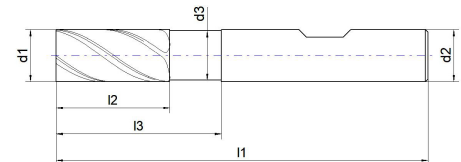
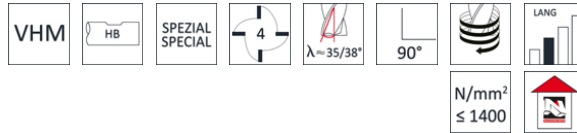


## VHM-HPC-Superstar-Fräser (ungleiche T.) abgesetzt, scharfkantig

Solid carbide HPC Superstar end mills (unequal pitch), reduced neck diameter, sharp corner



Artikelnummer Article-No.	d1	d3	l1	l2	l3	d2 h6
E. 7698HA. 1S. 0300	3	2.8	57	8	18	6,0
E. 7698HA. 1S. 0400	4	3.6	57	11	21	6,0
E. 7698HA. 1S. 0500	5	4.6	57	13	21	6,0
E. 7698HA. 1S. 0600	6	5.5	57	13	21	6,0
E. 7698HA. 1S. 0700	7	6.6	63	19	27	8,0
E. 7698HA. 1S. 0800	8	7.5	63	19	27	8,0
E. 7698HA. 1S. 0900	9	8.6	72	22	32	10,0
E. 7698HA. 1S. 1000	10	9.5	72	22	32	10,0
E. 7698HA. 1S. 1100	11	10.6	83	26	38	12,0
E. 7698HA. 1S. 1200	12	11.5	83	26	38	12,0
E. 7698HA. 1S. 1300	13	12.6	83	26	42	14,0
E. 7698HA. 1S. 1400	14	13.5	83	26	42	14,0
E. 7698HA. 1S. 1600	16	15.5	92	32	44	16,0
E. 7698HA. 1S. 1800	18	17.5	102	32	50	18,0
E. 7698HA. 1S. 2000	20	19.5	104	38	54	20,0
E. 7698HA. 1S. 2500	25	24.5	110	42	65	25,0



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)

# PRODUKTDATENBLATT



Materialbezeichnung material description		Bearbeitung Process	Vc m/min	fz							
				Ø 3.00	Ø 4.00-5.00	Ø 6.00-7.00	Ø 8.00-9.00	Ø 10.00-11.00	Ø 12.00-14.00	Ø 16.00-18.00	Ø 20.00-25.00
PA	allg. Stähle General steels	Schlichten finishing	200.00	0.014	0.023	0.040	0.055	0.070	0.085	0.100	0.120
		Schruppen roughing	140.00	0.012	0.019	0.034	0.046	0.059	0.072	0.084	0.101
	allg. Stähle General steels	Schlichten finishing	180.00	0.012	0.020	0.035	0.045	0.063	0.085	0.100	0.110
		Schruppen roughing	125.00	0.010	0.017	0.029	0.038	0.053	0.072	0.084	0.093
	allg. Stähle General steels	Schlichten finishing	160.00	0.012	0.020	0.035	0.045	0.063	0.085	0.100	0.110
		Schruppen roughing	115.00	0.010	0.017	0.029	0.038	0.053	0.072	0.084	0.093
	allg. Stähle General steels	Schlichten finishing	120.00	0.010	0.015	0.030	0.045	0.060	0.080	0.090	0.100
		Schruppen roughing	85.00	0.008	0.013	0.025	0.038	0.051	0.067	0.076	0.084
PV	Vergütungsstähle < 850N/mm <sup>2</sup> Tempering steel < 850N/mm <sup>2</sup>	Schlichten finishing	180.00	0.012	0.020	0.035	0.045	0.063	0.085	0.100	0.110
		Schruppen roughing	125.00	0.010	0.017	0.029	0.038	0.053	0.072	0.084	0.093
	Vergütungsstähle < 1000N/mm <sup>2</sup> Tempering steel < 1000N/mm <sup>2</sup>	Schlichten finishing	160.00	0.012	0.020	0.035	0.045	0.063	0.085	0.100	0.110
		Schruppen roughing	115.00	0.010	0.017	0.029	0.038	0.053	0.072	0.084	0.093
	Vergütungsstähle < 1400N/mm <sup>2</sup> Tempering steel < 1400N/mm <sup>2</sup>	Schlichten finishing	120.00	0.010	0.015	0.030	0.045	0.060	0.080	0.090	0.100
		Schruppen roughing	85.00	0.008	0.013	0.025	0.038	0.051	0.067	0.076	0.084
	Vergütungsstähle > 1400N/mm <sup>2</sup> Tempering steel > 1400N/mm <sup>2</sup>	Schlichten finishing	120.00	0.010	0.015	0.030	0.045	0.060	0.080	0.090	0.100
		Schruppen roughing	85.00	0.008	0.013	0.025	0.038	0.051	0.067	0.076	0.084
K	Gusseisen Cast iron	Schlichten finishing	180.00	0.012	0.020	0.032	0.042	0.065	0.085	0.100	0.110
		Schruppen roughing	125.00	0.010	0.017	0.027	0.035	0.055	0.072	0.084	0.093
	Temperguss Malleable cast iron	Schlichten finishing	160.00	0.012	0.020	0.032	0.042	0.065	0.085	0.100	0.110
		Schruppen roughing	115.00	0.010	0.017	0.027	0.035	0.055	0.072	0.084	0.093
	Gusseisen mit Kugelgraphit Nodular cast iron	Schlichten finishing	140.00	0.010	0.020	0.030	0.040	0.062	0.080	0.095	0.100
		Schruppen roughing	100.00	0.008	0.017	0.025	0.034	0.052	0.067	0.080	0.084