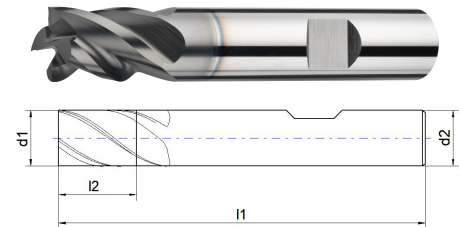
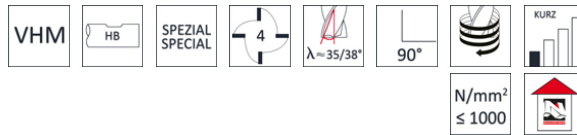


VHM-HPC-Superstar-Fräser (ungleiche Teilung) kurz, scharfkantig

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.7675WK.1S.0300	3	54	6	6,0
E.7675WK.1S.0400	4	54	8	6,0
E.7675WK.1S.0500	5	54	9	6,0
E.7675WK.1S.0600	6	54	10	6,0
E.7675WK.1S.0700	7	58	12	8,0
E.7675WK.1S.0800	8	58	12	8,0
E.7675WK.1S.1000	10	66	14	10,0
E.7675WK.1S.1200	12	73	16	12,0
E.7675WK.1S.1300	13	75	18	14,0
E.7675WK.1S.1400	14	75	18	14,0
E.7675WK.1S.1600	16	82	22	16,0
E.7675WK.1S.1800	18	84	24	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	∅ 6.00-7.00	∅ 8.00	∅ 10.00	∅ 12.00-14.00	∅ 16.00-18.00	
PA allg. Stähle General steels	Schruppen roughing	165.00	0.011	0.021	0.029	0.063	0.093	0.101	0.118	
	Schlichten finishing	230.00	0.013	0.025	0.035	0.075	0.110	0.120	0.140	
	Schruppen roughing	150.00	0.011	0.021	0.029	0.063	0.093	0.101	0.118	
	Schlichten finishing	210.00	0.013	0.025	0.035	0.075	0.110	0.120	0.140	
	Schruppen roughing	135.00	0.011	0.021	0.029	0.063	0.093	0.101	0.118	
	Schlichten finishing	190.00	0.013	0.025	0.035	0.075	0.110	0.120	0.140	
allg. Stähle General steels	Schruppen roughing	105.00	0.008	0.017	0.024	0.035	0.044	0.051	0.059	
	Schlichten finishing	150.00	0.009	0.020	0.029	0.042	0.052	0.060	0.070	

PRODUCT DATA SHEET



Materialbezeichnung material description		Bearbeitung Process	Vc m/min	fz						
				∅ 3.00	∅ 4.00-5.00	∅ 6.00-7.00	∅ 8.00	∅ 10.00	∅ 12.00-14.00	∅ 16.00-18.00
PV	Vergütungsstähle < 850N/mm ² Tempering steel < 850N/mm ²	Schruppen roughing	135.00	0.011	0.021	0.029	0.063	0.093	0.101	0.118
		Schlichten finishing	190.00	0.013	0.025	0.035	0.075	0.110	0.120	0.140
	Vergütungsstähle < 1000N/mm ² Tempering steel < 1000N/mm ²	Schruppen roughing	105.00	0.008	0.017	0.024	0.035	0.044	0.051	0.059
		Schlichten finishing	150.00	0.009	0.020	0.029	0.042	0.052	0.060	0.070
M	Rost und säurebeständige Stähle Stainless steels	Schruppen roughing	85.00	0.008	0.014	0.029	0.051	0.059	0.067	0.080
		Schlichten finishing	120.00	0.010	0.017	0.035	0.060	0.070	0.080	0.095
	Rost und säurebeständige Stähle >700N/mm ² Stainless steels >700N/mm ²	Schruppen roughing	65.00	0.008	0.013	0.027	0.046	0.051	0.059	0.071
		Schlichten finishing	90.00	0.009	0.015	0.032	0.055	0.060	0.070	0.084
K	Gusseisen Cast iron	Schruppen roughing	135.00	0.010	0.017	0.029	0.038	0.063	0.084	0.101
		Schlichten finishing	190.00	0.012	0.020	0.035	0.045	0.075	0.100	0.120
	Temperguss Malleable cast iron	Schruppen roughing	115.00	0.010	0.017	0.029	0.038	0.063	0.084	0.101
		Schlichten finishing	160.00	0.012	0.020	0.035	0.045	0.075	0.100	0.120
	Gusseisen mit Kugelgraphit Nodular cast iron	Schruppen roughing	100.00	0.010	0.017	0.029	0.038	0.063	0.084	0.101
		Schlichten finishing	140.00	0.012	0.020	0.035	0.045	0.075	0.100	0.120
S	Nickelbasierende Stähle Nickel based alloys	Schruppen roughing	25.00	0.005	0.008	0.010	0.017	0.021	0.029	0.038
		Schlichten finishing	35.00	0.006	0.009	0.012	0.020	0.025	0.035	0.045
	Titan Titanium	Schruppen roughing	35.00	0.006	0.008	0.013	0.021	0.027	0.044	0.051
		Schlichten finishing	50.00	0.007	0.009	0.015	0.025	0.032	0.052	0.060