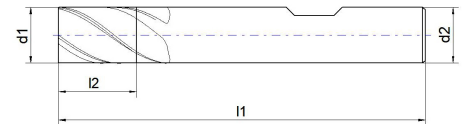
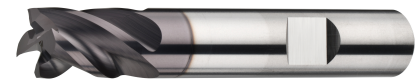
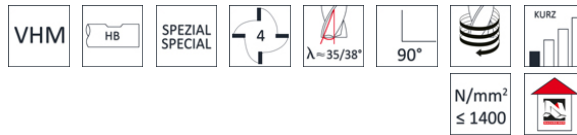


VHM-HPC-Superstar-Fräser (ungleiche Teilung) kurz, scharfkantig

Solid carbide HPC Superstar end mills (unequal pitch), short, sharp corner



P	P	M	K	N	S	H
●	●		●			

Artikelnummer Article-No.	d1	l1	l2	d2 h6
E.7675HK.1S.0300	3	54	6	6,0
E.7675HK.1S.0400	4	54	8	6,0
E.7675HK.1S.0500	5	54	9	6,0
E.7675HK.1S.0600	6	54	10	6,0
E.7675HK.1S.0700	7	58	12	8,0
E.7675HK.1S.0800	8	58	12	8,0
E.7675HK.1S.0900	9	66	14	10,0
E.7675HK.1S.1000	10	66	14	10,0
E.7675HK.1S.1100	11	73	16	12,0
E.7675HK.1S.1200	12	73	16	12,0
E.7675HK.1S.1300	13	75	18	14,0
E.7675HK.1S.1400	14	75	18	14,0
E.7675HK.1S.1600	16	82	22	16,0



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	∅ 7.00-9.00	∅ 10.00-13.00	∅ 14.00-16.00
PA allg. Stähle General steels	Schruppen roughing	125.00	0.010	0.017	0.029	0.038	0.063	0.084
	Schlichten finishing	180.00	0.012	0.020	0.035	0.045	0.075	0.100
	Schruppen roughing	105.00	0.008	0.013	0.021	0.027	0.044	0.059
	Schlichten finishing	150.00	0.009	0.015	0.025	0.032	0.052	0.070
	Schruppen roughing	80.00	0.008	0.013	0.021	0.027	0.044	0.059
	Schlichten finishing	110.00	0.009	0.015	0.025	0.032	0.052	0.070

PRODUCT DATA SHEET



Materialbezeichnung material description		Bearbeitung Process	Vc m/min	fz					
				∅ 3.00	∅ 4.00	∅ 5.00-6.00	∅ 7.00-9.00	∅ 10.00-13.00	∅ 14.00-16.00
PV	Vergütungsstähle < 850N/mm² Tempering steel < 850N/mm ²	Schruppen roughing	120.00	0.010	0.017	0.029	0.038	0.063	0.084
		Schlichten finishing	170.00	0.012	0.020	0.035	0.045	0.075	0.100
	Vergütungsstähle < 1000N/mm² Tempering steel < 1000N/mm ²	Schruppen roughing	105.00	0.008	0.013	0.021	0.027	0.044	0.059
		Schlichten finishing	150.00	0.009	0.015	0.025	0.032	0.052	0.070
	Vergütungsstähle < 1400N/mm² Tempering steel < 1400N/mm ²	Schruppen roughing	80.00	0.008	0.013	0.021	0.027	0.044	0.059
		Schlichten finishing	110.00	0.009	0.015	0.025	0.032	0.052	0.070
Vergütungsstähle > 1400N/mm² Tempering steel > 1400N/mm ²	Schruppen roughing	80.00	0.008	0.013	0.021	0.027	0.044	0.059	
	Schlichten finishing	110.00	0.009	0.015	0.025	0.032	0.052	0.070	
K	Gusseisen Cast iron	Schruppen roughing	140.00	0.010	0.029	0.034	0.046	0.074	0.084
		Schlichten finishing	200.00	0.012	0.035	0.040	0.055	0.088	0.100
	Temperguss Malleable cast iron	Schruppen roughing	120.00	0.010	0.017	0.029	0.038	0.063	0.084
		Schlichten finishing	170.00	0.012	0.020	0.035	0.045	0.075	0.100
	Gusseisen mit Kugelgraphit Nodular cast iron	Schruppen roughing	115.00	0.009	0.013	0.025	0.034	0.042	0.059
		Schlichten finishing	160.00	0.011	0.015	0.030	0.040	0.050	0.070