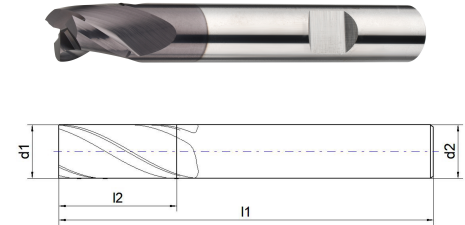
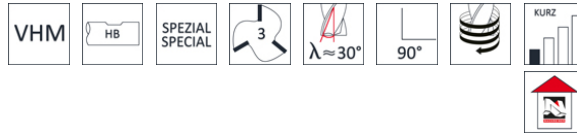


## VHM-Universal-Bohrnutenfräser 30°, mit Untermaß

Solid carbide universal drill slot end mills 30°, with undersize



| Artikelnummer<br>Article-No. | d1  | l1 | l2 | d2 h6 |
|------------------------------|-----|----|----|-------|
| E. 7625.1.0180               | 1.8 | 50 | 3  | 6,0   |
| E. 7625.1.0280               | 2.8 | 50 | 4  | 6,0   |
| E. 7625.1.0380               | 3.8 | 50 | 5  | 6,0   |
| E. 7625.1.0480               | 4.8 | 50 | 6  | 6,0   |
| E. 7625.1.0580               | 5.8 | 50 | 7  | 6,0   |
| E. 7625.1.0670               | 6.7 | 58 | 8  | 8,0   |
| E. 7625.1.0780               | 7.8 | 58 | 10 | 8,0   |
| E. 7625.1.0870               | 8.7 | 72 | 10 | 10,0  |
| E. 7625.1.0970               | 9.7 | 72 | 11 | 10,0  |



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         |            |            |            |            |
|---------------------------------------------|--------------------------------|-------------------------|-------------|------------|------------|------------|------------|------------|
|                                             |                                |                         |             | Ø<br>0.013 | Ø<br>0.020 | Ø<br>0.033 | Ø<br>0.043 | Ø<br>0.050 |
| PA                                          | allg. Stähle<br>General steels | Schruppen<br>roughing   | 100.00      | 0.013      | 0.020      | 0.033      | 0.043      | 0.050      |
|                                             |                                | Schlichten<br>finishing | 220.00      | 0.020      | 0.030      | 0.050      | 0.064      | 0.075      |
|                                             | allg. Stähle<br>General steels | Schruppen<br>roughing   | 90.00       | 0.013      | 0.020      | 0.033      | 0.043      | 0.050      |
|                                             |                                | Schlichten<br>finishing | 200.00      | 0.020      | 0.030      | 0.050      | 0.064      | 0.075      |
|                                             | allg. Stähle<br>General steels | Schruppen<br>roughing   | 85.00       | 0.013      | 0.020      | 0.033      | 0.043      | 0.050      |
|                                             |                                | Schlichten<br>finishing | 190.00      | 0.020      | 0.030      | 0.050      | 0.064      | 0.075      |
|                                             | allg. Stähle<br>General steels | Schruppen<br>roughing   | 80.00       | 0.007      | 0.011      | 0.017      | 0.021      | 0.029      |
|                                             |                                | Schlichten<br>finishing | 175.00      | 0.010      | 0.016      | 0.026      | 0.032      | 0.044      |
|                                             | allg. Stähle<br>General steels | Schruppen<br>roughing   | 70.00       | 0.007      | 0.011      | 0.017      | 0.021      | 0.029      |
|                                             |                                | Schlichten<br>finishing | 155.00      | 0.010      | 0.016      | 0.026      | 0.032      | 0.044      |

# PRODUKTDATENBLATT



| Materialbezeichnung<br>material description |                                                                                     | Bearbeitung<br>Process  | Vc<br>m/min | fz         |            |            |            |            |
|---------------------------------------------|-------------------------------------------------------------------------------------|-------------------------|-------------|------------|------------|------------|------------|------------|
|                                             |                                                                                     |                         |             | Ø<br>0.013 | Ø<br>0.020 | Ø<br>0.033 | Ø<br>0.043 | Ø<br>0.050 |
| PV                                          | Vergütungsstähle < 850N/mm <sup>2</sup><br>Tempering steel < 850N/mm <sup>2</sup>   | Schruppen<br>roughing   | 85.00       | 0.013      | 0.020      | 0.033      | 0.043      | 0.050      |
|                                             |                                                                                     | Schlichten<br>finishing | 190.00      | 0.020      | 0.030      | 0.050      | 0.064      | 0.075      |
|                                             | Vergütungsstähle < 1000N/mm <sup>2</sup><br>Tempering steel < 1000N/mm <sup>2</sup> | Schruppen<br>roughing   | 80.00       | 0.007      | 0.011      | 0.017      | 0.021      | 0.029      |
|                                             |                                                                                     | Schlichten<br>finishing | 175.00      | 0.010      | 0.016      | 0.026      | 0.032      | 0.044      |
|                                             | Vergütungsstähle < 1400N/mm <sup>2</sup><br>Tempering steel < 1400N/mm <sup>2</sup> | Schruppen<br>roughing   | 70.00       | 0.007      | 0.011      | 0.017      | 0.021      | 0.029      |
|                                             |                                                                                     | Schlichten<br>finishing | 155.00      | 0.010      | 0.016      | 0.026      | 0.032      | 0.044      |
| M                                           | Rost und säurebeständige Stähle<br>Stainless steels                                 | Schruppen<br>roughing   | 55.00       | 0.013      | 0.020      | 0.033      | 0.043      | 0.050      |
|                                             |                                                                                     | Schlichten<br>finishing | 120.00      | 0.020      | 0.030      | 0.050      | 0.064      | 0.075      |
| K                                           | Gusseisen<br>Cast iron                                                              | Schruppen<br>roughing   | 80.00       | 0.013      | 0.020      | 0.033      | 0.043      | 0.050      |
|                                             |                                                                                     | Schlichten<br>finishing | 180.00      | 0.020      | 0.030      | 0.050      | 0.064      | 0.075      |
|                                             | Temperguss<br>Malleable cast iron                                                   | Schruppen<br>roughing   | 65.00       | 0.013      | 0.020      | 0.033      | 0.043      | 0.050      |
|                                             |                                                                                     | Schlichten<br>finishing | 150.00      | 0.020      | 0.030      | 0.050      | 0.064      | 0.075      |
|                                             | Gusseisen mit Kugelgraphit<br>Nodular cast iron                                     | Schruppen<br>roughing   | 65.00       | 0.013      | 0.020      | 0.033      | 0.043      | 0.050      |
|                                             |                                                                                     | Schlichten<br>finishing | 140.00      | 0.020      | 0.030      | 0.050      | 0.064      | 0.075      |
| N                                           | AL- und AL-Legierungen<br>AL und AL-alloys                                          | Schruppen<br>roughing   | 110.00      | 0.013      | 0.020      | 0.033      | 0.043      | 0.050      |
|                                             |                                                                                     | Schlichten<br>finishing | 250.00      | 0.020      | 0.030      | 0.050      | 0.064      | 0.075      |
|                                             | AL- und AL-Legierungen<br>AL und AL-alloys                                          | Schruppen<br>roughing   | 100.00      | 0.013      | 0.020      | 0.033      | 0.043      | 0.050      |
|                                             |                                                                                     | Schlichten<br>finishing | 220.00      | 0.020      | 0.030      | 0.050      | 0.064      | 0.075      |
|                                             | AL- und AL-Legierungen >12% Si<br>AL und AL-alloys >12% Si                          | Schruppen<br>roughing   | 90.00       | 0.013      | 0.020      | 0.033      | 0.043      | 0.050      |
|                                             |                                                                                     | Schlichten<br>finishing | 200.00      | 0.020      | 0.030      | 0.050      | 0.064      | 0.075      |
|                                             | Kupfer, Messing, Bronze, Rotguss<br>Copper, brass, bronze, red brass                | Schruppen<br>roughing   | 80.00       | 0.013      | 0.020      | 0.033      | 0.043      | 0.050      |
|                                             |                                                                                     | Schlichten<br>finishing | 180.00      | 0.020      | 0.030      | 0.050      | 0.064      | 0.075      |
|                                             | Kunststoff<br>Thermoplaste                                                          | Schruppen<br>roughing   | 90.00       | 0.013      | 0.020      | 0.033      | 0.043      | 0.050      |
|                                             |                                                                                     | Schlichten<br>finishing | 200.00      | 0.020      | 0.030      | 0.050      | 0.064      | 0.075      |