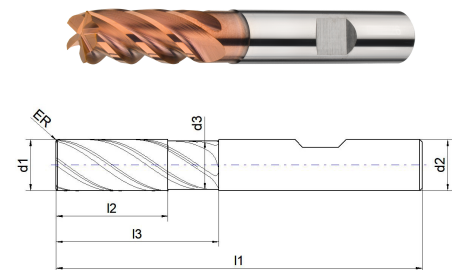


VHM-HPC-Superstar Plus-Fräser (ungleiche Teilung) abgesetzt mit Schutzeckenradius

Solid carbide HPC Superstar Plus end mills (unequal pitch), reduced neck, with corner radius



| | | | | | | |
|---|---|---|---|---|---|---|
| P | P | M | K | N | S | H |
| ● | ● | | ● | | ● | |



| Artikelnummer Article-No. | d1 | CPR | d3 | l1 | l2 | l3 | d2 h6 |
|------------------------------|----|------|------|-----|----|----|-------|
| E.7768.1.0300 | 3 | 0.13 | 2.8 | 57 | 8 | 21 | 6,0 |
| E.7768.1.0400 | 4 | 0.18 | 3.6 | 57 | 8 | 21 | 6,0 |
| E.7768.1.0500 | 5 | 0.2 | 4.6 | 57 | 13 | 21 | 6,0 |
| E.7768.1.0600 | 6 | 0.2 | 5.5 | 57 | 13 | 21 | 6,0 |
| E.7768.1.0800 | 8 | 0.25 | 7.5 | 63 | 19 | 27 | 8,0 |
| E.7768.1.1000 | 10 | 0.3 | 9.5 | 72 | 22 | 32 | 10,0 |
| E.7768.1.1200 | 12 | 0.3 | 11.5 | 83 | 26 | 38 | 12,0 |
| E.7768.1.1400 | 14 | 0.3 | 13.5 | 83 | 26 | 38 | 14,0 |
| E.7768.1.1600 | 16 | 0.4 | 15.5 | 92 | 32 | 44 | 16,0 |
| E.7768.1.2000 | 20 | 0.5 | 19.5 | 104 | 38 | 54 | 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 | | | | | | | | | |
|---|-------------------------|-------------|-----------|----------------|-----------|-----------|------------|------------|------------|------------|------------|--|
| | | | ∅ 3.00 | ∅ 4.00-5.00 | ∅ 6.00 | ∅ 8.00 | ∅ 10.00 | ∅ 12.00 | ∅ 14.00 | ∅ 16.00 | ∅ 20.00 | |
| PA allg. Stähle General steels | Schruppen roughing | 180.00 | 0.011 | 0.023 | 0.032 | 0.054 | 0.072 | 0.081 | 0.090 | 0.108 | 0.131 | |
| | Schlichten finishing | 220.00 | 0.012 | 0.025 | 0.035 | 0.060 | 0.080 | 0.090 | 0.100 | 0.120 | 0.145 | |
| allg. Stähle General steels | Schruppen roughing | 165.00 | 0.011 | 0.023 | 0.032 | 0.054 | 0.072 | 0.081 | 0.090 | 0.108 | 0.131 | |
| | Schlichten finishing | 200.00 | 0.012 | 0.025 | 0.035 | 0.060 | 0.080 | 0.090 | 0.100 | 0.120 | 0.145 | |
| allg. Stähle General steels | Schruppen roughing | 80.00 | 0.008 | 0.018 | 0.027 | 0.041 | 0.054 | 0.063 | 0.072 | 0.090 | 0.104 | |
| | Schlichten finishing | 100.00 | 0.009 | 0.020 | 0.030 | 0.045 | 0.060 | 0.070 | 0.080 | 0.100 | 0.115 | |

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 | ∅ 20.00 |
| PV | Vergütungsstähle < 850N/mm² Tempering steel < 850N/mm ² | Schruppen roughing | 165.00 | 0.011 | 0.023 | 0.032 | 0.050 | 0.072 | 0.081 | 0.090 | 0.108 | 0.131 |
| | | Schlichten finishing | 200.00 | 0.012 | 0.025 | 0.035 | 0.055 | 0.080 | 0.090 | 0.100 | 0.120 | 0.145 |
| | Vergütungsstähle < 1000N/mm² Tempering steel < 1000N/mm ² | Schruppen roughing | 145.00 | 0.011 | 0.023 | 0.032 | 0.050 | 0.072 | 0.081 | 0.090 | 0.108 | 0.131 |
| | | Schlichten finishing | 180.00 | 0.012 | 0.025 | 0.035 | 0.055 | 0.080 | 0.090 | 0.100 | 0.120 | 0.145 |
| | Vergütungsstähle < 1400N/mm² Tempering steel < 1400N/mm ² | Schruppen roughing | 80.00 | 0.008 | 0.018 | 0.027 | 0.045 | 0.054 | 0.063 | 0.072 | 0.081 | 0.099 |
| | | Schlichten finishing | 100.00 | 0.009 | 0.020 | 0.030 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.110 |
| | Vergütungsstähle > 1400N/mm² Tempering steel > 1400N/mm ² | Schruppen roughing | 80.00 | 0.008 | 0.018 | 0.027 | 0.045 | 0.054 | 0.063 | 0.072 | 0.081 | 0.099 |
| | | Schlichten finishing | 100.00 | 0.009 | 0.020 | 0.030 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.110 |
| K | Gusseisen Cast iron | Schruppen roughing | 155.00 | 0.014 | 0.023 | 0.032 | 0.054 | 0.072 | 0.081 | 0.090 | 0.108 | 0.127 |
| | | Schlichten finishing | 190.00 | 0.015 | 0.025 | 0.035 | 0.060 | 0.080 | 0.090 | 0.100 | 0.120 | 0.140 |
| | Temperguss Malleable cast iron | Schruppen roughing | 115.00 | 0.014 | 0.023 | 0.032 | 0.054 | 0.072 | 0.081 | 0.090 | 0.108 | 0.127 |
| | | Schlichten finishing | 140.00 | 0.015 | 0.025 | 0.035 | 0.060 | 0.080 | 0.090 | 0.100 | 0.120 | 0.140 |
| | Gusseisen mit Kugelgraphit Nodular cast iron | Schruppen roughing | 105.00 | 0.014 | 0.018 | 0.029 | 0.050 | 0.065 | 0.072 | 0.081 | 0.099 | 0.108 |
| | | Schlichten finishing | 130.00 | 0.015 | 0.020 | 0.032 | 0.055 | 0.072 | 0.080 | 0.090 | 0.110 | 0.120 |
| S | Nickelbasierende Stähle Nickel based alloys | Schruppen roughing | 55.00 | 0.006 | 0.008 | 0.027 | 0.036 | 0.054 | 0.057 | 0.059 | 0.063 | 0.068 |
| | | Schlichten finishing | 70.00 | 0.007 | 0.009 | 0.030 | 0.040 | 0.060 | 0.063 | 0.065 | 0.070 | 0.075 |