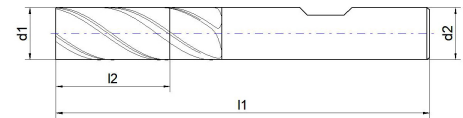
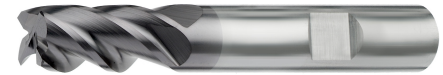
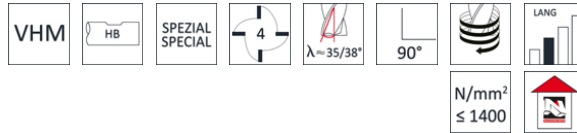


VHM-HPC-Superstar-Fräser (ungleiche Teilung) lang, scharfkantig

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



Artikelnummer Article-No.	d1	l1	l2	d2 h6
E.7676HL.1S.0300	3	57	8	6,0
E.7676HL.1S.0400	4	57	11	6,0
E.7676HL.1S.0500	5	57	13	6,0
E.7676HL.1S.0600	6	57	13	6,0
E.7676HL.1S.0700	7	63	19	8,0
E.7676HL.1S.0800	8	63	19	8,0
E.7676HL.1S.0900	9	72	22	10,0
E.7676HL.1S.1000	10	72	22	10,0
E.7676HL.1S.1200	12	83	26	12,0
E.7676HL.1S.1400	14	83	26	14,0
E.7676HL.1S.1600	16	92	32	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	∅ 8.00-9.00	∅ 10.00	∅ 12.00-14.00	∅ 16.00
PA allg. Stähle General steels	Schruppen roughing	140.00	0.012	0.019	0.034	0.046	0.059	0.072	0.084
	Schlichten finishing	200.00	0.014	0.023	0.040	0.055	0.070	0.085	0.100
	Schruppen roughing	125.00	0.010	0.017	0.029	0.038	0.053	0.072	0.084
	Schlichten finishing	180.00	0.012	0.020	0.035	0.045	0.063	0.085	0.100
	Schruppen roughing	115.00	0.010	0.017	0.029	0.038	0.053	0.072	0.084
	Schlichten finishing	160.00	0.012	0.020	0.035	0.045	0.063	0.085	0.100
allg. Stähle General steels	Schruppen roughing	85.00	0.008	0.013	0.025	0.038	0.051	0.067	0.076
	Schlichten finishing	120.00	0.010	0.015	0.030	0.045	0.060	0.080	0.090

PRODUCT DATA SHEET



Materialbezeichnung material description		Bearbeitung Process	Vc m/min	fz						
				∅ 3.00	∅ 4.00-5.00	∅ 6.00-7.00	∅ 8.00-9.00	∅ 10.00	∅ 12.00-14.00	∅ 16.00
PV	Vergütungsstähle < 850N/mm ² Tempering steel < 850N/mm ²	Schruppen roughing	125.00	0.010	0.017	0.029	0.038	0.053	0.072	0.084
		Schlichten finishing	180.00	0.012	0.020	0.035	0.045	0.063	0.085	0.100
	Vergütungsstähle < 1000N/mm ² Tempering steel < 1000N/mm ²	Schruppen roughing	115.00	0.010	0.017	0.029	0.038	0.053	0.072	0.084
		Schlichten finishing	160.00	0.012	0.020	0.035	0.045	0.063	0.085	0.100
	Vergütungsstähle < 1400N/mm ² Tempering steel < 1400N/mm ²	Schruppen roughing	85.00	0.008	0.013	0.025	0.038	0.051	0.067	0.076
		Schlichten finishing	120.00	0.010	0.015	0.030	0.045	0.060	0.080	0.090
	Vergütungsstähle > 1400N/mm ² Tempering steel > 1400N/mm ²	Schruppen roughing	85.00	0.008	0.013	0.025	0.038	0.051	0.067	0.076
		Schlichten finishing	120.00	0.010	0.015	0.030	0.045	0.060	0.080	0.090
K	Gusseisen Cast iron	Schruppen roughing	125.00	0.010	0.017	0.027	0.035	0.055	0.072	0.084
		Schlichten finishing	180.00	0.012	0.020	0.032	0.042	0.065	0.085	0.100
	Temperguss Malleable cast iron	Schruppen roughing	115.00	0.010	0.017	0.027	0.035	0.055	0.072	0.084
		Schlichten finishing	160.00	0.012	0.020	0.032	0.042	0.065	0.085	0.100
	Gusseisen mit Kugelgraphit Nodular cast iron	Schruppen roughing	100.00	0.008	0.017	0.025	0.034	0.052	0.067	0.080
		Schlichten finishing	140.00	0.010	0.020	0.030	0.040	0.062	0.080	0.095