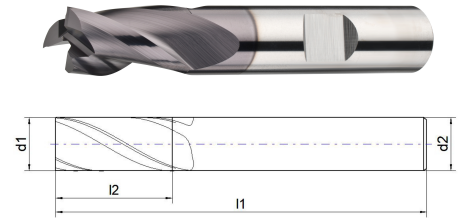
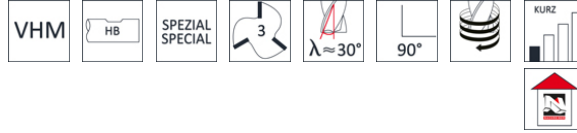


## VHM-Universal-Schaftfräser 30°, kurz

Solid carbide universal end mills 30°, short



| Artikelnummer<br>Article-No. | d1  | l1  | l2 | d2 h6 |
|------------------------------|-----|-----|----|-------|
| E.7623.1.0100                | 1   | 50  | 3  | 6,0   |
| E.7623.1.0150                | 1.5 | 50  | 4  | 6,0   |
| E.7623.1.0200                | 2   | 50  | 6  | 6,0   |
| E.7623.1.0300                | 3   | 50  | 6  | 6,0   |
| E.7623.1.0400                | 4   | 50  | 8  | 6,0   |
| E.7623.1.0500                | 5   | 50  | 8  | 6,0   |
| E.7623.1.0600                | 6   | 50  | 16 | 6,0   |
| E.7623.1.0800                | 8   | 63  | 20 | 8,0   |
| E.7623.1.1000                | 10  | 72  | 22 | 10,0  |
| E.7623.1.1200                | 12  | 73  | 22 | 12,0  |
| E.7623.1.1600                | 16  | 82  | 25 | 16,0  |
| E.7623.1.2000                | 20  | 104 | 32 | 20,0  |



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<br>material description | Bearbeitung<br>Process  | Vc<br>m/min | fz             |                |                |           |           |            |            |            |            |  |
|---|-------------------------|-------------|----------------|----------------|----------------|-----------|-----------|------------|------------|------------|------------|--|
|   |                         |             | ∅<br>1.00-1.50 | ∅<br>2.00-3.00 | ∅<br>4.00-5.00 | ∅<br>6.00 | ∅<br>8.00 | ∅<br>10.00 | ∅<br>12.00 | ∅<br>16.00 | ∅<br>20.00 |  |
| PA<br>allg. Stähle<br>General steels        | Schruppen<br>roughing   | 100.00      | 0.007          | 0.020          | 0.033          | 0.044     | 0.050     | 0.060      | 0.080      | 0.107      | 0.134      |  |
|   | Schlichten<br>finishing | 220.00      | 0.010          | 0.030          | 0.050          | 0.065     | 0.075     | 0.090      | 0.120      | 0.160      | 0.200      |  |
|   | Schruppen<br>roughing   | 90.00       | 0.007          | 0.020          | 0.033          | 0.044     | 0.050     | 0.060      | 0.080      | 0.107      | 0.134      |  |
|   | Schlichten<br>finishing | 200.00      | 0.010          | 0.030          | 0.050          | 0.065     | 0.075     | 0.090      | 0.120      | 0.160      | 0.200      |  |
|   | Schruppen<br>roughing   | 85.00       | 0.007          | 0.020          | 0.033          | 0.044     | 0.050     | 0.060      | 0.080      | 0.107      | 0.134      |  |
|   | Schlichten<br>finishing | 190.00      | 0.010          | 0.030          | 0.050          | 0.065     | 0.075     | 0.090      | 0.120      | 0.160      | 0.200      |  |
|   | Schruppen<br>roughing   | 80.00       | 0.002          | 0.011          | 0.017          | 0.021     | 0.029     | 0.040      | 0.047      | 0.054      | 0.067      |  |
|   | Schlichten<br>finishing | 175.00      | 0.003          | 0.016          | 0.026          | 0.032     | 0.044     | 0.060      | 0.070      | 0.080      | 0.100      |  |
|   | Schruppen<br>roughing   | 70.00       | 0.002          | 0.011          | 0.017          | 0.021     | 0.029     | 0.040      | 0.047      | 0.054      | 0.067      |  |
|   | Schlichten<br>finishing | 155.00      | 0.003          | 0.016          | 0.026          | 0.032     | 0.044     | 0.060      | 0.070      | 0.080      | 0.100      |  |

# PRODUKTDATENBLATT



| Materialbezeichnung<br>material description |   | Bearbeitung<br>Process  | Vc<br>m/min | fz        |           |           |       |       |       |       |       |       |
|---|---|-------------------------|-------------|-----------|-----------|-----------|-------|-------|-------|-------|-------|-------|
|   |   |                         |             | 1.00-1.50 | 2.00-3.00 | 4.00-5.00 | 6.00  | 8.00  | 10.00 | 12.00 | 16.00 | 20.00 |
| PV  | Vergütungsstähle < 850N/mm <sup>2</sup><br>Tempering steel < 850N/mm <sup>2</sup>               | Schruppen<br>roughing   | 85.00       | 0.007     | 0.020     | 0.033     | 0.044 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
|   |   | Schlichten<br>finishing | 190.00      | 0.010     | 0.030     | 0.050     | 0.065 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
|   | Vergütungsstähle < 1000N/mm <sup>2</sup><br>Tempering steel < 1000N/mm <sup>2</sup>             | Schruppen<br>roughing   | 80.00       | 0.007     | 0.020     | 0.033     | 0.044 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
|   |   | Schlichten<br>finishing | 175.00      | 0.010     | 0.030     | 0.050     | 0.065 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
|   | Vergütungsstähle < 1400N/mm <sup>2</sup><br>Tempering steel < 1400N/mm <sup>2</sup>             | Schruppen<br>roughing   | 70.00       | 0.002     | 0.011     | 0.017     | 0.021 | 0.029 | 0.040 | 0.047 | 0.054 | 0.067 |
|   |   | Schlichten<br>finishing | 155.00      | 0.003     | 0.016     | 0.026     | 0.032 | 0.044 | 0.060 | 0.070 | 0.080 | 0.100 |
|   | Vergütungsstähle > 1400N/mm <sup>2</sup><br>Tempering steel > 1400N/mm <sup>2</sup>             | Schruppen<br>roughing   | 65.00       | 0.002     | 0.011     | 0.017     | 0.021 | 0.029 | 0.040 | 0.047 | 0.054 | 0.067 |
|   |   | Schlichten<br>finishing | 140.00      | 0.003     | 0.016     | 0.026     | 0.032 | 0.044 | 0.060 | 0.070 | 0.080 | 0.100 |
| M   | Rost und säurebeständige Stähle<br>Stainless steels   | Schruppen<br>roughing   | 55.00       | 0.007     | 0.020     | 0.033     | 0.044 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
|   |   | Schlichten<br>finishing | 120.00      | 0.010     | 0.030     | 0.050     | 0.065 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
|   | Rost und säurebeständige Stähle >700N/mm <sup>2</sup><br>Stainless steels >700N/mm <sup>2</sup> | Schruppen<br>roughing   | 40.00       | 0.007     | 0.020     | 0.033     | 0.044 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
|   |   | Schlichten<br>finishing | 90.00       | 0.010     | 0.030     | 0.050     | 0.065 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
| K   | Gusseisen<br>Cast iron  | Schruppen<br>roughing   | 80.00       | 0.007     | 0.020     | 0.033     | 0.044 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
|   |   | Schlichten<br>finishing | 180.00      | 0.010     | 0.030     | 0.050     | 0.065 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
|   | Temperguss<br>Malleable cast iron   | Schruppen<br>roughing   | 65.00       | 0.007     | 0.020     | 0.033     | 0.044 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
|   |   | Schlichten<br>finishing | 150.00      | 0.010     | 0.030     | 0.050     | 0.065 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
|   | Gusseisen mit Kugelgraphit<br>Nodular cast iron   | Schruppen<br>roughing   | 65.00       | 0.007     | 0.020     | 0.033     | 0.044 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
|   |   | Schlichten<br>finishing | 140.00      | 0.010     | 0.030     | 0.050     | 0.065 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
| N   | AL- und AL-Legierungen<br>AL und AL-alloys  | Schruppen<br>roughing   | 105.00      | 0.007     | 0.020     | 0.033     | 0.044 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
|   |   | Schlichten<br>finishing | 230.00      | 0.010     | 0.030     | 0.050     | 0.065 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
|   | AL- und AL-Legierungen<br>AL und AL-alloys  | Schruppen<br>roughing   | 100.00      | 0.007     | 0.020     | 0.033     | 0.044 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
|   |   | Schlichten<br>finishing | 220.00      | 0.010     | 0.030     | 0.050     | 0.065 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
|   | AL- und AL-Legierungen >12% Si<br>AL und AL-alloys >12% Si                                      | Schruppen<br>roughing   | 90.00       | 0.007     | 0.020     | 0.033     | 0.044 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
|   |   | Schlichten<br>finishing | 200.00      | 0.010     | 0.030     | 0.050     | 0.065 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
|   | Kupfer, Messing, Bronze, Rotguss<br>Copper, brass, bronze, red brass                            | Schruppen<br>roughing   | 90.00       | 0.007     | 0.020     | 0.033     | 0.044 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
|   |   | Schlichten<br>finishing | 200.00      | 0.010     | 0.030     | 0.050     | 0.065 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
|   | Kunststoff<br>Thermoplaste  | Schruppen<br>roughing   | 90.00       | 0.007     | 0.020     | 0.033     | 0.044 | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |
|   |   | Schlichten<br>finishing | 200.00      | 0.010     | 0.030     | 0.050     | 0.065 | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |
| Duroplaste<br>Duroplast                     | Schruppen<br>roughing   | 90.00                   | 0.007       | 0.020     | 0.033     | 0.044     | 0.050 | 0.060 | 0.080 | 0.107 | 0.134 |       |
|   | Schlichten<br>finishing   | 200.00                  | 0.010       | 0.030     | 0.050     | 0.065     | 0.075 | 0.090 | 0.120 | 0.160 | 0.200 |       |