

CrazyMill Cool Vollradius - Typ C - Vorschlichten

ANWENDUNGSEMPFEHLUNG

● Sehr gut geeignet | ◐ Gut geeignet | ○ bedingt geeignet | ⊗ Nicht empfohlen

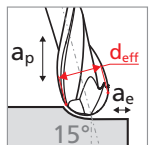
P	N	S ₃
M	S ₁	H ₁
K	S ₂	H ₂
		⊗

v_c [m/min]
 f_z [mm]
 d_{eff} [mm]

FRÄSEN MIT INTEGRIERTER KÜHLUNG | SCHNITTDATENÜBERSICHT

Werkstoffgruppe	Werkstoff	Wr.Nr.	DIN	Ød1 0.3 mm		Ød1 0.4 mm		Ød1 0.5 mm		Ød1 0.6 mm		Ød1 0.8 mm		Ød1 1.0 mm		Ød1 1.2 mm		Ød1 1.5 mm		Ød1 1.8 mm		Ød1 2.0 mm		Ød1 2.5 mm		Ød1 3.0 mm		Ød1 4.0 mm		Ød1 6.0 mm		Ød1 8.0 mm																
				v_c	d_{eff}	f_z	v_c	d_{eff}	f_z	v_c	d_{eff}	f_z	v_c	d_{eff}	f_z	v_c	d_{eff}	f_z	v_c	d_{eff}	f_z	v_c	d_{eff}	f_z	v_c	d_{eff}	f_z	v_c	d_{eff}	f_z	v_c	d_{eff}	f_z	v_c	d_{eff}	f_z												
P	Stähle unlegiert Rm < 800 N/mm ²	1.0301	C10																																													
		1.0401	C15																																													
		1.1191	C45E/CK45	55	0.29	0.005	73	0.39	0.007	92	0.48	0.010	100	0.60	0.012	100	0.80	0.014	140	1.00	0.015	140	1.20	0.017	200	1.50	0.024	200	1.80	0.026	220	2.00	0.034	220	2.50	0.036	240	3.00	0.040	260	4.00	0.050	260	6.00	0.050	260	8.00	0.050
		1.0044	S275JR																																													
		1.0715	11SMn30																																													
	Stähle niedriglegiert Rm > 900 N/mm ²	1.5752	15NiCr13																																													
		1.7131	16MnCr5																																													
		1.3505	100Cr6	55	0.29	0.004	73	0.39	0.006	92	0.48	0.009	100	0.60	0.011	100	0.80	0.012	140	1.00	0.014	140	1.20	0.016	200	1.50	0.022	200	1.80	0.024	220	2.00	0.032	220	2.50	0.034	240	3.00	0.038	260	4.00	0.048	260	6.00	0.048	260	8.00	0.048
		1.7225	42CrMo4																																													
		1.2842	90MnCrV8																																													
	Werkzeugstähle hochlegiert Rm < 1200 N/mm ²	1.2379	X153CrMoV12																																													
		1.2436	X210CrW12																																													
		1.3343	HS6-5-2C	55	0.29	0.004	73	0.39	0.006	92	0.48	0.008	100	0.60	0.009	100	0.80	0.011	140	1.00	0.011	140	1.20	0.013	200	1.50	0.020	200	1.80	0.022	220	2.00	0.030	220	2.50	0.032	240	3.00	0.035	260	4.00	0.044	260	6.00	0.044	260	8.00	0.044
1.3355		HS18-0-1																																														
M	Rostfreie Stähle-ferritisch	1.4016	X6Cr17	55	0.29	0.005	73	0.39	0.007	92	0.48	0.010	100	0.60	0.012	100	0.80	0.014	140	1.00	0.016	140	1.20	0.018	200	1.50	0.024	200	1.80	0.026	220	2.00	0.034	220	2.50	0.036	240	3.00	0.040	260	4.00	0.048	260	6.00	0.048	260	8.00	0.048
		1.4105	X6CrMoS17																																													
	Rostfreie Stähle-martensitisch	1.4034	X46Cr13	55	0.29	0.004	73	0.39	0.006	92	0.48	0.009	100	0.60	0.010	100	0.80	0.012	140	1.00	0.015	140	1.20	0.017	200	1.50	0.022	200	1.80	0.024	220	2.00	0.032	220	2.50	0.034	240	3.00	0.036	260	4.00	0.046	260	6.00	0.046	260	8.00	0.046
		1.4112	X90CrMoV18																																													
	Rostfreie Stähle-martensitisch-PH	1.4542	X5CrNiCuNb 16-4	55	0.29	0.004	73	0.39	0.006	92	0.48	0.009	100	0.60	0.010	100	0.80	0.012	140	1.00	0.015	140	1.20	0.017	200	1.50	0.022	200	1.80	0.024	220	2.00	0.032	220	2.50	0.034	240	3.00	0.036	260	4.00	0.046	260	6.00	0.046	260	8.00	0.046
		1.4545	X5CrNiCuNb 15-5																																													
	Rostfreie Stähle-austenitisch	1.4301	X5CrNi 18-10																																													
1.4435		X2CrNiMo 18-14-3	55	0.29	0.004	73	0.39	0.006	92	0.48	0.008	100	0.60	0.010	100	0.80	0.011	140	1.00	0.012	140	1.20	0.014	200	1.50	0.016	200	1.80	0.018	220	2.00	0.030	220	2.50	0.032	240	3.00	0.034	260	4.00	0.044	260	6.00	0.044	260	8.00	0.044	
1.4441		X2CrNiMo 18-15-3																																														
1.4539	X1NiCrMoCu25-20-5																																															
K	Gusseisen	0.6020	GG20																																													
		0.6030	GG30	55	0.29	0.003	73	0.39	0.005	92	0.48	0.006	100	0.60	0.008	100	0.80	0.009	120	1.00	0.011	120	1.20	0.022	140	1.50	0.024	140	1.80	0.026	160	2.00	0.028	160	2.50	0.036	180	3.00	0.042	200	4.00	0.052	200	6.00	0.052	200	8.00	0.052
		0.7040	GGG40																																													
		0.7060	GGG60																																													

Vorschlichten



- $a_p = 0.25 \times d_1$
($\varnothing d_1 \leq 0.5$ mm)
- $a_p = 0.5 \times d_1$
($\varnothing d_1 > 0.5$ mm)
- $a_e = 0.1 \times d_1$

Bearbeitungswinkel = 15°

