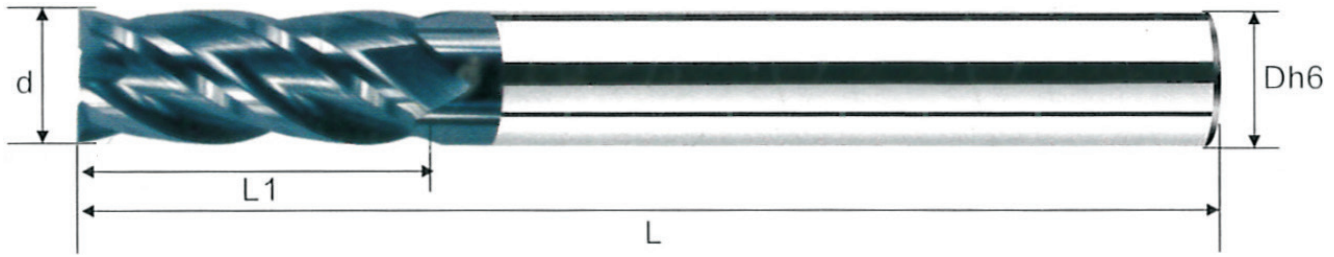


Schaftfräser 4 Schneiden Typ P45+

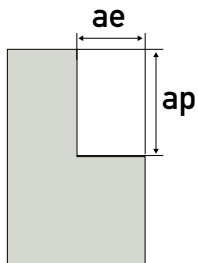


P M K



Anwendung	
Schlichten	ja
Mittlere Bearbeitung	ja
Schruppen	nein

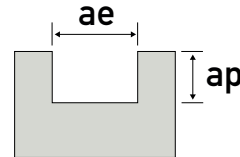
D	Toleranz
$\varnothing < 3$	0 - 0,02
$3 \geq \varnothing \leq 10$	0 - 0,03
$\varnothing > 10$	0 - 0,04



Umfangsfräsen

$$ae = 0,5xD$$

$$ap = 2,0xD$$



Vollnut-Fräsen

$$ap = 1,5xD$$

Für Nutenfräsen f2 um 20% reduzieren.

Material	Stahl	Rostfrei	Gusseisen (GGG/GT)
Zugfestigkeit / Härte	< 850 N/mm ²	< 700 N/mm ²	> 260 HB
Vc (m/min) Schlichten	200	70	110
Vc (m/min) Schrappen	180	50	90

Durchmesser	Schruppen	Schlichten
1	0,006-0,014	0,006-0,010
1,5	0,006-0,017	0,006-0,014
2	0,006-0,011	0,006-0,010
2,5	0,006-0,011	0,006-0,010
3	0,011-0,017	0,010-0,014
3,5	0,011-0,017	0,010-0,014
4	0,015-0,022	0,014-0,019
5	0,019-0,026	0,018-0,023
6	0,021-0,031	0,020-0,027
8	0,032-0,042	0,029-0,036
10	0,042-0,055	0,039-0,048
12	0,047-0,061	0,044-0,052
14	0,053-0,066	0,049-0,057
16	0,074-0,088	0,069-0,076
18	0,074-0,095	0,069-0,082
20	0,074-0,099	0,069-0,086
25	0,137-0,187	0,127-0,162
25	0,158 - 0,209	0,150 - 0,190

Bezeichnung	Materialhärte	Durchmesser (D)	Zustelltiefe (ap)	Schaft-durchmesser (S)	Gesamtlänge (L)
P45+D1R0ap3F0S4L50Z4	P45+	1	3	4	50
P45+D1,5R0ap4F0S4L50Z4	P45+	1,5	4	4	50
P45+D2R0ap6F0S4L50Z4	P45+	2	6	4	50
P45+D2,5R0ap8F0S4L50Z4	P45+	2,50	8	4	50
P45+D3R0ap8F0S3L50Z4	P45+	3	8	3	50
P45+D3R0ap8F0S4L50Z4	P45+	3	8	4	50
P45+D3,5R0ap8F0S4L50Z4	P45+	3,5	8	4	50
P45+D4R0ap10F0S4L50Z4	P45+	4	10	4	50
P45+D5R0ap13F0S5L50Z4	P45+	5	13	5	50
P45+D5R0ap13F0S6L50Z4	P45+	5	13	6	50
P45+D5,5R0ap15F0S6L50Z4	P45+	5,5	15	6	50
P45+D6R0ap15F0S6L50Z4	P45+	6	15	6	50
P45+D8R0ap20F0S8L60Z4	P45+	8	20	8	60
P45+D3R0ap12F0S3L75Z4	P45+	3	12	3	75
P45+D4R0ap15F0S4L75Z4	P45+	4	15	4	75
P45+D5R0ap20F0S5L75Z4	P45+	5	20	5	75
P45+D6R0ap20F0S6L75Z4	P45+	6	20	6	75
P45+D8R0ap25F0S8L75Z4	P45+	8	25	8	75
P45+D9R0ap25F0S10L75Z4	P45+	9	25	10	75
P45+D10R0ap25F0S10L75Z4	P45+	10	25	10	75
P45+D12R0ap30F0S12L75Z4	P45+	12	30	12	75
P45+D14R0ap32F0S14L80Z4	P45+	14	32	14	80
P45+D3R0ap12F0S3L100Z4	P45+	3	12	3	100
P45+D4R0ap16F0S4L100Z4	P45+	4	16	4	100
P45+D5R0ap20F0S5L100Z4	P45+	5	20	5	100
P45+D6R0ap25F0S6L100Z4	P45+	6	25	6	100
P45+D8R0ap35F0S8L100Z4	P45+	8	35	8	100
P45+D10R0ap40F0S10L100Z4	P45+	10	40	10	100
P45+D12R0ap45F0S12L100Z4	P45+	12	45	12	100
P45+D14R0ap45F0S14L100Z4	P45+	14	45	14	100
P45+D16R0ap45F0S16L100Z4	P45+	16	45	16	100
P45+D18R0ap45F0S18L100Z4	P45+	18	45	18	100
P45+D20R0ap45F0S20L100Z4	P45+	20	45	20	100
P45+D25R0ap45F0S25L100Z4	P45+	25	45	25	100
P45+D6R0ap25F0S6L150Z4	P45+	6	25	6	150
P45+D8R0ap35F0S8L150Z4	P45+	8	35	8	150
P45+D10R0ap45F0S10L150Z4	P45+	10	45	10	150
P45+D12R0ap45F0S12L150Z4	P45+	12	45	12	150
P45+D14R0ap45F0S14L150Z4	P45+	14	45	14	150
P45+D16R0ap50F0S16L150Z4	P45+	16	50	16	150
P45+D18R0ap50F0S18L150Z4	P45+	18	50	18	150
P45+D20R0ap55F0S20L150Z4	P45+	20	55	20	150
P45+D25R0ap60F0S25L150Z4	P45+	25	60	25	150