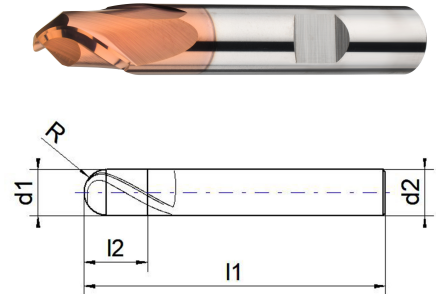
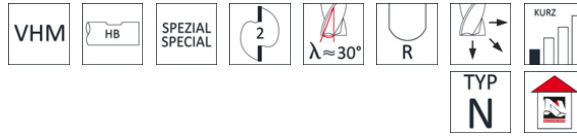


## VHM-Universal-Vollradiusfräser 30°

Solid carbide universal ball nose end mills 30°



| Artikelnummer<br>Article-No. | d1  | R    | l1 | l2 | d2 h6 |
|------------------------------|-----|------|----|----|-------|
| E.7641.1.0100                | 1   | 0.5  | 50 | 3  | 6,0   |
| E.7641.1.0200                | 2   | 1    | 50 | 4  | 6,0   |
| E.7641.1.0250                | 2.5 | 1.25 | 50 | 4  | 6,0   |
| E.7641.1.0300                | 3   | 1.5  | 50 | 5  | 6,0   |
| E.7641.1.0350                | 3.5 | 1.75 | 50 | 5  | 6,0   |
| E.7641.1.0400                | 4   | 2    | 54 | 6  | 6,0   |
| E.7641.1.0450                | 4.5 | 2.25 | 54 | 6  | 6,0   |
| E.7641.1.0500                | 5   | 2.5  | 54 | 7  | 6,0   |
| E.7641.1.0600                | 6   | 3    | 54 | 9  | 6,0   |
| E.7641.1.0800                | 8   | 4    | 58 | 12 | 8,0   |
| E.7641.1.1000                | 10  | 5    | 66 | 14 | 10,0  |
| E.7641.1.1200                | 12  | 6    | 73 | 14 | 12,0  |
| E.7641.1.1400                | 14  | 7    | 75 | 16 | 14,0  |
| E.7641.1.1600                | 16  | 8    | 82 | 18 | 16,0  |
| E.7641.1.1800                | 18  | 9    | 92 | 20 | 18,0  |
| E.7641.1.2000                | 20  | 10   | 92 | 22 | 20,0  |



Individuelle Schnittdaten online im  
Schnittdaten-Rechner berechnen lassen:  
Calculate individual cutting  
data online in the cutting data calculator  
[www.nachreiner-schnittdaten.eu](http://www.nachreiner-schnittdaten.eu)

| Materialbezeichnung<br>material description | Bearbeitung<br>Process  | Vc<br>m/min | fz     |             |             |        |        |               |               |               |
|---|-------------------------|-------------|--------|-------------|-------------|--------|--------|---------------|---------------|---------------|
|   |                         |             | ∅ 1.00 | ∅ 2.00-3.50 | ∅ 4.00-5.00 | ∅ 6.00 | ∅ 8.00 | ∅ 10.00-12.00 | ∅ 14.00-16.00 | ∅ 18.00-20.00 |
| PA<br>allg. Stähle<br>General steels        | Schlichten<br>finishing | 360.00      | 0.007  | 0.011       | 0.035       | 0.045  | 0.055  | 0.065         | 0.090         | 0.120         |
|   | Schlichten<br>finishing | 320.00      | 0.007  | 0.011       | 0.035       | 0.045  | 0.055  | 0.065         | 0.090         | 0.120         |
|   | Schlichten<br>finishing | 250.00      | 0.007  | 0.011       | 0.035       | 0.045  | 0.055  | 0.065         | 0.090         | 0.120         |
|   | Schlichten<br>finishing | 210.00      | 0.007  | 0.011       | 0.035       | 0.045  | 0.055  | 0.065         | 0.090         | 0.120         |
|   | Schlichten<br>finishing | 145.00      | 0.005  | 0.007       | 0.025       | 0.032  | 0.040  | 0.045         | 0.060         | 0.080         |

# PRODUCT DATA SHEET



| Materialbezeichnung<br>material description   | Bearbeitung<br>Process  | Vc<br>m/min | fz        |                |                |           |           |                  |                  |                  |  |
|---|-------------------------|-------------|-----------|----------------|----------------|-----------|-----------|------------------|------------------|------------------|--|
|   |                         |             | ∅<br>1.00 | ∅<br>2.00-3.50 | ∅<br>4.00-5.00 | ∅<br>6.00 | ∅<br>8.00 | ∅<br>10.00-12.00 | ∅<br>14.00-16.00 | ∅<br>18.00-20.00 |  |
| PV<br>Vergütungsstähle < 850N/mm <sup>2</sup><br>Tempering steel < 850N/mm <sup>2</sup><br>Vergütungsstähle < 1000N/mm <sup>2</sup><br>Tempering steel < 1000N/mm <sup>2</sup><br>Vergütungsstähle < 1400N/mm <sup>2</sup><br>Tempering steel < 1400N/mm <sup>2</sup> | Schlichten<br>finishing | 250.00      | 0.007     | 0.011          | 0.035          | 0.045     | 0.055     | 0.065            | 0.090            | 0.120            |  |
|   | Schlichten<br>finishing | 210.00      | 0.007     | 0.011          | 0.035          | 0.045     | 0.055     | 0.065            | 0.090            | 0.120            |  |
|   | Schlichten<br>finishing | 145.00      | 0.005     | 0.007          | 0.025          | 0.032     | 0.040     | 0.045            | 0.060            | 0.080            |  |
| M<br>Rost und säurebeständige Stähle<br>Stainless steels<br>Rost und säurebeständige Stähle >700N/mm <sup>2</sup><br>Stainless steels >700N/mm <sup>2</sup>   | Schlichten<br>finishing | 160.00      | 0.005     | 0.007          | 0.025          | 0.032     | 0.040     | 0.045            | 0.060            | 0.070            |  |
|   | Schlichten<br>finishing | 120.00      | 0.005     | 0.007          | 0.025          | 0.032     | 0.040     | 0.045            | 0.060            | 0.070            |  |
| K<br>Gusseisen<br>Cast iron<br>Temperguss<br>Malleable cast iron<br>Gusseisen mit Kugelgraphit<br>Nodular cast iron   | Schlichten<br>finishing | 360.00      | 0.007     | 0.011          | 0.035          | 0.045     | 0.055     | 0.065            | 0.080            | 0.120            |  |
|   | Schlichten<br>finishing | 330.00      | 0.007     | 0.011          | 0.035          | 0.045     | 0.055     | 0.065            | 0.080            | 0.120            |  |
|   | Schlichten<br>finishing | 310.00      | 0.007     | 0.011          | 0.035          | 0.045     | 0.055     | 0.065            | 0.080            | 0.120            |  |
| N<br>AL- und AL-Legierungen<br>AL und AL-alloys<br>AL- und AL-Legierungen<br>AL und AL-alloys<br>AL- und AL-Legierungen >12% Si<br>AL und AL-alloys >12% Si   | Schlichten<br>finishing | 500.00      | 0.007     | 0.011          | 0.035          | 0.045     | 0.055     | 0.065            | 0.090            | 0.120            |  |
|   | Schlichten<br>finishing | 450.00      | 0.007     | 0.011          | 0.035          | 0.045     | 0.055     | 0.065            | 0.090            | 0.120            |  |
|   | Schlichten<br>finishing | 400.00      | 0.007     | 0.011          | 0.035          | 0.045     | 0.055     | 0.065            | 0.090            | 0.120            |  |
| H<br>Kupfer, Messing, Bronze, Rotguss<br>Copper, brass, bronze, red brass<br>gehärtete Stähle 45-55 HRC<br>Hardened steels 45-55 HRC  | Schlichten<br>finishing | 500.00      | 0.007     | 0.011          | 0.035          | 0.045     | 0.055     | 0.065            | 0.090            | 0.120            |  |
|   | Schlichten<br>finishing | 100.00      | 0.005     | 0.007          | 0.025          | 0.032     | 0.040     | 0.045            | 0.060            | 0.080            |  |