



PRODUKTBESCHREIBUNG

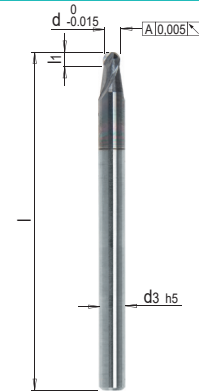
- » Hochleistungs-Fräser mit Zentrumsschnitt für 3D-Bearbeitung
- » Mit höchster Präzision im μ -Bereich

MATERIAL

» AlCrN-beschichtet

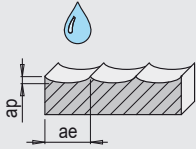


Z	l	l1	d3	d	Nr.	EUR
2	38	1	3	0,5	WZF 28246/0,5	< >
2	38	1,2	3	0,6	WZF 28246/0,6	< >
2	38	1,4	3	0,7	WZF 28246/0,7	< >
2	38	1,6	3	0,8	WZF 28246/0,8	< >
2	38	1,8	3	0,9	WZF 28246/0,9	< >
2	38	2	3	1	WZF 28246/1	< >
2	38	3	3	1,5	WZF 28246/1,5	< >
2	38	4	3	2	WZF 28246/2	< >
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2	38	6	3	3	WZF 28246/3	< >



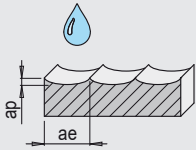
RICHTWERTE SCHRUPPEN

WZF 28246	Werkstoff	Festigkeit	Vc ¹ m/min.	d									
				0.5	0.6	0.7	0.8	0.9	1	1.5	2	2.5	3
				fz ² (mm/z)									
	1.1730	640 N/mm ²	70	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2083	780 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2085	1080 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2162	660 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2311	1080 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2312	1080 N/mm ²	70	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2316	1010 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2343	780 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2379	780 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2714 HH	1350 N/mm ²	70	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2767	830 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	1.2842	775 N/mm ²	70	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
	Stahl	1400 N/mm ²	35	0.006	0.007	0.008	0.010	0.011	0.012	0.018	0.024	0.030	0.036
ap (mm)				0.125	0.150	0.175	0.200	0.225	0.250	0.375	0.500	0.625	0.750
ae (mm)				0.050	0.060	0.070	0.080	0.090	0.100	0.150	0.200	0.250	0.300



RICHTWERTE SCHLICHTEN

WZF 28246	Werkstoff	Festigkeit	Vc ¹ m/min.	d									
				0.5	0.6	0.7	0.8	0.9	1	1.5	2	2.5	3
				fz ² (mm/z)									
	1.1730	640 N/mm ²	90	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2083	780 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2085	1080 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2162	660 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2311	1080 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2312	1080 N/mm ²	90	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2316	1010 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2343	780 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2379	780 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2714 HH	1350 N/mm ²	90	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2767	830 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	1.2842	775 N/mm ²	90	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
	Stahl	1400 N/mm ²	60	0.003	0.0036	0.0042	0.0048	0.0054	0.006	0.009	0.012	0.015	0.018
ap (mm)				0.025	0.03	0.035	0.040	0.045	0.050	0.075	0.10	0.125	0.15
ae (mm)				0.015	0.018	0.021	0.024	0.027	0.030	0.045	0.06	0.075	0.09



1) Vc: Schnittgeschwindigkeit (m/min.)

2) fz: Vorschub pro Schneide (mm/z)

i Weitere Materialien und Schnittwerte finden Sie im Schnittdaten-Kalkulator