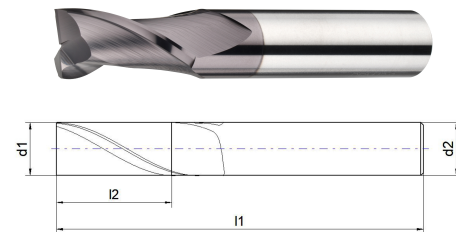
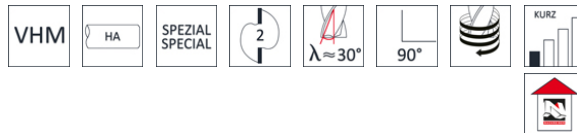


VHM-Universal-Schaftfräser 30°, kurz

Solid carbide universal end mills 30°, short



| Artikelnummer Article-No. | d1 | l1 | l2 | d2 h6 |
|------------------------------|----|-----|----|-------|
| E.7666.1.0100 | 1 | 50 | 5 | 6,0 |
| E.7666.1.0200 | 2 | 50 | 6 | 6,0 |
| E.7666.1.0300 | 3 | 50 | 6 | 6,0 |
| E.7666.1.0400 | 4 | 50 | 8 | 6,0 |
| E.7666.1.0500 | 5 | 50 | 8 | 6,0 |
| E.7666.1.0600 | 6 | 50 | 16 | 6,0 |
| E.7666.1.0800 | 8 | 60 | 20 | 8,0 |
| E.7666.1.1000 | 10 | 70 | 22 | 10,0 |
| E.7666.1.1200 | 12 | 70 | 22 | 12,0 |
| E.7666.1.1600 | 16 | 75 | 25 | 16,0 |
| E.7666.1.2000 | 20 | 100 | 32 | 20,0 |



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 | | | | | | | | |
|---|-------------------------|-------------|--------|-------------|-------------|--------|--------|---------------|---------|---------|--|
| | | | ∅ 1.00 | ∅ 2.00-3.00 | ∅ 4.00-5.00 | ∅ 6.00 | ∅ 8.00 | ∅ 10.00-12.00 | ∅ 16.00 | ∅ 20.00 | |
| PA allg. Stähle General steels | Schruppen roughing | 70.00 | 0.011 | 0.020 | 0.033 | 0.043 | 0.060 | 0.080 | 0.087 | 0.094 | |
| | Schlichten finishing | 160.00 | 0.017 | 0.030 | 0.050 | 0.064 | 0.090 | 0.120 | 0.130 | 0.140 | |
| | Schruppen roughing | 70.00 | 0.010 | 0.015 | 0.024 | 0.029 | 0.043 | 0.056 | 0.074 | 0.087 | |
| | Schlichten finishing | 160.00 | 0.015 | 0.022 | 0.036 | 0.044 | 0.064 | 0.084 | 0.110 | 0.130 | |
| | Schruppen roughing | 70.00 | 0.010 | 0.015 | 0.024 | 0.029 | 0.043 | 0.056 | 0.074 | 0.087 | |
| | Schlichten finishing | 160.00 | 0.015 | 0.022 | 0.036 | 0.044 | 0.064 | 0.084 | 0.110 | 0.130 | |
| | Schruppen roughing | 65.00 | 0.007 | 0.011 | 0.017 | 0.021 | 0.029 | 0.040 | 0.054 | 0.067 | |
| | Schlichten finishing | 140.00 | 0.010 | 0.016 | 0.026 | 0.032 | 0.044 | 0.060 | 0.080 | 0.100 | |
| | Schruppen roughing | 60.00 | 0.007 | 0.011 | 0.017 | 0.021 | 0.029 | 0.040 | 0.054 | 0.067 | |
| | Schlichten finishing | 130.00 | 0.010 | 0.016 | 0.026 | 0.032 | 0.044 | 0.060 | 0.080 | 0.100 | |

PRODUCT DATA SHEET



| Materialbezeichnung material description | | Bearbeitung Process | Vc m/min | fz | | | | | | | |
|---|---|-------------------------|-------------|-----------|----------------|----------------|-----------|-----------|------------------|------------|------------|
| | | | | ∅ 1.00 | ∅ 2.00-3.00 | ∅ 4.00-5.00 | ∅ 6.00 | ∅ 8.00 | ∅ 10.00-12.00 | ∅ 16.00 | ∅ 20.00 |
| PV | Vergütungsstähle < 850N/mm ² Tempering steel < 850N/mm ² | Schruppen roughing | 70.00 | 0.010 | 0.015 | 0.024 | 0.029 | 0.043 | 0.056 | 0.074 | 0.087 |
| | | Schlichten finishing | 160.00 | 0.015 | 0.022 | 0.036 | 0.044 | 0.064 | 0.084 | 0.110 | 0.130 |
| | Vergütungsstähle < 1000N/mm ² Tempering steel < 1000N/mm ² | Schruppen roughing | 70.00 | 0.007 | 0.011 | 0.017 | 0.021 | 0.029 | 0.040 | 0.054 | 0.067 |
| | | Schlichten finishing | 160.00 | 0.010 | 0.016 | 0.026 | 0.032 | 0.044 | 0.060 | 0.080 | 0.100 |
| | Vergütungsstähle < 1400N/mm ² Tempering steel < 1400N/mm ² | Schruppen roughing | 60.00 | 0.007 | 0.011 | 0.017 | 0.021 | 0.029 | 0.040 | 0.054 | 0.067 |
| | | Schlichten finishing | 130.00 | 0.010 | 0.016 | 0.026 | 0.032 | 0.044 | 0.060 | 0.080 | 0.100 |
| | Vergütungsstähle > 1400N/mm ² Tempering steel > 1400N/mm ² | Schruppen roughing | 60.00 | 0.007 | 0.011 | 0.017 | 0.021 | 0.029 | 0.040 | 0.054 | 0.067 |
| | | Schlichten finishing | 130.00 | 0.010 | 0.016 | 0.026 | 0.032 | 0.044 | 0.060 | 0.080 | 0.100 |
| M | Rost und säurebeständige Stähle Stainless steels | Schruppen roughing | 35.00 | 0.010 | 0.015 | 0.024 | 0.029 | 0.043 | 0.056 | 0.074 | 0.087 |
| | | Schlichten finishing | 80.00 | 0.015 | 0.022 | 0.036 | 0.044 | 0.064 | 0.084 | 0.110 | 0.130 |
| | Rost und säurebeständige Stähle >700N/mm ² Stainless steels >700N/mm ² | Schruppen roughing | 25.00 | 0.010 | 0.015 | 0.024 | 0.029 | 0.043 | 0.056 | 0.074 | 0.087 |
| | | Schlichten finishing | 60.00 | 0.015 | 0.022 | 0.036 | 0.044 | 0.064 | 0.084 | 0.110 | 0.130 |
| K | Gusseisen Cast iron | Schruppen roughing | 80.00 | 0.010 | 0.015 | 0.024 | 0.029 | 0.043 | 0.056 | 0.074 | 0.094 |
| | | Schlichten finishing | 180.00 | 0.015 | 0.022 | 0.036 | 0.044 | 0.064 | 0.084 | 0.110 | 0.140 |
| | Temperguss Malleable cast iron | Schruppen roughing | 65.00 | 0.010 | 0.015 | 0.024 | 0.029 | 0.043 | 0.056 | 0.074 | 0.094 |
| | | Schlichten finishing | 150.00 | 0.015 | 0.022 | 0.036 | 0.044 | 0.064 | 0.084 | 0.110 | 0.140 |
| | Gusseisen mit Kugelgraphit Nodular cast iron | Schruppen roughing | 65.00 | 0.010 | 0.015 | 0.024 | 0.029 | 0.043 | 0.056 | 0.074 | 0.094 |
| | | Schlichten finishing | 140.00 | 0.015 | 0.022 | 0.036 | 0.044 | 0.064 | 0.084 | 0.110 | 0.140 |
| N | AL- und AL-Legierungen AL und AL-alloys | Schruppen roughing | 110.00 | 0.010 | 0.015 | 0.024 | 0.029 | 0.043 | 0.056 | 0.074 | 0.094 |
| | | Schlichten finishing | 250.00 | 0.015 | 0.022 | 0.036 | 0.044 | 0.064 | 0.084 | 0.110 | 0.140 |
| | AL- und AL-Legierungen AL und AL-alloys | Schruppen roughing | 110.00 | 0.010 | 0.015 | 0.024 | 0.029 | 0.043 | 0.056 | 0.074 | 0.094 |
| | | Schlichten finishing | 250.00 | 0.015 | 0.022 | 0.036 | 0.044 | 0.064 | 0.084 | 0.110 | 0.140 |
| | AL- und AL-Legierungen >12% Si AL und AL-alloys >12% Si | Schruppen roughing | 100.00 | 0.010 | 0.015 | 0.024 | 0.029 | 0.043 | 0.056 | 0.074 | 0.094 |
| | | Schlichten finishing | 220.00 | 0.015 | 0.022 | 0.036 | 0.044 | 0.064 | 0.084 | 0.110 | 0.140 |
| | Kupfer, Messing, Bronze, Rotguss Copper, brass, bronze, red brass | Schruppen roughing | 90.00 | 0.010 | 0.015 | 0.024 | 0.029 | 0.043 | 0.056 | 0.074 | 0.094 |
| | | Schlichten finishing | 200.00 | 0.015 | 0.022 | 0.036 | 0.044 | 0.064 | 0.084 | 0.110 | 0.140 |
| | Kunststoff Thermoplaste | Schruppen roughing | 90.00 | 0.010 | 0.015 | 0.024 | 0.029 | 0.043 | 0.056 | 0.074 | 0.094 |
| | | Schlichten finishing | 200.00 | 0.015 | 0.022 | 0.036 | 0.044 | 0.064 | 0.084 | 0.110 | 0.140 |
| | Duroplaste Duroplast | Schruppen roughing | 90.00 | 0.010 | 0.015 | 0.024 | 0.029 | 0.043 | 0.056 | 0.074 | 0.094 |
| | | Schlichten finishing | 200.00 | 0.015 | 0.022 | 0.036 | 0.044 | 0.064 | 0.084 | 0.110 | 0.140 |