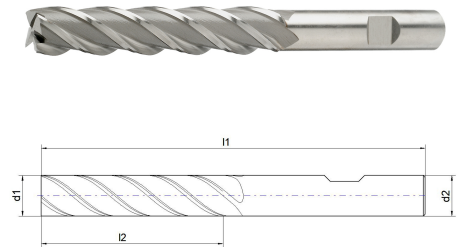
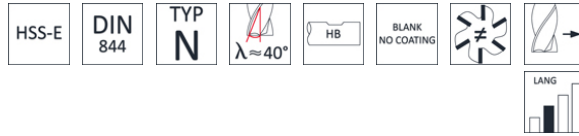


## HSSE-Schaftfräser lang HSSE end mills, long



Artikelnummer Article-No.	d1 k10	l1	l2	d2 h6	flutes
E.9614.0.0600	6	68	24	6,0	4
E.9614.0.0800	8	88	38	10,0	4
E.9614.0.1000	10	95	45	10,0	4
E.9614.0.1200	12	110	53	12,0	4
E.9614.0.1400	14	110	53	12,0	4
E.9614.0.1600	16	123	63	16,0	4
E.9614.0.1800	18	123	63	16,0	4
E.9614.0.2000	20	141	75	20,0	4
E.9614.0.2200	22	141	75	20,0	5
E.9614.0.2500	25	166	90	25,0	5



Individuelle Schnittdaten online im  
Schnittdaten-Rechner berechnen lassen:  
Calculate individual cutting  
data online in the cutting data calculator  
[www.nachreiner-schnittdaten.eu](http://www.nachreiner-schnittdaten.eu)

Materialbezeichnung material description	Bearbeitung Process	Vc m/min	fz								
			∅ 6.00	∅ 8.00	∅ 10.00	∅ 12.00-14.00	∅ 16.00	∅ 18.00	∅ 20.00-22.00	∅ 25.00	
PA allg. Stähle General steels	Schruppen roughing	30.00	0.012	0.017	0.022	0.027	0.035	0.041	0.045	0.057	
	Schlichten finishing	45.00	0.015	0.021	0.028	0.034	0.044	0.051	0.057	0.071	
	Schruppen roughing	25.00	0.012	0.017	0.022	0.027	0.035	0.041	0.045	0.057	
	Schlichten finishing	40.00	0.015	0.021	0.028	0.034	0.044	0.051	0.057	0.071	
	Schruppen roughing	20.00	0.012	0.017	0.022	0.027	0.035	0.041	0.045	0.057	
	Schlichten finishing	35.00	0.015	0.021	0.028	0.034	0.044	0.051	0.057	0.071	
PV Vergütungsstähle < 850N/mm <sup>2</sup> Tempering steel < 850N/mm <sup>2</sup>	Schruppen roughing	20.00	0.012	0.017	0.022	0.027	0.035	0.041	0.045	0.057	
	Schlichten finishing	35.00	0.015	0.021	0.028	0.034	0.044	0.051	0.057	0.071	
	Schruppen roughing	20.00	0.012	0.017	0.022	0.027	0.035	0.041	0.045	0.057	
	Schlichten finishing	30.00	0.015	0.021	0.028	0.034	0.044	0.051	0.057	0.071	

# PRODUCT DATA SHEET



Materialbezeichnung material description		Bearbeitung Process	Vc m/min	fz							
				∅ 6.00	∅ 8.00	∅ 10.00	∅ 12.00-14.00	∅ 16.00	∅ 18.00	∅ 20.00-22.00	∅ 25.00
K	Gusseisen Cast iron	Schruppen roughing	20.00	0.012	0.017	0.022	0.027	0.035	0.041	0.045	0.057
		Schlichten finishing	35.00	0.015	0.021	0.028	0.034	0.044	0.051	0.057	0.071
	Temperguss Malleable cast iron	Schruppen roughing	20.00	0.012	0.017	0.022	0.027	0.035	0.041	0.045	0.057
		Schlichten finishing	30.00	0.015	0.021	0.028	0.034	0.044	0.051	0.057	0.071
N	AL- und AL-Legierungen AL and AL-alloys	Schruppen roughing	190.00	0.023	0.030	0.037	0.045	0.060	0.068	0.076	0.095
		Schlichten finishing	300.00	0.029	0.038	0.047	0.057	0.075	0.085	0.095	0.120
	AL- und AL-Legierungen AL and AL-alloys	Schruppen roughing	145.00	0.023	0.030	0.037	0.045	0.060	0.068	0.076	0.095
		Schlichten finishing	230.00	0.029	0.038	0.047	0.057	0.075	0.085	0.095	0.120
	AL- und AL-Legierungen >12% Si AL and AL-alloys >12% Si	Schruppen roughing	100.00	0.023	0.030	0.037	0.045	0.060	0.068	0.076	0.095
		Schlichten finishing	160.00	0.029	0.038	0.047	0.057	0.075	0.085	0.095	0.120