

CrazyMill Cool Vollradius - Typ A - Schruppen

ANWENDUNGSEMPFEHLUNG

● Sehr gut geeignet | ● Gut geeignet | ○ bedingt geeignet | ☒ Nicht empfohlen

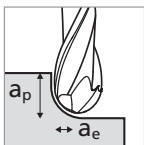
P	N	S ₃
M	S ₁	H ₁
K	S ₂	H ₂

FRÄSEN MIT INTEGRIERTER KÜHLUNG | SCHNITTDATENÜBERSICHT

v_c [m/min]
 f_z [mm]

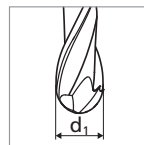
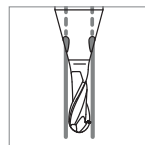
Werkstoffgruppe	Werkstoff	Wr.Nr.	DIN	Ød1 0.3–0.4 mm		Ød1 0.5–0.8 mm		Ød1 1.0–1.2 mm		Ød1 1.5–1.8 mm		Ød1 2.0–2.5 mm		Ød1 3.0 mm		Ød1 4.0–6.0 mm		Ød1 8.0 mm	
				v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z
P	Stähle unlegiert Rm < 800 N/mm ²	1.0301	C10	60	0.005–0.007	100	0.010–0.014	140	0.015–0.017	200	0.024–0.026	220	0.034–0.036	240	0.048	280	0.050	280	0.050
		1.0401	C15																
		1.1191	C45E/CK45																
		1.0044	S275JR																
		1.0715	11SMn30																
	Stähle niedriglegiert Rm > 900 N/mm ²	1.5752	15NiCr13	60	0.004–0.006	100	0.009–0.012	140	0.014–0.016	200	0.022–0.024	220	0.032–0.034	240	0.046	280	0.048	280	0.048
		1.7131	16MnCr5																
		1.3505	100Cr6																
		1.7225	42CrMo4																
	Werkzeugstähle hochlegiert Rm < 1200 N/mm ²	1.2842	90MnCrV8	60	0.004–0.006	100	0.008–0.011	140	0.011–0.013	200	0.020–0.022	220	0.030–0.032	240	0.042	280	0.044	280	0.044
		1.2379	X153CrMoV12																
		1.2436	X210CrW12																
		1.3343	HS6-5-2C																
M	Rostfreie Stähle- ferritisch	1.3355	HS18-0-1	60	0.004–0.006	100	0.008–0.011	140	0.011–0.013	200	0.020–0.022	220	0.030–0.032	240	0.042	280	0.044	280	0.044
		1.4016	X6Cr17																
	Rostfreie Stähle- martensitisch	1.4105	X6CrMoS17	60	0.005–0.007	100	0.010–0.014	140	0.016–0.018	200	0.024–0.026	220	0.034–0.036	240	0.046	280	0.048	280	0.048
		1.4034	X46Cr13																
		1.4112	X90CrMoV18																
	Rostfreie Stähle- martensitisch – PH	1.4542	X5CrNiCuNb 16-4	60	0.004–0.006	100	0.009–0.012	140	0.015–0.017	200	0.022–0.024	220	0.032–0.034	240	0.044	280	0.046	280	0.046
		1.4545	X5CrNiCuNb 15-5																
	Rostfreie Stähle- austenitisch	1.4301	X5CrNi 18-10	60	0.004–0.006	100	0.008–0.011	140	0.012–0.014	200	0.016–0.018	220	0.030–0.032	240	0.042	280	0.044	280	0.044
		1.4435	X2CrNiMo 18-14-3																
		1.4441	X2CrNiMo 18-15-3																
1.4539		X1NiCrMoCu 25-20-5																	
K	Gusseisen	0.6020	GG20	60	0.003–0.005	100	0.006–0.009	120	0.011–0.022	140	0.024–0.026	160	0.028–0.036	180	0.042–0.048	200	0.052–0.057	200	0.052–0.057
		0.6030	GG30																
		0.7040	GGG40																
		0.7060	GGG60																

Schruppen



- $a_p = 0.5 \times d_1$
($\varnothing d_1 \leq 0.5$ mm)
- $a_p = 1 \times d_1$
($\varnothing d_1 > 0.5$ mm)
- $a_e = 0.3 \times d_1$

Bearbeitungswinkel = 0°



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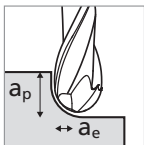
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M	S ₁	H ₁
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		☒

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v_c [m/min]
 f_z [mm]

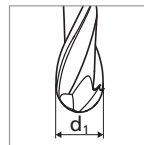
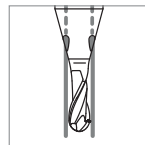
Werkstoffgruppe	Werkstoff	Wr.Nr.	DIN	Ød1 0.3–0.4 mm		Ød1 0.5–0.8 mm		Ød1 1.0–1.2 mm		Ød1 1.5–1.8 mm		Ød1 2.0–2.5 mm		Ød1 3.0 mm		Ød1 4.0–6.0 mm		Ød1 8.0 mm	
				v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z	v_c	f_z
N	Aluminium Knetlegierungen	3.2315	AlMgSi1	60	0.006–0.008	100	0.012–0.016	140	0.018–0.020	200	0.026–0.028	220	0.036–0.040	240	0.058	280	0.060	280	0.060
		3.4365	AlZnMgCu1.5																
	Aluminium Druckgusslegierungen	3.2163	GD-ALSi9Cu3	60	0.006–0.008	100	0.012–0.016	140	0.018–0.020	200	0.026–0.028	220	0.036–0.040	240	0.058	280	0.060	280	0.060
		3.2381	GD-ALSi10Mg																
	Kupfer	2.004	Cu-OF / CW008A	60	0.006–0.008	100	0.014–0.018	140	0.020–0.022	200	0.026–0.028	220	0.036–0.040	240	0.058	280	0.060	280	0.060
		2.0065	Cu-ETP / CW004A																
	Messing bleifrei	2.0321	CuZn37 CW508L	60	0.006–0.008	100	0.014–0.018	140	0.020–0.022	200	0.026–0.028	220	0.036–0.040	240	0.058	280	0.060	280	0.060
		2.036	CuZn40 CW509L																
	Messing, Bronze Rm < 400 N/mm²	2.0401	CuZn39Pb3 / CW614N	60	0.006–0.008	100	0.014–0.018	140	0.020–0.022	200	0.026–0.028	220	0.036–0.040	240	0.058	280	0.060	280	0.060
		2.102	CuSn6																
Bronze Rm < 600 N/mm²	2.0966	CuAl10Ni5Fe4	60	0.006–0.008	100	0.012–0.016	140	0.018–0.020	200	0.026–0.028	220	0.036–0.040	240	0.058	280	0.060	280	0.060	
	2.096	CuAl9Mn2																	
S ₁	Hitzebeständige Stähle	2.4856		60	0.003–0.004	100	0.004–0.006	120	0.007–0.008	130	0.009–0.010	140	0.010–0.012	150	0.015	170	0.020	170	0.020
		2.4668																	
		2.4617	NiMo28																
		2.4665	NiCr22Fe18Mo																
S ₂	Titan rein	3.7035	Gr.2	60	0.004–0.006	100	0.008–0.011	120	0.016–0.018	130	0.020–0.022	140	0.028–0.030	150	0.042	170	0.044	170	0.044
		3.7065	Gr.4																
S ₂	Titan Legierungen	3.7165	TiAl6V4	60	0.004–0.006	100	0.008–0.011	120	0.016–0.018	130	0.020–0.022	140	0.028–0.030	150	0.042	170	0.044	170	0.044
		9.9367	TiAl6Nb7																
S ₃	CrCo-Legierungen	2.4964	CoCr20W15Ni	60	0.003–0.004	100	0.004–0.006	140	0.007–0.008	180	0.009–0.010	200	0.010–0.012	220	0.015	240	0.020	240	0.020
			CrCoMo28																
H ₁ H ₂	Stähle gehärtet < 55 HRC	1.2510	100MnCrMoW4	60	0.004–0.006	80	0.007–0.009	100	0.010–0.012	140	0.014–0.018	180	0.020–0.026	200	0.035	240	0.040	240	0.040
	Stähle gehärtet ≥ 55 HRC	1.2379	X153CrMoV12																

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