

PRODUKTBESCHREIBUNG

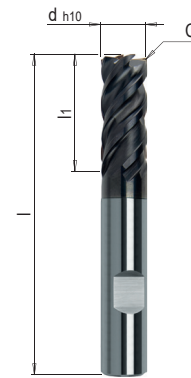
- » Hochleistungs-Fräser mit ungleicher Teilung und Zentrumsschnitt
- » Kernsprung für erhöhte Stabilität ab 6mm

MATERIAL

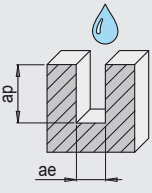
» VHM, TiAlN Multilayer-beschichtet



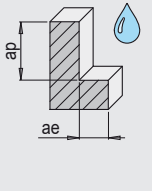
| Z | I | I1 | C | d | Nr. | EUR |
|---|----|----|-------|----|--------------|-----|
| 4 | 57 | 11 | 0,060 | 4 | WZF 12648/ 4 | < > |
| 4 | 57 | 15 | 0,090 | 6 | WZF 12648/ 6 | < > |
| 4 | 63 | 20 | 0,120 | 8 | WZF 12648/ 8 | < > |
| 4 | 72 | 24 | 0,150 | 10 | WZF 12648/10 | < > |
| 4 | 83 | 28 | 0,180 | 12 | WZF 12648/12 | < > |
| 4 | 92 | 36 | 0,240 | 16 | WZF 12648/16 | < > |



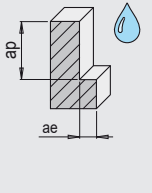
RICHTWERTE NUTEN

| WZF 12648 | Werkstoff | Festigkeit | Vc ¹ m/min. | d | | | | | |
|--|-----------|------------------------|---------------------------|------------------------|-------|-------|-------|-------|-------|
| | | | | 4 | 6 | 8 | 10 | 12 | 16 |
| | | | | fz ² (mm/z) | | | | | |
|  <p>ae = 1 x d ap = 0.8 x d</p> | 1.1730 | 640 N/mm ² | 160 | 0.021 | 0.032 | 0.042 | 0.053 | 0.063 | 0.084 |
| | 1.2083 | 780 N/mm ² | 120 | 0.017 | 0.025 | 0.034 | 0.042 | 0.051 | 0.068 |
| | 1.2085 | 1080 N/mm ² | 120 | 0.017 | 0.025 | 0.034 | 0.042 | 0.051 | 0.068 |
| | 1.2162 | 660 N/mm ² | 140 | 0.021 | 0.032 | 0.042 | 0.053 | 0.063 | 0.084 |
| | 1.2311 | 1080 N/mm ² | 130 | 0.019 | 0.028 | 0.037 | 0.047 | 0.056 | 0.075 |
| | 1.2312 | 1080 N/mm ² | 140 | 0.019 | 0.028 | 0.037 | 0.047 | 0.056 | 0.075 |
| | 1.2316 | 1010 N/mm ² | 120 | 0.017 | 0.025 | 0.034 | 0.042 | 0.051 | 0.068 |
| | 1.2343 | 780 N/mm ² | 140 | 0.021 | 0.032 | 0.042 | 0.053 | 0.063 | 0.084 |
| | 1.2379 | 780 N/mm ² | 120 | 0.017 | 0.025 | 0.034 | 0.042 | 0.051 | 0.068 |
| | 1.2714HH | 1350 N/mm ² | 90 | 0.017 | 0.025 | 0.034 | 0.042 | 0.051 | 0.068 |
| | 1.2767 | 830 N/mm ² | 140 | 0.019 | 0.028 | 0.037 | 0.047 | 0.056 | 0.075 |
| | 1.2842 | 775 N/mm ² | 140 | 0.019 | 0.028 | 0.037 | 0.047 | 0.056 | 0.075 |
| | Stahl | 1400 N/mm ² | 60 | 0.017 | 0.025 | 0.034 | 0.042 | 0.051 | 0.068 |

RICHTWERTE SCHRUPPEN


| WZF 12648 | Werkstoff | Festigkeit | Vc ¹ m/min. | d | | | | | |
|--|-----------|------------------------|---------------------------|------------------------|-------|-------|-------|-------|-------|
| | | | | 4 | 6 | 8 | 10 | 12 | 16 |
| | | | | fz ² (mm/z) | | | | | |
|  <p>ae = 0.15 x d ap = 2 x d</p> | 1.1730 | 640 N/mm ² | 290 | 0.040 | 0.060 | 0.080 | 0.100 | 0.120 | 0.160 |
| | 1.2083 | 780 N/mm ² | 215 | 0.032 | 0.048 | 0.064 | 0.080 | 0.097 | 0.129 |
| | 1.2085 | 1080 N/mm ² | 215 | 0.032 | 0.048 | 0.064 | 0.080 | 0.097 | 0.129 |
| | 1.2162 | 660 N/mm ² | 250 | 0.040 | 0.060 | 0.080 | 0.100 | 0.120 | 0.160 |
| | 1.2311 | 1080 N/mm ² | 235 | 0.035 | 0.053 | 0.071 | 0.088 | 0.106 | 0.142 |
| | 1.2312 | 1080 N/mm ² | 250 | 0.035 | 0.053 | 0.071 | 0.088 | 0.106 | 0.142 |
| | 1.2316 | 1010 N/mm ² | 215 | 0.032 | 0.048 | 0.064 | 0.080 | 0.097 | 0.129 |
| | 1.2343 | 780 N/mm ² | 250 | 0.040 | 0.060 | 0.080 | 0.100 | 0.120 | 0.160 |
| | 1.2379 | 780 N/mm ² | 215 | 0.032 | 0.048 | 0.064 | 0.080 | 0.097 | 0.129 |
| | 1.2714HH | 1350 N/mm ² | 160 | 0.032 | 0.048 | 0.064 | 0.080 | 0.097 | 0.129 |
| | 1.2767 | 830 N/mm ² | 250 | 0.035 | 0.053 | 0.071 | 0.088 | 0.106 | 0.142 |
| | 1.2842 | 775 N/mm ² | 250 | 0.035 | 0.053 | 0.071 | 0.088 | 0.106 | 0.142 |
| | Stahl | 1400 N/mm ² | 110 | 0.032 | 0.048 | 0.064 | 0.080 | 0.097 | 0.129 |

RICHTWERTE SCHLICHTEN

| WZF 12648 | Werkstoff | Festigkeit | Vc ¹ m/min. | d | | | | | |
|---|-----------|------------------------|---------------------------|------------------------|-------|-------|-------|-------|-------|
| | | | | 4 | 6 | 8 | 10 | 12 | 16 |
| | | | | fz ² (mm/z) | | | | | |
|  <p>ae = 0.02 x d ap = 2 x d</p> | 1.1730 | 640 N/mm ² | 320 | 0.023 | 0.035 | 0.046 | 0.058 | 0.069 | 0.092 |
| | 1.2083 | 780 N/mm ² | 240 | 0.019 | 0.028 | 0.037 | 0.047 | 0.056 | 0.075 |
| | 1.2085 | 1080 N/mm ² | 240 | 0.019 | 0.028 | 0.037 | 0.047 | 0.056 | 0.075 |
| | 1.2162 | 660 N/mm ² | 280 | 0.023 | 0.035 | 0.046 | 0.058 | 0.069 | 0.092 |
| | 1.2311 | 1080 N/mm ² | 260 | 0.020 | 0.031 | 0.041 | 0.051 | 0.061 | 0.082 |
| | 1.2312 | 1080 N/mm ² | 280 | 0.020 | 0.031 | 0.041 | 0.051 | 0.061 | 0.082 |
| | 1.2316 | 1010 N/mm ² | 240 | 0.019 | 0.028 | 0.037 | 0.047 | 0.056 | 0.075 |
| | 1.2343 | 780 N/mm ² | 280 | 0.023 | 0.035 | 0.046 | 0.058 | 0.069 | 0.092 |
| | 1.2379 | 780 N/mm ² | 240 | 0.019 | 0.028 | 0.037 | 0.047 | 0.056 | 0.075 |
| | 1.2714HH | 1350 N/mm ² | 180 | 0.019 | 0.028 | 0.037 | 0.047 | 0.056 | 0.075 |
| | 1.2767 | 830 N/mm ² | 280 | 0.020 | 0.031 | 0.041 | 0.051 | 0.061 | 0.082 |
| | 1.2842 | 775 N/mm ² | 280 | 0.020 | 0.031 | 0.041 | 0.051 | 0.061 | 0.082 |
| | Stahl | 1400 N/mm ² | 120 | 0.019 | 0.028 | 0.037 | 0.047 | 0.056 | 0.075 |

1) Vc: Schnittgeschwindigkeit (m/min.)

2) fz: Vorschub pro Schneide (mm/z)

 Weitere Materialien und Schnittwerte finden Sie im Schnittdaten-Kalkulator