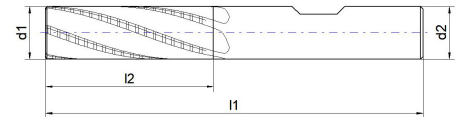
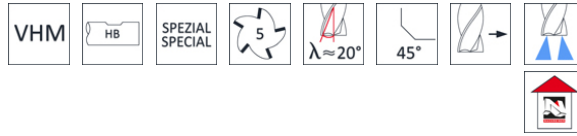


VHM-Schrupfräser 20°, mit IK

Solid carbide roughing end mills 20°, with IC



| Artikelnummer Article-No. | d1 | l1 | l2 | d2 |
|------------------------------|----|-----|----|------|
| E.7827.1.0600 | 6 | 57 | 14 | 6,0 |
| E.7827.1.0800 | 8 | 63 | 18 | 8,0 |
| E.7827.1.1000 | 10 | 72 | 22 | 10,0 |
| E.7827.1.1200 | 12 | 83 | 28 | 12,0 |
| E.7827.1.1600 | 16 | 92 | 35 | 16,0 |
| E.7827.1.2000 | 20 | 104 | 42 | 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 | | | | | |
|---|-------------------------|-------------|-----------|-----------|------------|------------|------------|------------|
| | | | ∅ 6.00 | ∅ 8.00 | ∅ 10.00 | ∅ 12.00 | ∅ 16.00 | ∅ 20.00 |
| allg. Stähle General steels | Schruppen roughing | 100.00 | 0.029 | 0.038 | 0.063 | 0.069 | 0.084 | 0.101 |
| | Schlichten finishing | 140.00 | 0.035 | 0.045 | 0.075 | 0.082 | 0.100 | 0.120 |
| allg. Stähle General steels | Schruppen roughing | 85.00 | 0.029 | 0.038 | 0.063 | 0.069 | 0.084 | 0.101 |
| | Schlichten finishing | 120.00 | 0.035 | 0.045 | 0.075 | 0.082 | 0.100 | 0.120 |
| PA allg. Stähle General steels | Schruppen roughing | 80.00 | 0.025 | 0.034 | 0.044 | 0.051 | 0.059 | 0.071 |
| | Schlichten finishing | 115.00 | 0.030 | 0.040 | 0.052 | 0.060 | 0.070 | 0.084 |
| allg. Stähle General steels | Schruppen roughing | 70.00 | 0.025 | 0.034 | 0.044 | 0.051 | 0.059 | 0.071 |
| | Schlichten finishing | 100.00 | 0.030 | 0.040 | 0.052 | 0.060 | 0.070 | 0.084 |
| allg. Stähle General steels | Schruppen roughing | 55.00 | 0.025 | 0.034 | 0.044 | 0.051 | 0.059 | 0.071 |
| | Schlichten finishing | 80.00 | 0.030 | 0.040 | 0.052 | 0.060 | 0.070 | 0.084 |

PRODUKTDATENBLATT



| Materialbezeichnung material description | | Bearbeitung Process | Vc m/min | fz | | | | | |
|---|---|-------------------------|-------------|-----------|-----------|------------|------------|------------|------------|
| | | | | ∅ 6.00 | ∅ 8.00 | ∅ 10.00 | ∅ 12.00 | ∅ 16.00 | ∅ 20.00 |
| PV | Vergütungsstähle < 850N/mm ² Tempering steel < 850N/mm ² | Schruppen roughing | 80.00 | 0.025 | 0.034 | 0.044 | 0.051 | 0.059 | 0.072 |
| | | Schlichten finishing | 115.00 | 0.030 | 0.040 | 0.052 | 0.060 | 0.070 | 0.085 |
| | Vergütungsstähle < 1000N/mm ² Tempering steel < 1000N/mm ² | Schruppen roughing | 70.00 | 0.025 | 0.034 | 0.044 | 0.051 | 0.059 | 0.072 |
| | | Schlichten finishing | 100.00 | 0.030 | 0.040 | 0.052 | 0.060 | 0.070 | 0.085 |
| | Vergütungsstähle < 1400N/mm ² Tempering steel < 1400N/mm ² | Schruppen roughing | 55.00 | 0.025 | 0.034 | 0.044 | 0.046 | 0.059 | 0.069 |
| | | Schlichten finishing | 80.00 | 0.030 | 0.040 | 0.052 | 0.055 | 0.070 | 0.082 |
| M | Rost und säurebeständige Stähle Stainless steels | Schruppen roughing | 55.00 | 0.025 | 0.034 | 0.044 | 0.051 | 0.059 | 0.071 |
| | | Schlichten finishing | 80.00 | 0.030 | 0.040 | 0.052 | 0.060 | 0.070 | 0.084 |
| K | Gusseisen Cast iron | Schruppen roughing | 90.00 | 0.029 | 0.038 | 0.063 | 0.069 | 0.084 | 0.101 |
| | | Schlichten finishing | 130.00 | 0.035 | 0.045 | 0.075 | 0.082 | 0.100 | 0.120 |
| | Temperguss Malleable cast iron | Schruppen roughing | 70.00 | 0.029 | 0.038 | 0.063 | 0.069 | 0.084 | 0.101 |
| | | Schlichten finishing | 100.00 | 0.035 | 0.045 | 0.075 | 0.082 | 0.100 | 0.120 |
| | Gusseisen mit Kugelgraphit Nodular cast iron | Schruppen roughing | 70.00 | 0.029 | 0.038 | 0.063 | 0.069 | 0.084 | 0.101 |
| | | Schlichten finishing | 100.00 | 0.035 | 0.045 | 0.075 | 0.082 | 0.100 | 0.120 |
| N | AL- und AL-Legierungen AL und AL-alloys | Schruppen roughing | 155.00 | 0.029 | 0.038 | 0.063 | 0.069 | 0.084 | 0.101 |
| | | Schlichten finishing | 220.00 | 0.035 | 0.045 | 0.075 | 0.082 | 0.100 | 0.120 |
| | AL- und AL-Legierungen > 12% Si AL und AL-alloys >12% Si | Schruppen roughing | 125.00 | 0.029 | 0.038 | 0.063 | 0.069 | 0.084 | 0.101 |
| | | Schlichten finishing | 180.00 | 0.035 | 0.045 | 0.075 | 0.082 | 0.100 | 0.120 |
| | Kupfer, Messing, Bronze, Rotguss Copper, brass, bronze, red brass | Schruppen roughing | 120.00 | 0.029 | 0.038 | 0.063 | 0.069 | 0.084 | 0.101 |
| | | Schlichten finishing | 170.00 | 0.035 | 0.045 | 0.075 | 0.082 | 0.100 | 0.120 |