	50
SM+D8R0ap20F0S8L60Z4	SM+	8	20	8	60
SM+D3R0ap12F0S3L75Z4	SM+	3	12	3	75
SM+D4R0ap15F0S4L75Z4	SM+	4	15	4	75
SM+D5R0ap20F0S5L75Z4	SM+	5	20	5	75
SM+D6R0ap20F0S6L75Z4	SM+	6	20	6	75
SM+D8R0ap25F0S8L75Z4	SM+	8	25	8	75
SM+D9R0ap25F0S10L75Z4	SM+	9	25	10	75
SM+D10R0ap25F0S10L75Z4	SM+	10	25	10	75
SM+D12R0ap30F0S12L75Z4	SM+	12	30	12	75
SM+D14R0ap32F0S14L80Z4	SM+	14	32	14	80
SM+D3R0ap12F0S3L100Z4	SM+	3	12	3	100
SM+D4R0ap16F0S4L100Z4	SM+	4	16	4	100
SM+D5R0ap20F0S5L100Z4	SM+	5	20	5	100
SM+D6R0ap25F0S6L100Z4	SM+	6	25	6	100
SM+D8R0ap35F0S8L100Z4	SM+	8	35	8	100
SM+D10R0ap40F0S10L100Z4	SM+	10	40	10	100
SM+D12R0ap45F0S12L100Z4	SM+	12	45	12	100
SM+D14R0ap45F0S14L100Z4	SM+	14	45	14	100
SM+D16R0ap45F0S16L100Z4	SM+	16	45	16	100
SM+D18R0ap45F0S18L100Z4	SM+	18	45	18	100
SM+D20R0ap45F0S20L100Z4	SM+	20	45	20	100
SM+D25R0ap45F0S25L100Z4	SM+	25	45	25	100
SM+D6R0ap25F0S6L150Z4	SM+	6	25	6	150
SM+D8R0ap35F0S8L150Z4	SM+	8	35	8	150
SM+D10R0ap45F0S10L150Z4	SM+	10	45	10	150
SM+D12R0ap45F0S12L150Z4	SM+	12	45	12	150
SM+D14R0ap45F0S14L150Z4	SM+	14	45	14	150
SM+D16R0ap50F0S16L150Z4	SM+	16	50	16	150
SM+D18R0ap50F0S18L150Z4	SM+	18	50	18	150
SM+D20R0ap55F0S20L150Z4	SM+	20	55	20	150
SM+D25R0ap60F0S25L150Z4	SM+	25	60	25	150