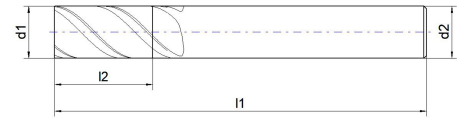
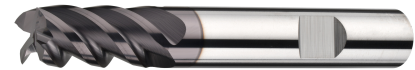


VHM-Universal-Schaftfräser 45° lange Schneide

Solid carbide universal end mills 45°, long cutting edge



| Artikelnummer Article-No. | d1 | l1 | l2 | d2 h6 |
|------------------------------|----|----|----|-------|
| E.7652.1.0300 | 3 | 57 | 8 | 6,0 |
| E.7652.1.0400 | 4 | 57 | 11 | 6,0 |
| E.7652.1.0500 | 5 | 57 | 13 | 6,0 |
| E.7652.1.0600 | 6 | 57 | 13 | 6,0 |
| E.7652.1.0800 | 8 | 63 | 19 | 8,0 |
| E.7652.1.1000 | 10 | 72 | 22 | 10,0 |
| E.7652.1.1200 | 12 | 83 | 26 | 12,0 |
| E.7652.1.1400 | 14 | 83 | 26 | 14,0 |
| E.7652.1.1600 | 16 | 92 | 32 | 16,0 |
| E.7652.1.1800 | 18 | 92 | 32 | 18,0 |



Individuelle Schnittdaten online im
Schnittdaten-Rechner berechnen lassen:
Calculate individual cutting
data online in the cutting data calculator
www.nachreiner-schnittdaten.eu

| Materialbezeichnung material description | Bearbeitung Process | Vc m/min | fz | | | | | | | |
|---|-------------------------|-------------|-----------|----------------|-----------|-----------|------------|------------|------------------|------------|
| | | | ∅ 3.00 | ∅ 4.00-5.00 | ∅ 6.00 | ∅ 8.00 | ∅ 10.00 | ∅ 12.00 | ∅ 14.00-16.00 | ∅ 18.00 |
| PA allg. Stähle General steels | Schruppen roughing | 100.00 | 0.020 | 0.033 | 0.043 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
| | Schlichten finishing | 220.00 | 0.030 | 0.050 | 0.064 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
| | Schruppen roughing | 90.00 | 0.020 | 0.033 | 0.043 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
| | Schlichten finishing | 200.00 | 0.030 | 0.050 | 0.064 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
| | Schruppen roughing | 85.00 | 0.020 | 0.033 | 0.043 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
| | Schlichten finishing | 190.00 | 0.030 | 0.050 | 0.064 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
| | Schruppen roughing | 80.00 | 0.011 | 0.017 | 0.021 | 0.029 | 0.040 | 0.047 | 0.054 | 0.067 |
| | Schlichten finishing | 175.00 | 0.016 | 0.026 | 0.032 | 0.044 | 0.060 | 0.070 | 0.080 | 0.100 |
| | Schruppen roughing | 70.00 | 0.011 | 0.017 | 0.021 | 0.029 | 0.040 | 0.047 | 0.054 | 0.067 |
| | Schlichten finishing | 155.00 | 0.016 | 0.026 | 0.032 | 0.044 | 0.060 | 0.070 | 0.080 | 0.100 |

PRODUCT DATA SHEET



| Materialbezeichnung material description | | Bearbeitung Process | Vc m/min | fz | | | | | | | |
|---|---|-------------------------|-------------|-----------|----------------|-----------|-----------|------------|------------|------------------|------------|
| | | | | ∅ 3.00 | ∅ 4.00-5.00 | ∅ 6.00 | ∅ 8.00 | ∅ 10.00 | ∅ 12.00 | ∅ 14.00-16.00 | ∅ 18.00 |
| PV | Vergütungsstähle < 850N/mm ² Tempering steel < 850N/mm ² | Schruppen roughing | 85.00 | 0.020 | 0.033 | 0.043 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
| | | Schlichten finishing | 190.00 | 0.030 | 0.050 | 0.064 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
| | Vergütungsstähle < 1000N/mm ² Tempering steel < 1000N/mm ² | Schruppen roughing | 75.00 | 0.011 | 0.017 | 0.021 | 0.029 | 0.040 | 0.047 | 0.054 | 0.067 |
| | | Schlichten finishing | 170.00 | 0.016 | 0.026 | 0.032 | 0.044 | 0.060 | 0.070 | 0.080 | 0.100 |
| | Vergütungsstähle < 1400N/mm ² Tempering steel < 1400N/mm ² | Schruppen roughing | 70.00 | 0.011 | 0.017 | 0.021 | 0.029 | 0.040 | 0.047 | 0.054 | 0.067 |
| | | Schlichten finishing | 155.00 | 0.016 | 0.026 | 0.032 | 0.044 | 0.060 | 0.070 | 0.080 | 0.100 |
| M | Rost und säurebeständige Stähle Stainless steels | Schruppen roughing | 55.00 | 0.020 | 0.033 | 0.043 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
| | | Schlichten finishing | 120.00 | 0.030 | 0.050 | 0.064 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
| K | Gusseisen Cast iron | Schruppen roughing | 80.00 | 0.020 | 0.033 | 0.043 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
| | | Schlichten finishing | 180.00 | 0.030 | 0.050 | 0.064 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
| | Temperguss Malleable cast iron | Schruppen roughing | 65.00 | 0.020 | 0.033 | 0.043 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
| | | Schlichten finishing | 150.00 | 0.030 | 0.050 | 0.064 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
| | Gusseisen mit Kugelgraphit Nodular cast iron | Schruppen roughing | 65.00 | 0.020 | 0.033 | 0.043 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
| | | Schlichten finishing | 140.00 | 0.030 | 0.050 | 0.064 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
| N | AL- und AL-Legierungen AL und AL-alloys | Schruppen roughing | 110.00 | 0.020 | 0.033 | 0.043 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
| | | Schlichten finishing | 250.00 | 0.030 | 0.050 | 0.064 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
| | AL- und AL-Legierungen AL und AL-alloys | Schruppen roughing | 100.00 | 0.020 | 0.033 | 0.428 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
| | | Schlichten finishing | 220.00 | 0.030 | 0.050 | 0.640 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
| | AL- und AL-Legierungen >12% Si AL und AL-alloys >12% Si | Schruppen roughing | 90.00 | 0.020 | 0.033 | 0.043 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
| | | Schlichten finishing | 200.00 | 0.030 | 0.050 | 0.064 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
| | Kupfer, Messing, Bronze, Rotguss Copper, brass, bronze, red brass | Schruppen roughing | 90.00 | 0.020 | 0.033 | 0.043 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
| | | Schlichten finishing | 200.00 | 0.030 | 0.050 | 0.064 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |