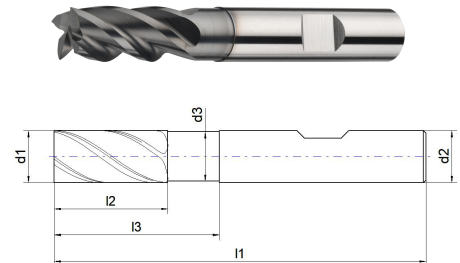
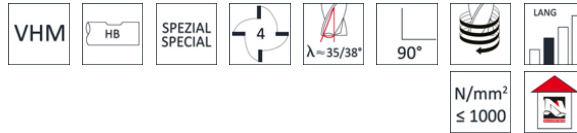


VHM-HPC-Superstar-Fräser (ungleiche T.) abgesetzt , scharfkantig

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



| Artikelnummer Article-No. | d1 | d3 | l1 | l2 | l3 | d2 h6 |
|------------------------------|----|------|-----|----|----|-------|
| E. 7698WA.1S.0300 | 3 | 2.8 | 57 | 8 | 18 | 6,0 |
| E. 7698WA.1S.0400 | 4 | 3.6 | 57 | 11 | 21 | 6,0 |
| E. 7698WA.1S.0500 | 5 | 4.6 | 57 | 13 | 21 | 6,0 |
| E. 7698WA.1S.0600 | 6 | 5.5 | 57 | 13 | 21 | 6,0 |
| E. 7698WA.1S.0700 | 7 | 6.6 | 63 | 19 | 27 | 8,0 |
| E. 7698WA.1S.0800 | 8 | 7.5 | 63 | 19 | 27 | 8,0 |
| E. 7698WA.1S.0900 | 9 | 8.6 | 72 | 22 | 32 | 10,0 |
| E. 7698WA.1S.1000 | 10 | 9.5 | 72 | 22 | 32 | 10,0 |
| E. 7698WA.1S.1100 | 11 | 10.6 | 83 | 26 | 38 | 12,0 |
| E. 7698WA.1S.1200 | 12 | 11.5 | 83 | 26 | 38 | 12,0 |
| E. 7698WA.1S.1300 | 13 | 12.6 | 83 | 26 | 42 | 14,0 |
| E. 7698WA.1S.1400 | 14 | 13.5 | 83 | 26 | 42 | 14,0 |
| E. 7698WA.1S.1600 | 16 | 15.5 | 92 | 32 | 44 | 16,0 |
| E. 7698WA.1S.1800 | 18 | 17.5 | 102 | 32 | 50 | 18,0 |
| E. 7698WA.1S.2000 | 20 | 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 | 6.00-7.00 | 8.00-9.00 | 10.00-11.00 | 12.00-14.00 | 16.00-18.00 | 20.00 |
| PA allg. Stähle General steels | Schruppen roughing | 160.00 | 0.013 | 0.019 | 0.034 | 0.042 | 0.067 | 0.088 | 0.101 | 0.114 |
| | Schlichten finishing | 225.00 | 0.015 | 0.022 | 0.040 | 0.050 | 0.080 | 0.105 | 0.120 | 0.135 |
| | Schruppen roughing | 140.00 | 0.013 | 0.019 | 0.034 | 0.042 | 0.067 | 0.088 | 0.101 | 0.114 |
| | Schlichten finishing | 200.00 | 0.015 | 0.022 | 0.040 | 0.050 | 0.080 | 0.105 | 0.120 | 0.135 |
| allg. Stähle General steels | Schruppen roughing | 105.00 | 0.013 | 0.019 | 0.034 | 0.042 | 0.067 | 0.088 | 0.101 | 0.114 |
| | Schlichten finishing | 150.00 | 0.015 | 0.022 | 0.040 | 0.050 | 0.080 | 0.105 | 0.120 | 0.135 |

PRODUKTDATENBLATT



| Materialbezeichnung material description | | Bearbeitung Process | Vc m/min | fz | | | | | | | |
|---|---|-------------------------|-------------|-----------|----------------|----------------|----------------|------------------|------------------|------------------|------------|
| | | | | ∅ 3.00 | ∅ 4.00-5.00 | ∅ 6.00-7.00 | ∅ 8.00-9.00 | ∅ 10.00-11.00 | ∅ 12.00-14.00 | ∅ 16.00-18.00 | ∅ 20.00 |
| | allg. Stähle General steels | Schruppen roughing | 90.00 | 0.011 | 0.017 | 0.032 | 0.040 | 0.059 | 0.067 | 0.084 | 0.093 |
| | | Schlichten finishing | 130.00 | 0.013 | 0.020 | 0.038 | 0.048 | 0.070 | 0.080 | 0.100 | 0.110 |
| PV | Vergütungsstähle < 850N/mm ² Tempering steel < 850N/mm ² | Schruppen roughing | 105.00 | 0.013 | 0.019 | 0.034 | 0.042 | 0.067 | 0.088 | 0.101 | 0.114 |
| | | Schlichten finishing | 150.00 | 0.015 | 0.022 | 0.040 | 0.050 | 0.080 | 0.105 | 0.120 | 0.135 |
| | Vergütungsstähle < 1000N/mm ² Tempering steel < 1000N/mm ² | Schruppen roughing | 90.00 | 0.011 | 0.017 | 0.032 | 0.040 | 0.059 | 0.067 | 0.084 | 0.093 |
| | | Schlichten finishing | 130.00 | 0.013 | 0.020 | 0.038 | 0.048 | 0.070 | 0.080 | 0.100 | 0.110 |
| M | Rost und säurebeständige Stähle Stainless steels | Schruppen roughing | 70.00 | 0.008 | 0.013 | 0.025 | 0.029 | 0.044 | 0.059 | 0.071 | 0.077 |
| | | Schlichten finishing | 100.00 | 0.010 | 0.015 | 0.030 | 0.035 | 0.052 | 0.070 | 0.084 | 0.091 |
| | Rost und säurebeständige Stähle >700N/mm ² Stainless steels >700N/mm ² | Schruppen roughing | 65.00 | 0.008 | 0.013 | 0.021 | 0.025 | 0.034 | 0.046 | 0.059 | 0.067 |
| | | Schlichten finishing | 90.00 | 0.010 | 0.015 | 0.025 | 0.030 | 0.040 | 0.055 | 0.070 | 0.080 |
| K | Gusseisen Cast iron | Schruppen roughing | 130.00 | 0.013 | 0.019 | 0.021 | 0.042 | 0.067 | 0.084 | 0.101 | 0.114 |
| | | Schlichten finishing | 185.00 | 0.015 | 0.022 | 0.025 | 0.050 | 0.080 | 0.100 | 0.120 | 0.135 |
| | Temperguss Malleable cast iron | Schruppen roughing | 105.00 | 0.013 | 0.019 | 0.021 | 0.042 | 0.067 | 0.084 | 0.101 | 0.114 |
| | | Schlichten finishing | 150.00 | 0.015 | 0.022 | 0.025 | 0.050 | 0.080 | 0.100 | 0.120 | 0.135 |
| | Gusseisen mit Kugelgraphit Nodular cast iron | Schruppen roughing | 95.00 | 0.008 | 0.017 | 0.029 | 0.038 | 0.055 | 0.076 | 0.084 | 0.101 |
| | | Schlichten finishing | 135.00 | 0.010 | 0.020 | 0.035 | 0.045 | 0.065 | 0.090 | 0.100 | 0.120 |
| S | Nickelbasierende Stähle Nickel based alloys | Schruppen roughing | 25.00 | 0.006 | 0.008 | 0.010 | 0.018 | 0.025 | 0.038 | 0.051 | 0.063 |
| | | Schlichten finishing | 35.00 | 0.007 | 0.009 | 0.012 | 0.021 | 0.030 | 0.045 | 0.060 | 0.075 |
| | Titan Titanium | Schruppen roughing | 35.00 | 0.006 | 0.008 | 0.013 | 0.021 | 0.027 | 0.044 | 0.051 | 0.071 |
| | | Schlichten finishing | 50.00 | 0.007 | 0.009 | 0.015 | 0.025 | 0.032 | 0.052 | 0.060 | 0.084 |