



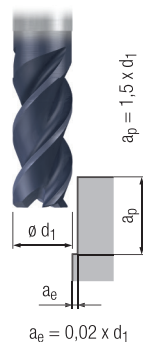
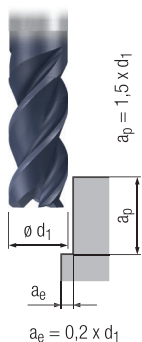
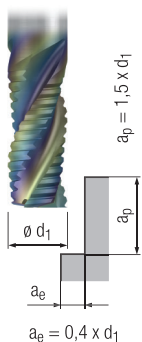
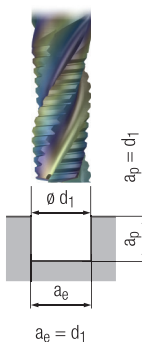
Hartmetall-Schaftfräser – lange Ausführung

Solid carbide end mills – long design

WF

W

W



Gültig für · Valid for

1818A 1909 2870R
1856A 1909R 2871R

Achtung:
Bei unbeschichteter Ausführung ist die Schnittgeschwindigkeit v_c um 30% zu reduzieren!

Please note:
For uncoated design, please reduce cutting speed v_c by 30%!



		v_c [m/min]	f_z [mm]	v_c [m/min]	f_z [mm]	v_c [m/min]	f_z [mm]	v_c [m/min]	f_z [mm]				
P	1.1	120	$0,005 \times d_1$	130	$0,005 \times d_1$	150	$0,006 \times d_1$	170	$0,007 \times d_1$	□	■	□	■
	2.1	110	$0,004 \times d_1$	120	$0,005 \times d_1$	140	$0,005 \times d_1$	150	$0,006 \times d_1$	□	■	□	■
	3.1												
	4.1												
	5.1												
M	1.1	60	$0,003 \times d_1$	70	$0,003 \times d_1$	80	$0,004 \times d_1$	80	$0,004 \times d_1$			□	■
	2.1	50	$0,003 \times d_1$	60	$0,003 \times d_1$	60	$0,004 \times d_1$	70	$0,004 \times d_1$			□	■
	3.1												
	4.1												
K	1.1												
	1.2												
	2.1												
	2.2												
	3.1												
	3.2												
	4.1												
	4.2												
N	1.1	540	$0,009 \times d_1$	590	$0,010 \times d_1$	680	$0,011 \times d_1$	760	$0,013 \times d_1$				■
	1.2	540	$0,008 \times d_1$	590	$0,009 \times d_1$	680	$0,010 \times d_1$	760	$0,011 \times d_1$				■
	1.3	540	$0,007 \times d_1$	590	$0,008 \times d_1$	680	$0,009 \times d_1$	760	$0,010 \times d_1$				■
	1.4	320	$0,008 \times d_1$	350	$0,009 \times d_1$	400	$0,010 \times d_1$	450	$0,011 \times d_1$				■
	1.5	260	$0,007 \times d_1$	290	$0,008 \times d_1$	330	$0,009 \times d_1$	360	$0,010 \times d_1$				■
	1.6	160	$0,006 \times d_1$	180	$0,007 \times d_1$	200	$0,008 \times d_1$	220	$0,008 \times d_1$				■
	2.1	110	$0,005 \times d_1$	120	$0,006 \times d_1$	140	$0,006 \times d_1$	150	$0,007 \times d_1$			□	■
	2.2	110	$0,005 \times d_1$	120	$0,006 \times d_1$	140	$0,006 \times d_1$	150	$0,007 \times d_1$			□	■
	2.3	110	$0,005 \times d_1$	120	$0,006 \times d_1$	140	$0,006 \times d_1$	150	$0,007 \times d_1$	□	□	□	■
	2.4	100	$0,004 \times d_1$	110	$0,005 \times d_1$	130	$0,005 \times d_1$	140	$0,006 \times d_1$			□	■
	2.5	100	$0,004 \times d_1$	110	$0,005 \times d_1$	130	$0,005 \times d_1$	140	$0,006 \times d_1$			□	■
	2.6	100	$0,004 \times d_1$	110	$0,005 \times d_1$	130	$0,005 \times d_1$	140	$0,006 \times d_1$	□	□	□	■
	2.7	60	$0,003 \times d_1$	70	$0,003 \times d_1$	80	$0,004 \times d_1$	80	$0,004 \times d_1$			□	■
	2.8	60	$0,003 \times d_1$	70	$0,003 \times d_1$	80	$0,004 \times d_1$	80	$0,004 \times d_1$			□	■
	3.1	240	$0,009 \times d_1$	260	$0,010 \times d_1$	300	$0,011 \times d_1$	340	$0,013 \times d_1$	□	□	□	■
	3.2	240	$0,007 \times d_1$	260	$0,008 \times d_1$	300	$0,009 \times d_1$	340	$0,010 \times d_1$	□	□	□	■
	4.1	240	$0,008 \times d_1$	260	$0,009 \times d_1$	300	$0,009 \times d_1$	340	$0,011 \times d_1$		□	□	■
	4.2	360	$0,008 \times d_1$	400	$0,009 \times d_1$	450	$0,009 \times d_1$	500	$0,011 \times d_1$			□	■
	4.3												
	4.4												
	5.1												
	5.2												
	5.3	120	$0,006 \times d_1$	130	$0,007 \times d_1$	150	$0,008 \times d_1$	170	$0,008 \times d_1$	□	■		
S	1.1	60	$0,004 \times d_1$	70	$0,004 \times d_1$	80	$0,004 \times d_1$	80	$0,005 \times d_1$				■
	1.2	50	$0,003 \times d_1$	60	$0,003 \times d_1$	60	$0,004 \times d_1$	70	$0,004 \times d_1$				■
	1.3	30	$0,003 \times d_1$	30	$0,003 \times d_1$	40	$0,003 \times d_1$	40	$0,004 \times d_1$				■
	2.1	50	$0,002 \times d_1$	60	$0,002 \times d_1$	60	$0,003 \times d_1$	70	$0,003 \times d_1$				■
	2.2												
	2.3												
	2.4												
	2.5												
H	1.1												
	1.2												
	1.3												
	1.4												
	1.5												