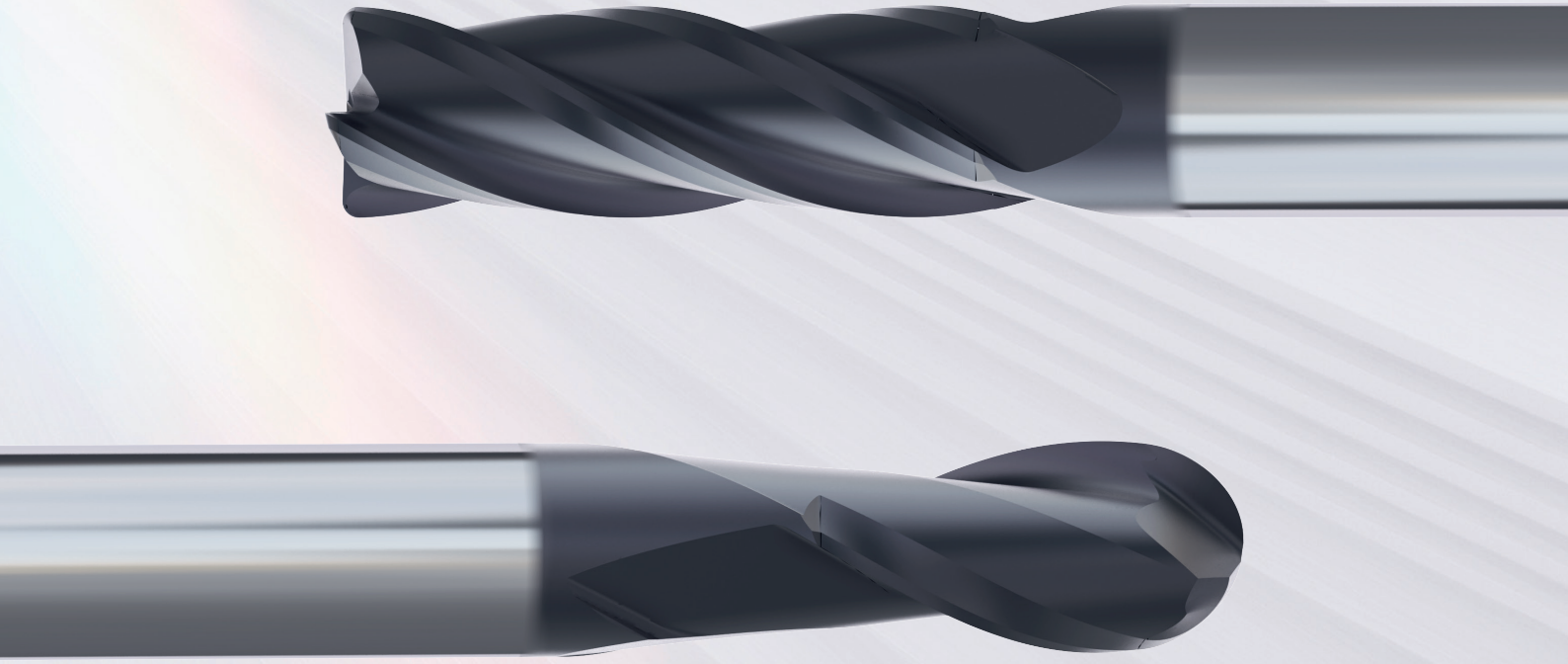
Seco

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Katalog & Technischer Guide

Fräsen – Vollhartmetall 2026.1



Seco entwickelt Werkzeuge, Technologien und Lösungen für anspruchsvollste Fertigungsaufgaben. Seit der Gründung in Fagersta, Schweden, bis zur heutigen globalen Unternehmensausrichtung ist unser Geschäftsmodell stets auf die speziellen Bedürfnisse unserer Kunden ausgerichtet und von Vertrauen geprägt.

Wir kombinieren hochmoderne Präzisionswerkzeuge mit partnerschaftlichen Kundenbeziehungen und technischem Know-How, um die Zerspanungswelt gemeinsam voranzubringen.

Wir sind "Made for Makers" - mit innovativen Ideen und nachhaltigen Ansätzen. Nachhaltigkeit steht im Mittelpunkt unseres Handelns. Wir stellen uns den Herausforderungen einer sich wandelnden Industrie und sind stolz darauf, mitzuwirken, neue Wege zu erschließen, um mit unseren Kunden und Partnern die Zukunft zu gestalten. Wenn nicht, schaffen wir es.

Made for Makers

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Übersicht Produktfamilien

C-Serie



Seco bietet mit diesem Programm eine Vielfalt an Vollhartmetallfräsern für den universellen Einsatz. Dazu gehören universell einsetzbare beschichtete und unbeschichtete Schaftfräser. Die breite Produktpalette für die Universalbearbeitung
Die Seco C-Serie ist in einer breiten Palette von Fasen-, Eckradien- und Kugelkopfgeometrien zum Schruppen und Schlichten beim Eckfräsen oder Nutenfräsen erhältlich.

SOLID²



Seco Solid² ist eine Reihe von Vollhartmetall-Schaftfräsern für Anwendungen in der allgemeinen Bearbeitung und bietet Flexibilität, Geschwindigkeit und Kosteneffizienz. Seco Solid² ist verfügbar in einem Durchmesserbereich von ∅1-∅32 mm und in ∅1/32 - 1 1/4 *Zoll*.
Seco Solid² beinhaltet auch eine Reihe spezieller leistungsfähiger Fräser für dynamisches Fräsen (JS564 und JS565). Diese Werkzeuge zeigen eine extrem hohe Leistungsfähigkeit bei klar definiertem Werkzeugweg mit konstantem seitlichem Eingriff, bei hohen Schnittgeschwindigkeiten und gleichzeitig großer Schnitttiefe.

Eine gruppierte Übersicht der Seco Solid²-Produkte finden Sie auf Seite 11.

Stabilizer



Seco Universalfräser der Stabilizer Serie erreichen hohes Zeitspanvolumen (HPM-Level) durch spezielles Geometriedesign.
Die Seco Stabilizer Serie ist im Standard als Schaftfräser und als Kugelkopfversion erhältlich. Sie ist universell einsetzbar für Nutfräsen, Eckfräsen und Kopierfräsen.

HSM/TORNADO



Die Seco HSM/Tornado Serie zeichnet sich aus durch hohe Werkzeugtoleranz und eine Vielzahl an Standardabmessungen für die Strategie der HSM-Bearbeitung (Hochgeschwindigkeitsbearbeitung) aus.
Einen Überblick über alle Produkte der HSM/TORNADO-Reihe finden Sie auf Seite 11.

Übersicht Produktfamilien

HPM



Optimierte Schaftfräser sind speziell für Erstausrüster und Hauptlieferanten gedacht, die Einzelteile in großen Chargen produzieren und hohe Anforderungen an optimale Prozesse mit kurzen Zykluszeiten und niedrigen Stückkosten haben.
Einen Überblick über alle Produkte der HPM-Reihe finden Sie auf Seite 12.

HFM



Kosteneffizienter Einsatz
Ein Komplettprogramm an Vollhartmetallfräsern für die Bearbeitung mit hohen Vorschubgeschwindigkeiten.
Auch zum Tauchfräsen bestens geeignet.
- Durchmesserbereich von 1 bis 12 mm
- Geringe Vibrationsneigung auch bei großen Werkzeugauskragungen aufgrund geringer radialer Schnittkräfte Hochvorschubwerkzeuge leisten hervorragende Arbeit auch beim Tauchfräsen.

Einen Überblick über alle Produkte für die Hochvorschubbearbeitung finden Sie auf Seite 12.

Übersicht Produktfamilien

MINI



Die Vollhartmetallfräser für die Mikrozerspanung von Seco umfassen Eckfräser und Kugelkopffräser mit kleinem Durchmesser. Universal-Werkzeuge eignen sich für die meisten Werkstoff-Gruppen. Spezifische Werkzeuge eignen sich für Graphite und gehärteten Stahl. Alle Werkzeuge sind mit einer dünnen Beschichtung für optimale Leistung versehen.
Einen Überblick über alle Produkte der MINI-Reihe finden Sie auf Seite 12.

DIAMOND



Verfügbar in einer großen Anzahl an Geometrien in einem großen Durchmesserbereich mit bestmöglichem Substrat für perfekte Adhäsion der Diamantbeschichtung. Insgesamt steigern diese Schaftfräser erheblich die Produktivität und senken die Werkzeugkosten durch weniger Werkzeugwechsel und hohe Vorschübe bei der Bearbeitung von Präzisionsteilen.
Einen Überblick über alle diamantbeschichteten Produkte finden Sie auf Seite 12.

COMPOSITE



Das Produktprogramm besteht aus diamantbeschichteten, unbeschichteten und PKD-Fräsern mit verschiedenen Geometrien sowie Fräser mit eingelöteter PKD-Spitze. Die Werkzeuge sind speziell für schwierige Zerspanungsbedingungen in anspruchsvollen Werkstoffen optimiert.
Einen Überblick über alle Produkte der Composite-Reihe (JC) finden Sie auf Seite 12.

VHM



Beinhaltet universelle beschichtete und unbeschichtete Schaftfräser speziell zur Zerspanung von Kunststoffen und Aluminium, als Fasfräser oder konisch. Die Produkte bestehen aus hochqualitativen Sorten und Beschichtungen für berechenbare Standzeiten.
Einen Überblick über alle Vollhartmetallfräser finden Sie auf Seite 13.

Übersicht Produktfamilien

CERAMIC



Zum schnellen Zerspanen der härtesten hitzeresistenten Superlegierungen (HRSA) brauchen Sie ein Werkzeug, das genauso robust und fortschrittlich ist wie die Werkstoffe selbst. Optimieren Sie Ihre Prozesse und zerspanen Sie Ihre HRSA-Werkstücke deutlich schneller mit diesen leistungsstarken Keramik-Vollhartmetallfräsern.
Einen Überblick über alle CERAMIC-Produkte finden Sie auf Seite 13.

HSCO



Kobalthaltiger Schnellarbeitsstahl ist eine Premiumsorte für mehr Leistung im Vergleich zu herkömmlichen Schnellarbeitsstählen. Dank mehr Härte weisen diese HSS_Fräser eine längere Standzeit in abrasiven, wärmebeständigen und exotischen Werkstoffen auf.
Das Spannutdesign, die verschleißfeste Beschichtung und optimierte Kühlschmiermittelkanäle sorgen für hohe Qualität und geringere Werkzeugkosten in diesen anspruchsvollen Werkstoffen.
Einen Überblick über alle HSS-CO-Produkte finden Sie auf Seite 13.

X-Heads



Mit dem Wechselkopfsystem von Seco kann man schnell und einfach zwischen verschiedenen Vollhartmetall-Fräskopfgeometrien wechseln, um alle Fräsvorgänge zu optimieren und gleichzeitig die Herstellungskosten und den Werkzeugbestand zu reduzieren. X-Head-Schaftfräser werden für eine noch größere Vielseitigkeit auf einer Vielzahl von verfügbaren Schaftlängen montiert, mit langen Ausführungen. Der Wechsel von X-Head Köpfen erfordert nur eine einfache Drehung eines Schraubenschlüssels, wobei der Schaft in der Maschine verbleiben kann. Dank einer sicheren und zuverlässigen Verbindung, die eine Wechselgenauigkeit von 50 Mikrometern ermöglicht, müssen die Werkzeuglängen nicht mehr neu eingemessen werden.
Einen Überblick über alle Produkte der X-Head-Reihe (austauschbare Köpfe) finden Sie auf Seite XX.

Übersicht Produktfamilien

Produktfamilie	Technologie	Produkt	1xx	4xx	5xx	6xx	7xx	8xx	9xx
C-series	Allgemeine Bearbeitung	C			■				
Solid²	Allgemeine Bearbeitung	JS		■	■		■		
Stabilizer	Hochleistungsbearbeitung	ST			■				
HPM	Hochleistungsbearbeitung	JHP	■	■			■		■
HFM	Hochvorschubbearbeitung	JHF	■						■
Mini	Mikrofräsen	JM	■	■	■	■			■
HSM/Tornado	Hochgeschwindigkeitsbearbeitung	JH	■	■			■		■
Ceramic	Hochleistungsbearbeitung	JCG					■		
Diamond	Graphitbearbeitung	JD				■			
Composite	Composite-Bearbeitung	JC, JPD						■	
VHM	Allgemeine Bearbeitung	J		■					■
HSS-E	Allgemeine Bearbeitung	JCO					■		
X-Heads - Solid²	Hochleistungsbearbeitung	XS		■	■		■		
X-Heads - HFM	Hochvorschubbearbeitung	XHF			■		■		
X-Heads - HSM/Tornado	Hochgeschwindigkeitsbearbeitung	XH			■		■		
X-Heads - VHM	Allgemeine Bearbeitung	XV			■		■		
SMG									
P1-8					■				■
P11-12					■				■
M1-3					■		■		
M4-5					■		■		
K1-7					■				■
S1-3					■		■		
S11-13					■		■		
H			■		■				
N1				■	■				
N2-3				■	■				
N11				■	■				
TS				■				■	
TP				■				■	
GR						■			
Weitere Informationen zu SMG (Seco Werkstoff-Gruppe), siehe Seite 802									

Zusammenfassung

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210	C-Series	C5021	●	○	●	○	●	○	○	○	○	○	○	○			○				○
212		C5041	●	○	●	○	●	○	○	○	○	○	○	○			○				○
38		C5121	●	○	●	○	●	○	○	○	○	○	○	○			○				○
50		C5131	●	○	●	○	●	○	○	○	○	○	○	○			○				○
56		C5141	●	○	●	○	●	○	○	○	○	○	○	○			○				○
73		C5231	●	○	●	○	●	○	○	○	○	○	○	○			○				○
73		C5241	●	○	●	○	●	○	○	○	○	○	○	○			○				○
181		C5321	●	○	●	○	●	○	○	○	○	○	○	○			○				○
189		C5341	●	○	●	○	●	○	○	○	○	○	○	○			○				○
466	HPM	HP4931						●	●												
75	SOLID^2	JSE512	●	○	●	○	●	○	○	○	○	○	○	○			○				○
79		JSE513	●	○	●	○	●	○	○	○	○	○	○	○			○				○
85		JSE514	●	○	●	○	●	○	○	○	○	○	○	○			○				○
196		JSB512	●	○	●	○	●	○	○	○	○	○	○	○			○				○
95		JS553	●	●	●	●	●	●	●	●	●	●	●	●			●				○
115		JS554	●	●	●	●	●	●	●	●	●	●	●	●			●				○
443		JS412						●	●					●			●				
446		JS413						●	●					●			●				
485		S4321						●	●					●			●				
449		S4521						●	●					●			●				
454		S4531						●	●					●			●				
463		S4651						●	●	●											
174		JS520	●	○	○	○	●	●	●	●	○	●	○	●			●				○
178		JS522	●	●	●	●	●	●	●	●	○	●		●			●				○
198		JS532	●	○	●	●	●	●	●	●	○	●		●			●				○
202		JS533	●	○	●	●	●	●	●	●	○	●		●			●				○
206		JS534	●	○	●	●	●	●	●	●	○	●		●			●				○
214		JS506	●	○	●	●	●	●	●	●	○	●	●	●			●				○
218		JS509	●	○	●	●	●	●	●	●	○	●	●	●			●				○
166		JS564	●	○	●	●	●	●	●	●	●	●	●								
170		JS565	●	○	●	●	●	●	●	●	●	●	●								
354		JS720			●	●					●	●									
374		JS730			●	●					●	●									
326		JS754		○	●	●					●	●									
343		JS755		○	●	●					●	●									
474	HSM/TORNADO	JH40						●		●				●							
313, 517		JH112					●						●								
507		JH120											●								
509		JH130											●								
303, 514		JH142	●	●			●						●								
520		JH150					●						●								
522		JH160	●	○									●								
481		JH410						●		●				●							
477		JH421						●		●				●			●				
483		JH440						●	●	●				●			●				
488		JH450						●	●	●				●			●				
490		JH460						●		●		●		●			●				
417		JH710									●	●									
427		JHB720			●	●		●	●	●	○	●		●			●				
429		JH721									●	●									
431		JH722									●	●									
431		JH724			●	●					●	●									
431		JH726			●	●					●	●									
421		JH730									●	●									
405		JH734	○	●	●						○	●									
407		JH736	○	●	●						○	●									
415		JH740									●	●									
409		JH744	○	●	●						○	●									
411		JH746	○	●	●						○	●									
413		JH770									●	●									
425		JH780									●	●									
419		JH790									●	●									
222		JH910	●	○	●	●	●				●	●					●				●
226, 511		JH930	●	○			●				●	●	●								
228, 311		JHB970	●	○	●	●					●	●									

● Erste Wahl, ○ Alternative

Zusammenfassung

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306	Stabilizer	ST5341	●	●			●														
276		ST5541	●	●			●														
140		ST5551	●	●	●	●	●	●	●	●	●	●	●	●		●					○
501	HPM	JHP170											●								
470	Solid²	S4931						●	●												
378	HPM	JHP751									●	●									
381		JHP760			●	●															
385		JHP770										●									
392		JHP780									●										
381		JHP794			●	●															
299		JHP951	●	○			●														
293		JHP993	●	○			●														
423		JHP994									●	●									
504	HFM	JHF181	○	○			●				●	●	●								
504		SHF712																			
230		JHF980	●	○	●	●	●				●	●	○								
531	MINI	JMB112											●								
524		JME142											●								
529		JME144											●								
494		JM403/404/406						●	●												
496		JM413/416						●	●	●				●		●					
496		SMB413/414/416						●	●					●		●					
264		JMB542	●	●	●	●		○	○	○		●	○								○
267		JMB562	●	●	●	●		○	○	○		●	○								○
271		JMB563	●	●	●	●		○	○	○		●	○								○
254		JME542	●	●	●	●		○	○	○		●	○								○
257		JME562	●	●	●	●		○	○	○		●	○								○
261		JME564	●	●	●	●		○	○	○		●	○								○
261		SMB713/714/416																			
261		JME714/716									●	●									
606	MINI DIAMOND	JMB642/JMB662																			●
606		JMB662																			●
604		JME642																			●
604		SMB614/616																			●
594	DIAMOND	JD620																			●
596		JD630																			●
598		JD640																			●
600		JD660																			●
539	COMPOSITE	D8961													●		●				
542		JC845													●		●				
544		JC850													●		●				
546		JC860													●		●			●	
548		JC870													●		●			●	
554		JC871													●		●			●	
560		JC875													●		●				
564		JC876													●		●				
568		JC877													●		●				
572		JC880													●		●				
574		JC885													●		●				
576		JC898																●	●		
578		JC899																●	●		
581	PCD	JPD850													●		●				
583		JPD880													●		●				
585		JPD890													●		●				

Zusammenfassung

Seite	Produktfamilie	Werkzeugbezeich-nung	P1-8	P11-12	M1-3	M4-5	K1-7	N1	N2-3	N11	S1-3	S11-13	H3-31	TS1	TS2-3	TS4	TP1	TP2-3	TP4	Honeycomb	GR
589	VHM	J28												●							
237		J36	○	●	○	○	○	○	●	●	○	○		○			○				
240		HK/HKM	●		●	●	●	●	○		●	●	●	●			●				
251		V31	●	○	●	○	●	●	●	●	●	●	●	●			●				●
234		J29	●	●	●	●	●	●	●	●	●	●	○	●			●				●
587		J93F												●			●				
399	Ceramic	JCG790									●										
669	X-HEADS SOLID[2]	XS5021	●	●	●	●	●	○	○	○	○	○	●	●			●				○
671		XS5061	●	●	●	●	●	○	○	○	○	○	●	●			●				○
620		XSE550	●	●	●	●	●	●	●	●	●	●	●	●			●				○
637		XSB540	●	○	●	●	●	●	●	●	○	●	○	●			●				○
639		XSE720	○	●	●	●					●	●									
651		XSE450						●	●	●				●			●				
645		XSB720	○	●	●	●					●	●									
655	X-HEADS HSM/TORNADO	XHT740	○	●	●						○	●									
658	X-HEADS HFM	XHF580	●	●	●	●	●				○	○	○								
663		XHF780	○	○	●	●					●	●	○								
680	X-HEADS VHM	XVE540	●	●	●	●	●	●	●	●	○	○	○	●			●				○
685		XVE510	●	●	●	●	●	○	○	○	○	○		●			●				○
688		XVB510	●	●	●	●	●	○	○	○	○	○		●			●				○
692		XVC506/509/512	●	●	●	●	●	○	○	○	○	○		●			●				○
696		XVK310	●	●	●	●	●	●	●	●	○	○	○	●			●				○

● Erste Wahl, ○ Alternative

Code-Schlüssel

Vollhartmetall-Schaftfräser (neu)

R	S	4321	-	100	D	2	R050	.0	Z3	C	,	AXT
1	2	3		5	6	7	8	9	10	11		12

Vollhartmetall-Schaftfräser

R	JS	720	100	D	2	R050	.0	Z6	C	,	HXT
1	2	3	5	6	7	8	9	10	11		12

X-Head Köpfe

R	XSE	550	E10	100	D	2	R050	Z4	A	,	SIRA
1	2	3	4	5	6	7	8	10	11		12

1. Fräsertyp

Leer = Standard (Katalog) Produkt
R = Nachgeschliffenes Produkt (komplett)
RK = Nachgeschliffenes Produkt (stirnseitig)

2. Produktprogramm

J = VHM
JC = Verbundwerkstoffe
JD = Diamant
JH = HSM/Tornado
JHF = HFM
JHP = HPM
JM = Mini
JS = SOLID²
JPD = PCD
JCO = HSS-Co
JCG = Keramik
C = C-Serie
ST = Stabilizer
XS* = X-Head SOLID²
XH* = X-Head HSM/Tornado
XV* = X-Head VHM
XHF = X-Head HFM

3. Geometrie

Eine dreistellige Zahlenkombination gibt die Schneidgeometrie an. Beispiel: 111, 951, 553, 514 usw.

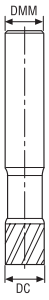
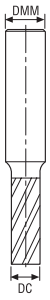
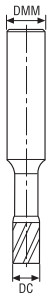
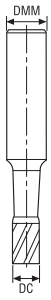
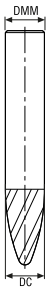
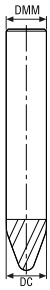
4. Anschlussgröße

Diese Abbildung zeigt die Größe der Gewindeverbindung zwischen Kopf und Adapter
E10 = 10 mm
E12 = 12 mm
E16 = 16 mm
E20 = 20 mm
E25 = 25 mm

5. Fräsdurchmesser

Metrisch = 3-stelliger Code (im Fall eines 4-stelligen Codes – xx,xx mm)
Zoll = ein Punkt gefolgt von einem 3-stelliger Code
Beispiel: Zoll = 4-stelliger Code (0250 = 1/4")

6. Ausführung

(DC = DMM)		(DC < DMM)			(DC > DMM)
					
D	**E**	**F**	**G**	**J**	**P**
Form					
					
N		**X**		**T**	

7. Werkzeuglänge

Eine einzelne Zahl gibt die Werkzeuglänge an, im Vergleich zu anderen Werkzeugen mit derselben Geometrie.

9. Aufnahmetyp

0 = Zylindrisch
3 = Weldon
5 = Whistle Notch
9 = Safe-Lock

10. Schneidenzahl

Anzahl der Schneiden des Fräsers
Beispiel: PCEDC2 = 2 Schneiden, PCEDC6 = 6 Schneiden

11. Kühlschmiermittelkanäle

LEER = Keine interne Kühlschmiermittelzufuhr
A = Mit interner Kühlschmiermittelzufuhr
C = Spanteiler

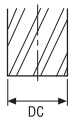
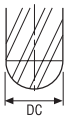
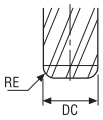
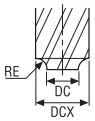
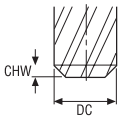
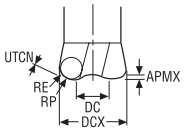
12. Sorten

Ein 4-stelliger Code spezifiziert die Beschichtung des Fräsers.

MEGA =	MEGA	DURA =	DURA
MT =	MEGA-T	NXT =	NXT
M64 =	MEGA-64	HXT =	HXT
M64 T =	MEGA-64-T	STAX =	STAX
SIRA =	SIRON-A	TAN =	TAN
HEMI =	HEMI	M9 =	M9
DIA =	DIAMOND	AXT =	AXT

Bezeichnung

8. Fräserausführung

Scharfe Schneide	Kugelkopf	Ecken -radius	Konvexradien -fräsen	Fase	Hochvorschubfräser
					
S	**B**	**R...**	**K...**	**C**	**H**

Radiusgröße für Produkte mit konvexem oder konkavem Radius

000 = Für metrische Werkzeuge ist die Ausführung in einem dreistelligen Zahlencode angegeben.
Durch 100 dividiert, erhält man den tatsächlichen Eckenradius in Millimeter.

.000 = Für Werkzeuge in Zollabmessungen ist die Ausführung in einem 4-stelligen Zahlencode angegeben (d. h. ein Punkt, gefolgt von einer dreistelligen Zahl).
Die Abbildung zeigt die Größe des Eckenradius in *Zoll* (e.g. R.100 = Eckenradius 0,100").

Code-Schlüssel

X-Heads – Schäfte

X	E10	100	E	2	-	055	-	00	.0	S
1	2	3	4	5		6		7	8	9

1. Produktprogramm

X = X-Head-Zylinderschaft

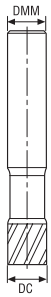
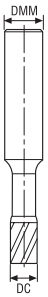
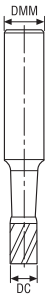
2. Anschlussgröße

Diese Abbildung zeigt die Größe der Gewindeverbindung zwischen Kopf und Adapter
E10 = 10 mm
E12 = 12 mm
E16 = 16 mm
E20 = 20 mm
E25 = 25 mm

3. Schaftdurchmesser

Metrisch = 3-stelliger Code
Zöllig = ein Punkt gefolgt von einem 3-stelligen Code
Beispiel: (050 = metrisch, 5 mm)/(.500 = zöllig, 1/2 Zoll)

4. Ausführung

(DC = DMM)	(DC < DMM)	
		
E	**G**	**J**

5. Werkzeuglänge

Eine einzelne Zahl gibt die Werkzeuglänge an, im Vergleich zu anderen Werkzeugen mit derselben Geometrie.

6. Gesamtlänge

Metrisch = 3-stelliger Code
Zöllig = 3-stelliger Code mit einem Punkt nach der ersten Ziffer
Beispiel: (055 = metrisch, 55 mm)/(2.50 = zöllig, 2 1/2 Zoll)

7. Kegelwinkel

Gibt den Konuswinkel an.
Beispiel: (00 = 0°; 05 = 5°; 10 = 10°)

8. Aufnahmetyp

0 = Zylindrisch
3 = Weldon
5 = Whistle Notch
9 = Safe-Lock

9. Werkstoffarten

Gibt die verschiedenen verfügbaren Schaftwerkstoffe an.
S = Stahl
DM = Densimet
E = Vollhartmetall

Ihre Vorteile

Individuelle Lösungen - Sonder- und modifizierte Werkzeuge



Falls Standardprodukte nicht für Ihre Anwendung passen, haben wir individuelle Sonderlösungen für Sie. Steigern Sie Ihre Produktivität!
Zusätzlich zu unseren Standardprodukten bieten wir:

Werkzeuge nach Kundenwunsch
Modifizierte Geometrien oder Formwerkzeuge für kundenspezifische Anforderungen. Wir arbeiten mit Ihnen zusammen, um eine passende Lösung zu finden. Zum Beispiel:

- Modifizierte Werkzeuge mit Standard-Geometrie
- VHM-Formfräser für Fasen und Radien (MEP, Mechanised Edge Profiling)
- Tannenbaumfräser
- Schwalbenschwanz
- Konischer Kugelkopf
- Kondylusfräser
- Formwerkzeuge
- Tonnenfräser

Modifizierte Werkzeuge
Für spezielle Anforderungen bietet Seco die Möglichkeit einer schnellen Modifizierung auf Basis von Jabro-Werkzeugen an, wie z.B.:

- Eckenradius/Fase
- Freilegung, inkl. Verlängerung
- Beschichtung (für unbeschichtete Werkzeuge)
- Kleinerer Werkzeugdurchmesser
- Spanbrecher
- Weldon/Safelock
- Externe Kühlschmiermittelzufuhr

NOCH LANGE KEIN GRUND ZUM WEGWERFEN

Dank ihrer hervorragenden Kombination aus Hartmetallsubstraten, hoch verschleißfesten Beschichtungen, optimierter Geometrie und kontrollierter Schneidkantenpräparation zeigen die Hartmetallwerkzeuge der neuesten Generation von Seco bemerkenswerte Leistungen.

Aber auch die hochwertigsten Werkzeuge weisen früher oder später Zeichen von Verschleiß an der Schneide auf. Bei kontrolliertem Verschleiß und rechtzeitigem Ersatz können diese Werkzeuge wieder aufbereitet werden. Dadurch reduzieren Sie Ihre Anschaffungskosten erheblich. Wir nutzen die gleichen modernen Technologien, um unsere Vollhartmetallfräser nachzuschleifen, wie um neue Fräser herzustellen.

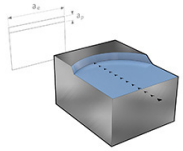
IHRE VORTEILE DURCH NACHSCHLEIFEN

- Die Werkzeuge werden in der original Jabro-Ausführung (Geometrie, Kantenpräparation und Beschichtung) wieder aufbereitet.
- Deutliche Kosteneinsparungen durch wiederholten Einsatz desselben Vollhartmetallwerkzeuges.
- Mit unserer kostenlosen Recondition-Box erhalten Sie gleichzeitig einen vorbereiteten Lieferschein.
- Kostenlose, zuverlässige Abholung am Tag, nachdem Sie Ihren Seco-Kontakt benachrichtigt haben.
- Schneller und einfacher Service - wir haben alles für Sie vorbereitet, Sie brauchen nur noch anzurufen!
- Rücklieferung über den normalen Seco-Lieferweg.
- Sichere Transport- und Lagermöglichkeit der aufbereiteten Werkzeuge durch die gleiche Verpackung wie bei Neuwerkzeugen.
- Ein neuer Versandaufkleber ist beigefügt.
- Recondition ist ein wichtiger Schritt für die Umwelt! Secos Verfahren sind weltweit zertifiziert gemäß ISO14001.
- Die Qualität der einzelnen Verfahren ist durch ISO9001 zertifiziert.

Basisbearbeitungen:

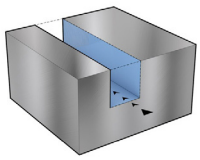
Planfräsen:

Vorgang, bei dem das Werkzeug mit weniger als 180° Kontaktbogen eingreift.
Eingriff:
Kleine Schnitttiefe a_p und große Schnittbreite a_e.



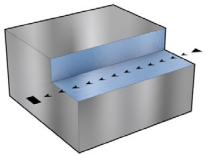
Nutfräsen:

Volle Eingriffsbreite des Fräsers
Der volle Durchmesser ist im Eingriff, d.h. a_e entspricht DC und a_p ist bis zu 2 x DC abhängig von der genutzten Zerspanungsmethode.



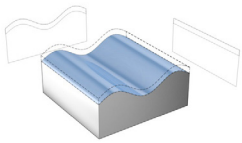
Eck-/Konturfräsen:

Bei der Hauptschneide
große Schnitttiefe a_p
kleine Eingriffsbreite a_e



Kopierfräsen:

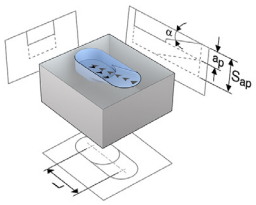
Kleine Spanquerschnitte mit Werkzeugen mit großen Radien (a_p und a_e sind klein).



Weitere Bearbeitungsstrategien:

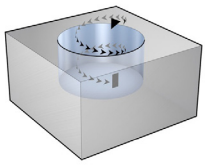
Einwärtskopieren:

Öffnen einer Tasche durch Zustellung in z unter einem Winkel.



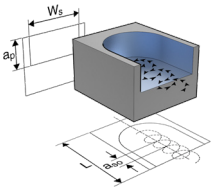
Bohrzirkularfräsen:

Öffnen einer Bohrung durch zirkulare Zustellung in z-Richtung.



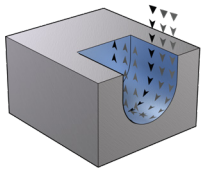
Trochoides Fräsen:

Öffnen einer Nut durch Überlagerung einer Kreisbewegung mit einer Linearbewegung (Trochoides Fräsen ist die Umsetzung von Nutfräsen in Konturfräsen).



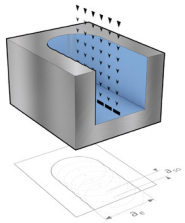
Bohr- und Ziehfräsen:

Bearbeitung einer 3D-Kontur durch bohrende Zustellung.



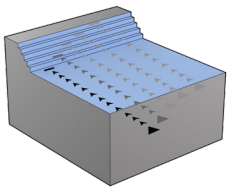
Tauchfräsen:

Öffnen einer tiefen Nut durch Bohrbewegungen in z.



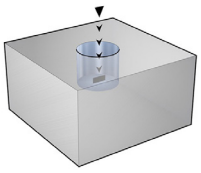
Fräsen in Höhenlinien (Z-Linie):

Bearbeitung einer Oberfläche durch kurze Bohr- und Tauchbewegungen in z, dann Tasche öffnen.



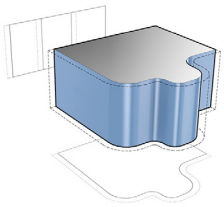
Bohren:

Zustellung in z.



Dynamisches Fräsen

Definierte Werkzeugwege mit konstantem Kontaktbogen für zuverlässige Schruppbearbeitungen von einfachen und komplexen Formen.
Die großen axialen (a_p) und kleinen radialen Schnitttiefen (a_e) kombiniert mit hohen Vorschüben pro Zahn (f_z) und Schnittgeschwindigkeiten (v_c) sorgen für hohe Produktivität.



Definitionen, Bearbeitungsstrategien:

Allgemeine Bearbeitung:
Bearbeitungsstrategie für allgemeinen Einsatz. Verhältnis a_e-a_p sehr stark abhängig von der Bearbeitung.
Werkzeugmerkmale: Werkzeuge weisen sehr große Schneidenlängen und dünne Kerndurchmesser auf. Keine hohen Toleranzanforderungen.
Maschinenanforderungen: Keine speziellen Anforderungen.
Beim Einsatz der CNC-Technologie sind keine modernen Bearbeitungsmethoden möglich.
Nur durchschnittliche Ergebnisse beim Zeitspanvolumen Q (cm^3/min).
Anwendungsgebiet ist die Kleinserienfertigung mit vielen verschiedenen Werkstoffen.

Hochleistungsbearbeitung (HPM):
Eine Bearbeitungsstrategie, bei der sehr hohe Zeitspanvolumen zu erzielen sind.
Typisch für diese Strategie ist a_e = 1 x DC und a_p = 1 bis 1½ x DC je nach zu bearbeitendem Werkstoff.
Mit HPM erzielen Sie extrem hohe Zeitspanvolumen in weit geringerer Zeit als bei der konventionellen Bearbeitung.
Werkzeugmerkmale: Speziell geformte Spankammern im Werkzeug, Beschichtung, mit oder ohne Weldon.
Maschinenanforderungen: Hohe Stabilität, hohe Energieanforderungen, CNC-Steuerung, stabiles Klemmsystem.
Anwendungsgebiet: Serienproduktion, wo Produktions-/Lieferzeit sehr wichtig ist oder bei Einzelproduktion, wo hohe Zeitspanvolumen Q (cm^3/min) gefordert sind.

Hochvorschubbearbeitung (HFM)
Bearbeitungsstrategie, bei der hohe Vorschübe mit vollem Eingriff im Werkzeugdurchmesser (a_e) in Kombination mit einem kleinen a_p erzielt werden können.
Mit Hochvorschubbearbeitung erzielen Sie Zeitspanvolumen und/oder hohe Oberflächengüten bei einem im Vergleich zur allgemeinen Bearbeitung sehr viel höheren Vorschub.
Werkzeugmerkmale: Speziell entwickelte Schneidengeometrie, sehr kurze Schneidlänge und angepasste Beschichtung.

Maschinenanforderungen: Hohe Stabilität, Möglichkeit für hohe Vorschubgeschwindigkeiten (v_f).
Ein großer Vorteil dieser Technologie ist ihre große Bedienerfreundlichkeit; die Programmierung in CAM lässt sich einfach, sicher und schnell vornehmen. Durch Fräsen in Höhenlinien (mit konstanter Schnitttiefe) kann man ohne viel Erfahrung sogar komplexe Formen recht einfach programmieren.
Anwendungsgebiet: Das Anwendungsgebiet reicht von normalem zu gehärtetem Stahl, Titan und Rostfrei, die Bearbeitung eignet sich sehr gut zum Vorschlichten vor der HSM-Bearbeitung.
Auch für tiefe Plattensitze geeignet.

Mikrofräsen:
Bearbeitungsstrategie, bei der extrem kleine Werkzeugdurchmesser verwendet werden.
Werkzeugmerkmale: Durchmesserbereich von 0,1 bis 2,0 mm, kleine Schnittlängen, umfangreiches Programm an Freilegungen, hohe Präzision, Beschichtung.

Maschinenanforderungen: Hohe Spindelgenauigkeit, hohe Drehzahlen, CNC-Steuerung.
Anwendungsgebiet: Herstellung von Kavitäten wie Nuten, Plattensitze, Bohrungen oder Gravierungen in verschiedenen Werkstoffen.

Hochgeschwindigkeitsbearbeitung:
Bearbeitungsstrategie mit einer Kombination aus kleinen Spanquerschnitten und hohen Schnittgeschwindigkeiten sowie hohen Vorschubgeschwindigkeiten.
Je nach Bearbeitungsmethode können hohe Zeitspanvolumen und ein geringer R_a-Wert erzielt werden. Typisch für diese Strategie sind die geringen Schnittkräfte, geringe Erwärmung des Werkzeuges und Werkstückes, geringe Gratbildung und hohe Maßgenauigkeit am Werkstück.

Durch die Hochgeschwindigkeitsbearbeitung erzielen Sie Zeitspanvolumen und/oder hohe Oberflächengüten bei einer im Vergleich zur allgemeinen Bearbeitung sehr viel höheren Schnittgeschwindigkeit.
Werkzeugmerkmale: Stabile Ausführung (dicker Kerndurchmesser und kurze Schneidenlänge), durchgängig geformte Spankammern für gute Spanabfuhr, Beschichtung.

Maschinenanforderungen: Schnelle CNC-Steuerung, hohe Maximaldrehzahlen und höchste Stabilität.
Anwendungsgebiet: Werkzeug- und Formenbau bei Vorschlicht- oder Schlichtbearbeitungen in gehärtetem Stahl (48-62 HRC).
Mit dem richtigen Werkzeug und modernen Bearbeitungsmethoden kann diese Technologie bei den meisten anderen Werkstoffen ebenfalls eingesetzt werden.

Dynamisches Fräsen:
Definierte Werkzeugwege mit konstantem Kontaktbogen für zuverlässige Schruppbearbeitungen von einfachen und komplexen Formen. Die großen axialen (ap) und kleinen radialen Schnitttiefen (ae) kombiniert mit hohen Vorschüben pro Zahn (fz) und Schnittgeschwindigkeiten (Vc) sorgen für hohe Produktivität.

Dieses CAM-basierte Schruppverfahren, oder Dynamisches Fräsen, legt den Fokus auf den Kontaktbogen des Werkzeuges und die mittlere Spanlast.

Durch Verringerung des Kontaktbogens, entsteht weniger Wärme bei der Schruppbearbeitung. Der Kontaktbogen wird durch geringe seitliche Zustellungen reduziert. Eine geringere Kontaktmenge führt zu weniger Reibung und somit zu weniger Wärme zwischen den Schneidkanten des Werkzeugs und dem Werkstück, das bearbeitet wird. Diese niedrigeren Bearbeitungstemperaturen wiederum ermöglichen höhere Schnittgeschwindigkeiten und kürzere Zykluszeiten.

Dynamisches Fräsen

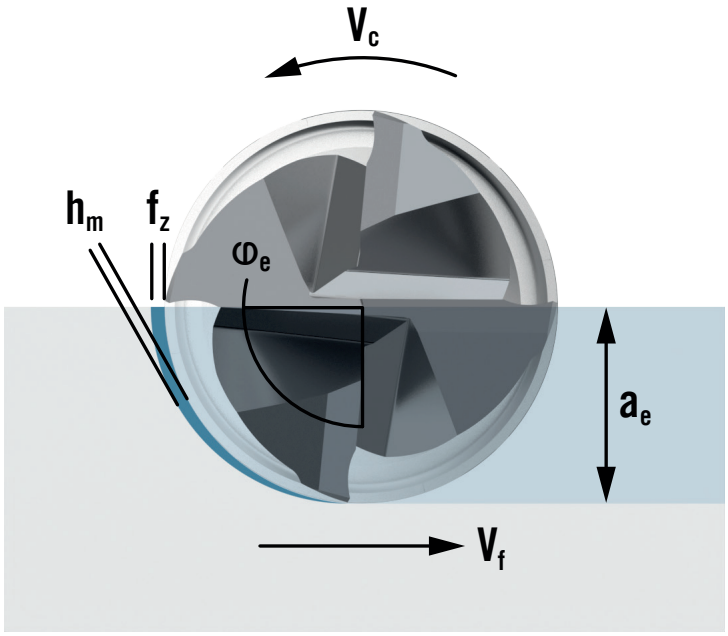
Was versteht man unter „Dynamischem Fräsen“?

Die aktuellen CAM-Pakete bieten Werkzeugbahnen für spezifische Innen-/Außenradien an. Bei konventionellen Werkzeugbahnen ändert sich der Kontaktbogen stets. Die neuen CAM-Software-Pakete verwenden automatisch verschiedene Vorschübe, um den Kontaktbogen zu steuern und die Spanlast konsistent zu halten.
Dieses CAM-basierte Schruppverfahren, oder Dynamisches Fräsen, legt den Fokus auf den Kontaktbogen des Werkzeuges und die mittlere Spanlast. Durch Verringerung des Kontaktbogens, entsteht weniger Wärme bei der Schruppbearbeitung. Der Kontaktbogen wird durch geringe seitliche Zustellungen reduziert. Eine geringere Kontaktmenge führt zu weniger Reibung und somit zu weniger Wärme zwischen den Schneiden des Werkzeugs und dem Werkstück, das bearbeitet wird. Diese niedrigeren Bearbeitungstemperaturen wiederum ermöglichen höhere Schnittgeschwindigkeiten und kürzere Zykluszeiten. Auch die Zerspankraft ist geringer. Das ermöglicht eine größere Schnitttiefe (APMXS).

Beim Dynamischen Fräsen wird der Kontaktbogen durch Anwendung verschiedener Frässtrategien konstant gehalten.

Durch optimale Werkzeugbahnen und einen konstanten Kontaktbogen kann der Werkzeugradius den Innenradius ohne Gefahr einer Überlastung bearbeiten. Mit diesen Merkmalen können unsere Werkzeuge fürs Dynamische Fräsen (JS554-3C, JS564, JS656, JS754, JS755 und JS720) mehr Material pro Durchgang in der Schruppbearbeitung entfernen - das führt zu kürzeren Zykluszeiten und längerer Standzeit. Durch das konstante verbliebene Material kann das Schlichtwerkzeug eine höhere Oberflächengüte bei längerer Standzeit erzeugen.

Einfluss von Kontaktbogen und Vorschub pro Zahn



Ihre Vorteile

Erzielen Sie hohe Geschwindigkeiten in Superlegierungen mit Seco Keramik-Schaftfräsern

Zum schnellen Zerspanen der härtesten hitzeresistenten Superlegierungen (HRSA) brauchen Sie ein Werkzeug, das genauso robust und fortschrittlich ist wie die Werkstoffe selbst.

Optimieren Sie Ihre Prozesse und zerspanen Sie Ihre HRSA-Werkstücke deutlich schneller mit diesen leistungsstarken Keramik-Vollhartmetallfräsern.

Einen Überblick über alle CERAMIC-Produkte finden Sie auf Seite 399.



Hybrid-Composite-Werkstoffe mit innovativer Geometrie meistern

Der JC899 mit patentierter Geometrie eignet sich speziell für hybride Plattenpakete, wie CFRP-Ti und CFRP-Alu. Aufgrund des Linksdralls verhindert das Werkzeug eine Beschädigung der Oberfläche durch Delamination, Absplitterungen oder Spanmarken. Der JC899 mit Linksdrall und der rechtsschneidige STAX-Schlichter sorgen für eine hohe Oberflächengüte und verhindern Späne zwischen den zwei Schichten.

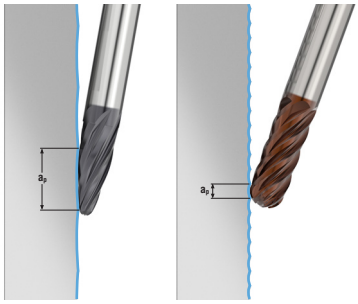
Nachbehandeln, Trennen, Säubern, Entgraten und Zusammenfügen der Werkstücke gehört der Vergangenheit an. Dies erhöht die Effizienz und verlängert die Standzeit.
Die Bohrungsbearbeitung kann mit dem JC898 Hochvorschub-Schruppwerkzeug ersetzt werden. Das Werkzeug wird in Bohrzirkularbearbeitung eingesetzt und ermöglicht dem JC899 einen kontinuierlichen Schnitt. Das erhöht den Ausstoß und verbessert Bohrungsgröße und Toleranz.

Seco JC898/JC899 finden Sie auf Seite 576 - 578.



Größere Stepover für schnelleres Schlichten

Die neuen Tonnenfräser von Seco Tools verkürzen zeitintensive Schlichtprozesse im Vergleich zu herkömmlichen Kugelkopffräsern um bis zu 80 Prozent. Die innovativen Werkzeuggeometrien und -formen ermöglichen eine schnelle Bearbeitung mit großen Stepover ohne Erhöhung der Schnittgeschwindigkeit. Anwender profitieren von geringeren Zykluszeiten, weniger Werkzeugwechseln und hoher Zuverlässigkeit sowie gleichbleibender Oberflächenqualität. Mit neuartigen CAM-Systemen erfolgt eine optimale Unterstützung bezüglich geringerem Werkzeugverschleiß.



Senken Sie das Risiko bei Mikrozerspanung

Erreichen Sie Präzision, Genauigkeit und hohe Oberflächengüten für kleinste Werkstücke mit den Seco Schaftfräsern. Das Produktprogramm an Mini-Fräsern bietet längere Standzeit, mehr Stabilität und Ruhe für Bearbeitungen, die mit dem bloßen Auge kaum sichtbar sind.

Die Vollhartmetallfräser für die Mikrozerspanung von Seco umfassen Eckfräser und Kugelkopffräser mit kleinem Durchmesser. Universal-Werkzeuge eignen sich für die meisten Werkstoff-Gruppen. Spezifische Werkzeuge eignen sich für Graphite und gehärteten Stahl.
Alle Werkzeuge sind mit einer dünnen Beschichtung für optimale Leistung versehen.

Einen Überblick über Seco Mini-Werkzeuge finden Sie auf Seite 12.

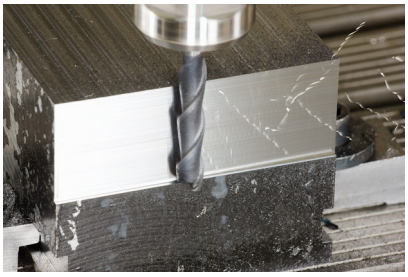


JS522 Schlichtfräser

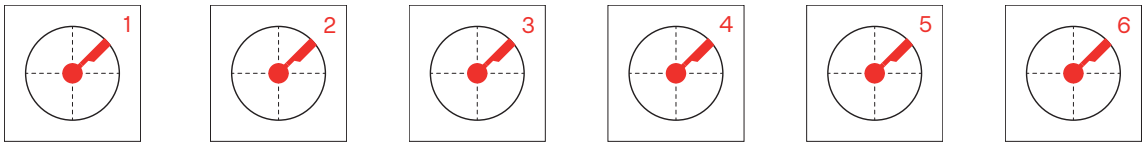
Der JS522 Schlichtfräser erfüllt die Anforderungen der Luft- und Raumfahrtbranche nach Rechtwinkligkeit, höchsten Oberflächengüten, hohem Zeitspanvolumen und effektiver Bearbeitung.

Mit einer Schneidenlänge von 5 x DC, einem größeren Kerndurchmesser, um Durchbiegung zu kompensieren, eignet sich der JS522 speziell zum Schlichten hoher Wandungen in einem Durchgang. Dies spart Zeit und bietet hohe Qualität. Das Werkzeug eignet sich für Serienbearbeitungen.

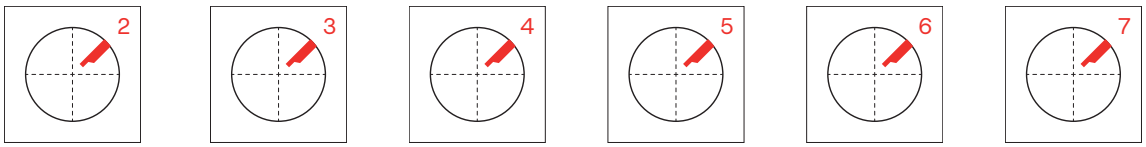
Seco JS522 finden Sie auf Seite 178 - .

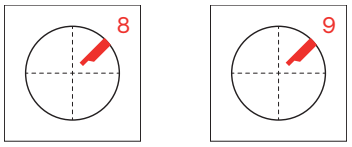


Zentrumsschnitt PCEDC

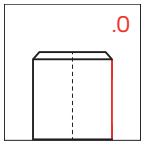


Kein Zentrumsschnitt PCEDC

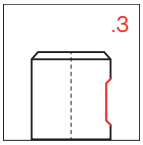




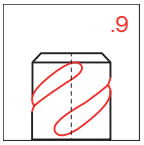
Zylindrisch



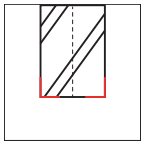
Weldon-Schaft



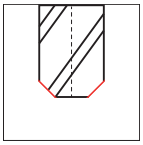
Safe-Lock™ Schaft



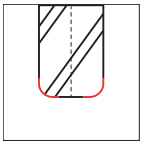
Scharfe Schneide



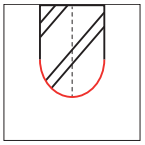
Fase



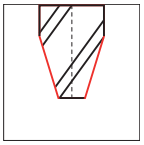
Eckenradius



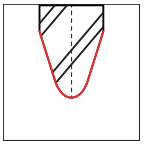
Kugelkopf



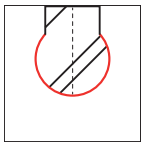
Scharfe Schneide



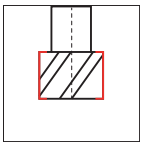
Konischer



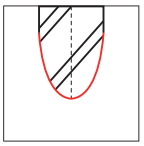
Fräser 250°



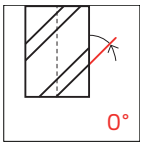
T-Form

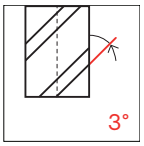


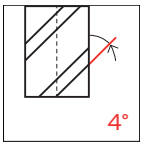
Kreissegment

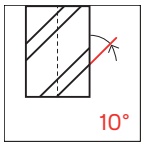


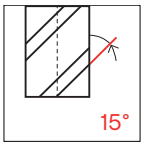
Drallwinkel

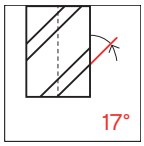


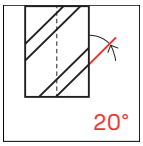


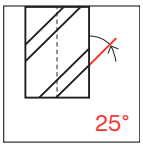


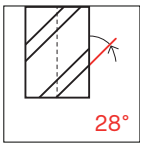


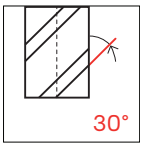


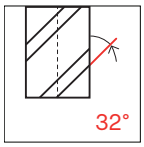


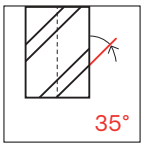


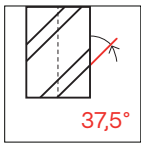


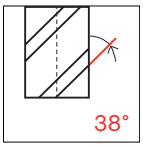


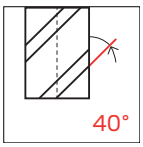


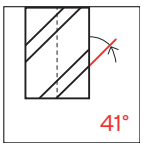


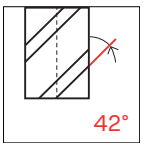


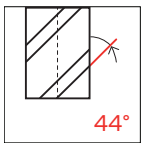


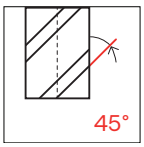


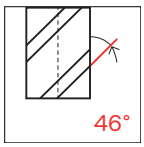


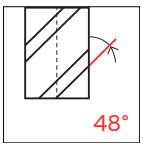


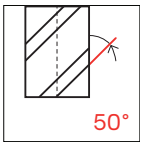




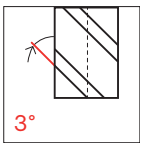


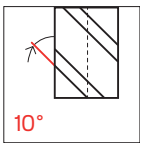


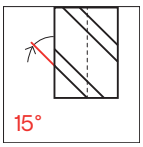




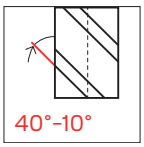
Drallwinkel Links



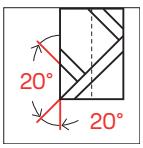


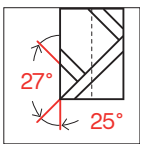


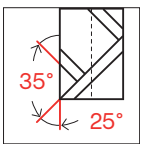
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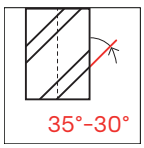


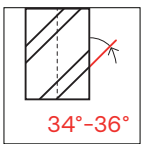
Drallwinkel links/rechts

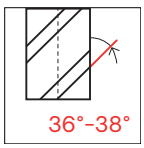


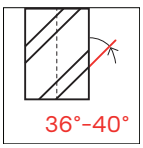


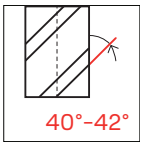




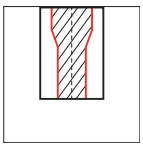




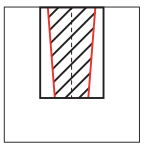




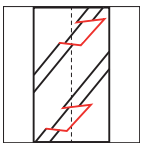
Verstärkter Kern



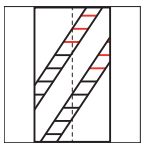
Konischer Kern



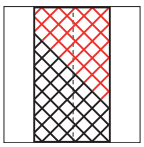
Spanteiler



Schruppprofil



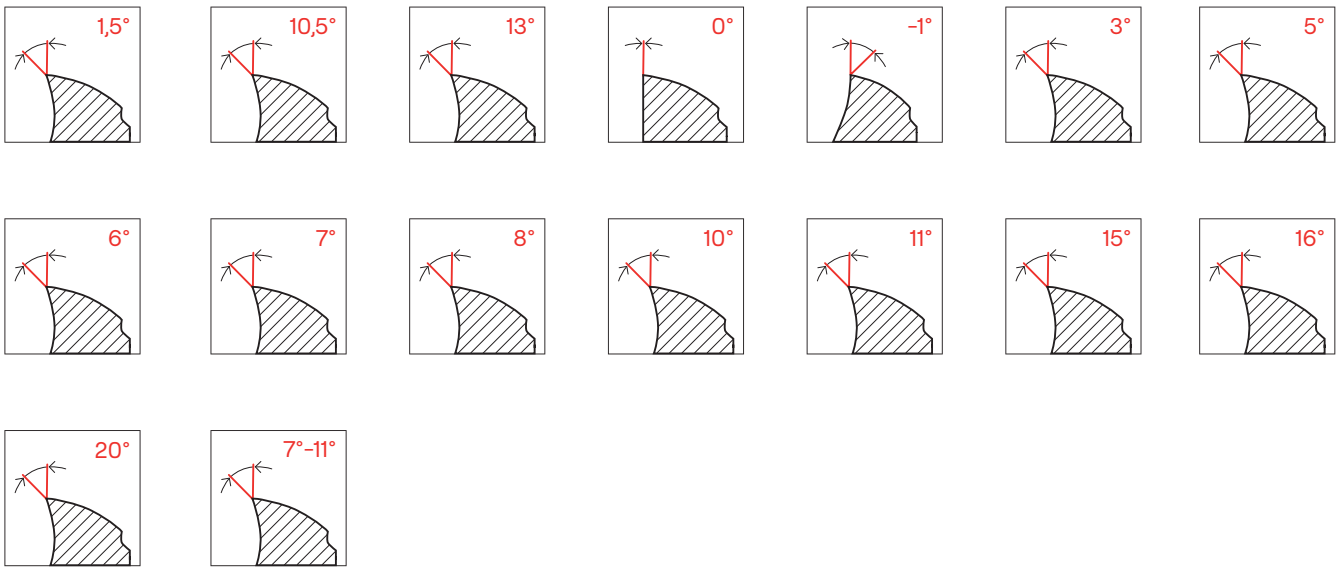
Fräserprofil



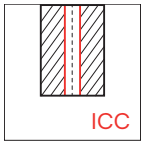
Spanwinkel Winkel



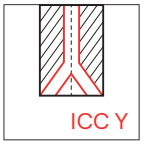
Spanwinkel Radial



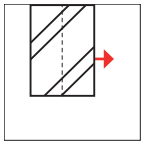
ICC Gerade



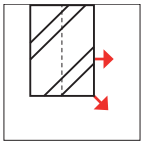
ICC und Y



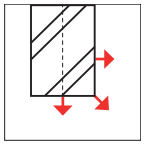
Radial



Radial/Einwärtskop-



Radial/Einwärtskop-



Symbole

DIAMOND

DIAMOND

DURA

DURA

HEMI

HEMI

HSCO

HSCO

HXT

HXT

MEGA

MEGA

MEGA-T

MEGA-T

MEGA-64

MEGA-64

MEGA-64-T

MEGA-64-T

NXT

NXT

STAX

STAX

SIRA

SIRON-A

TAN

TAN

AXT

AXT

Keramik

CERAMIC

PCD

PCD

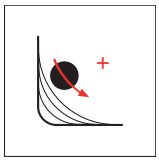
M9

M9

Nachschleifen möglich



Dynamisches Fräsen



Attribute Vollhartmetallfräsen und X-Head

ISO-Attribute	Erklärung
AP1	Teilweise Schnitttiefe
APMXS	Maximale axiale Schnitttiefe
BHTA	Konuswinkel
CA	Kollisionswinkel
CHW	Fasenbreite
CSP	Kühlschmiermittelzufuhreigenschaft
CZCMS	Maschinenseitiger Code der Anschlussgröße
CZCWS	Werkstückseitiger Code der Anschlussgröße
DC	Werkzeugdurchmesser
DCSFMS	Werkzeug-Auflagedurchmesser
DCSFWS	Werkstückseitiger Kontaktflächendurchmesser
DCX	Maximaler Werkzeugdurchmesser
DMM	Schaftdurchmesser
DN	Hinterer Schneidkopf-Durchmesser
FCEDC	Stirnschneiden
CSP	Kühlschmiermittelzufuhreigenschaft
L	Schneidenlänge
L2	Schneidenlänge 2
LF	Funktionale Länge
LN	Freilegung
LN2	Freilegung 2
LSCN	Länge der Pratze min.
NA	Winkel an der Freilegung
OAL	Gesamtlänge
PCEDC	Anzahl Peripherischneiden
PRFA/2	Halber Profilwinkel
PRFRAD1	Profilradius 1
PRFRAD2	Profilradius 2
PRFRAD3	Profilradius 3
PSIR	Werkzeugeinstellwinkel
RE	Eckenradius
RE2	Eckenradius 2
RP	Programmierter Radius
SA	Kugelsegmentwinkel
SIG	Spitzenwinkel
SW	Schlüsselgröße
TQ	Drehmoment
TQN	Mindestdrehmoment
TQX	Maximales Drehmoment
UTCN	Theoretische Abweichung

ISO-Attribute Minimaster

ISO-Attribute	Erklärung
APMXE	Maximale radiale Schnitttiefe
APMXS	Maximale axiale Schnitttiefe
AZ	Maximale Schneidenlänge
BEC	Hinterer Fasenwinkel
BHTA	Konuswinkel
CCER	Stirnschneidenradius
Cmax	Maximaler Bohrungsdurchmesser
Cmin	Minimaler Bohrungsdurchmesser
DC	Werkzeugdurchmesser
DCSFMS	Werkzeug-Auflagedurchmesser
DCSFWS	Aufnahmedurchmesser werkstückseitig
DCX	Maximaler Werkzeugdurchmesser
DMM	Schaftdurchmesser
DN	Hinterer Schneidkopf-Durchmesser
FCEDC	Stirnschneiden
FHA	Drallwinkel der Spankammer
KAPRS	Einstellwinkel
LE	Effektive Schneidenlänge
LF	Funktionale Länge
LPR	Länge Überstand
OAL	Gesamtlänge
RA	Freilegungswinkel
RE	Eckenradius
RMPX	Maximaler Einwärtskopierwinkel
RP	Programmierter Radius
RPMX	Maximale Drehzahl
SA	Kugelsegmentwinkel
SIG	Spitzenwinkel
UTCN	Theoretische Abweichung
ZEFP	Effektive Zähnezahl



UNIVERSAL

Das vollständige Programm an Vollhartmetall-Hochleistungsfräsern für hohe Produktivität und längere Werkzeugstandzeit besteht aus Schaftfräsern, Kugelkopffräsern und Kreissegmentfräsern. Dieses Programm umfasst universell geeignete Produkte und optimierte Schaftfräser für spezifische Werkstoffe.

Universell geeignete Produkte bieten volle Bearbeitungsflexibilität zu einem hervorragenden Preis-Leistungs-Verhältnis.

- C5121, C5131, C5141, C5231, C5241 und ST5551 Schaftfräser und Kugelkopffräser.
- JSE512, JSE513, JSE514, JS553, JS554, ST5551, JS564, JS565 und JS520 Schaftfräser, Mehrschneider und Schaftfräser mit Spanteiler
- C5121, C5141, JS522, JS553, JS554, ST5551, JH910, JH930, JHF980, J36, V31, JME542, JME562 und JME564 Schaftfräser, Hochvorschubfräser und VHM-Minifräser.
- C5021, C5041, JS506, JS509, HK, HKM und J29 Fasfräser und Formfräser.
- C5321, C5341, JSB512, JS532, JS533, JS534, JHB970, JMB542, JMB562 und JMB563 Kugelkopffräser.

Werkzeugauswahl Universal

									
Werkzeugbezeichnung		C5121	C5131	C5141	C5231	C5241	JSE512	JSE513	JSE514
Seite(n)		38	50	56	73	73	75	79	85
Produktfamilie		C-Series	C-Series	C-Series	C-Series	C-Series	SOLID²	SOLID²	SOLID²
Fräserausführung									
Auf-nahmen	Zylindrisch	■	■	■	■	■	■	■	■
	Weldon	■		■			■	■	■
Schneidenzahl		2	3	4	3	4	2	2	4
CSP									
	Metrisch	2-12	2-12	1-20			2-12	2-20	2-25
	Zoll	1/32-1	1/32-1	1/64-1 1/4	1/-5/8	3/4			
Verfügbare Längen		1,2,3,4,5,6,7,8	1,2,3,4	1,2,3,4,5,6,7,8,9	2,3	3	2	2,3	2,3
Bearbeitung									
									
SMG									
P1-8		●	●	●	●	●	●	●	●
P11-12		○	○	○	○	○	○	○	○
M1-3		●	●	●	●	●	●	●	●
M4-5		○	○	○	○	○	○	○	○
K1-7		●	●	●	●	●	●	●	●
S1-3		○	○	○	○	○	○	○	○
S11-13		○	○	○	○	○	○	○	○
H3 H5 H8 H11 H12 H21 H31		○	○	○	○	○	○	○	○
N1		○	○	○	○	○	○	○	○
N2-3		○	○	○	○	○	○	○	○
N11		○	○	○	○	○	○	○	○
TS1		○	○	○	○	○	○	○	○
TP1		○	○	○	○	○	○	○	○
GR		○	○	○	○	○	○	○	○

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative
*JS554 3C ist auch verfügbar. Kann für schweres Schruppen angewendet werden.

Werkzeugauswahl Universal

										
Werkzeugbezeichnung		JS553	JS554	ST5551	JS564	JS565	JS520	JS522	C5321	C5341
Seite(n)		95	115	140	166	170	174	178	181	189
Produktfamilie		SOLID²	SOLID²	Stabilizer	SOLID²	SOLID²	SOLID²	SOLID²	C-Series	C-Series
Fräserausführung										
Aufnahmen	Zylindrisch	■	■	■	■	■	■	■	■	■
	Weldon	■	■	□	■	■	□			
Schneidenzahl		3	4	5	4	5	5,6,8	2	2	4
CSP										
	Metrisch	2-25	3-25	6-25	3-20	4-20	4-25	6-32	1-12	1-20
	Zoll	1/8 - 1/2	1/4-1	1/4-1					1/64-1	1/64-1
Verfügbare Längen		1,2,3	1,2,3	1,2,3,4,5,6,8	2,3,4	2,3,4	2,3	4	1,2,3,4,5,6,7	1,2,3,4,5,6,7,8
Bearbeitung										
										
										
SMG										
P1-8		●	●	●	●	●	●	●	●	●
P11-12		●	●	●	○	○	○	●	○	○
M1-3		●	●	●	●	●	○	●	●	●
M4-5		●	●	●	●	●	○	●	○	○
K1-7		●	●	●	●	●	●	●	●	●
S1-3		●	●	●	●	●	○	○	○	○
S11-13		●	●	●	●	●	●	●	○	○
H3 H5 H8 H11 H12 H21 H31		●	●	●	●	●	○		○	○
N1		●	●	●	●	●	●	●	○	○
N2-3		●	●	●	●	●	●	●	○	○
N11		●	●	●	●	●	●	●	○	○
TS1		●	●	●			●	●	○	○
TP1		●	●	●			●	●	○	○
GR		○	○	○			○	○	○	○

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl Universal

									
Werkzeugbezeichnung		JSB512	JS532	JS533	JS534	C5021	C5041	JS506	JS509
Seite(n)		196	198	202	206	210	212	214	218
Produktfamilie		SOLID²	SOLID²	SOLID²	SOLID²	C-Series	C-Series	SOLID²	SOLID²
Fräserausführung									
Auf-nahmen	Zylindrisch	■	■	■	■	■	■	■	■
	Weldon		□	■	■			■	■
Schneidenzahl		2	2	3	4	2	4	3-4	3-4
CSP									
	Metrisch	2-12	1-20	1-20	2-20			3-12	3-12
	Zoll					1/4-1/2	1/4-3/4		
Verfügbare Längen		2	1,2,3	1,2	1,2,3	1	1	2	2
Bearbeitung									
									
SMG									
P1-8		●	●	●	●	●	●	●	●
P11-12		○	○	○	○	○	○	○	○
M1-3		●	●	●	●	●	●	●	●
M4-5		○	●	●	●	○	○	●	●
K1-7		●	●	●	●	●	●	●	●
S1-3		○	○	○	○	○	○	○	○
S11-13		○	●	●	●	○	○	●	●
H3 H5 H8 H11 H12 H21 H31		○				○	○	●	●
N1		○	●	●	●	○	○	●	●
N2-3		○	●	●	●	○	○	●	●
N11		○	●	●	●	○	○	●	●
TS1		○	●	●	●	○	○	●	●
TP1		○	●	●	●	○	○	●	●
GR		○	○	○	○	○	○	○	○

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl Universal

					
Werkzeugbezeichnung		JH910	JH930	JHB970	JHF980
Seite(n)		222	226, 511	228, 311	230
Produktfamilie		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HFM
Fräserausführung					
Auf-nahmen	Zylindrisch	■	■	■	■
	Weldon				
Schneidenzahl		3	5-6, 8	2	2,3,4,5
CSP					
	Metrisch	2-20	6-20	2-16	1-12
	Zoll				
Verfügbare Längen		2,3,4	2	1,2,3	1,2,3,4
Bearbeitung					
					
					
SMG					
P1-8		●	●	●	●
P11-12		○	○	○	○
M1-3		●		●	●
M4-5		●		●	●
K1-7		●	●		●
S1-3		●	●	●	●
S11-13		●	●	●	●
H3 H5 H8 H11 H12 H21 H31			●		○
N1					
N2-3					
N11					
TS1					
TP1		●			
GR		●			

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl Universal

					
Werkzeugbezeichnung		J29	J36	HK/HKM	V31
Seite(n)		234	237	240	251
Produktfamilie		VHM	VHM	VHM	VHM
Fräserausführung					
Auf-nahmen	Zylindrisch	■	■	■	■
	Weldon				
Schneidenzahl		1	3	2,3,4	4
CSP					
	Metrisch	0,2-6	2-20	1-10	6-28
	Zoll				
Verfügbare Längen		2	2	2	2
Bearbeitung					
					
					
SMG					
P1-8		●	○	●	●
P11-12		●	●		○
M1-3		●	○	●	●
M4-5		●	○	●	○
K1-7		●	○	●	●
S1-3		●	○	●	●
S11-13		●	○	●	●
H3 H5 H8 H11 H12 H21 H31		○		●	●
N1		●	○	●	●
N2-3		●	●	○	●
N11		●	●		●
TS1		●	○	●	●
TP1		●	○	●	●
GR		●			●

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl Universal

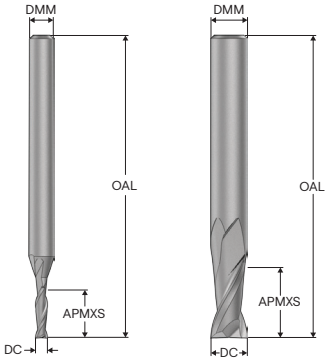
							
Werkzeugbezeichnung		JME542	JME562	JME564	JMB542	JMB562	JMB563
Seite(n)		254	257	261	264	267	271
Produktfamilie		MINI	MINI	MINI	MINI	MINI	MINI
Fräserausführung							
Auf-nahmen	Zylindrisch	■	■	■	■	■	■
	Weldon						
Schneidenzahl		2	2	4	2	2	3
CSP							
	Metrisch	2-20	0,5-3,0	0,5-3,0	0,2-3,0	0,5-3,0	1,0-3,0
	Zoll						
Verfügbare Längen		1,3,4,5,6	2,4,5,6,7	2,4	1,3,4,5,6	1,2,3,4,5,6	2,4
Bearbeitung							
							
							
SMG							
P1-8		●	●	●	●	●	●
P11-12		●	●	●	●	●	●
M1-3		●	●	●	●	●	●
M4-5		●	●	●	●	●	●
K1-7							
S1-3							
S11-13		●	●	●	●	●	●
H3 H5 H8 H11 H12 H21 H31							
N1		○	○	○	○	○	○
N2-3		○	○	○	○	○	○
N11		○	○	○	○	○	○
TS1							
TP1							
GR		○	○	○	○	○	○

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

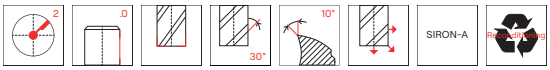
C5121

Allgemeine Anwendung – Universell – Eckfräser – 2 Schneiden – Zylindrisch – Scharfe Schneide





– Toleranzen:
– DMM=h5
– DC= h10
– Nachschleifen möglich, wenn DC ≥ Ø10 ist



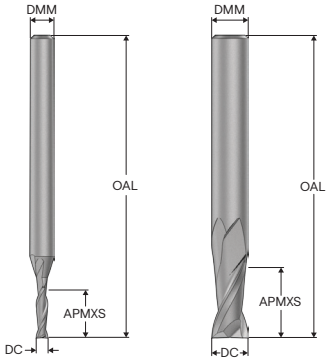
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm			
C5121-060D1S.0Z2	SIRA	10269100	1	D	6,0	6,0	9,0	57,0	2	Cylindrical	■
C5121-020F2S.0Z2	SIRA	10269091	2	F	2,0	3,0	4,0	38,0	2	Cylindrical	■
C5121-030D2S.0Z2	SIRA	10269093	2	D	3,0	3,0	6,0	38,0	2	Cylindrical	■
C5121-040D2S.0Z2	SIRA	10269096	2	D	4,0	4,0	8,0	50,0	2	Cylindrical	■
C5121-050F2S.0Z2	SIRA	10269098	2	F	5,0	6,0	10,0	57,0	2	Cylindrical	■
C5121-060D2S.0Z2	SIRA	10269101	2	D	6,0	6,0	12,0	57,0	2	Cylindrical	■
C5121-080D2S.0Z2	SIRA	10269103	2	D	8,0	8,0	16,0	63,0	2	Cylindrical	■
C5121-090F2S.0Z2	SIRA	10269105	2	F	9,0	10,0	22,0	72,0	2	Cylindrical	■
C5121-100D2S.0Z2	SIRA	10269106	2	D	10,0	10,0	22,0	72,0	2	Cylindrical	■
C5121-120D2S.0Z2	SIRA	10269108	2	D	12,0	12,0	25,0	83,0	2	Cylindrical	■
C5121-015F3S.0Z2	SIRA	10269090	3	F	1,5	3,0	4,5	38,0	2	Cylindrical	■
C5121-020F3S.0Z2	SIRA	10269092	3	F	2,0	3,0	6,3	38,0	2	Cylindrical	■
C5121-035F3S.0Z2	SIRA	10269095	3	F	3,5	4,0	12,0	50,0	2	Cylindrical	■
C5121-050F3S.0Z2	SIRA	10269099	3	F	5,0	6,0	16,0	57,0	2	Cylindrical	■
C5121-060D3S.0Z2	SIRA	10269102	3	D	6,0	6,0	19,0	63,0	2	Cylindrical	■
C5121-080D3S.0Z2	SIRA	10269104	3	D	8,0	8,0	20,0	63,0	2	Cylindrical	■
C5121-010F4S.0Z2	SIRA	10269089	4	F	1,0	3,0	4,0	38,0	2	Cylindrical	■
C5121-030D4S.0Z2	SIRA	10269094	4	D	3,0	3,0	12,0	38,0	2	Cylindrical	■
C5121-040D4S.0Z2	SIRA	10269097	4	D	4,0	4,0	14,0	50,0	2	Cylindrical	■
C5121-100D4S.0Z2	SIRA	10269107	4	D	10,0	10,0	35,0	89,0	2	Cylindrical	■
C5121-120D4S.0Z2	SIRA	10269109	4	D	12,0	12,0	50,0	100,0	2	Cylindrical	■

■ **Lagerstandard.**

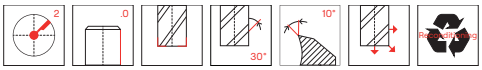
C5121

Allgemeine Anwendung – Universell – Eckfräser – 2 Schneiden – Zylindrisch – Scharfe Schneide – Zoll





—Toleranzen:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Nachschleifen möglich, wenn DC ≥ Ø.375 ist

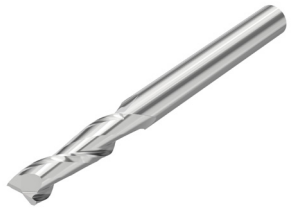


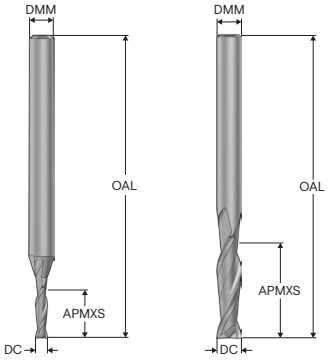
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
				Zoll	Zoll	Zoll	Zoll			
C5121-.375D1S.0Z2	10268850	1	D	0.375	0.375	0.625	2.000	2	Cylindrical	■
C5121-.500D1S.0Z2	10268858	1	D	0.500	0.500	0.625	2.500	2	Cylindrical	■
C5121-.047F2S.0Z2	10268818	2	F	0.047	0.125	0.109	1.500	2	Cylindrical	■
C5121-.063F2S.0Z2	10268820	2	F	0.063	0.125	0.125	1.500	2	Cylindrical	■
C5121-.094F2S.0Z2	10268824	2	F	0.094	0.125	0.188	1.500	2	Cylindrical	■
C5121-.125D2S.0Z2	10268828	2	D	0.125	0.125	0.250	1.500	2	Cylindrical	■
C5121-.156F2S.0Z2	10268833	2	F	0.156	0.188	0.313	2.000	2	Cylindrical	■
C5121-.188D2S.0Z2	10268835	2	D	0.188	0.188	0.375	2.000	2	Cylindrical	■
C5121-.250D2S.0Z2	10268841	2	D	0.250	0.250	0.500	2.000	2	Cylindrical	■
C5121-.313D2S.0Z2	10268846	2	D	0.313	0.313	0.500	2.000	2	Cylindrical	■
C5121-.375D2S.0Z2	10268851	2	D	0.375	0.375	1.000	2.500	2	Cylindrical	■
C5121-.438D2S.0Z2	10268856	2	D	0.438	0.438	1.000	2.750	2	Cylindrical	■
C5121-.500D2S.0Z2	10268859	2	D	0.500	0.500	1.000	3.000	2	Cylindrical	■
C5121-.563D2S.0Z2	10268864	2	D	0.563	0.563	1.125	3.500	2	Cylindrical	■
C5121-.625D2S.0Z2	10268865	2	D	0.625	0.625	1.250	3.500	2	Cylindrical	■
C5121-.750D2S.0Z2	10268869	2	D	0.750	0.750	1.500	4.000	2	Cylindrical	■
C5121-.875D2S.0Z2	10268872	2	D	0.875	0.875	1.500	4.000	2	Cylindrical	■
C5121-1.000D2S.0Z2	10268873	2	D	1.000	1.000	1.500	4.000	2	Cylindrical	■
C5121-.031F3S.0Z2	10268690	3	F	0.031	0.125	0.078	1.500	2	Cylindrical	■
C5121-.047F3S.0Z2	10268819	3	F	0.047	0.125	0.125	1.500	2	Cylindrical	■
C5121-.063F3S.0Z2	10268821	3	F	0.063	0.125	0.188	1.500	2	Cylindrical	■
C5121-.078F3S.0Z2	10268823	3	F	0.078	0.125	0.250	1.500	2	Cylindrical	■
C5121-.094F3S.0Z2	10268825	3	F	0.094	0.125	0.281	1.500	2	Cylindrical	■
C5121-.109F3S.0Z2	10268827	3	F	0.109	0.125	0.375	1.500	2	Cylindrical	■
C5121-.156F3S.0Z2	10268834	3	F	0.156	0.188	0.500	2.000	2	Cylindrical	■
C5121-.188D3S.0Z2	10268836	3	D	0.188	0.188	0.625	2.000	2	Cylindrical	■
C5121-.203F3S.0Z2	10268839	3	F	0.203	0.250	0.625	2.500	2	Cylindrical	■
C5121-.219F3S.0Z2	10268840	3	F	0.219	0.250	0.625	2.500	2	Cylindrical	■
C5121-.250D3S.0Z2	10268842	3	D	0.250	0.250	0.750	2.500	2	Cylindrical	■
C5121-.281F3S.0Z2	10268845	3	F	0.281	0.313	0.750	2.500	2	Cylindrical	■
C5121-.313D3S.0Z2	10268847	3	D	0.313	0.313	0.813	2.500	2	Cylindrical	■
C5121-.375D3S.0Z2	10268852	3	D	0.375	0.375	1.000	3.000	2	Cylindrical	■
C5121-.500D3S.0Z2	10268860	3	D	0.500	0.500	1.000	4.000	2	Cylindrical	■

■ **Lagerstandard.**

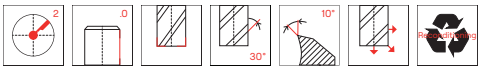
C5121

Allgemeine Anwendung – Universell – Eckfräser – 2 Schneiden – Zylindrisch – Scharfe Schneide – Zoll





—Toleranzen:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Nachschleifen möglich, wenn DC ≥ Ø.375 ist



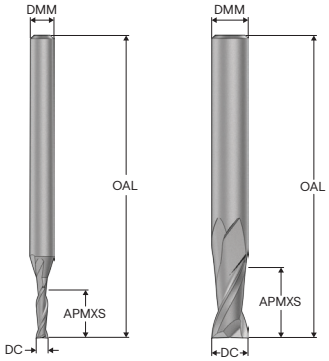
Bezeichnung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	PCEDC	Aufnahmen	Lagerstandard
				Zoll	Zoll	Zoll	Zoll			
C5121-.031F4S.0Z2	10268817	4	F	0.031	0.125	0.094	1.500	2	Cylindrical	■
C5121-.063F4S.0Z2	10268822	4	F	0.063	0.125	0.250	1.500	2	Cylindrical	■
C5121-.094F4S.0Z2	10268826	4	F	0.094	0.125	0.375	1.500	2	Cylindrical	■
C5121-.125D4S.0Z2	10268829	4	D	0.125	0.125	0.500	1.500	2	Cylindrical	■
C5121-.188D4S.0Z2	10268837	4	D	0.188	0.188	0.750	2.500	2	Cylindrical	■
C5121-.250D4S.0Z2	10268843	4	D	0.250	0.250	1.000	3.000	2	Cylindrical	■
C5121-.313D4S.0Z2	10268848	4	D	0.313	0.313	1.000	3.000	2	Cylindrical	■
C5121-.375D4S.0Z2	10268853	4	D	0.375	0.375	1.000	4.000	2	Cylindrical	■
C5121-.500D4S.0Z2	10268861	4	D	0.500	0.500	1.500	6.000	2	Cylindrical	■
C5121-.625D4S.0Z2	10268866	4	D	0.625	0.625	2.250	5.000	2	Cylindrical	■
C5121-.750D4S.0Z2	10268870	4	D	0.750	0.750	2.250	5.000	2	Cylindrical	■
C5121-.125D5S.0Z2	10268830	5	D	0.125	0.125	0.625	2.000	2	Cylindrical	■
C5121-.375D5S.0Z2	10268854	5	D	0.375	0.375	1.125	3.000	2	Cylindrical	■
C5121-.438D5S.0Z2	10268857	5	D	0.438	0.438	2.000	4.000	2	Cylindrical	■
C5121-.500D5S.0Z2	10268862	5	D	0.500	0.500	2.000	4.000	2	Cylindrical	■
C5121-.625D5S.0Z2	10268867	5	D	0.625	0.625	3.000	6.000	2	Cylindrical	■
C5121-.750D5S.0Z2	10268871	5	D	0.750	0.750	3.000	6.000	2	Cylindrical	■
C5121-.125D6S.0Z2	10268831	6	D	0.125	0.125	0.750	3.000	2	Cylindrical	■
C5121-.188D6S.0Z2	10268838	6	D	0.188	0.188	1.000	4.000	2	Cylindrical	■
C5121-.375D6S.0Z2	10268855	6	D	0.375	0.375	1.500	6.000	2	Cylindrical	■
C5121-.250D7S.0Z2	10268844	7	D	0.250	0.250	1.500	4.000	2	Cylindrical	■
C5121-.500D7S.0Z2	10268863	7	D	0.500	0.500	3.000	6.000	2	Cylindrical	■
C5121-.125D8S.0Z2	10268832	8	D	0.125	0.125	1.000	3.000	2	Cylindrical	■

■ **Lagerstandard.**

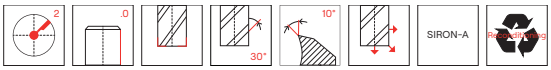
C5121

Allgemeine Anwendung – Universell – Eckfräser – 2 Schneiden – Zylindrisch – Scharfe Schneide – Zoll





—Toleranzen:
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—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Nachschleifen möglich, wenn DC ≥ Ø.375 ist



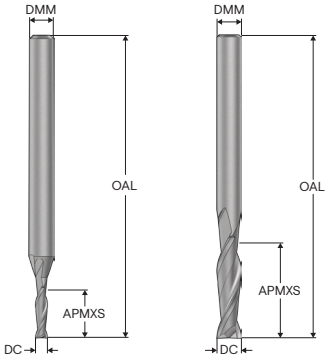
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll			
C5121-.375D1S.0Z2	SIRA	10268726	1	D	0.375	0.375	0.625	2.000	2	Cylindrical	■
C5121-.500D1S.0Z2	SIRA	10268734	1	D	0.500	0.500	0.625	2.500	2	Cylindrical	■
C5121-.047F2S.0Z2	SIRA	10268693	2	F	0.047	0.125	0.109	1.500	2	Cylindrical	■
C5121-.063F2S.0Z2	SIRA	10268695	2	F	0.063	0.125	0.125	1.500	2	Cylindrical	■
C5121-.094F2S.0Z2	SIRA	10268699	2	F	0.094	0.125	0.188	1.500	2	Cylindrical	■
C5121-.125D2S.0Z2	SIRA	10268703	2	D	0.125	0.125	0.250	1.500	2	Cylindrical	■
C5121-.156F2S.0Z2	SIRA	10268708	2	F	0.156	0.188	0.313	2.000	2	Cylindrical	■
C5121-.188D2S.0Z2	SIRA	10268710	2	D	0.188	0.188	0.375	2.000	2	Cylindrical	■
C5121-.250D2S.0Z2	SIRA	10268716	2	D	0.250	0.250	0.500	2.000	2	Cylindrical	■
C5121-.313D2S.0Z2	SIRA	10268722	2	D	0.313	0.313	0.500	2.000	2	Cylindrical	■
C5121-.375D2S.0Z2	SIRA	10268727	2	D	0.375	0.375	1.000	2.500	2	Cylindrical	■
C5121-.438D2S.0Z2	SIRA	10268732	2	D	0.438	0.438	1.000	2.750	2	Cylindrical	■
C5121-.500D2S.0Z2	SIRA	10268735	2	D	0.500	0.500	1.000	3.000	2	Cylindrical	■
C5121-.563D2S.0Z2	SIRA	10268740	2	D	0.563	0.563	1.125	3.500	2	Cylindrical	■
C5121-.625D2S.0Z2	SIRA	10268741	2	D	0.625	0.625	1.250	3.500	2	Cylindrical	■
C5121-.750D2S.0Z2	SIRA	10268745	2	D	0.750	0.750	1.500	4.000	2	Cylindrical	■
C5121-.875D2S.0Z2	SIRA	10268748	2	D	0.875	0.875	1.500	4.000	2	Cylindrical	■
C5121-1.000D2S.0Z2	SIRA	10268749	2	D	1.000	1.000	1.500	4.000	2	Cylindrical	■
C5121-.031F3S.0Z2	SIRA	10268691	3	F	0.031	0.125	0.078	1.500	2	Cylindrical	■
C5121-.047F3S.0Z2	SIRA	10268694	3	F	0.047	0.125	0.125	1.500	2	Cylindrical	■
C5121-.063F3S.0Z2	SIRA	10268696	3	F	0.063	0.125	0.188	1.500	2	Cylindrical	■
C5121-.078F3S.0Z2	SIRA	10268698	3	F	0.078	0.125	0.250	1.500	2	Cylindrical	■
C5121-.094F3S.0Z2	SIRA	10268700	3	F	0.094	0.125	0.281	1.500	2	Cylindrical	■
C5121-.109F3S.0Z2	SIRA	10268702	3	F	0.109	0.125	0.375	1.500	2	Cylindrical	■
C5121-.156F3S.0Z2	SIRA	10268709	3	F	0.156	0.188	0.500	2.000	2	Cylindrical	■
C5121-.188D3S.0Z2	SIRA	10268711	3	D	0.188	0.188	0.625	2.000	2	Cylindrical	■
C5121-.203F3S.0Z2	SIRA	10268714	3	F	0.203	0.250	0.625	2.500	2	Cylindrical	■
C5121-.219F3S.0Z2	SIRA	10268715	3	F	0.219	0.250	0.625	2.500	2	Cylindrical	■
C5121-.250D3S.0Z2	SIRA	10268717	3	D	0.250	0.250	0.750	2.500	2	Cylindrical	■
C5121-.281F3S.0Z2	SIRA	10268721	3	F	0.281	0.313	0.750	2.500	2	Cylindrical	■
C5121-.313D3S.0Z2	SIRA	10268723	3	D	0.313	0.313	0.813	2.500	2	Cylindrical	■
C5121-.344F3S.0Z2	SIRA	10268725	3	F	0.344	0.375	1.000	2.500	2	Cylindrical	■
C5121-.375D3S.0Z2	SIRA	10268728	3	D	0.375	0.375	1.000	3.000	2	Cylindrical	■
C5121-.500D3S.0Z2	SIRA	10268736	3	D	0.500	0.500	1.000	4.000	2	Cylindrical	■

■ **Lagerstandard.**

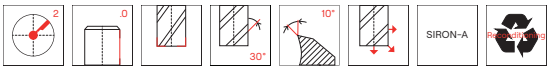
C5121

Allgemeine Anwendung – Universell – Eckfräser – 2 Schneiden – Zylindrisch – Scharfe Schneide – Zoll





—Toleranzen:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Nachschleifen möglich, wenn DC ≥ Ø.375 ist



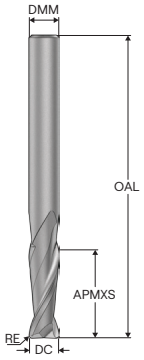
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll			
C5121-.031F4S.0Z2	SIRA	10268692	4	F	0.031	0.125	0.094	1.500	2	Cylindrical	■
C5121-.063F4S.0Z2	SIRA	10268697	4	F	0.063	0.125	0.250	1.500	2	Cylindrical	■
C5121-.094F4S.0Z2	SIRA	10268701	4	F	0.094	0.125	0.375	1.500	2	Cylindrical	■
C5121-.125D4S.0Z2	SIRA	10268704	4	D	0.125	0.125	0.500	1.500	2	Cylindrical	■
C5121-.188D4S.0Z2	SIRA	10268712	4	D	0.188	0.188	0.750	2.500	2	Cylindrical	■
C5121-.250D4S.0Z2	SIRA	10268718	4	D	0.250	0.250	1.000	3.000	2	Cylindrical	■
C5121-.313D4S.0Z2	SIRA	10268724	4	D	0.313	0.313	1.000	3.000	2	Cylindrical	■
C5121-.375D4S.0Z2	SIRA	10268729	4	D	0.375	0.375	1.000	4.000	2	Cylindrical	■
C5121-.500D4S.0Z2	SIRA	10268737	4	D	0.500	0.500	1.500	6.000	2	Cylindrical	■
C5121-.750D4S.0Z2	SIRA	10268746	4	D	0.750	0.750	2.250	5.000	2	Cylindrical	■
C5121-.125D5S.0Z2	SIRA	10268705	5	D	0.125	0.125	0.625	2.000	2	Cylindrical	■
C5121-.375D5S.0Z2	SIRA	10268730	5	D	0.375	0.375	1.125	3.000	2	Cylindrical	■
C5121-.500D5S.0Z2	SIRA	10268738	5	D	0.500	0.500	2.000	4.000	2	Cylindrical	■
C5121-.750D5S.0Z2	SIRA	10268747	5	D	0.750	0.750	3.000	6.000	2	Cylindrical	■
C5121-.125D6S.0Z2	SIRA	10268706	6	D	0.125	0.125	0.750	3.000	2	Cylindrical	■
C5121-.188D6S.0Z2	SIRA	10268713	6	D	0.188	0.188	1.000	4.000	2	Cylindrical	■
C5121-.375D6S.0Z2	SIRA	10268731	6	D	0.375	0.375	1.500	6.000	2	Cylindrical	■
C5121-.250D7S.0Z2	SIRA	10268719	7	D	0.250	0.250	1.500	4.000	2	Cylindrical	■
C5121-.500D7S.0Z2	SIRA	10268739	7	D	0.500	0.500	3.000	6.000	2	Cylindrical	■
C5121-.125D8S.0Z2	SIRA	10268707	8	D	0.125	0.125	1.000	3.000	2	Cylindrical	■

■ **Lagerstandard.**

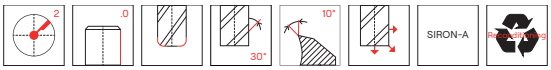
C5121

Allgemeine Anwendung – Universell – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius – Zoll





—Toleranzen:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—RE= ±.001"
—Nachschleifen möglich, wenn DC ≥ Ø.375 ist



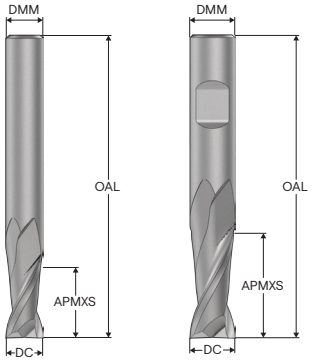
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	RE	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll	Zoll			
C5121-.500D2R015.0Z2	SIRA	10268755	2	D	0.500	0.500	1.000	3.000	0.015	2	Cylindrical	■
C5121-.500D2R030.0Z2	SIRA	10268756	2	D	0.500	0.500	1.000	3.000	0.030	2	Cylindrical	■
C5121-.500D2R060.0Z2	SIRA	10268757	2	D	0.500	0.500	1.000	3.000	0.060	2	Cylindrical	■
C5121-.500D2R125.0Z2	SIRA	10268758	2	D	0.500	0.500	1.000	3.000	0.125	2	Cylindrical	■
C5121-.625D2R015.0Z2	SIRA	10268759	2	D	0.625	0.625	1.250	3.500	0.015	2	Cylindrical	■
C5121-.625D2R030.0Z2	SIRA	10268760	2	D	0.625	0.625	1.250	3.500	0.030	2	Cylindrical	■
C5121-.625D2R125.0Z2	SIRA	10268762	2	D	0.625	0.625	1.250	3.500	0.125	2	Cylindrical	■
C5121-.750D2R015.0Z2	SIRA	10268763	2	D	0.750	0.750	1.500	4.000	0.015	2	Cylindrical	■
C5121-.750D2R030.0Z2	SIRA	10268764	2	D	0.750	0.750	1.500	4.000	0.030	2	Cylindrical	■
C5121-.750D2R060.0Z2	SIRA	10268765	2	D	0.750	0.750	1.500	4.000	0.060	2	Cylindrical	■
C5121-.750D2R125.0Z2	SIRA	10268766	2	D	0.750	0.750	1.500	4.000	0.125	2	Cylindrical	■
C5121-.250D3R015.0Z2	SIRA	10268750	3	D	0.250	0.250	0.750	2.500	0.015	2	Cylindrical	■
C5121-.250D3R030.0Z2	SIRA	10268751	3	D	0.250	0.250	0.750	2.500	0.030	2	Cylindrical	■
C5121-.375D3R015.0Z2	SIRA	10268752	3	D	0.375	0.375	1.000	2.500	0.015	2	Cylindrical	■
C5121-.375D3R030.0Z2	SIRA	10268753	3	D	0.375	0.375	1.000	2.500	0.030	2	Cylindrical	■

■ **Lagerstandard.**

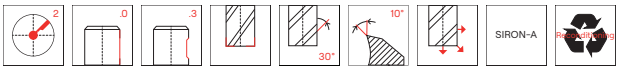
C5121

Allgemeine Anwendung – Universell – Eckfräser – 2 Schneiden – Zylindrisch/Weldon – Scharfe Schneide – Zoll





—Toleranzen:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.001"/-.000"
—NC-Toleranz
—Nachschleifen möglich, wenn DC ≥ Ø.375 ist



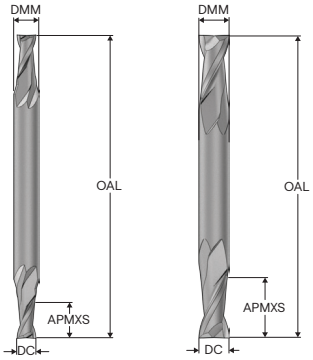
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll			
C5121-.375D2S.3Z2NC	SIRA	10269074	2	D	0.375	0.375	0.875	2.500	2	Weldon	■
C5121-.500D2S.3Z2NC	SIRA	10269075	2	D	0.500	0.500	1.000	3.000	2	Weldon	■
C5121-.625D2S.3Z2NC	SIRA	10269076	2	D	0.625	0.625	1.250	3.500	2	Weldon	■
C5121-.750D2S.3Z2NC	SIRA	10269077	2	D	0.750	0.750	1.500	4.000	2	Weldon	■
C5121-.250D3S.0Z2NC	SIRA	10269072	3	D	0.250	0.250	0.750	2.500	2	Cylindrical	■
C5121-.313D3S.0Z2NC	SIRA	10269073	3	D	0.313	0.313	0.813	2.500	2	Cylindrical	■

■ **Lagerstandard.**

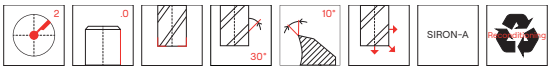
C5121

Allgemeine Anwendung – Universell – Eckfräser – 2 Schneiden – Zylindrisch – Scharfe Schneide – Zoll





—Toleranzen:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Doppelseitig
—Nachschleifen möglich, wenn DC ≥ Ø.375 ist



Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll			
C5121-.500D1S.0Z2D	SIRA	10269088	1	D	0.500	0.500	0.625	3.000	2	Cylindrical	■
C5121-.031F2S.0Z2D	SIRA	10269078	2	F	0.031	0.125	0.063	1.500	2	Cylindrical	■
C5121-.047F2S.0Z2D	SIRA	10269079	2	F	0.047	0.125	0.094	1.500	2	Cylindrical	■
C5121-.063F2S.0Z2D	SIRA	10269080	2	F	0.063	0.125	0.125	1.500	2	Cylindrical	■
C5121-.078F2S.0Z2D	SIRA	10269081	2	F	0.078	0.125	0.125	1.500	2	Cylindrical	■
C5121-.094F2S.0Z2D	SIRA	10269082	2	F	0.094	0.125	0.188	1.500	2	Cylindrical	■
C5121-.125D2S.0Z2D	SIRA	10269083	2	D	0.125	0.125	0.250	1.500	2	Cylindrical	■
C5121-.188D2S.0Z2D	SIRA	10269084	2	D	0.188	0.188	0.375	2.000	2	Cylindrical	■
C5121-.250D2S.0Z2D	SIRA	10269085	2	D	0.250	0.250	0.500	2.500	2	Cylindrical	■
C5121-.313D2S.0Z2D	SIRA	10269086	2	D	0.313	0.313	0.500	2.500	2	Cylindrical	■
C5121-.375D2S.0Z2D	SIRA	10269087	2	D	0.375	0.375	0.563	2.500	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – C5121 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	1,5	2	3	3,5	4	5	6	8	9	10	12	
P1	E	0,1	2	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	150 (135 — 165)
		0.10	*2.0*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*490 (440— 540)*
P2	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	58 (45— 70)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*190 (147 — 230)*
P3	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	85 (70 — 95)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*279 (246 — 312)*
P4	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	100 (90 — 110)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*330 (295 — 360)*
P5	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	68 (50 — 75)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*223 (165 — 245)*
P6	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	87 (77 — 100)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*285 (250 — 330)*
P7	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	65 (55 — 75)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*213 (180 — 245)*
P8	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	65 (50 — 75)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*213 (165 — 245)*
P11	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	85 (70 — 95)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*280 (230 — 310)*
P12	E	0,1	2	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	55 (45— 65)
		0.10	*2.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*180 (147 — 213)*
M1	E	0,1	2	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	93 (83 — 100)
		0.10	*2.0*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*305 (270 — 360)*
M2	E	0,1	2	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	60 (50 — 70)
		0.10	*2.0*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*200 (165 — 230)*
M3	E	0,1	2	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	55 (45 —65)
		0.10	*2.0*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*180 (147 — 213)*
M4	E	0,1	2	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	45 (35 — 55)
		0.10	*2.0*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*147 (115 — 180)*
M5	E	0,1	2	0,0044	0,0065	0,0085	0,013	0,015	0,017	0,022	0,026	0,034	0,038	0,042	0,05	35 (20 — 45)
		0.10	*2.0*	*0.00017*	*0.00026*	*0.00034*	*0.00050*	*0.00060*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*114 (65 — 147)*
K1	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	80 (70 — 90)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*260 (230 — 290)*
K2	E	0,1	2	0,0055	0,0085	0,011	0,017	0,02	0,022	0,028	0,034	0,044	0,05	0,055	0,065	87 (75 — 100)
		0.10	*2.0*	*0.00022*	*0.00034*	*0.00044*	*0.00065*	*0.00080*	*0.00085*	*0.0011*	*0.0013*	*0.0017*	*0.0020*	*0.0022*	*0.0026*	*285 (245 — 330)*
K3	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	65 (55 — 75)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*213 (180 — 245)*
K4	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	50 (35 — 65)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*165 (115 — 213)*
K5	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	45 (30 — 55)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*147 (100 — 180)*
K6	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	77 (65 — 85)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*250 (210 — 280)*
K7	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	77 (60 — 90)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*250 (200 — 290)*
S1	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	50 (35 — 60)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*165 (115 — 200)*
S2	E	0,1	2	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	25 (15 — 35)
		0.10	*2.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*82 (50 — 115)*
S3	E	0,1	2	0,002	0,0032	0,0042	0,0065	0,0075	0,0085	0,01	0,013	0,017	0,019	0,02	0,025	11 (7,5 — 16)
		0.10	*2.0*	*0.000080*	*0.00013*	*0.00017*	*0.00026*	*0.00030*	*0.00034*	*0.00040*	*0.00050*	*0.00065*	*0.00075*	*0.00080*	*0.0010*	*35 (25 — 52)*
S11	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	110 (95— 120)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*360 (311 — 390)*
S12	E	0,1	2	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	77 (60 — 90)
		0.10	*2.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*250 (190 — 290)*
S13	E	0,1	2	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	30 (20 — 40)
		0.10	*2.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*100 (65 — 130)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – C5121 Eckfräsen – Zoll

SMG		a_e/DC	a_p/DC	f_z													v_c
				1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	
P1	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	150 (135 — 165) *490 (440— 540)*
P2	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	58 (45— 70) *190 (147 — 230)*
P3	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	85 (70 — 95) *279 (246 — 312)*
P4	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	100 (90 — 110) *330 (295 — 360)*
P5	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	68 (50 — 75) *223 (165 — 245)*
P6	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	87 (77 — 100) *285 (250 — 330)*
P7	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	65 (55 — 75) *213 (180 — 245)*
P8	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	65 (50 — 75) *213 (165 — 245)*
P11	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	85 (70 — 95) *280 (230 — 310)*
P12	E	0,1 *0.10*	2 *2.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,08 *0.0032*	55 (45— 65) *180 (147 — 213)*
M1	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	93 (83 — 100) *305 (270 — 360)*
M2	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	60 (50 — 70) *200 (165 — 230)*
M3	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	55 (45 —65) *180 (147 — 213)*
M4	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	45 (35 — 55) *147 (115 — 180)*
M5	E	0,1 *0.10*	2 *2.0*	0,0034 *0.00013*	0,007 *0.00028*	0,014 *0.00055*	0,017 *0.00065*	0,02 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	0,034 *0.0013*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,11 *0.0044*	35 (20 — 45) *114 (65 — 147)*
K1	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	80 (70 — 90) *260 (230 — 290)*
K2	E	0,1 *0.10*	2 *2.0*	0,0044 *0.00017*	0,009 *0.00036*	0,018 *0.00070*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	87 (75 — 100) *285 (245 — 330)*
K3	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	65 (55 — 75) *213 (180 — 245)*
K4	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	50 (35 — 65) *165 (115 — 213)*
K5	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	45 (30 — 55) *147 (100 — 180)*
K6	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	77 (65 — 85) *250 (210 — 280)*
K7	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	77 (60 — 90) *250 (200 — 290)*
S1	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	50 (35 — 60) *165 (115 — 200)*
S2	E	0,1 *0.10*	2 *2.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,08 *0.0032*	25 (15 — 35) *82 (50 — 115)*
S3	E	0,1 *0.10*	2 *2.0*	0,0017 *0.000065*	0,0034 *0.00013*	0,0065 *0.00026*	0,0085 *0.00034*	0,01 *0.00040*	0,012 *0.00048*	0,013 *0.00050*	0,017 *0.00065*	0,02 *0.00080*	0,026 *0.0010*	0,034 *0.0013*	0,04 *0.0016*	0,055 *0.0022*	11 (7,5 — 16) *35 (25 — 52)*
S11	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	110 (95— 120) *360 (311 — 390)*
S12	E	0,1 *0.10*	2 *2.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,08 *0.0032*	77 (60 — 90) *250 (190 — 290)*
S13	E	0,1 *0.10*	2 *2.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,08 *0.0032*	30 (20 — 40) *100 (65 — 130)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – C5121 Nutfräsen

SMG		a_p/DC	f_z												v_c
			1	1,5	2	3	3,5	4	5	6	8	9	10	12	
P1	E	1	0,0024	0,0034	0,0046	0,007	0,008	0,009	0,012	0,014	0,018	0,02	0,024	0,028	75 (50 — 85)
		1.0	*0.000095*	*0.00013*	*0.00018*	*0.00028*	*0.00032*	*0.00036*	*0.00048*	*0.00055*	*0.00070*	*0.00080*	*0.00095*	*0.0011*	*245 (170 — 270)*
P2	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	32 (20 —40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*100 (66 — 130)*
P3	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	45 (30 — 60)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*147 (98— 196)*
P4	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	55 (40 — 65)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*180 (130 —210)*
P5	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	35 (20 — 45)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*115 (65— 145)*
P6	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	45 (30 — 60)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*145 (180 — 195)*
P7	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	35 (20 — 50)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*115 (65 — 165)*
P8	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	25 (15 — 35)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*80 (50 — 110)*
P11	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	32 (20 — 42)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*105 (65 — 138)*
P12	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	30 (20 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*100 (65 — 130)*
M1	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	42 (21 — 52)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*138 (69 — 170)*
M2	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	32 (20 — 42)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*105 (65 — 138)*
M3	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	30 (15 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*100 (50 — 130)*
M4	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	22 (10 — 35)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*72 (33 — 115)*
M5	E	1	0,0013	0,002	0,0026	0,004	0,0046	0,005	0,0065	0,008	0,01	0,012	0,013	0,016	19 (16 — 30)
		1.0	*0.000050*	*0.000080*	*0.00010*	*0.00016*	*0.00018*	*0.00020*	*0.00026*	*0.00032*	*0.00040*	*0.00048*	*0.00050*	*0.00065*	*62 (52 — 100)*
K1	E	1	0,0024	0,0034	0,0046	0,007	0,008	0,009	0,012	0,014	0,018	0,02	0,024	0,028	30 (20 — 45)
		1.0	*0.000095*	*0.00013*	*0.00018*	*0.00028*	*0.00032*	*0.00036*	*0.00048*	*0.00055*	*0.00070*	*0.00080*	*0.00095*	*0.0011*	*100 (65 — 147)*
K2	E	1	0,0024	0,0034	0,0046	0,007	0,008	0,009	0,012	0,014	0,018	0,02	0,024	0,028	40 (30 — 50)
		1.0	*0.000095*	*0.00013*	*0.00018*	*0.00028*	*0.00032*	*0.00036*	*0.00048*	*0.00055*	*0.00070*	*0.00080*	*0.00095*	*0.0011*	*130 (100 — 165)*
K3	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	32 (26 — 45)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*105 (85 — 148)*
K4	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	22 (18 — 30)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*72 (60 — 100)*
K5	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	20 (15 — 30)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*65 (50 — 100)*
K6	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	35 (20 — 50)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*115 (65 — 165)*
K7	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	35 (20 — 50)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*115 (65 — 165)*
S1	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	25 (18 — 30)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*80 (60 — 100)*
S2	E	1	0,001	0,0015	0,002	0,003	0,0036	0,004	0,005	0,006	0,008	0,009	0,01	0,012	13 (9 — 18)
		1.0	*0.000040*	*0.000060*	*0.000080*	*0.00012*	*0.00014*	*0.00016*	*0.00020*	*0.00024*	*0.00032*	*0.00036*	*0.00040*	*0.00048*	*62 (30 — 60)*
S3	E	1	0,001	0,0015	0,002	0,003	0,0036	0,004	0,005	0,006	0,008	0,009	0,01	0,012	7,0 (5 — 12)
		1.0	*0.000040*	*0.000060*	*0.000080*	*0.00012*	*0.00014*	*0.00016*	*0.00020*	*0.00024*	*0.00032*	*0.00036*	*0.00040*	*0.00048*	*23 (15— 39)*
S11	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	35 (25 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*114 (82— 130)*
S12	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	32 (22 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*105 (72 — 130)*
S13	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	10 (8— 15)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*33 (26 — 50)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – C5121 Nutfräsen – Zoll

SMG		a_p/DC	f_z													v_c
			1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	
P1	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	75 (50 — 85)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*245 (170 — 270)*
P2	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (20 —40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*100 (66 — 130)*
P3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	45 (30 — 60)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*147 (98— 196)*
P4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	55 (40 — 65)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*180 (130 —210)*
P5	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 45)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65— 145)*
P6	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	45 (30 — 60)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*145 (180 — 195)*
P7	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 50)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65 — 165)*
P8	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	25 (15 — 35)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*80 (50 — 110)*
P11	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (20 — 42)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (65 — 138)*
P12	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	30 (20 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*100 (65 — 130)*
M1	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	42 (21 — 52)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*138 (69 — 170)*
M2	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (20 — 42)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (65 — 138)*
M3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	30 (15 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*100 (50 — 130)*
M4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	22 (10 — 35)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*72 (33 — 115)*
M5	E	1	0,001	0,002	0,0042	0,005	0,006	0,007	0,0085	0,01	0,012	0,017	0,02	0,025	0,034	19 (16 — 30)
		1.0	*0.000040*	*0.000080*	*0.00017*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00048*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*62 (52 — 100)*
K1	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	30 (20 — 45)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*100 (65 — 147)*
K2	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	40 (30 — 50)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*130 (100 — 165)*
K3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (26 — 45)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (85 — 148)*
K4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	22 (18 — 30)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*72 (60 — 100)*
K5	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	20 (15 — 30)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*65 (50 — 100)*
K6	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 50)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65 — 165)*
K7	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 50)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65 — 165)*
S1	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	25 (18 — 30)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*80 (60 — 100)*
S2	E	1	0,0008	0,0016	0,0032	0,004	0,0048	0,0055	0,0065	0,008	0,0095	0,013	0,016	0,019	0,025	13 (9 — 18)
		1.0	*0.000032*	*0.000065*	*0.00013*	*0.00016*	*0.00019*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*62 (30 — 60)*
S3	E	1	0,0008	0,0016	0,0032	0,004	0,0048	0,0055	0,0065	0,008	0,0095	0,013	0,016	0,019	0,025	7,0 (5 — 12)
		1.0	*0.000032*	*0.000065*	*0.00013*	*0.00016*	*0.00019*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*23 (15— 39)*
S11	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (25 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*114 (82— 130)*
S12	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (22 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (72 — 130)*
S13	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	10 (8— 15)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*33 (26 — 50)*

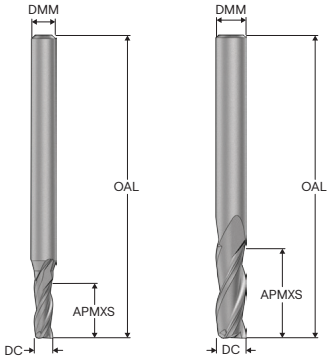
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

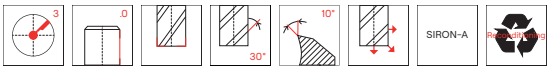
C5131

Allgemeine Anwendung – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Scharfe Schneide





– Toleranzen:
– DMM=h5
– DC= h10
– Nachschleifen möglich, wenn DC ≥ Ø10 ist



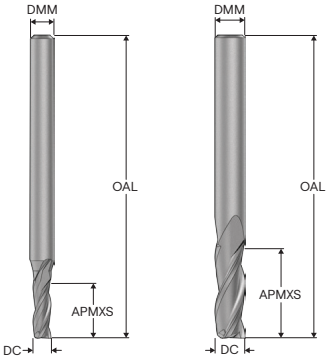
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm			
C5131-060D1S.0Z3	SIRA	10268801	1	D	6,0	6,0	9,0	57,0	3	Cylindrical	■
C5131-020F2S.0Z3	SIRA	10268792	2	F	2,0	3,0	4,0	38,0	3	Cylindrical	■
C5131-030D2S.0Z3	SIRA	10268794	2	D	3,0	3,0	6,0	38,0	3	Cylindrical	■
C5131-040D2S.0Z3	SIRA	10268797	2	D	4,0	4,0	8,0	50,0	3	Cylindrical	■
C5131-050F2S.0Z3	SIRA	10268799	2	F	5,0	6,0	10,0	57,0	3	Cylindrical	■
C5131-060D2S.0Z3	SIRA	10268802	2	D	6,0	6,0	12,0	57,0	3	Cylindrical	■
C5131-080D2S.0Z3	SIRA	10268804	2	D	8,0	8,0	16,0	63,0	3	Cylindrical	■
C5131-090F2S.0Z3	SIRA	10268806	2	F	9,0	10,0	22,0	72,0	3	Cylindrical	■
C5131-100D2S.0Z3	SIRA	10268807	2	D	10,0	10,0	22,0	72,0	3	Cylindrical	■
C5131-120D2S.0Z3	SIRA	10268809	2	D	12,0	12,0	25,0	83,0	3	Cylindrical	■
C5131-015F3S.0Z3	SIRA	10268791	3	F	1,5	3,0	4,5	38,0	3	Cylindrical	■
C5131-020F3S.0Z3	SIRA	10268793	3	F	2,0	3,0	6,3	38,0	3	Cylindrical	■
C5131-035F3S.0Z3	SIRA	10268796	3	F	3,5	4,0	12,0	50,0	3	Cylindrical	■
C5131-050F3S.0Z3	SIRA	10268800	3	F	5,0	6,0	16,0	57,0	3	Cylindrical	■
C5131-060D3S.0Z3	SIRA	10268803	3	D	6,0	6,0	19,0	63,0	3	Cylindrical	■
C5131-080D3S.0Z3	SIRA	10268805	3	D	8,0	8,0	20,0	63,0	3	Cylindrical	■
C5131-010F4S.0Z3	SIRA	10268790	4	F	1,0	3,0	4,0	38,0	3	Cylindrical	■
C5131-030D4S.0Z3	SIRA	10268795	4	D	3,0	3,0	12,0	38,0	3	Cylindrical	■
C5131-040D4S.0Z3	SIRA	10268798	4	D	4,0	4,0	14,0	50,0	3	Cylindrical	■
C5131-100D4S.0Z3	SIRA	10268808	4	D	10,0	10,0	35,0	89,0	3	Cylindrical	■
C5131-120D4S.0Z3	SIRA	10268810	4	D	12,0	12,0	50,0	100,0	3	Cylindrical	■

■ **Lagerstandard.**

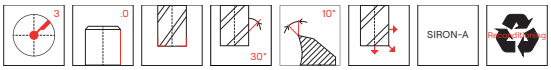
C5131

Allgemeine Anwendung – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Scharfe Schneide – Zoll





—Toleranzen:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Nachschleifen möglich, wenn DC ≥ Ø.375 ist



Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll			
C5131-.047F2S.0Z3	SIRA	10268772	2	F	0.047	0.125	0.109	1.500	3	Cylindrical	■
C5131-.078F2S.0Z3	SIRA	10268774	2	F	0.078	0.125	0.188	1.500	3	Cylindrical	■
C5131-.438D2S.0Z3	SIRA	10268784	2	D	0.438	0.438	1.000	2.750	3	Cylindrical	■
C5131-.500D2S.0Z3	SIRA	10268785	2	D	0.500	0.500	1.000	3.000	3	Cylindrical	■
C5131-.563D2S.0Z3	SIRA	10268786	2	D	0.563	0.563	1.125	3.500	3	Cylindrical	■
C5131-.625D2S.0Z3	SIRA	10268787	2	D	0.625	0.625	1.250	3.500	3	Cylindrical	■
C5131-.750D2S.0Z3	SIRA	10268788	2	D	0.750	0.750	1.500	4.000	3	Cylindrical	■
C5131-1.000D2S.0Z3	SIRA	10268789	2	D	1.000	1.000	1.500	4.000	3	Cylindrical	■
C5131-.031F3S.0Z3	SIRA	10268771	3	F	0.031	0.125	0.078	1.500	3	Cylindrical	■
C5131-.063F3S.0Z3	SIRA	10268773	3	F	0.063	0.125	0.188	1.500	3	Cylindrical	■
C5131-.094F3S.0Z3	SIRA	10268775	3	F	0.094	0.125	0.281	1.500	3	Cylindrical	■
C5131-.109F3S.0Z3	SIRA	10268776	3	F	0.109	0.125	0.375	1.500	3	Cylindrical	■
C5131-.156F3S.0Z3	SIRA	10268778	3	F	0.156	0.188	0.500	2.000	3	Cylindrical	■
C5131-.188D3S.0Z3	SIRA	10268779	3	D	0.188	0.188	0.625	2.000	3	Cylindrical	■
C5131-.250D3S.0Z3	SIRA	10268781	3	D	0.250	0.250	0.750	2.500	3	Cylindrical	■
C5131-.313D3S.0Z3	SIRA	10268782	3	D	0.313	0.313	0.813	2.500	3	Cylindrical	■
C5131-.375D3S.0Z3	SIRA	10268783	3	D	0.375	0.375	1.000	2.500	3	Cylindrical	■
C5131-.125D4S.0Z3	SIRA	10268777	4	D	0.125	0.125	0.500	1.500	3	Cylindrical	■

■ Lagerstandard.

Schnittdaten – C5131 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	1,5	2	3	3,5	4	5	6	8	9	10	12	
P1	E	0,1	1,9	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	150 (135 — 165)
		0.10	*1.9*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*490 (440— 540)*
P2	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	58 (45— 70)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*190 (147 — 230)*
P3	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	85 (70 — 95)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*279 (246 — 312)*
P4	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	100 (90 — 110)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*330 (295 — 360)*
P5	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	68 (50 — 75)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*223 (165 — 245)*
P6	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	87 (77 — 100)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*285 (250 — 330)*
P7	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	65 (55 — 75)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*213 (180 — 245)*
P8	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	65 (50 — 75)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*213 (165 — 245)*
P11	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	85 (70 — 95)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*280 (230 — 310)*
P12	E	0,1	1,9	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	55 (45— 65)
		0.10	*1.9*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*180 (147 — 213)*
M1	E	0,1	1,9	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	93 (83 — 100)
		0.10	*1.9*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*305 (270 — 360)*
M2	E	0,1	1,9	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	60 (50 — 70)
		0.10	*1.9*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*200 (165 — 230)*
M3	E	0,1	1,9	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	55 (45 —65)
		0.10	*1.9*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*180 (147 — 213)*
M4	E	0,1	1,9	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	45 (35 — 55)
		0.10	*1.9*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*147 (115 — 180)*
M5	E	0,1	1,9	0,0044	0,0065	0,0085	0,013	0,015	0,017	0,022	0,026	0,034	0,038	0,042	0,05	35 (20 — 45)
		0.10	*1.9*	*0.00017*	*0.00026*	*0.00034*	*0.00050*	*0.00060*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*114 (65 — 147)*
K1	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	80 (70 — 90)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*260 (230 — 290)*
K2	E	0,1	1,9	0,0055	0,0085	0,011	0,017	0,02	0,022	0,028	0,034	0,044	0,05	0,055	0,065	87 (75 — 100)
		0.10	*1.9*	*0.00022*	*0.00034*	*0.00044*	*0.00065*	*0.00080*	*0.00085*	*0.0011*	*0.0013*	*0.0017*	*0.0020*	*0.0022*	*0.0026*	*285 (245 — 330)*
K3	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	65 (55 — 75)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*213 (180 — 245)*
K4	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	50 (35 — 65)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*165 (115 — 213)*
K5	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	45 (30 — 55)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*147 (100 — 180)*
K6	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	77 (65 — 85)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*250 (210 — 280)*
K7	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	77 (60 — 90)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*250 (200 — 290)*
S1	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	50 (35 — 60)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*165 (115 — 200)*
S2	E	0,1	1,9	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	25 (15 — 35)
		0.10	*1.9*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*82 (50 — 115)*
S3	E	0,1	1,9	0,002	0,0032	0,0042	0,0065	0,0075	0,0085	0,01	0,013	0,017	0,019	0,02	0,025	11 (7,5 — 16)
		0.10	*1.9*	*0.000080*	*0.00013*	*0.00017*	*0.00026*	*0.00030*	*0.00034*	*0.00040*	*0.00050*	*0.00065*	*0.00075*	*0.00080*	*0.0010*	*35 (25 — 52)*
S11	E	0,1	1,9	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	110 (95— 120)
		0.10	*1.9*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*360 (311 — 390)*
S12	E	0,1	1,9	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	77 (60 — 90)
		0.10	*1.9*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*250 (190 — 290)*
S13	E	0,1	1,9	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	30 (20 — 40)
		0.10	*1.9*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*100 (65 — 130)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – C5131 Eckfräsen – Zoll

SMG		a_e/DC	a_p/DC	f_z													v_c
				1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	
P1	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	150 (135 — 165) *490 (440— 540)*
P2	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	58 (45— 70) *190 (147 — 230)*
P3	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	85 (70 — 95) *279 (246 — 312)*
P4	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	100 (90 — 110) *330 (295 — 360)*
P5	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	68 (50 — 75) *223 (165 — 245)*
P6	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	87 (77 — 100) *285 (250 — 330)*
P7	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	65 (55 — 75) *213 (180 — 245)*
P8	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	65 (50 — 75) *213 (165 — 245)*
P11	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	85 (70 — 95) *280 (230 — 310)*
P12	E	0,1 *0.10*	2 *2.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,08 *0.0032*	55 (45— 65) *180 (147 — 213)*
M1	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	93 (83 — 100) *305 (270 — 360)*
M2	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	60 (50 — 70) *200 (165 — 230)*
M3	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	55 (45 —65) *180 (147 — 213)*
M4	E	0,1 *0.10*	2 *2.0*	0,0038 *0.00015*	0,008 *0.00032*	0,016 *0.00065*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	45 (35 — 55) *147 (115 — 180)*
M5	E	0,1 *0.10*	2 *2.0*	0,0034 *0.00013*	0,007 *0.00028*	0,014 *0.00055*	0,017 *0.00065*	0,02 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	0,034 *0.0013*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,11 *0.0044*	35 (20 — 45) *114 (65 — 147)*
K1	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	80 (70 — 90) *260 (230 — 290)*
K2	E	0,1 *0.10*	2 *2.0*	0,0044 *0.00017*	0,009 *0.00036*	0,018 *0.00070*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	87 (75 — 100) *285 (245 — 330)*
K3	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	65 (55 — 75) *213 (180 — 245)*
K4	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	50 (35 — 65) *165 (115 — 213)*
K5	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	45 (30 — 55) *147 (100 — 180)*
K6	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	77 (65 — 85) *250 (210 — 280)*
K7	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	77 (60 — 90) *250 (200 — 290)*
S1	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	50 (35 — 60) *165 (115 — 200)*
S2	E	0,1 *0.10*	2 *2.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,08 *0.0032*	25 (15 — 35) *82 (50 — 115)*
S3	E	0,1 *0.10*	2 *2.0*	0,0017 *0.000065*	0,0034 *0.00013*	0,0065 *0.00026*	0,0085 *0.00034*	0,01 *0.00040*	0,012 *0.00048*	0,013 *0.00050*	0,017 *0.00065*	0,02 *0.00080*	0,026 *0.0010*	0,034 *0.0013*	0,04 *0.0016*	0,055 *0.0022*	11 (7,5 — 16) *35 (25 — 52)*
S11	E	0,1 *0.10*	2 *2.0*	0,0032 *0.00013*	0,0065 *0.00026*	0,013 *0.00050*	0,016 *0.00065*	0,02 *0.00080*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,04 *0.0016*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,1 *0.0040*	110 (95— 120) *360 (311 — 390)*
S12	E	0,1 *0.10*	2 *2.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,08 *0.0032*	77 (60 — 90) *250 (190 — 290)*
S13	E	0,1 *0.10*	2 *2.0*	0,0025 *0.00010*	0,005 *0.00020*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,02 *0.00080*	0,025 *0.0010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,08 *0.0032*	30 (20 — 40) *100 (65 — 130)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – C5131 Nutfräsen

SMG		a_p/DC	f_z												v_c
			1	1,5	2	3	3,5	4	5	6	8	9	10	12	
P1	E	1	0,0024	0,0034	0,0046	0,007	0,008	0,009	0,012	0,014	0,018	0,02	0,024	0,028	75 (50 — 85)
		1.0	*0.000095*	*0.00013*	*0.00018*	*0.00028*	*0.00032*	*0.00036*	*0.00048*	*0.00055*	*0.00070*	*0.00080*	*0.00095*	*0.0011*	*245 (170 — 270)*
P2	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	32 (20 —40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*100 (66 — 130)*
P3	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	45 (30 — 60)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*147 (98— 196)*
P4	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	55 (40 — 65)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*180 (130 —210)*
P5	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	35 (20 — 45)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*115 (65— 145)*
P6	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	45 (30 — 60)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*145 (180 — 195)*
P7	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	35 (20 — 50)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*115 (65 — 165)*
P8	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	25 (15 — 35)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*80 (50 — 110)*
P11	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	32 (20 — 42)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*105 (65 — 138)*
P12	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	30 (20 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*100 (65 — 130)*
M1	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	42 (21 — 52)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*138 (69 — 170)*
M2	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	32 (20 — 42)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*105 (65 — 138)*
M3	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	30 (15 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*100 (50 — 130)*
M4	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	22 (10 — 35)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*72 (33 — 115)*
M5	E	1	0,0013	0,002	0,0026	0,004	0,0046	0,005	0,0065	0,008	0,01	0,012	0,013	0,016	19 (16 — 30)
		1.0	*0.000050*	*0.000080*	*0.00010*	*0.00016*	*0.00018*	*0.00020*	*0.00026*	*0.00032*	*0.00040*	*0.00048*	*0.00050*	*0.00065*	*62 (52 — 100)*
K1	E	1	0,0024	0,0034	0,0046	0,007	0,008	0,009	0,012	0,014	0,018	0,02	0,024	0,028	30 (20 — 45)
		1.0	*0.000095*	*0.00013*	*0.00018*	*0.00028*	*0.00032*	*0.00036*	*0.00048*	*0.00055*	*0.00070*	*0.00080*	*0.00095*	*0.0011*	*100 (65 — 147)*
K2	E	1	0,0024	0,0034	0,0046	0,007	0,008	0,009	0,012	0,014	0,018	0,02	0,024	0,028	40 (30 — 50)
		1.0	*0.000095*	*0.00013*	*0.00018*	*0.00028*	*0.00032*	*0.00036*	*0.00048*	*0.00055*	*0.00070*	*0.00080*	*0.00095*	*0.0011*	*130 (100 — 165)*
K3	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	32 (26 — 45)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*105 (85 — 148)*
K4	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	22 (18 — 30)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*72 (60 — 100)*
K5	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	20 (15 — 30)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*65 (50 — 100)*
K6	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	35 (20 — 50)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*115 (65 — 165)*
K7	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	35 (20 — 50)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*115 (65 — 165)*
S1	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	25 (18 — 30)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*80 (60 — 100)*
S2	E	1	0,001	0,0015	0,002	0,003	0,0036	0,004	0,005	0,006	0,008	0,009	0,01	0,012	13 (9 — 18)
		1.0	*0.000040*	*0.000060*	*0.000080*	*0.00012*	*0.00014*	*0.00016*	*0.00020*	*0.00024*	*0.00032*	*0.00036*	*0.00040*	*0.00048*	*62 (30 — 60)*
S3	E	1	0,001	0,0015	0,002	0,003	0,0036	0,004	0,005	0,006	0,008	0,009	0,01	0,012	7,0 (5 — 12)
		1.0	*0.000040*	*0.000060*	*0.000080*	*0.00012*	*0.00014*	*0.00016*	*0.00020*	*0.00024*	*0.00032*	*0.00036*	*0.00040*	*0.00048*	*23 (15— 39)*
S11	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	35 (25 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*114 (82— 130)*
S12	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	32 (22 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*105 (72 — 130)*
S13	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	10 (8— 15)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*33 (26 — 50)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – C5131 Nutfräsen – Zoll

SMG		a_p/DC	f_z													v_c
			1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	
P1	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	75 (50 — 85)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*245 (170 — 270)*
P2	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (20 —40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*100 (66 — 130)*
P3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	45 (30 — 60)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*147 (98— 196)*
P4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	55 (40 — 65)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*180 (130 —210)*
P5	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 45)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65— 145)*
P6	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	45 (30 — 60)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*145 (180 — 195)*
P7	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 50)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65 — 165)*
P8	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	25 (15 — 35)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*80 (50 — 110)*
P11	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (20 — 42)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (65 — 138)*
P12	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	30 (20 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*100 (65 — 130)*
M1	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	42 (21 — 52)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*138 (69 — 170)*
M2	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (20 — 42)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (65 — 138)*
M3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	30 (15 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*100 (50 — 130)*
M4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	22 (10 — 35)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*72 (33 — 115)*
M5	E	1	0,001	0,002	0,0042	0,005	0,006	0,007	0,0085	0,01	0,012	0,017	0,02	0,025	0,034	19 (16 — 30)
		1.0	*0.000040*	*0.000080*	*0.00017*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00048*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*62 (52 — 100)*
K1	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	30 (20 — 45)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*100 (65 — 147)*
K2	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	40 (30 — 50)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*130 (100 — 165)*
K3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (26 — 45)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (85 — 148)*
K4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	22 (18 — 30)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*72 (60 — 100)*
K5	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	20 (15 — 30)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*65 (50 — 100)*
K6	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 50)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65 — 165)*
K7	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (20 — 50)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*115 (65 — 165)*
S1	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	25 (18 — 30)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*80 (60 — 100)*
S2	E	1	0,0008	0,0016	0,0032	0,004	0,0048	0,0055	0,0065	0,008	0,0095	0,013	0,016	0,019	0,025	13 (9 — 18)
		1.0	*0.000032*	*0.000065*	*0.00013*	*0.00016*	*0.00019*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*62 (30 — 60)*
S3	E	1	0,0008	0,0016	0,0032	0,004	0,0048	0,0055	0,0065	0,008	0,0095	0,013	0,016	0,019	0,025	7,0 (5 — 12)
		1.0	*0.000032*	*0.000065*	*0.00013*	*0.00016*	*0.00019*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*23 (15— 39)*
S11	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	35 (25 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*114 (82— 130)*
S12	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	32 (22 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*105 (72 — 130)*
S13	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	10 (8— 15)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*33 (26 — 50)*

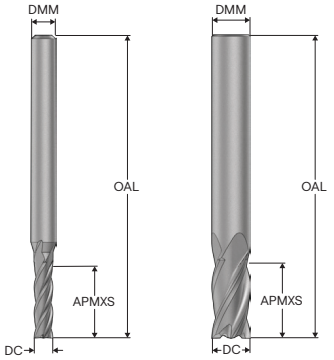
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

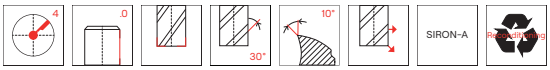
C5141

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Scharfe Schneide





– Toleranzen:
– DMM=h5
– DC= h10
– Nachschleifen möglich, wenn DC ≥ Ø10 ist



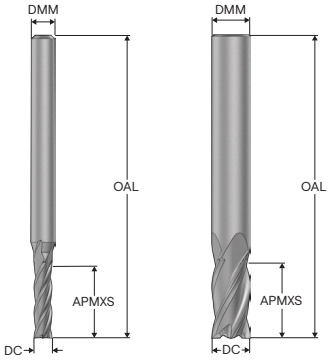
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm			
C5141-060D1S.0Z4	SIRA	10268459	1	D	6,0	6,0	9,0	57,0	4	Cylindrical	■
C5141-020F2S.0Z4	SIRA	10268450	2	F	2,0	3,0	4,0	39,0	4	Cylindrical	■
C5141-030D2S.0Z4	SIRA	10268452	2	D	3,0	3,0	6,0	38,0	4	Cylindrical	■
C5141-040D2S.0Z4	SIRA	10268455	2	D	4,0	4,0	8,0	50,0	4	Cylindrical	■
C5141-050F2S.0Z4	SIRA	10268457	2	F	5,0	6,0	10,0	57,0	4	Cylindrical	■
C5141-060D2S.0Z4	SIRA	10268460	2	D	6,0	6,0	12,0	57,0	4	Cylindrical	■
C5141-080D2S.0Z4	SIRA	10268462	2	D	8,0	8,0	16,0	63,0	4	Cylindrical	■
C5141-080D3S.0Z4	SIRA	10268463	2	D	8,0	8,0	20,0	64,0	4	Cylindrical	■
C5141-090F2S.0Z4	SIRA	10268464	2	F	9,0	10,0	22,0	73,0	4	Cylindrical	■
C5141-100D2S.0Z4	SIRA	10268465	2	D	10,0	10,0	22,0	73,0	4	Cylindrical	■
C5141-120D2S.0Z4	SIRA	10268467	2	D	12,0	12,0	25,0	74,0	4	Cylindrical	■
C5141-160D2S.0Z4	SIRA	10268469	2	D	16,0	16,0	32,0	92,0	4	Cylindrical	■
C5141-200D2S.0Z4	SIRA	10268471	2	D	20,0	20,0	35,0	104,0	4	Cylindrical	■
C5141-015F3S.0Z4	SIRA	10268449	3	F	1,5	3,0	4,5	39,0	4	Cylindrical	■
C5141-020F3S.0Z4	SIRA	10268451	3	F	2,0	3,0	6,3	39,0	4	Cylindrical	■
C5141-035F3S.0Z4	SIRA	10268454	3	F	3,5	4,0	12,0	51,0	4	Cylindrical	■
C5141-050F3S.0Z4	SIRA	10268458	3	F	5,0	6,0	16,0	51,0	4	Cylindrical	■
C5141-060D3S.0Z4	SIRA	10268461	3	D	6,0	6,0	19,0	51,0	4	Cylindrical	■
C5141-160D3S.0Z4	SIRA	10268470	3	D	16,0	16,0	50,0	115,0	4	Cylindrical	■
C5141-200D3S.0Z4	SIRA	10268472	3	D	20,0	20,0	60,0	125,0	4	Cylindrical	■
C5141-010F4S.0Z4	SIRA	10268448	4	F	1,0	3,0	4,0	39,0	4	Cylindrical	■
C5141-030D4S.0Z4	SIRA	10268453	4	D	3,0	3,0	12,0	39,0	4	Cylindrical	■
C5141-040D4S.0Z4	SIRA	10268456	4	D	4,0	4,0	14,0	51,0	4	Cylindrical	■
C5141-100D4S.0Z4	SIRA	10268466	4	D	10,0	10,0	35,0	89,0	4	Cylindrical	■
C5141-120D4S.0Z4	SIRA	10268468	4	D	12,0	12,0	50,0	100,0	4	Cylindrical	■

■ **Lagerstandard.**

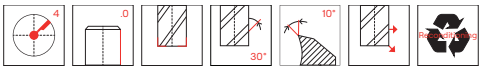
C5141

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Scharfe Schneide – Zoll





—Toleranzen:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Nachschleifen möglich, wenn DC ≥ Ø.375 ist



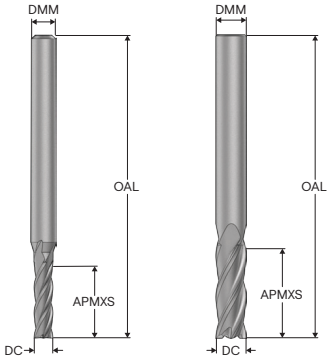
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
				Zoll	Zoll	Zoll	Zoll			
C5141-.375D1S.0Z4	10268208	1	D	0.375	0.375	0.625	2.000	4	Cylindrical	■
C5141-.438D1S.0Z4	10268220	1	D	0.438	0.438	0.625	2.500	4	Cylindrical	■
C5141-.500D1S.0Z4	10268228	1	D	0.500	0.500	0.625	2.500	4	Cylindrical	■
C5141-.625D1S.0Z4	10268236	1	D	0.625	0.625	0.750	3.000	4	Cylindrical	■
C5141-.750D1S.0Z4	10268242	1	D	0.750	0.750	1.000	3.000	4	Cylindrical	■
C5141-1.000D1S.0Z4	10268249	1	D	1.000	1.000	1.000	3.000	4	Cylindrical	■
C5141-.016F2S.0Z4	10268152	2	F	0.016	0.125	0.031	1.500	4	Cylindrical	■
C5141-.047F2S.0Z4	10268155	2	F	0.047	0.125	0.109	1.500	4	Cylindrical	■
C5141-.063F2S.0Z4	10268157	2	F	0.063	0.125	0.125	1.500	4	Cylindrical	■
C5141-.078F2S.0Z4	10268161	2	F	0.078	0.125	0.188	1.500	4	Cylindrical	■
C5141-.094F2S.0Z4	10268163	2	F	0.094	0.125	0.188	1.500	4	Cylindrical	■
C5141-.125D2S.0Z4	10268168	2	D	0.125	0.125	0.250	1.500	4	Cylindrical	■
C5141-.156F2S.0Z4	10268175	2	F	0.156	0.188	0.313	2.000	4	Cylindrical	■
C5141-.188D2S.0Z4	10268178	2	D	0.188	0.188	0.375	2.000	4	Cylindrical	■
C5141-.219F2S.0Z4	10268185	2	F	0.219	0.250	0.438	2.000	4	Cylindrical	■
C5141-.250D2S.0Z4	10268188	2	D	0.250	0.250	0.500	2.000	4	Cylindrical	■
C5141-.313D2S.0Z4	10268198	2	D	0.313	0.313	0.500	2.000	4	Cylindrical	■
C5141-.375D2S.0Z4	10268209	2	D	0.375	0.375	1.000	2.500	4	Cylindrical	■
C5141-.406F2S.0Z4	10268218	2	F	0.406	0.438	1.000	2.750	4	Cylindrical	■
C5141-.438D2S.0Z4	10268221	2	D	0.438	0.438	1.000	2.750	4	Cylindrical	■
C5141-.500D2S.0Z4	10268229	2	D	0.500	0.500	1.000	3.000	4	Cylindrical	■
C5141-.563D2S.0Z4	10268235	2	D	0.563	0.563	1.125	3.500	4	Cylindrical	■
C5141-.625D2S.0Z4	10268237	2	D	0.625	0.625	1.250	3.500	4	Cylindrical	■
C5141-.688F2S.0Z4	10268241	2	F	0.688	0.750	1.375	4.000	4	Cylindrical	■
C5141-.750D2S.0Z4	10268243	2	D	0.750	0.750	1.500	4.000	4	Cylindrical	■
C5141-.875D2S.0Z4	10268248	2	D	0.875	0.875	1.500	4.000	4	Cylindrical	■
C5141-1.000D2S.0Z4	10268250	2	D	1.000	1.000	1.500	4.000	4	Cylindrical	■
C5141-1.250D2S.0Z4	10268255	2	D	1.250	1.250	2.000	4.500	4	Cylindrical	■
C5141-.031F3S.0Z4	10268153	3	F	0.031	0.125	0.078	1.500	4	Cylindrical	■
C5141-.047F3S.0Z4	10268156	3	F	0.047	0.125	0.125	1.500	4	Cylindrical	■
C5141-.063F3S.0Z4	10268158	3	F	0.063	0.125	0.188	1.500	4	Cylindrical	■
C5141-.078F3S.0Z4	10268162	3	F	0.078	0.125	0.250	1.500	4	Cylindrical	■
C5141-.094F3S.0Z4	10268164	3	F	0.094	0.125	0.281	1.500	4	Cylindrical	■
C5141-.109F3S.0Z4	10268167	3	F	0.109	0.125	0.375	1.500	4	Cylindrical	■

■ **Lagerstandard.**

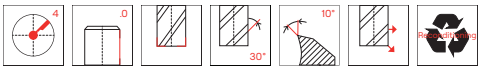
C5141

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Scharfe Schneide – Zoll





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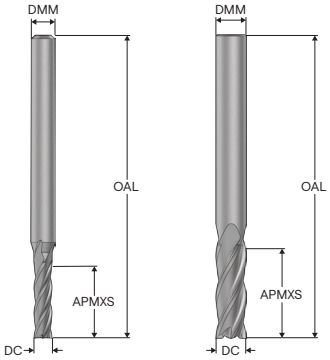
Bezeichnung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	PCEDC	Aufnahmen	Lagerstandard
				Zoll	Zoll	Zoll	Zoll			
C5141-.156F3S.0Z4	10268176	3	F	0.156	0.188	0.500	2.000	4	Cylindrical	■
C5141-.188D3S.0Z4	10268179	3	D	0.188	0.188	0.625	2.000	4	Cylindrical	■
C5141-.203F3S.0Z4	10268184	3	F	0.203	0.250	0.625	2.500	4	Cylindrical	■
C5141-.219F3S.0Z4	10268186	3	F	0.219	0.250	0.625	2.500	4	Cylindrical	■
C5141-.234F3S.0Z4	10268187	3	F	0.234	0.250	0.750	2.500	4	Cylindrical	■
C5141-.250D3S.0Z4	10268189	3	D	0.250	0.250	0.750	2.500	4	Cylindrical	■
C5141-.281F3S.0Z4	10268196	3	F	0.281	0.313	0.750	2.500	4	Cylindrical	■
C5141-.313D3S.0Z4	10268199	3	D	0.313	0.313	0.813	2.500	4	Cylindrical	■
C5141-.344F3S.0Z4	10268206	3	F	0.344	0.375	1.000	2.500	4	Cylindrical	■
C5141-.375D3S.0Z4	10268210	3	D	0.375	0.375	1.000	3.000	4	Cylindrical	■
C5141-.438D3S.0Z4	10268222	3	D	0.438	0.438	1.000	4.000	4	Cylindrical	■
C5141-.500D3S.0Z4	10268230	3	D	0.500	0.500	1.000	4.000	4	Cylindrical	■
C5141-.625D3S.0Z4	10268238	3	D	0.625	0.625	2.000	6.000	4	Cylindrical	■
C5141-.750D3S.0Z4	10268244	3	D	0.750	0.750	2.000	6.000	4	Cylindrical	■
C5141-1.000D3S.0Z4	10268251	3	D	1.000	1.000	2.000	6.000	4	Cylindrical	■
C5141-.031F4S.0Z4	10268154	4	F	0.031	0.125	0.094	1.500	4	Cylindrical	■
C5141-.063F4S.0Z4	10268159	4	F	0.063	0.125	0.250	1.500	4	Cylindrical	■
C5141-.094F4S.0Z4	10268165	4	F	0.094	0.125	0.375	1.500	4	Cylindrical	■
C5141-.125D4S.0Z4	10268169	4	D	0.125	0.125	0.500	1.500	4	Cylindrical	■
C5141-.141F4S.0Z4	10268174	4	F	0.141	0.188	0.500	2.000	4	Cylindrical	■
C5141-.172F4S.0Z4	10268177	4	F	0.172	0.188	0.625	2.000	4	Cylindrical	■
C5141-.188D4S.0Z4	10268180	4	D	0.188	0.188	0.750	2.500	4	Cylindrical	■
C5141-.250D4S.0Z4	10268190	4	D	0.250	0.250	1.000	3.000	4	Cylindrical	■
C5141-.313D4S.0Z4	10268200	4	D	0.313	0.313	1.000	3.000	4	Cylindrical	■
C5141-.375D4S.0Z4	10268211	4	D	0.375	0.375	1.000	4.000	4	Cylindrical	■
C5141-.438D4S.0Z4	10268223	4	D	0.438	0.438	1.500	6.000	4	Cylindrical	■
C5141-.500D4S.0Z4	10268231	4	D	0.500	0.500	1.500	6.000	4	Cylindrical	■
C5141-.625D4S.0Z4	10268239	4	D	0.625	0.625	2.250	5.000	4	Cylindrical	■
C5141-.750D4S.0Z4	10268245	4	D	0.750	0.750	2.250	5.000	4	Cylindrical	■
C5141-1.000D4S.0Z4	10268252	4	D	1.000	1.000	2.250	5.000	4	Cylindrical	■

■ **Lagerstandard.**

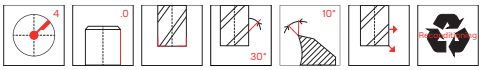
C5141

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Scharfe Schneide – Zoll





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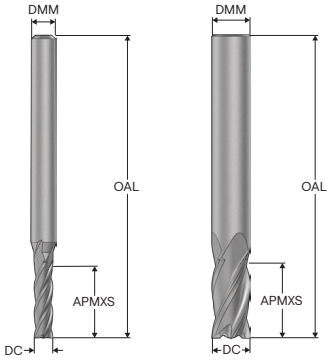
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
				Zoll	Zoll	Zoll	Zoll			
C5141-.125D5S.0Z4	10268170	5	D	0.125	0.125	0.625	2.000	4	Cylindrical	■
C5141-.188D5S.0Z4	10268181	5	D	0.188	0.188	1.000	3.000	4	Cylindrical	■
C5141-.250D5S.0Z4	10268191	5	D	0.250	0.250	1.000	4.000	4	Cylindrical	■
C5141-.313D5S.0Z4	10268201	5	D	0.313	0.313	1.000	4.000	4	Cylindrical	■
C5141-.375D5S.0Z4	10268212	5	D	0.375	0.375	1.125	3.000	4	Cylindrical	■
C5141-.438D5S.0Z4	10268224	5	D	0.438	0.438	2.000	4.000	4	Cylindrical	■
C5141-.500D5S.0Z4	10268232	5	D	0.500	0.500	2.000	4.000	4	Cylindrical	■
C5141-.625D5S.0Z4	10268240	5	D	0.625	0.625	3.000	6.000	4	Cylindrical	■
C5141-.750D5S.0Z4	10268246	5	D	0.750	0.750	3.000	6.000	4	Cylindrical	■
C5141-1.000D5S.0Z4	10268253	5	D	1.000	1.000	3.000	6.000	4	Cylindrical	■
C5141-.125D6S.0Z4	10268171	6	D	0.125	0.125	0.750	3.000	4	Cylindrical	■
C5141-.188D6S.0Z4	10268182	6	D	0.188	0.188	1.000	4.000	4	Cylindrical	■
C5141-.250D6S.0Z4	10268192	6	D	0.250	0.250	1.125	3.000	4	Cylindrical	■
C5141-.313D6S.0Z4	10268202	6	D	0.313	0.313	1.125	3.000	4	Cylindrical	■
C5141-.375D6S.0Z4	10268213	6	D	0.375	0.375	1.500	6.000	4	Cylindrical	■
C5141-.438D6S.0Z4	10268225	6	D	0.438	0.438	2.000	4.500	4	Cylindrical	■
C5141-.500D6S.0Z4	10268233	6	D	0.500	0.500	2.000	4.500	4	Cylindrical	■
C5141-.750D6S.0Z4	10268247	6	D	0.750	0.750	4.000	6.000	4	Cylindrical	■
C5141-1.000D6S.0Z4	10268254	6	D	1.000	1.000	4.000	7.000	4	Cylindrical	■
C5141-.188D7S.0Z4	10268183	7	D	0.188	0.188	1.125	3.000	4	Cylindrical	■
C5141-.250D7S.0Z4	10268193	7	D	0.250	0.250	1.500	4.000	4	Cylindrical	■
C5141-.313D7S.0Z4	10268203	7	D	0.313	0.313	1.500	6.000	4	Cylindrical	■
C5141-.375D7S.0Z4	10268214	7	D	0.375	0.375	1.750	4.000	4	Cylindrical	■
C5141-.438D7S.0Z4	10268226	7	D	0.438	0.438	3.000	6.000	4	Cylindrical	■
C5141-.500D7S.0Z4	10268234	7	D	0.500	0.500	3.000	6.000	4	Cylindrical	■
C5141-.063F8S.0Z4	10268160	8	F	0.063	0.125	1.000	3.000	4	Cylindrical	■
C5141-.094F8S.0Z4	10268166	8	F	0.094	0.125	1.000	3.000	4	Cylindrical	■
C5141-.125D8S.0Z4	10268172	8	D	0.125	0.125	1.000	3.000	4	Cylindrical	■
C5141-.250D8S.0Z4	10268194	8	D	0.250	0.250	1.500	6.000	4	Cylindrical	■
C5141-.313D8S.0Z4	10268204	8	D	0.313	0.313	1.625	4.000	4	Cylindrical	■
C5141-.375D8S.0Z4	10268215	8	D	0.375	0.375	2.000	4.000	4	Cylindrical	■
C5141-.125D9S.0Z4	10268173	9	D	0.125	0.125	1.000	4.000	4	Cylindrical	■
C5141-.375D9S.0Z4	10268216	9	D	0.375	0.375	3.000	6.000	4	Cylindrical	■

■ **Lagerstandard.**

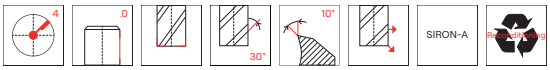
C5141

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Scharfe Schneide – Zoll





– Toleranzen:
– DMM=-.0001"/-.0004"
– DC ≤ Ø7/64" = ±.0005"
– DC > Ø7/64" = +.000"/-.002"
– Nachschleifen möglich, wenn DC ≥ Ø.375 ist



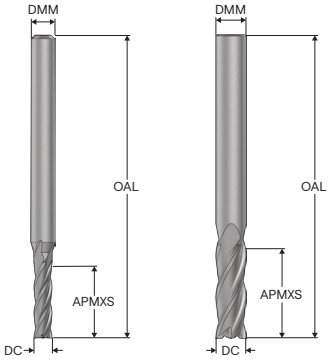
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll			
C5141-.375D1S.0Z4	SIRA	10268312	1	D	0.375	0.375	0.625	2.000	4	Cylindrical	■
C5141-.438D1S.0Z4	SIRA	10268324	1	D	0.438	0.438	0.625	2.500	4	Cylindrical	■
C5141-.500D1S.0Z4	SIRA	10268332	1	D	0.500	0.500	0.625	2.500	4	Cylindrical	■
C5141-.625D1S.0Z4	SIRA	10268340	1	D	0.625	0.625	0.750	3.000	4	Cylindrical	■
C5141-.750D1S.0Z4	SIRA	10268346	1	D	0.750	0.750	1.000	3.000	4	Cylindrical	■
C5141-1.000D1S.0Z4	SIRA	10268353	1	D	1.000	1.000	1.000	3.000	4	Cylindrical	■
C5141-.016F2S.0Z4	SIRA	10268256	2	F	0.016	0.125	0.031	1.500	4	Cylindrical	■
C5141-.047F2S.0Z4	SIRA	10268259	2	F	0.047	0.125	0.109	1.500	4	Cylindrical	■
C5141-.063F2S.0Z4	SIRA	10268261	2	F	0.063	0.125	0.125	1.500	4	Cylindrical	■
C5141-.078F2S.0Z4	SIRA	10268265	2	F	0.078	0.125	0.188	1.500	4	Cylindrical	■
C5141-.094F2S.0Z4	SIRA	10268267	2	F	0.094	0.125	0.188	1.500	4	Cylindrical	■
C5141-.125D2S.0Z4	SIRA	10268272	2	D	0.125	0.125	0.250	1.500	4	Cylindrical	■
C5141-.156F2S.0Z4	SIRA	10268279	2	F	0.156	0.188	0.313	2.000	4	Cylindrical	■
C5141-.188D2S.0Z4	SIRA	10268282	2	D	0.188	0.188	0.375	2.000	4	Cylindrical	■
C5141-.219F2S.0Z4	SIRA	10268289	2	F	0.219	0.250	0.438	2.000	4	Cylindrical	■
C5141-.250D2S.0Z4	SIRA	10268292	2	D	0.250	0.250	0.500	2.000	4	Cylindrical	■
C5141-.313D2S.0Z4	SIRA	10268302	2	D	0.313	0.313	0.500	2.000	4	Cylindrical	■
C5141-.375D2S.0Z4	SIRA	10268313	2	D	0.375	0.375	1.000	2.500	4	Cylindrical	■
C5141-.406F2S.0Z4	SIRA	10268322	2	F	0.406	0.438	1.000	2.750	4	Cylindrical	■
C5141-.438D2S.0Z4	SIRA	10268325	2	D	0.438	0.438	1.000	2.750	4	Cylindrical	■
C5141-.469F2S.0Z4	SIRA	10268331	2	F	0.469	0.500	1.000	3.000	4	Cylindrical	■
C5141-.500D2S.0Z4	SIRA	10268333	2	D	0.500	0.500	1.000	3.000	4	Cylindrical	■
C5141-.563D2S.0Z4	SIRA	10268339	2	D	0.563	0.563	1.125	3.500	4	Cylindrical	■
C5141-.625D2S.0Z4	SIRA	10268341	2	D	0.625	0.625	1.250	3.500	4	Cylindrical	■
C5141-.688F2S.0Z4	SIRA	10268345	2	F	0.688	0.750	1.375	4.000	4	Cylindrical	■
C5141-.750D2S.0Z4	SIRA	10268347	2	D	0.750	0.750	1.500	4.000	4	Cylindrical	■
C5141-.875D2S.0Z4	SIRA	10268352	2	D	0.875	0.875	1.500	4.000	4	Cylindrical	■
C5141-1.000D2S.0Z4	SIRA	10268354	2	D	1.000	1.000	1.500	4.000	4	Cylindrical	■
C5141-1.250D2S.0Z4	SIRA	10268359	2	D	1.250	1.250	2.000	4.500	4	Cylindrical	■

■ **Lagerstandard.**

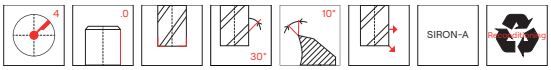
C5141

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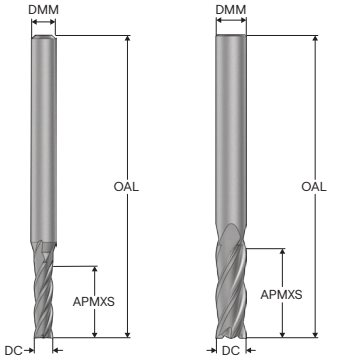
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll			
C5141-.031F3S.0Z4	SIRA	10268257	3	F	0.031	0.125	0.078	1.500	4	Cylindrical	■
C5141-.047F3S.0Z4	SIRA	10268260	3	F	0.047	0.125	0.125	1.500	4	Cylindrical	■
C5141-.063F3S.0Z4	SIRA	10268262	3	F	0.063	0.125	0.188	1.500	4	Cylindrical	■
C5141-.078F3S.0Z4	SIRA	10268266	3	F	0.078	0.125	0.250	1.500	4	Cylindrical	■
C5141-.094F3S.0Z4	SIRA	10268268	3	F	0.094	0.125	0.281	1.500	4	Cylindrical	■
C5141-.109F3S.0Z4	SIRA	10268271	3	F	0.109	0.125	0.375	1.500	4	Cylindrical	■
C5141-.156F3S.0Z4	SIRA	10268280	3	F	0.156	0.188	0.500	2.000	4	Cylindrical	■
C5141-.188D3S.0Z4	SIRA	10268283	3	D	0.188	0.188	0.625	2.000	4	Cylindrical	■
C5141-.203F3S.0Z4	SIRA	10268288	3	F	0.203	0.250	0.625	2.500	4	Cylindrical	■
C5141-.219F3S.0Z4	SIRA	10268290	3	F	0.219	0.250	0.625	2.500	4	Cylindrical	■
C5141-.234F3S.0Z4	SIRA	10268291	3	F	0.234	0.250	0.750	2.500	4	Cylindrical	■
C5141-.250D3S.0Z4	SIRA	10268293	3	D	0.250	0.250	0.750	2.500	4	Cylindrical	■
C5141-.266F3S.0Z4	SIRA	10268299	3	F	0.266	0.313	0.750	2.500	4	Cylindrical	■
C5141-.281F3S.0Z4	SIRA	10268300	3	F	0.281	0.313	0.750	2.500	4	Cylindrical	■
C5141-.297F3S.0Z4	SIRA	10268301	3	F	0.297	0.313	0.813	2.500	4	Cylindrical	■
C5141-.313D3S.0Z4	SIRA	10268303	3	D	0.313	0.313	0.813	2.500	4	Cylindrical	■
C5141-.328F3S.0Z4	SIRA	10268309	3	F	0.328	0.375	1.000	2.500	4	Cylindrical	■
C5141-.344F3S.0Z4	SIRA	10268310	3	F	0.344	0.375	1.000	2.500	4	Cylindrical	■
C5141-.359F3S.0Z4	SIRA	10268311	3	F	0.359	0.375	1.000	2.500	4	Cylindrical	■
C5141-.375D3S.0Z4	SIRA	10268314	3	D	0.375	0.375	1.000	3.000	4	Cylindrical	■
C5141-.391F3S.0Z4	SIRA	10268321	3	F	0.391	0.438	1.000	2.750	4	Cylindrical	■
C5141-.438D3S.0Z4	SIRA	10268326	3	D	0.438	0.438	1.000	4.000	4	Cylindrical	■
C5141-.500D3S.0Z4	SIRA	10268334	3	D	0.500	0.500	1.000	4.000	4	Cylindrical	■
C5141-.625D3S.0Z4	SIRA	10268342	3	D	0.625	0.625	2.000	6.000	4	Cylindrical	■
C5141-.750D3S.0Z4	SIRA	10268348	3	D	0.750	0.750	2.000	6.000	4	Cylindrical	■
C5141-1.000D3S.0Z4	SIRA	10268355	3	D	1.000	1.000	2.000	6.000	4	Cylindrical	■

■ **Lagerstandard.**

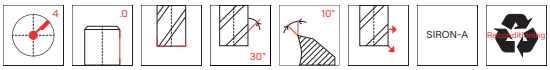
C5141

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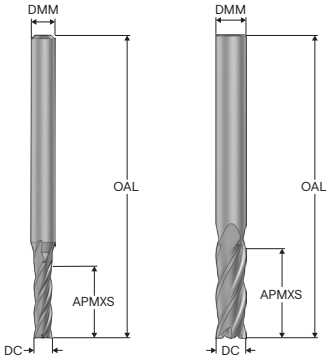
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll			
C5141-.031F4S.0Z4	SIRA	10268258	4	F	0.031	0.125	0.094	1.500	4	Cylindrical	■
C5141-.063F4S.0Z4	SIRA	10268263	4	F	0.063	0.125	0.250	1.500	4	Cylindrical	■
C5141-.094F4S.0Z4	SIRA	10268269	4	F	0.094	0.125	0.375	1.500	4	Cylindrical	■
C5141-.125D4S.0Z4	SIRA	10268273	4	D	0.125	0.125	0.500	1.500	4	Cylindrical	■
C5141-.141F4S.0Z4	SIRA	10268278	4	F	0.141	0.188	0.500	2.000	4	Cylindrical	■
C5141-.172F4S.0Z4	SIRA	10268281	4	F	0.172	0.188	0.625	2.000	4	Cylindrical	■
C5141-.188D4S.0Z4	SIRA	10268284	4	D	0.188	0.188	0.750	2.500	4	Cylindrical	■
C5141-.250D4S.0Z4	SIRA	10268294	4	D	0.250	0.250	1.000	3.000	4	Cylindrical	■
C5141-.313D4S.0Z4	SIRA	10268304	4	D	0.313	0.313	1.000	3.000	4	Cylindrical	■
C5141-.375D4S.0Z4	SIRA	10268315	4	D	0.375	0.375	1.000	4.000	4	Cylindrical	■
C5141-.438D4S.0Z4	SIRA	10268327	4	D	0.438	0.438	1.500	6.000	4	Cylindrical	■
C5141-.500D4S.0Z4	SIRA	10268335	4	D	0.500	0.500	1.500	6.000	4	Cylindrical	■
C5141-.625D4S.0Z4	SIRA	10268343	4	D	0.625	0.625	2.250	5.000	4	Cylindrical	■
C5141-.750D4S.0Z4	SIRA	10268349	4	D	0.750	0.750	2.250	5.000	4	Cylindrical	■
C5141-1.000D4S.0Z4	SIRA	10268356	4	D	1.000	1.000	2.250	5.000	4	Cylindrical	■
C5141-.125D5S.0Z4	SIRA	10268274	5	D	0.125	0.125	0.625	2.000	4	Cylindrical	■
C5141-.188D5S.0Z4	SIRA	10268285	5	D	0.188	0.188	1.000	3.000	4	Cylindrical	■
C5141-.250D5S.0Z4	SIRA	10268295	5	D	0.250	0.250	1.000	4.000	4	Cylindrical	■
C5141-.313D5S.0Z4	SIRA	10268305	5	D	0.313	0.313	1.000	4.000	4	Cylindrical	■
C5141-.375D5S.0Z4	SIRA	10268316	5	D	0.375	0.375	1.125	3.000	4	Cylindrical	■
C5141-.438D5S.0Z4	SIRA	10268328	5	D	0.438	0.438	2.000	4.000	4	Cylindrical	■
C5141-.500D5S.0Z4	SIRA	10268336	5	D	0.500	0.500	2.000	4.000	4	Cylindrical	■
C5141-.625D5S.0Z4	SIRA	10268344	5	D	0.625	0.625	3.000	6.000	4	Cylindrical	■
C5141-.750D5S.0Z4	SIRA	10268350	5	D	0.750	0.750	3.000	6.000	4	Cylindrical	■
C5141-1.000D5S.0Z4	SIRA	10268357	5	D	1.000	1.000	3.000	6.000	4	Cylindrical	■
C5141-1.000D6S.0Z4	SIRA	10268358	6	D	1.000	1.000	4.000	7.000	4	Cylindrical	■

■ **Lagerstandard.**

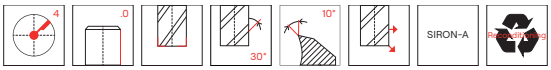
C5141

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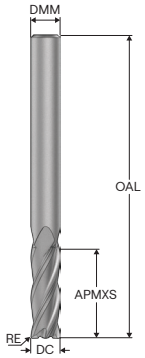
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll			
C5141-.125D6S.0Z4	SIRA	10268275	6	D	0.125	0.125	0.750	3.000	4	Cylindrical	■
C5141-.188D6S.0Z4	SIRA	10268286	6	D	0.188	0.188	1.000	4.000	4	Cylindrical	■
C5141-.250D6S.0Z4	SIRA	10268296	6	D	0.250	0.250	1.125	3.000	4	Cylindrical	■
C5141-.313D6S.0Z4	SIRA	10268306	6	D	0.313	0.313	1.125	3.000	4	Cylindrical	■
C5141-.375D6S.0Z4	SIRA	10268317	6	D	0.375	0.375	1.500	6.000	4	Cylindrical	■
C5141-.438D6S.0Z4	SIRA	10268329	6	D	0.438	0.438	2.000	4.500	4	Cylindrical	■
C5141-.500D6S.0Z4	SIRA	10268337	6	D	0.500	0.500	2.000	4.500	4	Cylindrical	■
C5141-.750D6S.0Z4	SIRA	10268351	6	D	0.750	0.750	4.000	6.000	4	Cylindrical	■
C5141-.188D7S.0Z4	SIRA	10268287	7	D	0.188	0.188	1.125	3.000	4	Cylindrical	■
C5141-.250D7S.0Z4	SIRA	10268297	7	D	0.250	0.250	1.500	4.000	4	Cylindrical	■
C5141-.313D7S.0Z4	SIRA	10268307	7	D	0.313	0.313	1.500	6.000	4	Cylindrical	■
C5141-.375D7S.0Z4	SIRA	10268318	7	D	0.375	0.375	1.750	4.000	4	Cylindrical	■
C5141-.438D7S.0Z4	SIRA	10268330	7	D	0.438	0.438	3.000	6.000	4	Cylindrical	■
C5141-.500D7S.0Z4	SIRA	10268338	7	D	0.500	0.500	3.000	6.000	4	Cylindrical	■
C5141-.063F8S.0Z4	SIRA	10268264	8	F	0.063	0.125	1.000	3.000	4	Cylindrical	■
C5141-.094F8S.0Z4	SIRA	10268270	8	F	0.094	0.125	1.000	3.000	4	Cylindrical	■
C5141-.125D8S.0Z4	SIRA	10268276	8	D	0.125	0.125	1.000	3.000	4	Cylindrical	■
C5141-.250D8S.0Z4	SIRA	10268298	8	D	0.250	0.250	1.500	6.000	4	Cylindrical	■
C5141-.313D8S.0Z4	SIRA	10268308	8	D	0.313	0.313	1.625	4.000	4	Cylindrical	■
C5141-.375D8S.0Z4	SIRA	10268319	8	D	0.375	0.375	2.000	4.000	4	Cylindrical	■
C5141-.125D9S.0Z4	SIRA	10268277	9	D	0.125	0.125	1.000	4.000	4	Cylindrical	■
C5141-.375D9S.0Z4	SIRA	10268320	9	D	0.375	0.375	3.000	6.000	4	Cylindrical	■

■ **Lagerstandard.**

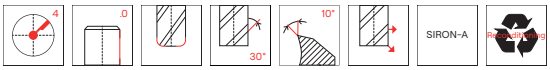
C5141

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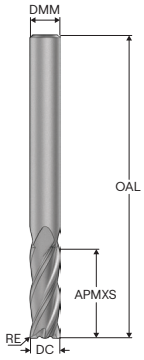
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll			
C5141-.438D2R015.0Z4	SIRA	10268379	2	D	0.438	0.438	1.000	2.750	0.015	4	Cylindrical	■
C5141-.438D2R030.0Z4	SIRA	10268380	2	D	0.438	0.438	1.000	2.750	0.030	4	Cylindrical	■
C5141-.438D2R060.0Z4	SIRA	10268381	2	D	0.438	0.438	1.000	2.750	0.060	4	Cylindrical	■
C5141-.438D2R125.0Z4	SIRA	10268382	2	D	0.438	0.438	1.000	2.750	0.125	4	Cylindrical	■
C5141-.500D2R015.0Z4	SIRA	10268383	2	D	0.500	0.500	1.000	3.000	0.015	4	Cylindrical	■
C5141-.500D2R020.0Z4	SIRA	10268384	2	D	0.500	0.500	1.000	3.000	0.020	4	Cylindrical	■
C5141-.500D2R030.0Z4	SIRA	10268385	2	D	0.500	0.500	1.000	3.000	0.030	4	Cylindrical	■
C5141-.500D2R045.0Z4	SIRA	10268386	2	D	0.500	0.500	1.000	3.000	0.045	4	Cylindrical	■
C5141-.500D2R060.0Z4	SIRA	10268387	2	D	0.500	0.500	1.000	3.000	0.060	4	Cylindrical	■
C5141-.500D2R090.0Z4	SIRA	10268388	2	D	0.500	0.500	1.000	3.000	0.090	4	Cylindrical	■
C5141-.500D2R125.0Z4	SIRA	10268389	2	D	0.500	0.500	1.000	3.000	0.125	4	Cylindrical	■
C5141-.625D2R015.0Z4	SIRA	10268390	2	D	0.625	0.625	1.250	3.500	0.015	4	Cylindrical	■
C5141-.625D2R030.0Z4	SIRA	10268391	2	D	0.625	0.625	1.250	3.500	0.030	4	Cylindrical	■
C5141-.625D2R060.0Z4	SIRA	10268392	2	D	0.625	0.625	1.250	3.500	0.060	4	Cylindrical	■
C5141-.625D2R125.0Z4	SIRA	10268393	2	D	0.625	0.625	1.250	3.500	0.125	4	Cylindrical	■
C5141-.750D2R015.0Z4	SIRA	10268394	2	D	0.750	0.750	1.500	4.000	0.015	4	Cylindrical	■
C5141-.750D2R020.0Z4	SIRA	10268395	2	D	0.750	0.750	1.500	4.000	0.020	4	Cylindrical	■
C5141-.750D2R030.0Z4	SIRA	10268396	2	D	0.750	0.750	1.500	4.000	0.030	4	Cylindrical	■
C5141-.750D2R045.0Z4	SIRA	10268397	2	D	0.750	0.750	1.500	4.000	0.045	4	Cylindrical	■
C5141-.750D2R060.0Z4	SIRA	10268398	2	D	0.750	0.750	1.500	4.000	0.060	4	Cylindrical	■
C5141-.750D2R090.0Z4	SIRA	10268399	2	D	0.750	0.750	1.500	4.000	0.090	4	Cylindrical	■
C5141-.750D2R125.0Z4	SIRA	10268400	2	D	0.750	0.750	1.500	4.000	0.125	4	Cylindrical	■
C5141-.750D2R190.0Z4	SIRA	10268402	2	D	0.750	0.750	1.500	4.000	0.190	4	Cylindrical	■
C5141-1.000D2R030.0Z4	SIRA	10268405	2	D	1.000	1.000	1.500	4.000	0.030	4	Cylindrical	■
C5141-1.000D2R060.0Z4	SIRA	10268406	2	D	1.000	1.000	1.500	4.000	0.060	4	Cylindrical	■
C5141-1.000D2R090.0Z4	SIRA	10268407	2	D	1.000	1.000	1.500	4.000	0.090	4	Cylindrical	■
C5141-1.000D2R125.0Z4	SIRA	10268408	2	D	1.000	1.000	1.500	4.000	0.125	4	Cylindrical	■
C5141-1.000D2R190.0Z4	SIRA	10268409	2	D	1.000	1.000	1.500	4.000	0.190	4	Cylindrical	■

■ **Lagerstandard.**

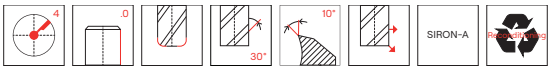
C5141

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius – Zoll





—Toleranzen:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—RE= ±.001"
—Nachschleifen möglich, wenn DC ≥ Ø.375 ist



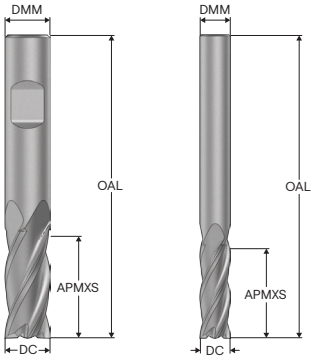
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll			
C5141-.188D3R015.0Z4	SIRA	10268363	3	D	0.188	0.188	0.625	2.000	0.015	4	Cylindrical	■
C5141-.188D3R020.0Z4	SIRA	10268364	3	D	0.188	0.188	0.625	2.000	0.020	4	Cylindrical	■
C5141-.188D3R030.0Z4	SIRA	10268365	3	D	0.188	0.188	0.625	2.000	0.030	4	Cylindrical	■
C5141-.250D3R015.0Z4	SIRA	10268366	3	D	0.250	0.250	0.750	2.500	0.015	4	Cylindrical	■
C5141-.250D3R020.0Z4	SIRA	10268367	3	D	0.250	0.250	0.750	2.500	0.020	4	Cylindrical	■
C5141-.250D3R030.0Z4	SIRA	10268368	3	D	0.250	0.250	0.750	2.500	0.030	4	Cylindrical	■
C5141-.250D3R045.0Z4	SIRA	10268369	3	D	0.250	0.250	0.750	2.500	0.045	4	Cylindrical	■
C5141-.313D3R015.0Z4	SIRA	10268370	3	D	0.313	0.313	0.813	2.500	0.015	4	Cylindrical	■
C5141-.313D3R020.0Z4	SIRA	10268371	3	D	0.313	0.313	0.813	2.500	0.020	4	Cylindrical	■
C5141-.313D3R030.0Z4	SIRA	10268372	3	D	0.313	0.313	0.813	2.500	0.030	4	Cylindrical	■
C5141-.313D3R045.0Z4	SIRA	10268373	3	D	0.313	0.313	0.813	2.500	0.045	4	Cylindrical	■
C5141-.375D3R015.0Z4	SIRA	10268374	3	D	0.375	0.375	1.000	2.500	0.015	4	Cylindrical	■
C5141-.375D3R020.0Z4	SIRA	10268375	3	D	0.375	0.375	1.000	2.500	0.020	4	Cylindrical	■
C5141-.375D3R030.0Z4	SIRA	10268376	3	D	0.375	0.375	1.000	2.500	0.030	4	Cylindrical	■
C5141-.375D3R045.0Z4	SIRA	10268377	3	D	0.375	0.375	1.000	2.500	0.045	4	Cylindrical	■
C5141-.125D4R015.0Z4	SIRA	10268360	4	D	0.125	0.125	0.500	1.500	0.015	4	Cylindrical	■
C5141-.125D4R020.0Z4	SIRA	10268361	4	D	0.125	0.125	0.500	1.500	0.020	4	Cylindrical	■
C5141-.125D4R030.0Z4	SIRA	10268362	4	D	0.125	0.125	0.500	1.500	0.030	4	Cylindrical	■

■ Lagerstandard.

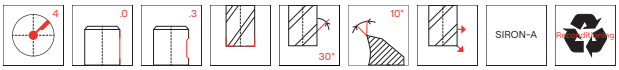
C5141

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Zylindrisch/Weldon – Scharfe Schneide – Zoll





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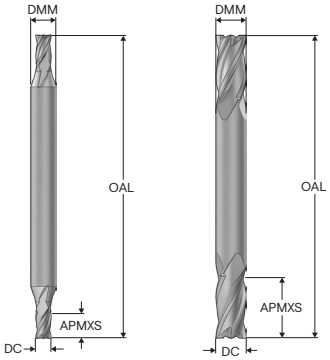
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll			
C5141-.375D2S.3Z4NC	SIRA	10268423	2	D	0.375	0.375	0.875	2.500	4	Weldon	■
C5141-.500D2S.3Z4NC	SIRA	10268424	2	D	0.500	0.500	1.000	3.000	4	Weldon	■
C5141-.625D2S.3Z4NC	SIRA	10268425	2	D	0.625	0.625	1.250	3.500	4	Weldon	■
C5141-.750D2S.3Z4NC	SIRA	10268426	2	D	0.750	0.750	1.500	4.000	4	Weldon	■
C5141-1.000D2S.3Z4NC	SIRA	10268427	2	D	1.000	1.000	1.500	4.000	4	Weldon	■
C5141-.250D3S.0Z4NC	SIRA	10268421	3	D	0.250	0.250	0.750	2.500	4	Cylindrical	■
C5141-.313D3S.0Z4NC	SIRA	10268422	3	D	0.313	0.313	0.813	2.500	4	Cylindrical	■

■ **Lagerstandard.**

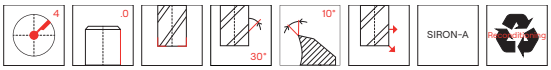
C5141

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Scharfe Schneide – Zoll





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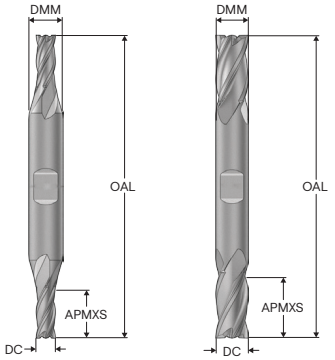
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll			
C5141-.438D1S.0Z4D	SIRA	10268446	1	D	0.438	0.438	0.563	2.750	4	Cylindrical	■
C5141-.500D1S.0Z4D	SIRA	10268447	1	D	0.500	0.500	0.625	3.000	4	Cylindrical	■
C5141-.031F2S.0Z4D	SIRA	10268428	2	F	0.031	0.125	0.063	1.500	4	Cylindrical	■
C5141-.047F2S.0Z4D	SIRA	10268429	2	F	0.047	0.125	0.094	1.500	4	Cylindrical	■
C5141-.063F2S.0Z4D	SIRA	10268430	2	F	0.063	0.125	0.125	1.500	4	Cylindrical	■
C5141-.078F2S.0Z4D	SIRA	10268431	2	F	0.078	0.125	0.125	1.500	4	Cylindrical	■
C5141-.094F2S.0Z4D	SIRA	10268432	2	F	0.094	0.125	0.188	1.500	4	Cylindrical	■
C5141-.109F2S.0Z4D	SIRA	10268433	2	F	0.109	0.125	0.188	1.500	4	Cylindrical	■
C5141-.125D2S.0Z4D	SIRA	10268434	2	D	0.125	0.125	0.250	1.500	4	Cylindrical	■
C5141-.141F2S.0Z4D	SIRA	10268435	2	F	0.141	0.188	0.313	2.000	4	Cylindrical	■
C5141-.156F2S.0Z4D	SIRA	10268436	2	F	0.156	0.188	0.313	2.000	4	Cylindrical	■
C5141-.172F2S.0Z4D	SIRA	10268437	2	F	0.172	0.188	0.313	2.000	4	Cylindrical	■
C5141-.188D2S.0Z4D	SIRA	10268438	2	D	0.188	0.188	0.375	2.000	4	Cylindrical	■
C5141-.203F2S.0Z4D	SIRA	10268439	2	F	0.203	0.250	0.500	2.500	4	Cylindrical	■
C5141-.219F2S.0Z4D	SIRA	10268440	2	F	0.219	0.250	0.500	2.500	4	Cylindrical	■
C5141-.234F2S.0Z4D	SIRA	10268441	2	F	0.234	0.250	0.500	2.500	4	Cylindrical	■
C5141-.250D2S.0Z4D	SIRA	10268442	2	D	0.250	0.250	0.500	2.500	4	Cylindrical	■
C5141-.281F2S.0Z4D	SIRA	10268443	2	F	0.281	0.313	0.500	2.500	4	Cylindrical	■
C5141-.313D2S.0Z4D	SIRA	10268444	2	D	0.313	0.313	0.500	2.500	4	Cylindrical	■
C5141-.375D2S.0Z4D	SIRA	10268445	2	D	0.375	0.375	0.563	2.500	4	Cylindrical	■

■ **Lagerstandard.**

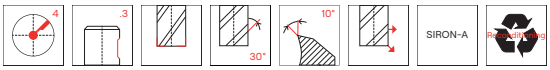
C5141

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Weldon – Scharfe Schneide – Zoll





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Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll			
C5141-.281F2S.3Z4D	SIRA	10268415	2	F	0.281	0.375	0.688	3.500	4	Weldon	■
C5141-.313F2S.3Z4D	SIRA	10268416	2	F	0.313	0.375	0.750	3.500	4	Weldon	■
C5141-.344F2S.3Z4D	SIRA	10268417	2	F	0.344	0.375	0.750	3.500	4	Weldon	■
C5141-.375D2S.3Z4D	SIRA	10268418	2	D	0.375	0.375	0.750	3.500	4	Weldon	■
C5141-.438F2S.3Z4D	SIRA	10268419	2	F	0.438	0.500	0.875	4.000	4	Weldon	■
C5141-.500D2S.3Z4D	SIRA	10268420	2	D	0.500	0.500	1.000	4.000	4	Weldon	■
C5141-.125F3S.3Z4D	SIRA	10268410	3	F	0.125	0.375	0.375	3.063	4	Weldon	■
C5141-.156F3S.3Z4D	SIRA	10268411	3	F	0.156	0.375	0.438	3.125	4	Weldon	■
C5141-.188F3S.3Z4D	SIRA	10268412	3	F	0.188	0.375	0.500	3.250	4	Weldon	■
C5141-.219F3S.3Z4D	SIRA	10268413	3	F	0.219	0.375	0.563	3.375	4	Weldon	■
C5141-.250F3S.3Z4D	SIRA	10268414	3	F	0.250	0.375	0.625	3.375	4	Weldon	■

■ **Lagerstandard.**

Schnittdaten – C5141 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z														v_c
				1	1,5	2	3	3,5	4	5	6	8	9	10	12	16	20	
P1	E	0,1	2	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	0,08	0,1	150 (135 — 165)
		0.10	*2.0*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*0.0032*	*0.0040*	*490 (440— 540)*
P2	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	58 (45— 70)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*190 (147 — 230)*
P3	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	85 (70 — 95)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*279 (246 — 312)*
P4	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	100 (90 — 110)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*330 (295 — 360)*
P5	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	68 (50 — 75)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*223 (165 — 245)*
P6	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	87 (77 — 100)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*285 (250 — 330)*
P7	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	65 (55 — 75)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*213 (180 — 245)*
P8	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	65 (50 — 75)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*213 (165 — 245)*
P11	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	85 (70 — 95)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*280 (230 — 310)*
P12	E	0,1	2	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,05	0,065	55 (45— 65)
		0.10	*2.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0020*	*0.0026*	*180 (147 — 213)*
M1	E	0,1	2	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	0,08	0,1	93 (83 — 100)
		0.10	*2.0*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*0.0032*	*0.0040*	*305 (270 — 360)*
M2	E	0,1	2	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	0,08	0,1	60 (50 — 70)
		0.10	*2.0*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*0.0032*	*0.0040*	*200 (165 — 230)*
M3	E	0,1	2	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	0,08	0,1	55 (45 —65)
		0.10	*2.0*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*0.0032*	*0.0040*	*180 (147 — 213)*
M4	E	0,1	2	0,0048	0,0075	0,01	0,015	0,017	0,02	0,025	0,03	0,04	0,044	0,048	0,06	0,08	0,09	45 (35 — 55)
		0.10	*2.0*	*0.00019*	*0.00030*	*0.00040*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0017*	*0.0019*	*0.0024*	*0.0032*	*0.0036*	*147 (115 — 180)*
M5	E	0,1	2	0,0044	0,0065	0,0085	0,013	0,015	0,017	0,022	0,026	0,034	0,038	0,042	0,05	0,07	0,085	35 (20 — 45)
		0.10	*2.0*	*0.00017*	*0.00026*	*0.00034*	*0.00050*	*0.00060*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*0.0028*	*0.0034*	*114 (65 — 147)*
K1	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	80 (70 — 90)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*260 (230 — 290)*
K2	E	0,1	2	0,0055	0,0085	0,011	0,017	0,02	0,022	0,028	0,034	0,044	0,05	0,055	0,065	0,09	0,11	87 (75 — 100)
		0.10	*2.0*	*0.00022*	*0.00034*	*0.00044*	*0.00065*	*0.00080*	*0.00085*	*0.0011*	*0.0013*	*0.0017*	*0.0020*	*0.0022*	*0.0026*	*0.0036*	*0.0044*	*285 (245 — 330)*
K3	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	65 (55 — 75)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*213 (180 — 245)*
K4	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	50 (35 — 65)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*165 (115 — 213)*
K5	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	45 (30 — 55)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*147 (100 — 180)*
K6	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	77 (65 — 85)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*250 (210 — 280)*
K7	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	77 (60 — 90)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*250 (200 — 290)*
S1	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	50 (35 — 60)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*165 (115 — 200)*
S2	E	0,1	2	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,05	0,065	25 (15 — 35)
		0.10	*2.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0020*	*0.0026*	*82 (50 — 115)*
S3	E	0,1	2	0,002	0,0032	0,0042	0,0065	0,0075	0,0085	0,01	0,013	0,017	0,019	0,02	0,025	0,034	0,042	11 (7,5 — 16)
		0.10	*2.0*	*0.000080*	*0.00013*	*0.00017*	*0.00026*	*0.00030*	*0.00034*	*0.00040*	*0.00050*	*0.00065*	*0.00075*	*0.00080*	*0.0010*	*0.0013*	*0.0017*	*35 (25 — 52)*
S11	E	0,1	2	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,025	0,032	0,036	0,04	0,05	0,065	0,08	110 (95— 120)
		0.10	*2.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0014*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*360 (311 — 390)*
S12	E	0,1	2	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,05	0,065	77 (60 — 90)
		0.10	*2.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0020*	*0.0026*	*250 (190 — 290)*
S13	E	0,1	2	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,05	0,065	30 (20 — 40)
		0.10	*2.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0020*	*0.0026*	*100 (65 — 130)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – C5141 Eckfräsen – Zoll

SMG		a_p/DC	f_z													v_c
			1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	1 1/4	
P1	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	0,075	150 (135 — 165)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*0.0030*	*490 (440— 540)*
P2	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	58 (45— 70)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*190 (147 — 230)*
P3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	85 (70 — 95)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*279 (246 — 312)*
P4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	100 (90 — 110)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*330 (295 — 360)*
P5	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	68 (50 — 75)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*223 (165 — 245)*
P6	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	87 (77 — 100)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*285 (250 — 330)*
P7	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	65 (55 — 75)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*213 (180 — 245)*
P8	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	65 (50 — 75)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*213 (165 — 245)*
P11	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	85 (70 — 95)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*280 (230 — 310)*
P12	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	55 (45— 65)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*180 (147 — 213)*
M1	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	93 (83 — 100)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*305 (270 — 360)*
M2	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	60 (50 — 70)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*200 (165 — 230)*
M3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	55 (45 —65)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*180 (147 — 213)*
M4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	45 (35 — 55)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*147 (115 — 180)*
M5	E	1	0,001	0,002	0,0042	0,005	0,006	0,007	0,0085	0,01	0,012	0,017	0,02	0,025	0,034	0,042	35 (20 — 45)
		1.0	*0.000040*	*0.000080*	*0.00017*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00048*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0017*	*114 (65 — 147)*
K1	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	0,075	80 (70 — 90)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*0.0030*	*260 (230 — 290)*
K2	E	1	0,0018	0,0036	0,0075	0,009	0,011	0,013	0,015	0,018	0,022	0,03	0,036	0,044	0,06	0,075	87 (75 — 100)
		1.0	*0.000070*	*0.00014*	*0.00030*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0012*	*0.0014*	*0.0017*	*0.0024*	*0.0030*	*285 (245 — 330)*
K3	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	65 (55 — 75)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*213 (180 — 245)*
K4	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	50 (35 — 65)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*165 (115 — 213)*
K5	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	45 (30 — 55)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*147 (100 — 180)*
K6	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	77 (65 — 85)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*250 (210 — 280)*
K7	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	77 (60 — 90)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*250 (200 — 290)*
S1	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	50 (35 — 60)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*165 (115 — 200)*
S2	E	1	0,0008	0,0016	0,0032	0,004	0,0048	0,0055	0,0065	0,008	0,0095	0,013	0,016	0,019	0,025	0,032	25 (15 — 35)
		1.0	*0.000032*	*0.000065*	*0.00013*	*0.00016*	*0.00019*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0013*	*82 (50 — 115)*
S3	E	1	0,0008	0,0016	0,0032	0,004	0,0048	0,0055	0,0065	0,008	0,0095	0,013	0,016	0,019	0,025	0,032	11 (7,5 — 16)
		1.0	*0.000032*	*0.000065*	*0.00013*	*0.00016*	*0.00019*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0013*	*35 (25 — 52)*
S11	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	110 (95— 120)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*360 (311 — 390)*
S12	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	77 (60 — 90)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*250 (190 — 290)*
S13	E	1	0,0013	0,0028	0,0055	0,0065	0,008	0,0095	0,011	0,014	0,016	0,022	0,026	0,032	0,044	0,055	30 (20 — 40)
		1.0	*0.000050*	*0.00011*	*0.00022*	*0.00026*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0022*	*100 (65 — 130)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – C5141 Nutfräsen

SMG		a_p/DC	f_z														v_c
			1	1,5	2	3	3,5	4	5	6	8	9	10	12	16	20	
P1	E	1	0,0024	0,0034	0,0046	0,007	0,008	0,009	0,012	0,014	0,018	0,02	0,024	0,028	0,036	0,046	75 (50 — 85)
		1.0	*0.000095*	*0.00013*	*0.00018*	*0.00028*	*0.00032*	*0.00036*	*0.00048*	*0.00055*	*0.00070*	*0.00080*	*0.00095*	*0.0011*	*0.0014*	*0.0018*	*245 (170 — 270)*
P2	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	32 (20 —40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*100 (66 — 130)*
P3	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	45 (30 — 60)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*147 (98— 196)*
P4	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	55 (40 — 65)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*180 (130 —210)*
P5	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	35 (20 — 45)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*115 (65— 145)*
P6	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	45 (30 — 60)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*145 (180 — 195)*
P7	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	35 (20 — 50)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*115 (65 — 165)*
P8	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	25 (15 — 35)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*80 (50 — 110)*
P11	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	32 (20 — 42)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*105 (65 — 138)*
P12	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	30 (20 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*100 (65 — 130)*
M1	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	42 (21 — 52)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*138 (69 — 170)*
M2	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	32 (20 — 42)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*105 (65 — 138)*
M3	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	30 (15 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*100 (50 — 130)*
M4	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	22 (10 — 35)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*72 (33 — 115)*
M5	E	1	0,0013	0,002	0,0026	0,004	0,0046	0,005	0,0065	0,008	0,01	0,012	0,013	0,016	0,02	0,026	19 (16 — 30)
		1.0	*0.000050*	*0.000080*	*0.00010*	*0.00016*	*0.00018*	*0.00020*	*0.00026*	*0.00032*	*0.00040*	*0.00048*	*0.00050*	*0.00065*	*0.00080*	*0.0010*	*62 (52 — 100)*
K1	E	1	0,0024	0,0034	0,0046	0,007	0,008	0,009	0,012	0,014	0,018	0,02	0,024	0,028	0,036	0,046	30 (20 — 45)
		1.0	*0.000095*	*0.00013*	*0.00018*	*0.00028*	*0.00032*	*0.00036*	*0.00048*	*0.00055*	*0.00070*	*0.00080*	*0.00095*	*0.0011*	*0.0014*	*0.0018*	*100 (65 — 147)*
K2	E	1	0,0024	0,0034	0,0046	0,007	0,008	0,009	0,012	0,014	0,018	0,02	0,024	0,028	0,036	0,046	40 (30 — 50)
		1.0	*0.000095*	*0.00013*	*0.00018*	*0.00028*	*0.00032*	*0.00036*	*0.00048*	*0.00055*	*0.00070*	*0.00080*	*0.00095*	*0.0011*	*0.0014*	*0.0018*	*130 (100 — 165)*
K3	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	32 (26 — 45)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*105 (85 — 148)*
K4	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	22 (18 — 30)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*72 (60 — 100)*
K5	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	20 (15 — 30)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*65 (50 — 100)*
K6	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	35 (20 — 50)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*115 (65 — 165)*
K7	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	35 (20 — 50)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*115 (65 — 165)*
S1	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	25 (18 — 30)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*80 (60 — 100)*
S2	E	1	0,001	0,0015	0,002	0,003	0,0036	0,004	0,005	0,006	0,008	0,009	0,01	0,012	0,016	0,02	13 (9 — 18)
		1.0	*0.000040*	*0.000060*	*0.000080*	*0.00012*	*0.00014*	*0.00016*	*0.00020*	*0.00024*	*0.00032*	*0.00036*	*0.00040*	*0.00048*	*0.00065*	*0.00080*	*62 (30 — 60)*
S3	E	1	0,001	0,0015	0,002	0,003	0,0036	0,004	0,005	0,006	0,008	0,009	0,01	0,012	0,016	0,02	7,0 (5 — 12)
		1.0	*0.000040*	*0.000060*	*0.000080*	*0.00012*	*0.00014*	*0.00016*	*0.00020*	*0.00024*	*0.00032*	*0.00036*	*0.00040*	*0.00048*	*0.00065*	*0.00080*	*23 (15— 39)*
S11	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	35 (25 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*114 (82— 130)*
S12	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	32 (22 — 40)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*105 (72 — 130)*
S13	E	1	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,028	0,034	10 (8— 15)
		1.0	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0011*	*0.0013*	*33 (26 — 50)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – C5141 Nutfräsen – Zoll

SMG		a_e/DC	a_p/DC	f_z													v_c
				1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	1 1/4	
P1	E	0,1	2	0,0038	0,008	0,016	0,019	0,024	0,028	0,032	0,038	0,046	0,06	0,08	0,095	0,12	0,16	75 (50 — 85)
		0.10	*2.0*	*0.00015*	*0.00032*	*0.00065*	*0.00075*	*0.00095*	*0.0011*	*0.0013*	*0.0015*	*0.0018*	*0.0024*	*0.0032*	*0.0038*	*0.0048*	*0.0065*	*245 (170 — 270)*
P2	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	32 (20 —40)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*100 (66 — 130)*
P3	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	45 (30 — 60)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*147 (98— 196)*
P4	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	55 (40 — 65)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*180 (130 —210)*
P5	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	35 (20 — 45)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*115 (65— 145)*
P6	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	45 (30 — 60)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*145 (180 — 195)*
P7	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	35 (20 — 50)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*115 (65 — 165)*
P8	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	25 (15 — 35)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*80 (50 — 110)*
P11	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	32 (20 — 42)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*105 (65 — 138)*
P12	E	0,1	2	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,025	0,03	0,04	0,05	0,06	0,08	0,1	30 (20 — 40)
		0.10	*2.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0032*	*0.0040*	*100 (65 — 130)*
M1	E	0,1	2	0,0038	0,008	0,016	0,019	0,024	0,028	0,032	0,038	0,046	0,06	0,08	0,095	0,12	0,16	42 (21 — 52)
		0.10	*2.0*	*0.00015*	*0.00032*	*0.00065*	*0.00075*	*0.00095*	*0.0011*	*0.0013*	*0.0015*	*0.0018*	*0.0024*	*0.0032*	*0.0038*	*0.0048*	*0.0065*	*138 (69 — 170)*
M2	E	0,1	2	0,0038	0,008	0,016	0,019	0,024	0,028	0,032	0,038	0,046	0,06	0,08	0,095	0,12	0,16	32 (20 — 42)
		0.10	*2.0*	*0.00015*	*0.00032*	*0.00065*	*0.00075*	*0.00095*	*0.0011*	*0.0013*	*0.0015*	*0.0018*	*0.0024*	*0.0032*	*0.0038*	*0.0048*	*0.0065*	*105 (65 — 138)*
M3	E	0,1	2	0,0038	0,008	0,016	0,019	0,024	0,028	0,032	0,038	0,046	0,06	0,08	0,095	0,12	0,13	30 (15 — 40)
		0.10	*2.0*	*0.00015*	*0.00032*	*0.00065*	*0.00075*	*0.00095*	*0.0011*	*0.0013*	*0.0015*	*0.0018*	*0.0024*	*0.0032*	*0.0038*	*0.0048*	*0.0050*	*100 (50 — 130)*
M4	E	0,1	2	0,0038	0,008	0,016	0,019	0,024	0,028	0,032	0,038	0,046	0,06	0,08	0,09	0,1	0,11	22 (10 — 35)
		0.10	*2.0*	*0.00015*	*0.00032*	*0.00065*	*0.00075*	*0.00095*	*0.0011*	*0.0013*	*0.0015*	*0.0018*	*0.0024*	*0.0032*	*0.0036*	*0.0040*	*0.0044*	*72 (33 — 115)*
M5	E	0,1	2	0,0034	0,007	0,014	0,017	0,02	0,024	0,028	0,034	0,04	0,055	0,07	0,08	0,11	0,14	19 (16 — 30)
		0.10	*2.0*	*0.00013*	*0.00028*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0011*	*0.0013*	*0.0016*	*0.0022*	*0.0028*	*0.0032*	*0.0044*	*0.0055*	*62 (52 — 100)*
K1	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	30 (20 — 45)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*100 (65 — 147)*
K2	E	0,1	2	0,0044	0,009	0,018	0,022	0,026	0,032	0,036	0,044	0,055	0,07	0,09	0,11	0,14	0,18	40 (30 — 50)
		0.10	*2.0*	*0.00017*	*0.00036*	*0.00070*	*0.00085*	*0.0010*	*0.0013*	*0.0014*	*0.0017*	*0.0022*	*0.0028*	*0.0036*	*0.0044*	*0.0055*	*0.0070*	*130 (100 — 165)*
K3	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	32 (26 — 45)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*105 (85 — 148)*
K4	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	22 (18 — 30)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*72 (60 — 100)*
K5	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	20 (15 — 30)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*65 (50 — 100)*
K6	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	35 (20 — 50)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*115 (65 — 165)*
K7	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	35 (20 — 50)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*115 (65 — 165)*
S1	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	25 (18 — 30)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*80 (60 — 100)*
S2	E	0,1	2	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,025	0,03	0,04	0,05	0,06	0,08	0,1	13 (9 — 18)
		0.10	*2.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0032*	*0.0040*	*62 (30 — 60)*
S3	E	0,1	2	0,0017	0,0034	0,0065	0,0085	0,01	0,012	0,013	0,017	0,02	0,026	0,034	0,04	0,055	0,065	7,0 (5 — 12)
		0.10	*2.0*	*0.000065*	*0.00013*	*0.00026*	*0.00034*	*0.00040*	*0.00048*	*0.00050*	*0.00065*	*0.00080*	*0.0010*	*0.0013*	*0.0016*	*0.0022*	*0.0026*	*23 (15— 39)*
S11	E	0,1	2	0,0032	0,0065	0,013	0,016	0,02	0,022	0,026	0,032	0,04	0,05	0,065	0,08	0,1	0,13	35 (25 — 40)
		0.10	*2.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00080*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0020*	*0.0026*	*0.0032*	*0.0040*	*0.0050*	*114 (82— 130)*
S12	E	0,1	2	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,025	0,03	0,04	0,05	0,06	0,08	0,1	32 (22 — 40)
		0.10	*2.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0032*	*0.0040*	*105 (72 — 130)*
S13	E	0,1	2	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,025	0,03	0,04	0,05	0,06	0,08	0,1	10 (8— 15)
		0.10	*2.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0020*	*0.0024*	*0.0032*	*0.0040*	*33 (26 — 50)*

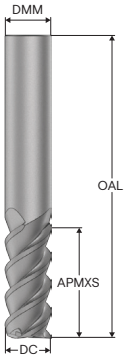
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

C5231/C5241

Allgemeine Anwendung – Universell – Fase – 3-4 Schneiden – Zylindrisch – Zoll





—Toleranzen:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—Nachschleifen möglich, wenn DC ≥ Ø.375 ist



Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll			
C5231-.375D2S.0Z3	SIRA	10268591	2	D	0.375	0.375	0.875	2.500	3	Cylindrical	■
C5231-.500D2S.0Z3	SIRA	10268592	2	D	0.500	0.500	1.000	3.000	3	Cylindrical	■
C5231-.625D2S.0Z3	SIRA	10268593	2	D	0.625	0.625	1.250	3.500	3	Cylindrical	■
C5231-.250D3S.0Z3	SIRA	10268590	3	D	0.250	0.250	0.750	2.500	3	Cylindrical	■
C5241-.750D3S.0Z4	SIRA	10268594	3	D	0.750	0.750	1.500	4.000	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – C5231-C5241 Eckfräsen – Zoll

SMG		a_e/DC	a_p/DC	f_z						v_c
				1/4	3/8	1/2	5/8	3/4	1	
P1	E	0,1 *0.10*	2 *2.0*	0,04 *0.0016*	0,058 *0.0023*	0,075 *0.003*	0,1 *0.004*	0,12 *0.0048*	0,15 *0.006*	150 (135 — 165) *490 (440— 540)*
P2	E	0,1 *0.10*	2 *2.0*	0,033 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,081 *0.0033*	0,1 *0.004*	0,13 *0.005*	58 (45— 70) *190 (147 — 230)*
P3	E	0,1 *0.10*	2 *2.0*	0,033 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	85 (70 — 95) *279 (246 — 312)*
P4	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	100 (90 — 110) *330 (295 — 360)*
P5	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	68 (50 — 75) *223 (165 — 245)*
P6	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	87 (77 — 100) *285 (250 — 330)*
P7	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	65 (55 — 75) *213 (180 — 245)*
P8	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	65 (50 — 75) *213 (165 — 245)*
P11	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	85 (70 — 95) *280 (230 — 310)*
P12	E	0,1 *0.10*	2 *2.0*	0,025 *0.001*	0,038 *0.0015*	0,05 *0.002*	0,063 *0.0025*	0,075 *0.003*	0,1 *0.004*	55 (45— 65) *180 (147 — 213)*
M1	E	0,1 *0.10*	2 *2.0*	0,04 *0.0016*	0,0575 *0.0023*	0,075 *0.003*	0,1 *0.004*	0,12 *0.0048*	0,15 *0.006*	93 (83 — 100) *305 (270 — 360)*
M2	E	0,1 *0.10*	2 *2.0*	0,04 *0.0016*	0,0023 *0.0023*	0,075 *0.003*	0,1 *0.004*	0,12 *0.0048*	0,15 *0.006*	60 (50 — 70) *200 (165 — 230)*
M3	E	0,1 *0.10*	2 *2.0*	0,0016 *0.0016*	0,0023 *0.0023*	0,075 *0.003*	0,1 *0.004*	0,12 *0.0048*	0,15 *0.006*	55 (45 —65) *180 (147 — 213)*
M4	E	0,1 *0.10*	2 *2.0*	0,0016 *0.0016*	0,058 *0.0023*	0,075 *0.003*	0,1 *0.004*	0,12 *0.0045*	0,13 *0.005*	45 (35 — 55) *147 (115 — 180)*
M5	E	0,1 *0.10*	2 *2.0*	0,035 *0.0014*	0,05 *0.002*	0,069 *0.0028*	0,088 *0.0035*	0,1 *0.004*	0,14 *0.0055*	35 (20 — 45) *114 (65 — 147)*
K1	E	0,1 *0.10*	2 *2.0*	0,033 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,081 *0.0033*	0,1 *0.004*	0,13 *0.005*	80 (70 — 90) *260 (230 — 290)*
K2	E	0,1 *0.10*	2 *2.0*	0,045 *0.0018*	0,069 *0.0028*	0,063 *0.0035*	0,11 *0.0045*	0,14 *0.0055*	0,18 *0.0069*	87 (75 — 100) *285 (245 — 330)*
K3	E	0,1 *0.10*	2 *2.0*	0,033 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,081 *0.0033*	0,1 *0.004*	0,13 *0.005*	65 (55 — 75) *213 (180 — 245)*
K4	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,081 *0.0033*	0,1 *0.004*	0,13 *0.005*	50 (35 — 65) *165 (115 — 213)*
K5	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	45 (30 — 55) *147 (100 — 180)*
K6	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	77 (65 — 85) *250 (210 — 280)*
K7	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	77 (60 — 90) *250 (200 — 290)*
S1	E	0,1 *0.10*	2 *2.0*	0,0013 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,0033 *0.0033*	0,1 *0.004*	0,13 *0.005*	50 (35 — 60) *165 (115 — 200)*
S2	E	0,1 *0.10*	2 *2.0*	0,025 *0.001*	0,038 *0.0015*	0,05 *0.002*	0,063 *0.0025*	0,075 *0.003*	0,1 *0.004*	25 (15 — 35) *82 (50 — 115)*
S3	E	0,1 *0.10*	2 *2.0*	0,016 *0.00063*	0,025 *0.001*	0,033 *0.0013*	0,043 *0.0016*	0,05 *0.002*	0,069 *0.0028*	11 (7,5 — 16) *35 (25 — 52)*
S11	E	0,1 *0.10*	2 *2.0*	0,033 *0.0013*	0,05 *0.002*	0,063 *0.0025*	0,081 *0.0033*	0,1 *0.004*	0,13 *0.005*	110 (95— 120) *360 (311 — 390)*
S12	E	0,1 *0.10*	2 *2.0*	0,025 *0.001*	0,038 *0.0015*	0,05 *0.002*	0,063 *0.0025*	0,075 *0.003*	0,1 *0.004*	77 (60 — 90) *250 (190 — 290)*
S13	E	0,1 *0.10*	2 *2.0*	0,025 *0.001*	0,038 *0.0015*	0,05 *0.002*	0,063 *0.0025*	0,075 *0.003*	0,1 *0.004*	30 (20 — 40) *100 (65 — 130)*

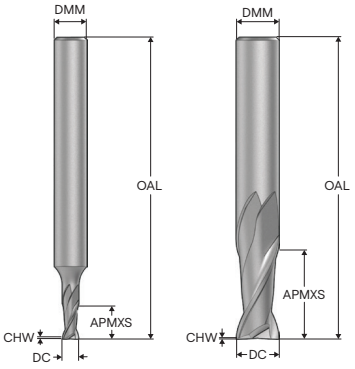
Schnittdaten, siehe Seite 699 - 707

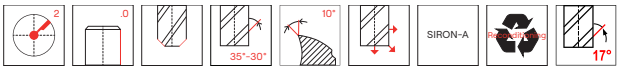
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JSE512

Allgemeine Anwendung – Universell – Eckfräser – 2 Schneiden – Zylindrisch – Fase







—Toleranzen:
—DMM=h5
—DC=e8
—Nachschleifen möglich, wenn DC ≥ Ø10 ist

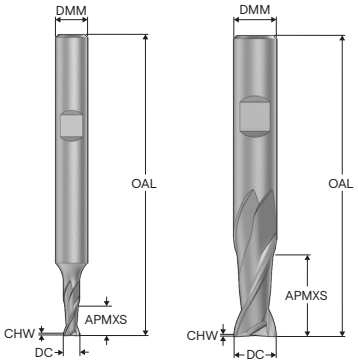
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	CHW	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm			
JSE512021F2C.0Z2	SIRA	10052986	2	F	2,0	3,0	4,0	50,0	0,02	2	Cylindrical	■
JSE512020F2C.0Z2	SIRA	10052990	2	F	2,0	6,0	4,0	57,0	0,02	2	Cylindrical	■
JSE512030D2C.0Z2	SIRA	10052987	2	D	3,0	3,0	6,0	50,0	0,03	2	Cylindrical	■
JSE512030F2C.0Z2	SIRA	10052991	2	F	3,0	6,0	6,0	57,0	0,03	2	Cylindrical	■
JSE512040D2C.0Z2	SIRA	10052988	2	D	4,0	4,0	8,0	50,0	0,04	2	Cylindrical	■
JSE512040F2C.0Z2	SIRA	10052992	2	F	4,0	6,0	8,0	57,0	0,04	2	Cylindrical	■
JSE512050D2C.0Z2	SIRA	10052989	2	D	5,0	5,0	10,0	50,0	0,05	2	Cylindrical	■
JSE512060D2C.0Z2	SIRA	10052993	2	D	6,0	6,0	12,0	57,0	0,06	2	Cylindrical	■
JSE512080D2C.0Z2	SIRA	10052994	2	D	8,0	8,0	16,0	63,0	0,08	2	Cylindrical	■
JSE512100D2C.0Z2	SIRA	10052995	2	D	10,0	10,0	20,0	72,0	0,1	2	Cylindrical	■
JSE512120D2C.0Z2	SIRA	10052996	2	D	12,0	12,0	24,0	83,0	0,12	2	Cylindrical	■

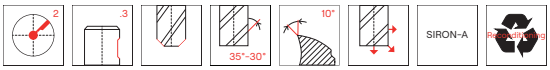
■ **Lagerstandard.**

JSE512

Allgemeine Anwendung – Universell – Eckfräser – 2 Schneiden – Weldon – Fase







– Toleranzen:
– DMM=h5
– DC=e8
– Nachschleifen möglich, wenn DC ≥ Ø10 ist

Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JSE512020F2C.3Z2	SIRA	10053113	2	F	2,0	6,0	4,0	57,0	0,02	2	Weldon	■
JSE512030F2C.3Z2	SIRA	10053114	2	F	3,0	6,0	6,0	57,0	0,03	2	Weldon	■
JSE512040F2C.3Z2	SIRA	10053115	2	F	4,0	6,0	8,0	57,0	0,04	2	Weldon	■
JSE512060D2C.3Z2	SIRA	10053116	2	D	6,0	6,0	12,0	57,0	0,06	2	Weldon	■
JSE512080D2C.3Z2	SIRA	10053117	2	D	8,0	8,0	16,0	63,0	0,08	2	Weldon	■
JSE512100D2C.3Z2	SIRA	10053118	2	D	10,0	10,0	20,0	72,0	0,1	2	Weldon	■
JSE512120D2C.3Z2	SIRA	10053119	2	D	12,0	12,0	24,0	83,0	0,12	2	Weldon	■

■ **Lagerstandard.**

Schnittdaten – JSE512 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	5	6	8	10	12	
P1	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P2	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P3	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P4	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P5	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P6	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P7	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P8	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
P11	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
P12	M/A/D/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
M1	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
M2	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
M3	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
M4	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
M5	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
K1	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K2	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K3	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K4	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K5	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K6	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K7	A/D/M/E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
N1	E/M/A	0.200 *0,200*	1.5 *1,5*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	500 (380 — 630) *1650 (1300 — 2000)*
N11	E/M/A	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	365 (250 — 480) *1200 (830 — 1500)*
S11	E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
S12	E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*
S13	E	0.250 *0,250*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (61 — 120) *280 (210 — 390)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JSE512 Nutfräsen

SMG		a_p/DC	f_z								v_c
			2	3	4	5	6	8	10	12	
P1	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (51 — 150) *395 (170 — 490)*
P2	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
P3	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (51 — 150) *395 (170 — 490)*
P4	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
P5	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
P6	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
P7	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (51 — 150) *395 (170 — 490)*
P8	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
P11	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (51 — 100) *230 (170 — 320)*
P12	M/A/D/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M1	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M2	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M3	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M4	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
M5	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
K1	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K2	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K3	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K4	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K5	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K6	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
K7	A/D/M/E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	120 (50 — 140) *395 (170 — 450)*
N1	E/M/A	0.40 *0,40*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	400 (300 — 500) *1300 (990 — 1600)*
N11	E/M/A	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	300 (200 — 390) *980 (660 — 1200)*
S11	E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
S12	E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*
S13	E	0.60 *0,60*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	70 (50 — 99) *230 (170 — 320)*

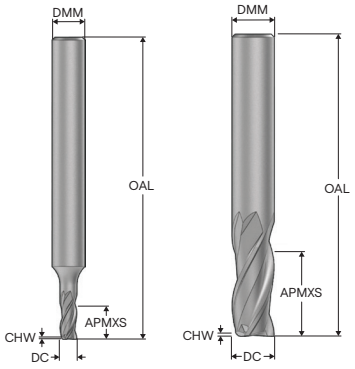
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

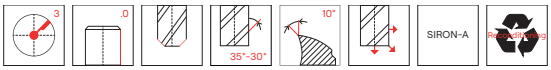
JSE513

Allgemeine Anwendung – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Fase





—Toleranzen:
—DMM=h5
—DC=e8
—Nachschleifen möglich, wenn DC ≥ Ø10 ist



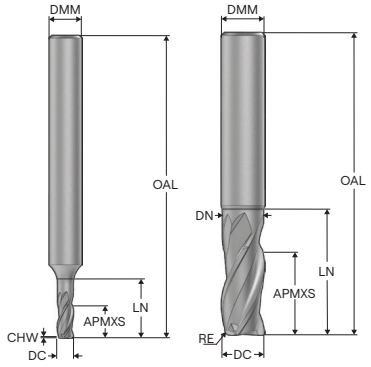
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	CHW	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm			
JSE513020F2C.0Z3	SIRA	10053000	2	F	2,0	6,0	4,0	57,0	0,02	3	Cylindrical	■
JSE513025F2C.0Z3	SIRA	10053001	2	F	2,5	6,0	5,0	57,0	0,025	3	Cylindrical	■
JSE513030D2C.0Z3	SIRA	10052998	2	D	3,0	3,0	6,0	50,0	0,03	3	Cylindrical	■
JSE513030F2C.0Z3	SIRA	10053002	2	F	3,0	6,0	6,0	57,0	0,03	3	Cylindrical	■
JSE513040D2C.0Z3	SIRA	10052999	2	D	4,0	4,0	8,0	50,0	0,04	3	Cylindrical	■
JSE513040F2C.0Z3	SIRA	10053003	2	F	4,0	6,0	8,0	57,0	0,04	3	Cylindrical	■
JSE513050F2C.0Z3	SIRA	10053004	2	F	5,0	6,0	10,0	57,0	0,05	3	Cylindrical	■
JSE513060D2C.0Z3	SIRA	10053005	2	D	6,0	6,0	12,0	57,0	0,06	3	Cylindrical	■
JSE513070F2C.0Z3	SIRA	10053006	2	F	7,0	8,0	14,0	63,0	0,07	3	Cylindrical	■
JSE513080D2C.0Z3	SIRA	10053007	2	D	8,0	8,0	16,0	63,0	0,08	3	Cylindrical	■
JSE513090F2C.0Z3	SIRA	10053008	2	F	9,0	10,0	18,0	72,0	0,09	3	Cylindrical	■
JSE513100D2C.0Z3	SIRA	10053009	2	D	10,0	10,0	20,0	72,0	0,1	3	Cylindrical	■
JSE513110F2C.0Z3	SIRA	10053010	2	F	11,0	12,0	22,0	83,0	0,11	3	Cylindrical	■
JSE513120D2C.0Z3	SIRA	10053011	2	D	12,0	12,0	24,0	83,0	0,12	3	Cylindrical	■
JSE513140D2C.0Z3	SIRA	10053012	2	D	14,0	14,0	28,0	80,0	0,14	3	Cylindrical	■
JSE513160D2C.0Z3	SIRA	10053013	2	D	16,0	16,0	32,0	92,0	0,16	3	Cylindrical	■
JSE513180D2C.0Z3	SIRA	10053014	2	D	18,0	18,0	35,0	100,0	0,18	3	Cylindrical	■
JSE513200D2C.0Z3	SIRA	10053015	2	D	20,0	20,0	35,0	104,0	0,2	3	Cylindrical	■
JSE513030F3C.0Z3	SIRA	10053038	3	F	3,0	6,0	10,0	57,0	0,03	3	Cylindrical	■
JSE513040F3C.0Z3	SIRA	10053039	3	F	4,0	6,0	14,0	57,0	0,04	3	Cylindrical	■
JSE513050F3C.0Z3	SIRA	10053040	3	F	5,0	6,0	18,0	57,0	0,05	3	Cylindrical	■
JSE513060D3C.0Z3	SIRA	10053046	3	D	6,0	6,0	20,0	63,0	0,06	3	Cylindrical	■
JSE513080D3C.0Z3	SIRA	10053047	3	D	8,0	8,0	28,0	80,0	0,08	3	Cylindrical	■
JSE513100D3C.0Z3	SIRA	10053048	3	D	10,0	10,0	35,0	89,0	0,1	3	Cylindrical	■
JSE513120D3C.0Z3	SIRA	10053049	3	D	12,0	12,0	42,0	100,0	0,12	3	Cylindrical	■
JSE513160D3C.0Z3	SIRA	10053050	3	D	16,0	16,0	50,0	115,0	0,16	3	Cylindrical	■
JSE513200D3C.0Z3	SIRA	10053052	3	D	20,0	20,0	60,0	125,0	0,2	3	Cylindrical	■
JSE513030F4C.0Z3	SIRA	10201454	4	F	3,0	6,0	15,0	57,0	0,03	3	Cylindrical	■
JSE513040F4C.0Z3	SIRA	10201455	4	F	4,0	6,0	20,0	63,0	0,04	3	Cylindrical	■
JSE513050F4C.0Z3	SIRA	10201456	4	F	5,0	6,0	25,0	75,0	0,05	3	Cylindrical	■
JSE513060D4C.0Z3	SIRA	10201457	4	D	6,0	6,0	30,0	75,0	0,06	3	Cylindrical	■
JSE513080D4C.0Z3	SIRA	10201458	4	D	8,0	8,0	40,0	87,0	0,08	3	Cylindrical	■
JSE513100D4C.0Z3	SIRA	10201459	4	D	10,0	10,0	50,0	104,0	0,1	3	Cylindrical	■
JSE513120D4C.0Z3	SIRA	10201460	4	D	12,0	12,0	60,0	125,0	0,12	3	Cylindrical	■
JSE513160D4C.0Z3	SIRA	10201461	4	D	16,0	16,0	80,0	150,0	0,16	3	Cylindrical	■
JSE513200D4C.0Z3	SIRA	10201462	4	D	20,0	20,0	100,0	170,0	0,2	3	Cylindrical	■

■ **Lagerstandard.**

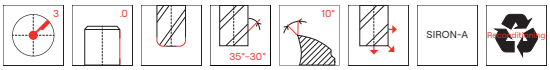
JSE513

Allgemeine Anwendung – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius





G E



– Toleranzen:
– DMM=h5
– DC=e8
– RE= ±0,05 mm
– Nachschleifen möglich, wenn DC ≥ Ø10 ist

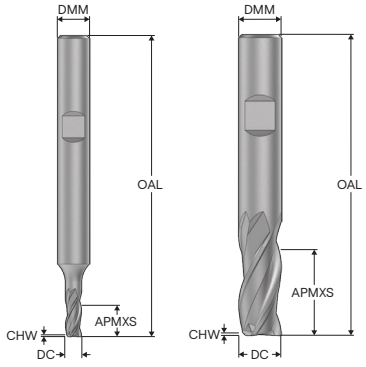
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm	mm	mm			
JSE513030G2R050.0Z3	SIRA	10053023	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	3	Cylindrical	■
JSE513040G2R050.0Z3	SIRA	10053024	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	3	Cylindrical	■
JSE513050G2R050.0Z3	SIRA	10053025	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	3	Cylindrical	■
JSE513060E2R050.0Z3	SIRA	10053026	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	3	Cylindrical	■
JSE513060E2R100.0Z3	SIRA	10053032	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	3	Cylindrical	■
JSE513080E2R050.0Z3	SIRA	10053027	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	3	Cylindrical	■
JSE513080E2R100.0Z3	SIRA	10053033	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	3	Cylindrical	■
JSE513100E2R050.0Z3	SIRA	10053028	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	3	Cylindrical	■
JSE513100E2R100.0Z3	SIRA	10053034	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	3	Cylindrical	■
JSE513120E2R050.0Z3	SIRA	10053029	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	3	Cylindrical	■
JSE513120E2R100.0Z3	SIRA	10053035	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	3	Cylindrical	■
JSE513160E2R050.0Z3	SIRA	10053030	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	3	Cylindrical	■
JSE513200E2R050.0Z3	SIRA	10053031	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	3	Cylindrical	■

■ **Lagerstandard.**

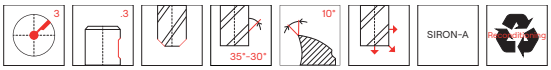
JSE513

Allgemeine Anwendung – Universell – Eckfräser – 3 Schneiden – Weldon – Fase





—Toleranzen:
—DMM=h5
—DC=e8
—Nachschleifen möglich, wenn DC ≥ Ø10 ist



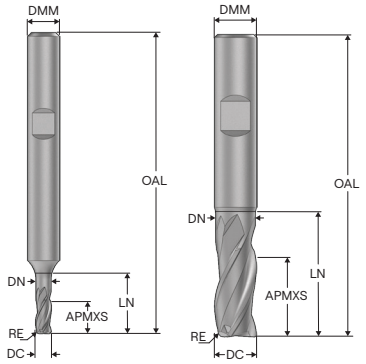
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JSE513020F2C.3Z3	SIRA	10053120	2	F	2,0	6,0	4,0	57,0	0,02	3	Weldon	■
JSE513025F2C.3Z3	SIRA	10053121	2	F	2,5	6,0	5,0	57,0	0,025	3	Weldon	■
JSE513030F2C.3Z3	SIRA	10053122	2	F	3,0	6,0	6,0	57,0	0,03	3	Weldon	■
JSE513040F2C.3Z3	SIRA	10053123	2	F	4,0	6,0	8,0	57,0	0,04	3	Weldon	■
JSE513050F2C.3Z3	SIRA	10053124	2	F	5,0	6,0	10,0	57,0	0,05	3	Weldon	■
JSE513060D2C.3Z3	SIRA	10053125	2	D	6,0	6,0	12,0	57,0	0,06	3	Weldon	■
JSE513070F2C.3Z3	SIRA	10053126	2	F	7,0	8,0	14,0	63,0	0,07	3	Weldon	■
JSE513080D2C.3Z3	SIRA	10053127	2	D	8,0	8,0	16,0	63,0	0,08	3	Weldon	■
JSE513090F2C.3Z3	SIRA	10053128	2	F	9,0	10,0	18,0	72,0	0,09	3	Weldon	■
JSE513100D2C.3Z3	SIRA	10053129	2	D	10,0	10,0	20,0	72,0	0,1	3	Weldon	■
JSE513110F2C.3Z3	SIRA	10053130	2	F	11,0	12,0	22,0	83,0	0,11	3	Weldon	■
JSE513120D2C.3Z3	SIRA	10053131	2	D	12,0	12,0	24,0	83,0	0,12	3	Weldon	■
JSE513140D2C.3Z3	SIRA	10053132	2	D	14,0	14,0	28,0	80,0	0,14	3	Weldon	■
JSE513160D2C.3Z3	SIRA	10053133	2	D	16,0	16,0	32,0	92,0	0,16	3	Weldon	■
JSE513180D2C.3Z3	SIRA	10053258	2	D	18,0	18,0	35,0	100,0	0,18	3	Weldon	■
JSE513200D2C.3Z3	SIRA	10053259	2	D	20,0	20,0	35,0	104,0	0,2	3	Weldon	■
JSE513030F3C.3Z3	SIRA	10053275	3	F	3,0	6,0	10,0	57,0	0,03	3	Weldon	■
JSE513040F3C.3Z3	SIRA	10053276	3	F	4,0	6,0	14,0	57,0	0,04	3	Weldon	■
JSE513050F3C.3Z3	SIRA	10053277	3	F	5,0	6,0	18,0	57,0	0,05	3	Weldon	■
JSE513060D3C.3Z3	SIRA	10053283	3	D	6,0	6,0	20,0	63,0	0,06	3	Weldon	■
JSE513080D3C.3Z3	SIRA	10053284	3	D	8,0	8,0	28,0	80,0	0,08	3	Weldon	■
JSE513100D3C.3Z3	SIRA	10053285	3	D	10,0	10,0	35,0	89,0	0,1	3	Weldon	■
JSE513120D3C.3Z3	SIRA	10053286	3	D	12,0	12,0	42,0	100,0	0,12	3	Weldon	■
JSE513160D3C.3Z3	SIRA	10053287	3	D	16,0	16,0	50,0	115,0	0,16	3	Weldon	■
JSE513200D3C.3Z3	SIRA	10053288	3	D	20,0	20,0	60,0	125,0	0,2	3	Weldon	■
JSE513030F4C.3Z3	SIRA	10201463	4	F	3,0	6,0	15,0	57,0	0,03	3	Weldon	□
JSE513040F4C.3Z3	SIRA	10201464	4	F	4,0	6,0	20,0	63,0	0,04	3	Weldon	□
JSE513050F4C.3Z3	SIRA	10201465	4	F	5,0	6,0	25,0	75,0	0,05	3	Weldon	□
JSE513060D4C.3Z3	SIRA	10201466	4	D	6,0	6,0	30,0	75,0	0,06	3	Weldon	□
JSE513080D4C.3Z3	SIRA	10201467	4	D	8,0	8,0	40,0	87,0	0,08	3	Weldon	□
JSE513100D4C.3Z3	SIRA	10201468	4	D	10,0	10,0	50,0	104,0	0,1	3	Weldon	□
JSE513120D4C.3Z3	SIRA	10201469	4	D	12,0	12,0	60,0	125,0	0,12	3	Weldon	□
JSE513160D4C.3Z3	SIRA	10201470	4	D	16,0	16,0	80,0	150,0	0,16	3	Weldon	□
JSE513200D4C.3Z3	SIRA	10201471	4	D	20,0	20,0	100,0	170,0	0,2	3	Weldon	□

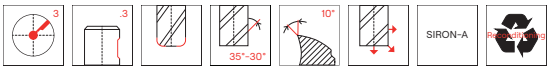
■ **Lagerstandard.**

JSE513

Allgemeine Anwendung – Universell – Eckfräser – 3 Schneiden – Weldon – Eckenradius







– Toleranzen:
– DMM=h5
– DC=e8
– RE= ±0,05 mm
– Nachschleifen möglich, wenn DC ≥ Ø10 ist

Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm	mm	mm			
JSE513030G2R050.3Z3	SIRA	10053260	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	3	Weldon	■
JSE513040G2R050.3Z3	SIRA	10053261	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	3	Weldon	■
JSE513050G2R050.3Z3	SIRA	10053262	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	3	Weldon	■
JSE513060E2R050.3Z3	SIRA	10053263	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	3	Weldon	■
JSE513060E2R100.3Z3	SIRA	10053269	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	3	Weldon	■
JSE513080E2R050.3Z3	SIRA	10053264	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	3	Weldon	■
JSE513080E2R100.3Z3	SIRA	10053270	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	3	Weldon	■
JSE513100E2R050.3Z3	SIRA	10053265	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	3	Weldon	■
JSE513100E2R100.3Z3	SIRA	10053271	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	3	Weldon	■
JSE513120E2R050.3Z3	SIRA	10053266	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	3	Weldon	■
JSE513120E2R100.3Z3	SIRA	10053272	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	3	Weldon	■
JSE513160E2R050.3Z3	SIRA	10053267	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	3	Weldon	■
JSE513200E2R050.3Z3	SIRA	10053268	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	3	Weldon	■

■ **Lagerstandard.**

Schnittdaten – JSE513 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z															v_c
				2	3	4	5	6	7	8	9	10	11	12	14	16	18	20	
P1	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P2	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P3	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P4	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P5	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P6	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P7	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P8	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
P11	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
P12	M/A/D/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (64 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (210 — 390)*
M1	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
M2	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
M3	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
M4	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
M5	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
K1	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K2	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K3	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K4	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K5	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K6	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
K7	A/D/M/E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	155 (65 — 190)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*510 (220 — 620)*
N1	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	510 (390 — 630)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*1675 (1300 — 2000)*
N11	E/M/A	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	385 (260 — 510)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*1275 (860 — 1600)*
S11	E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
S12	E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*
S13	E	0.200	1.5	0.012	0.018	0.024	0.030	0.036	0.042	0.048	0.055	0.060	0.065	0.070	0.080	0.090	0.095	0.10	90 (65 — 120)
		0,200	*1,5*	*0,00048*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*295 (220 — 390)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JSE513 Nutfräsen

SMG		a_p/DC	f_z														v_c
			2	3	4	5	6	7	8	9	10	11	12	14	16	18	20	
P1	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51 — 150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P2	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
P3	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51 — 150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P4	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
P5	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51 — 150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P6	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
P7	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51 — 150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P8	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (51 — 150)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 490)*
P11	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (51 — 100)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
P12	M/A/D/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M1	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M2	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M3	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M4	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
M5	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
K1	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K2	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K3	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K4	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K5	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K6	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
K7	A/D/M/E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	120 (50 — 140)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*395 (170 — 450)*
N1	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	400 (310 — 500)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*1300 (1100 — 1600)*
N11	E/M/A	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	300 (200 — 400)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*980 (660 — 1300)*
S11	E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
S12	E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*
S13	E	0.50	0.0060	0.0090	0.012	0.015	0.018	0.022	0.024	0.028	0.030	0.034	0.036	0.042	0.048	0.055	0.060	70 (50 — 99)
		0,50	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00085*	*0,00095*	*0,0011*	*0,0012*	*0,0013*	*0,0014*	*0,0017*	*0,0019*	*0,0022*	*0,0024*	*230 (170 — 320)*

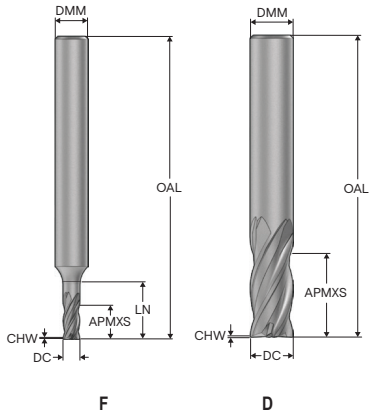
Schnittdaten, siehe Seite 699 - 707

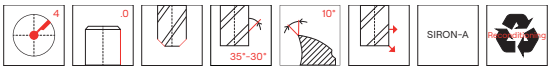
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JSE514

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Fase







– Toleranzen:
– DMM=h5
– DC=e8
– Nachschleifen möglich, wenn DC ≥ Ø10 ist

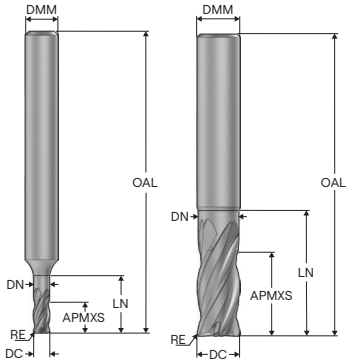
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JSE514021F2C.0Z4	SIRA	10053053	2	F	2,0	3,0	4,0	50,0	0,02	4	Cylindrical	■
JSE514020F2C.0Z4	SIRA	10053057	2	F	2,0	6,0	4,0	57,0	0,02	4	Cylindrical	■
JSE514030D2C.0Z4	SIRA	10053054	2	D	3,0	3,0	6,0	50,0	0,03	4	Cylindrical	■
JSE514030F2C.0Z4	SIRA	10053058	2	F	3,0	6,0	6,0	57,0	0,03	4	Cylindrical	■
JSE514040D2C.0Z4	SIRA	10053055	2	D	4,0	4,0	8,0	50,0	0,04	4	Cylindrical	■
JSE514040F2C.0Z4	SIRA	10053059	2	F	4,0	6,0	8,0	57,0	0,04	4	Cylindrical	■
JSE514050D2C.0Z4	SIRA	10053056	2	D	5,0	5,0	10,0	50,0	0,05	4	Cylindrical	■
JSE514050F2C.0Z4	SIRA	10053060	2	F	5,0	6,0	10,0	57,0	0,05	4	Cylindrical	■
JSE514060D2C.0Z4	SIRA	10053061	2	D	6,0	6,0	12,0	57,0	0,06	4	Cylindrical	■
JSE514080D2C.0Z4	SIRA	10053062	2	D	8,0	8,0	16,0	63,0	0,08	4	Cylindrical	■
JSE514100D2C.0Z4	SIRA	10053063	2	D	10,0	10,0	20,0	72,0	0,1	4	Cylindrical	■
JSE514120D2C.0Z4	SIRA	10053064	2	D	12,0	12,0	24,0	83,0	0,12	4	Cylindrical	■
JSE514160D2C.0Z4	SIRA	10053067	2	D	16,0	16,0	32,0	92,0	0,16	4	Cylindrical	■
JSE514180D2C.0Z4	SIRA	10053068	2	D	18,0	18,0	35,0	100,0	0,18	4	Cylindrical	■
JSE514200D2C.0Z4	SIRA	10053069	2	D	20,0	20,0	35,0	104,0	0,2	4	Cylindrical	■
JSE514250D2C.0Z4	SIRA	10053070	2	D	25,0	25,0	40,0	125,0	0,25	4	Cylindrical	■
JSE514030F3C.0Z4	SIRA	10053090	3	F	3,0	6,0	10,0	57,0	0,03	4	Cylindrical	■
JSE514040F3C.0Z4	SIRA	10053091	3	F	4,0	6,0	14,0	57,0	0,04	4	Cylindrical	■
JSE514050F3C.0Z4	SIRA	10053092	3	F	5,0	6,0	18,0	57,0	0,05	4	Cylindrical	■
JSE514060D3C.0Z4	SIRA	10053093	3	D	6,0	6,0	20,0	63,0	0,06	4	Cylindrical	■
JSE514080D3C.0Z4	SIRA	10053094	3	D	8,0	8,0	28,0	80,0	0,08	4	Cylindrical	■
JSE514100D3C.0Z4	SIRA	10053095	3	D	10,0	10,0	35,0	89,0	0,1	4	Cylindrical	■
JSE514120D3C.0Z4	SIRA	10053096	3	D	12,0	12,0	42,0	100,0	0,12	4	Cylindrical	■
JSE514160D3C.0Z4	SIRA	10053097	3	D	16,0	16,0	50,0	115,0	0,16	4	Cylindrical	■
JSE514200D3C.0Z4	SIRA	10053098	3	D	20,0	20,0	60,0	125,0	0,2	4	Cylindrical	■
JSE514030F4C.0Z4	SIRA	10201472	4	F	3,0	6,0	15,0	57,0	0,03	4	Cylindrical	■
JSE514040F4C.0Z4	SIRA	10201473	4	F	4,0	6,0	20,0	63,0	0,04	4	Cylindrical	■
JSE514050F4C.0Z4	SIRA	10201474	4	F	5,0	6,0	25,0	75,0	0,05	4	Cylindrical	■
JSE514060D4C.0Z4	SIRA	10201475	4	D	6,0	6,0	30,0	75,0	0,06	4	Cylindrical	■
JSE514080D4C.0Z4	SIRA	10201476	4	D	8,0	8,0	40,0	87,0	0,08	4	Cylindrical	■
JSE514100D4C.0Z4	SIRA	10201477	4	D	10,0	10,0	50,0	104,0	0,1	4	Cylindrical	■
JSE514120D4C.0Z4	SIRA	10201478	4	D	12,0	12,0	60,0	125,0	0,12	4	Cylindrical	■
JSE514160D4C.0Z4	SIRA	10201479	4	D	16,0	16,0	80,0	150,0	0,16	4	Cylindrical	■
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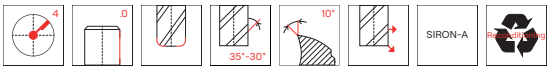
■ **Lagerstandard.**

JSE514

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius







– Toleranzen:
– DMM=h5
– DC=e8
– RE= ±0,05 mm
– Nachschleifen möglich, wenn DC ≥ Ø10 ist

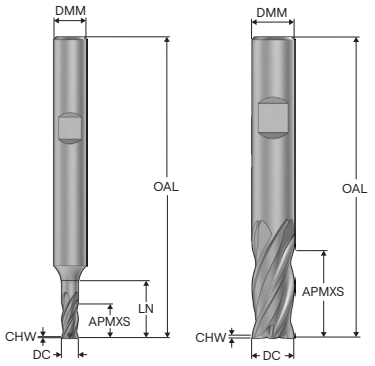
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JSE514030G2R050.0Z4	SIRA	10053071	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	4	Cylindrical	■
JSE514040G2R050.0Z4	SIRA	10053072	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	4	Cylindrical	■
JSE514050G2R050.0Z4	SIRA	10053073	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	4	Cylindrical	■
JSE514060E2R050.0Z4	SIRA	10053074	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	Cylindrical	■
JSE514060E2R100.0Z4	SIRA	10053081	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	Cylindrical	■
JSE514080E2R050.0Z4	SIRA	10053075	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	Cylindrical	■
JSE514080E2R100.0Z4	SIRA	10053082	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	Cylindrical	■
JSE514100E2R050.0Z4	SIRA	10053076	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	Cylindrical	■
JSE514100E2R100.0Z4	SIRA	10053083	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	Cylindrical	■
JSE514120E2R050.0Z4	SIRA	10053077	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	Cylindrical	■
JSE514120E2R100.0Z4	SIRA	10053084	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	Cylindrical	■
JSE514160E2R050.0Z4	SIRA	10053078	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	Cylindrical	■
JSE514160E2R100.0Z4	SIRA	10053087	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	Cylindrical	■
JSE514200E2R050.0Z4	SIRA	10053079	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	4	Cylindrical	■
JSE514200E2R100.0Z4	SIRA	10053088	2	E	20,0	20,0	35,0	104,0	51,0	19,0	1,0	4	Cylindrical	■
JSE514250E2R050.0Z4	SIRA	10053080	2	E	25,0	25,0	40,0	125,0	66,0	23,8	0,5	4	Cylindrical	■

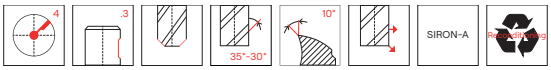
■ **Lagerstandard.**

JSE514

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Weldon – Fase







– Toleranzen:
– DMM=h5
– DC=e8
– Nachschleifen möglich, wenn DC ≥ Ø10 ist

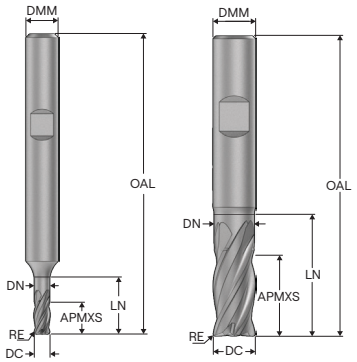
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JSE514020F2C.3Z4	SIRA	10053289	2	F	2,0	6,0	4,0	57,0	0,02	4	Weldon	■
JSE514030F2C.3Z4	SIRA	10053290	2	F	3,0	6,0	6,0	57,0	0,03	4	Weldon	■
JSE514040F2C.3Z4	SIRA	10053291	2	F	4,0	6,0	8,0	57,0	0,04	4	Weldon	■
JSE514050F2C.3Z4	SIRA	10053292	2	F	5,0	6,0	10,0	57,0	0,05	4	Weldon	■
JSE514060D2C.3Z4	SIRA	10053293	2	D	6,0	6,0	12,0	57,0	0,06	4	Weldon	■
JSE514080D2C.3Z4	SIRA	10053294	2	D	8,0	8,0	16,0	63,0	0,08	4	Weldon	■
JSE514100D2C.3Z4	SIRA	10053295	2	D	10,0	10,0	20,0	72,0	0,1	4	Weldon	■
JSE514120D2C.3Z4	SIRA	10053296	2	D	12,0	12,0	24,0	83,0	0,12	4	Weldon	■
JSE514160D2C.3Z4	SIRA	10053297	2	D	16,0	16,0	32,0	92,0	0,16	4	Weldon	■
JSE514180D2C.3Z4	SIRA	10053298	2	D	18,0	18,0	35,0	100,0	0,18	4	Weldon	■
JSE514200D2C.3Z4	SIRA	10053299	2	D	20,0	20,0	35,0	104,0	0,2	4	Weldon	■
JSE514250D2C.3Z4	SIRA	10053300	2	D	25,0	25,0	40,0	125,0	0,25	4	Weldon	■
JSE514030F3C.3Z4	SIRA	10053321	3	F	3,0	6,0	10,0	57,0	0,03	4	Weldon	■
JSE514040F3C.3Z4	SIRA	10053322	3	F	4,0	6,0	14,0	57,0	0,04	4	Weldon	■
JSE514050F3C.3Z4	SIRA	10053323	3	F	5,0	6,0	18,0	57,0	0,05	4	Weldon	■
JSE514060D3C.3Z4	SIRA	10053324	3	D	6,0	6,0	20,0	63,0	0,06	4	Weldon	■
JSE514080D3C.3Z4	SIRA	10053325	3	D	8,0	8,0	28,0	80,0	0,08	4	Weldon	■
JSE514100D3C.3Z4	SIRA	10053326	3	D	10,0	10,0	35,0	89,0	0,1	4	Weldon	■
JSE514120D3C.3Z4	SIRA	10053327	3	D	12,0	12,0	42,0	100,0	0,12	4	Weldon	■
JSE514160D3C.3Z4	SIRA	10053328	3	D	16,0	16,0	50,0	115,0	0,16	4	Weldon	■
JSE514200D3C.3Z4	SIRA	10053329	3	D	20,0	20,0	60,0	125,0	0,2	4	Weldon	■
JSE514030F4C.3Z4	SIRA	10201481	4	F	3,0	6,0	15,0	57,0	0,03	4	Weldon	□
JSE514040F4C.3Z4	SIRA	10201482	4	F	4,0	6,0	20,0	63,0	0,04	4	Weldon	□
JSE514050F4C.3Z4	SIRA	10201483	4	F	5,0	6,0	25,0	75,0	0,05	4	Weldon	□
JSE514060D4C.3Z4	SIRA	10201484	4	D	6,0	6,0	30,0	75,0	0,06	4	Weldon	□
JSE514080D4C.3Z4	SIRA	10201485	4	D	8,0	8,0	40,0	87,0	0,08	4	Weldon	□
JSE514100D4C.3Z4	SIRA	10201486	4	D	10,0	10,0	50,0	104,0	0,1	4	Weldon	□
JSE514120D4C.3Z4	SIRA	10201487	4	D	12,0	12,0	60,0	125,0	0,12	4	Weldon	□
JSE514160D4C.3Z4	SIRA	10201488	4	D	16,0	16,0	80,0	150,0	0,16	4	Weldon	□
JSE514200D4C.3Z4	SIRA	10201489	4	D	20,0	20,0	100,0	170,0	0,2	4	Weldon	□

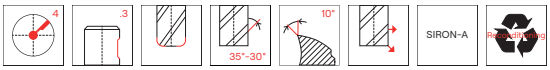
■ **Lagerstandard.**

JSE514

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Weldon – Eckenradius







– Toleranzen:
– DMM=h5
– DC=e8
– RE= ±0,05 mm
– Nachschleifen möglich, wenn DC ≥ Ø10 ist

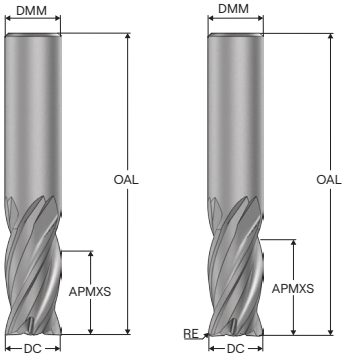
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm	mm	mm			
JSE514030G2R050.3Z4	SIRA	10053301	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,5	4	Weldon	■
JSE514040G2R050.3Z4	SIRA	10053302	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,5	4	Weldon	■
JSE514050G2R050.3Z4	SIRA	10053306	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,5	4	Weldon	■
JSE514060E2R050.3Z4	SIRA	10053307	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	Weldon	■
JSE514060E2R100.3Z4	SIRA	10053314	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	Weldon	■
JSE514080E2R050.3Z4	SIRA	10053308	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	Weldon	■
JSE514080E2R100.3Z4	SIRA	10053315	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	Weldon	■
JSE514100E2R050.3Z4	SIRA	10053309	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	Weldon	■
JSE514100E2R100.3Z4	SIRA	10053316	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	Weldon	■
JSE514120E2R050.3Z4	SIRA	10053310	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	Weldon	■
JSE514120E2R100.3Z4	SIRA	10053317	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	Weldon	■
JSE514160E2R050.3Z4	SIRA	10053311	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	Weldon	■
JSE514160E2R100.3Z4	SIRA	10053318	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	Weldon	■
JSE514200E2R050.3Z4	SIRA	10053312	2	E	20,0	20,0	35,0	104,0	51,0	19,0	0,5	4	Weldon	■
JSE514200E2R100.3Z4	SIRA	10053319	2	E	20,0	20,0	35,0	104,0	51,0	19,0	1,0	4	Weldon	■
JSE514250E2R050.3Z4	SIRA	10053313	2	E	25,0	25,0	40,0	125,0	66,0	23,8	0,5	4	Weldon	■

■ **Lagerstandard.**

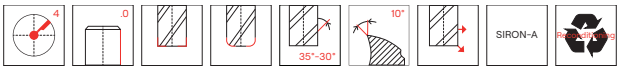
JSE514

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Zylindrisch – scharf oder Eckenradius – Zoll





—Toleranzen:
—DMM=h5
—DC=e8
—RE= ±.002 Zoll
—Nachschleifen möglich, wenn DC ≥ Ø.375 ist



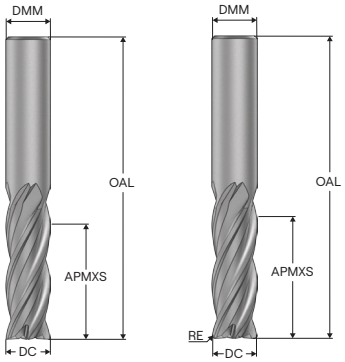
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	RE	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll	Zoll			
JSE514.250D1S.0Z4	SIRA	10201805	1	D	0.250	0.250	0.375	2.000	–	4	Cylindrical	■
JSE514.250D1R030.0Z4	SIRA	10201812	1	D	0.250	0.250	0.375	2.000	0.030	4	Cylindrical	■
JSE514.375D1S.0Z4	SIRA	10201806	1	D	0.375	0.375	0.500	2.000	–	4	Cylindrical	■
JSE514.375D1R030.0Z4	SIRA	10201813	1	D	0.375	0.375	0.500	2.000	0.030	4	Cylindrical	■
JSE514.500D1S.0Z4	SIRA	10201807	1	D	0.500	0.500	0.625	2.500	–	4	Cylindrical	■
JSE514.500D1R030.0Z4	SIRA	10201814	1	D	0.500	0.500	0.625	2.500	0.030	4	Cylindrical	■
JSE514.500D1R060.0Z4	SIRA	10201815	1	D	0.500	0.500	0.625	2.500	0.060	4	Cylindrical	■
JSE514.625D1S.0Z4	SIRA	10201808	1	D	0.625	0.625	0.750	3.000	–	4	Cylindrical	■
JSE514.625D1R030.0Z4	SIRA	10201816	1	D	0.625	0.625	0.750	3.000	0.030	4	Cylindrical	■
JSE514.625D1R060.0Z4	SIRA	10201817	1	D	0.625	0.625	0.750	3.000	0.060	4	Cylindrical	■
JSE514.750D1S.0Z4	SIRA	10201809	1	D	0.750	0.750	0.875	3.000	–	4	Cylindrical	■
JSE514.750D1R030.0Z4	SIRA	10201818	1	D	0.750	0.750	0.875	3.000	0.030	4	Cylindrical	■
JSE514.750D1R060.0Z4	SIRA	10201819	1	D	0.750	0.750	0.875	3.000	0.060	4	Cylindrical	■
JSE514.125D2S.0Z4	SIRA	10201803	2	D	0.125	0.125	0.250	1.500	–	4	Cylindrical	■
JSE514.125D2R015.0Z4	SIRA	10201810	2	D	0.125	0.125	0.250	1.500	0.015	4	Cylindrical	■
JSE514.188D2S.0Z4	SIRA	10201804	2	D	0.188	0.188	0.375	2.000	–	4	Cylindrical	■
JSE514.188D2R020.0Z4	SIRA	10201811	2	D	0.188	0.188	0.375	2.000	0.020	4	Cylindrical	■
JSE514.250D2S.0Z4	SIRA	10201822	2	D	0.250	0.250	0.500	2.000	–	4	Cylindrical	■
JSE514.250D2R030.0Z4	SIRA	10201829	2	D	0.250	0.250	0.500	2.000	0.030	4	Cylindrical	■
JSE514.375D2S.0Z4	SIRA	10201823	2	D	0.375	0.375	0.625	2.000	–	4	Cylindrical	■
JSE514.375D2R030.0Z4	SIRA	10201830	2	D	0.375	0.375	0.625	2.000	0.030	4	Cylindrical	■
JSE514.500D2S.0Z4	SIRA	10201824	2	D	0.500	0.500	1.000	3.000	–	4	Cylindrical	■
JSE514.500D2R030.0Z4	SIRA	10201831	2	D	0.500	0.500	1.000	3.000	0.030	4	Cylindrical	■
JSE514.500D2R060.0Z4	SIRA	10201832	2	D	0.500	0.500	1.000	3.000	0.060	4	Cylindrical	■
JSE514.625D2S.0Z4	SIRA	10201825	2	D	0.625	0.625	1.250	3.500	–	4	Cylindrical	■
JSE514.625D2R030.0Z4	SIRA	10201833	2	D	0.625	0.625	1.250	3.500	0.030	4	Cylindrical	■
JSE514.625D2R060.0Z4	SIRA	10201834	2	D	0.625	0.625	1.250	3.500	0.060	4	Cylindrical	■
JSE514.750D2S.0Z4	SIRA	10201826	2	D	0.750	0.750	1.500	4.000	–	4	Cylindrical	■
JSE514.750D2R030.0Z4	SIRA	10201835	2	D	0.750	0.750	1.500	4.000	0.030	4	Cylindrical	■
JSE514.750D2R060.0Z4	SIRA	10201836	2	D	0.750	0.750	1.500	4.000	0.060	4	Cylindrical	■

■ **Lagerstandard.**

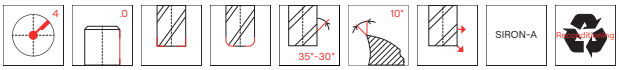
JSE514

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Zylindrisch – scharf oder Eckenradius – Zoll





– Toleranzen:
– DMM=h5
– DC=e8
– RE= ±.002 Zoll
– Nachschleifen möglich, wenn DC ≥ Ø.375 ist



Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll			
JSE514.125D3S.0Z4	SIRA	10201820	3	D	0.125	0.125	0.500	1.500	–	4	Cylindrical	■
JSE514.125D3R015.0Z4	SIRA	10201827	3	D	0.125	0.125	0.500	1.500	0.015	4	Cylindrical	■
JSE514.188D3S.0Z4	SIRA	10201821	3	D	0.188	0.188	0.625	2.000	–	4	Cylindrical	■
JSE514.188D3R020.0Z4	SIRA	10201828	3	D	0.188	0.188	0.625	2.000	0.020	4	Cylindrical	■
JSE514.250D3S.0Z4	SIRA	10201837	3	D	0.250	0.250	0.750	2.500	–	4	Cylindrical	■
JSE514.250D3R030.0Z4	SIRA	10201842	3	D	0.250	0.250	0.750	2.500	0.030	4	Cylindrical	■
JSE514.375D3S.0Z4	SIRA	10201838	3	D	0.375	0.375	1.000	2.500	–	4	Cylindrical	■
JSE514.375D3R030.0Z4	SIRA	10201843	3	D	0.375	0.375	1.000	2.500	0.030	4	Cylindrical	■
JSE514.500D3S.0Z4	SIRA	10201839	3	D	0.500	0.500	2.000	4.000	–	4	Cylindrical	■
JSE514.500D3R030.0Z4	SIRA	10201844	3	D	0.500	0.500	2.000	4.000	0.030	4	Cylindrical	■
JSE514.500D3R060.0Z4	SIRA	10201845	3	D	0.500	0.500	2.000	4.000	0.060	4	Cylindrical	■
JSE514.625D3S.0Z4	SIRA	10201840	3	D	0.625	0.625	2.250	5.000	–	4	Cylindrical	■
JSE514.625D3R030.0Z4	SIRA	10201846	3	D	0.625	0.625	2.250	5.000	0.030	4	Cylindrical	■
JSE514.625D3R060.0Z4	SIRA	10201847	3	D	0.625	0.625	2.250	5.000	0.060	4	Cylindrical	■
JSE514.750D3S.0Z4	SIRA	10201841	3	D	0.750	0.750	2.250	5.000	–	4	Cylindrical	■
JSE514.750D3R030.0Z4	SIRA	10201848	3	D	0.750	0.750	2.250	5.000	0.030	4	Cylindrical	■
JSE514.750D3R060.0Z4	SIRA	10201849	3	D	0.750	0.750	2.250	5.000	0.060	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JSE514 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z												v_c
				2	3	4	5	6	8	10	12	16	18	20	25	
P1	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P2	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	0.11 *0,0044*	0.13 *0,0050*	160 (67 — 190) *520 (220 — 620)*
P3	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P4	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P5	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P6	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P7	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P8	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
P11	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
P12	M/A/D/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
M1	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
M2	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
M3	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
M4	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
M5	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
K1	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K2	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K3	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K4	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K5	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K6	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
K7	A/D/M/E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	165 (69 — 200) *540 (230 — 650)*
N1	E/M/A	0.150 *0,150*	1.5 *1,5*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	520 (400 — 650) *1700 (1400 — 2100)*
N11	E/M/A	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	410 (280 — 540) *1350 (920 — 1700)*
S11	E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
S12	E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*
S13	E	0.150 *0,150*	1.5 *1,5*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	95 (69 — 130) *310 (230 — 420)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JSE514 Nutfräsen

SMG		a_p/DC	f_z												v_c
			2	3	4	5	6	8	10	12	16	18	20	25	
P1	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (51 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
P2	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (51 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
P3	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (51 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
P4	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 140)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 450)*
P5	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (51 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
P6	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 140)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 450)*
P7	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (51 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
P8	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (51 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
P11	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (51 — 100)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
P12	M/A/D/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
M1	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
M2	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
M3	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
M4	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
M5	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
K1	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
K2	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
K3	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
K4	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
K5	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
K6	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
K7	A/D/M/E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	120 (50 — 150)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*395 (170 — 490)*
N1	E/M/A	0.30	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	400 (300 — 500)
		0,30	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*1300 (990 — 1600)*
N11	E/M/A	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	300 (200 — 390)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*980 (660 — 1200)*
S11	E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
S12	E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*
S13	E	0.40	0.0060	0.0090	0.012	0.015	0.018	0.024	0.030	0.036	0.048	0.055	0.060	0.075	70 (50 — 99)
		0,40	*0,00024*	*0,00036*	*0,00048*	*0,00060*	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0022*	*0,0024*	*0,0030*	*230 (170 — 320)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS514 Eckfräsen – Zoll

SMG		a_e/DC	a_p/DC	f_z							v_c
				1/8	3/16	1.4	3/8	1/2	5/8	3/4	
P1	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (69 — 200) *540 (230 — 650)*
P2	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,022 *0.00085*	0,032 *0.0013*	0,042 *0.0017*	0,065 *0.0026*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	160 (67 — 200) *520 (220 — 650)*
P3	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P4	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P5	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P6	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P7	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P8	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
P11	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
P12	M/A/D/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
M1	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
M2	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
M3	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
M4	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
M5	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
K1	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K2	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K3	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K4	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K5	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K6	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
K7	A/D/M/E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	165 (68 — 200) *540 (230 — 650)*
N1	E/M/A	0,15 *0.15*	1,2 *1.2*	0,025 *0.0010*	0,036 *0.0014*	0,050 *0.0020*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	520 (400 — 650) *1700 (1400 — 2100)*
N11	E/M/A	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	410 (280 — 540) *1350 (920 — 1700)*
S11	E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
S12	E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*
S13	E	0,15 *0.15*	1,2 *1.2*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (68 — 130) *310 (230 — 420)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS514 Nutfräsen – Zoll

SMG		a_p/DC	f_z							v_c
			1/8	3/16	1/4	3/8	1/2	5/8	3/4	
P1	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P2	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P3	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P4	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P5	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P6	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P7	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P8	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
P11	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
P12	M/A/D/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
M1	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
M2	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
M3	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
M4	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
M5	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
K1	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K2	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K3	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K4	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K5	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K6	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
K7	A/D/M/E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	120 (51 — 150) *395 (170 — 490)*
N1	E/M/A	0,30 *0.30*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	400 (310 — 500) *1300 (1100 — 1600)*
N11	E/M/A	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	300 (210 — 400) *980 (690 — 1300)*
S11	E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
S12	E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*
S13	E	0,40 *0.40*	0,0095 *0.00038*	0,014 *0.00055*	0,019 *0.00075*	0,028 *0.0011*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	70 (51 — 100) *230 (170 — 320)*

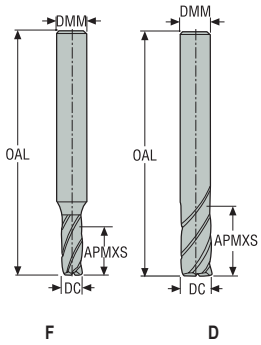
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Scharfe Schneide





—Toleranzen:
—DMM=h5
—DC=e7
—Nachschleifen möglich, wenn DC ≥ Ø6 ist



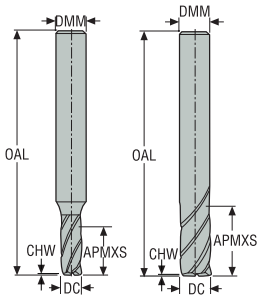
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm			
553020SZ3.0-SIRON-A	02733903	2	F	2,0	6,0	5,0	50,0	3	Cylindrical	■
553030SZ3.0-SIRON-A	02733906	2	F	3,0	6,0	7,0	50,0	3	Cylindrical	■
553040SZ3.0-SIRON-A	02733910	2	F	4,0	6,0	10,0	55,0	3	Cylindrical	■
553050SZ3.0-SIRON-A	02733912	2	F	5,0	6,0	12,0	55,0	3	Cylindrical	■
553060SZ3.0-SIRON-A	02733914	2	D	6,0	6,0	14,0	55,0	3	Cylindrical	■
553080SZ3.0-SIRON-A	02733918	2	D	8,0	8,0	18,0	60,0	3	Cylindrical	■
553100SZ3.0-SIRON-A	02733922	2	D	10,0	10,0	22,0	70,0	3	Cylindrical	■

■ **Lagerstandard.**

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Fase





—Toleranzen:
—DMM= h5
—DC= e7
—Nachschleifen möglich, wenn DC ≥ Ø6 ist



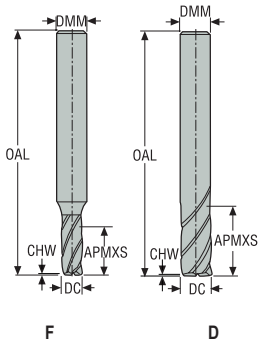
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JS553020F1C.0Z3-SIRA	10041466	1	F	2,0	6,0	3,0	40,0	0,025	3	Cylindrical	■
JS553030F1C.0Z3-SIRA	10041467	1	F	3,0	6,0	4,0	40,0	0,035	3	Cylindrical	■
JS553040F1C.0Z3-SIRA	10041468	1	F	4,0	6,0	6,0	40,0	0,045	3	Cylindrical	■
JS553045F1C.0Z3-SIRA	10041469	1	F	4,5	6,0	6,0	40,0	0,045	3	Cylindrical	■
JS553050F1C.0Z3-SIRA	10041470	1	F	5,0	6,0	7,0	40,0	0,055	3	Cylindrical	■
JS553055F1C.0Z3-SIRA	10041472	1	F	5,5	6,0	8,0	40,0	0,055	3	Cylindrical	■
JS553060D1C.0Z3-SIRA	10041473	1	D	6,0	6,0	8,0	40,0	0,075	3	Cylindrical	■
JS553080D1C.0Z3-SIRA	10041474	1	D	8,0	8,0	11,0	50,0	0,1	3	Cylindrical	■
JS553100D1C.0Z3-SIRA	10041475	1	D	10,0	10,0	13,0	57,0	0,125	3	Cylindrical	■
JS553120D1C.0Z3-SIRA	10041476	1	D	12,0	12,0	15,0	65,0	0,15	3	Cylindrical	■
553020Z3.0-SIRON-A	02679241	2	F	2,0	6,0	5,0	50,0	0,025	3	Cylindrical	■
553025Z3.0-SIRON-A	02679352	2	F	2,5	6,0	7,0	50,0	0,025	3	Cylindrical	■
553030Z3.0-SIRON-A	02679353	2	F	3,0	6,0	7,0	50,0	0,035	3	Cylindrical	■
553035Z3.0-SIRON-A	02679359	2	F	3,5	6,0	9,0	55,0	0,035	3	Cylindrical	■
553040Z3.0-SIRON-A	02679360	2	F	4,0	6,0	10,0	55,0	0,045	3	Cylindrical	■
553045Z3.0-SIRON-A	02679361	2	F	4,5	6,0	12,0	55,0	0,045	3	Cylindrical	■
553050Z3.0-SIRON-A	02679364	2	F	5,0	6,0	12,0	55,0	0,055	3	Cylindrical	■
553055Z3.0-SIRON-A	02679365	2	F	5,5	6,0	14,0	55,0	0,055	3	Cylindrical	■
553060Z3.0-SIRON-A	02679368	2	D	6,0	6,0	14,0	55,0	0,075	3	Cylindrical	■
553075Z3.0-SIRON-A	02733916	2	F	7,5	8,0	18,0	60,0	0,1	3	Cylindrical	■
553080Z3.0-SIRON-A	02679371	2	D	8,0	8,0	18,0	60,0	0,1	3	Cylindrical	■
553095Z3.0-SIRON-A	02733920	2	F	9,5	10,0	22,0	70,0	0,125	3	Cylindrical	■
553100Z3.0-SIRON-A	02679374	2	D	10,0	10,0	22,0	70,0	0,125	3	Cylindrical	■
553115Z3.0-SIRON-A	02733925	2	F	11,5	12,0	26,0	80,0	0,15	3	Cylindrical	■
553120Z3.0-SIRON-A	02679380	2	D	12,0	12,0	26,0	80,0	0,15	3	Cylindrical	■
553140Z3.0-SIRON-A	02733932	2	D	14,0	14,0	30,0	85,0	0,175	3	Cylindrical	■
553160Z3.0-SIRON-A	02679384	2	D	16,0	16,0	34,0	90,0	0,2	3	Cylindrical	■
553200Z3.0-SIRON-A	02679389	2	D	20,0	20,0	42,0	110,0	0,25	3	Cylindrical	■
553250Z3.0-SIRON-A	02679393	2	D	25,0	25,0	52,0	125,0	0,3	3	Cylindrical	■

■ **Lagerstandard.**

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Fase





—Toleranzen:
—DMM= h5
—DC= e7
—Nachschleifen möglich, wenn DC ≥ Ø6 ist



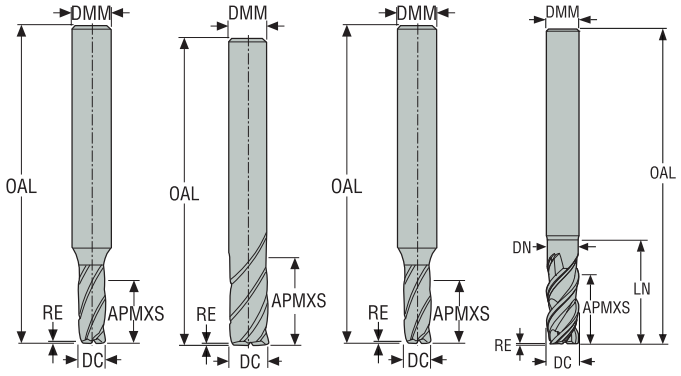
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
553L020Z3.0-SIRON-A	02733962	3	F	2,0	6,0	7,0	50,0	0,025	3	Cylindrical	■
553L030Z3.0-SIRON-A	02733971	3	F	3,0	6,0	10,0	55,0	0,035	3	Cylindrical	■
553L040Z3.0-SIRON-A	02733972	3	F	4,0	6,0	14,0	60,0	0,045	3	Cylindrical	■
553L050Z3.0-SIRON-A	02733974	3	F	5,0	6,0	18,0	60,0	0,055	3	Cylindrical	■
553L060Z3.0-SIRON-A	02733982	3	D	6,0	6,0	20,0	65,0	0,075	3	Cylindrical	■
553L080Z3.0-SIRON-A	02733986	3	D	8,0	8,0	28,0	70,0	0,1	3	Cylindrical	■
553L100Z3.0-SIRON-A	02733992	3	D	10,0	10,0	35,0	85,0	0,125	3	Cylindrical	■
553L120Z3.0-SIRON-A	02733994	3	D	12,0	12,0	40,0	95,0	0,15	3	Cylindrical	■
553L160Z3.0-SIRON-A	02733996	3	D	16,0	16,0	50,0	110,0	0,2	3	Cylindrical	■
553L200Z3.0-SIRON-A	02733998	3	D	20,0	20,0	60,0	125,0	0,25	3	Cylindrical	■
553L250Z3.0-SIRON-A	02734000	3	D	25,0	25,0	75,0	150,0	0,3	3	Cylindrical	■

■ **Lagerstandard.**

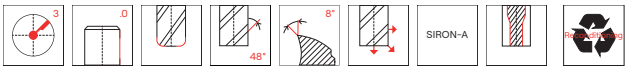
JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius





F



– Toleranzen:
– DMM=h5
– DC=e7
– RE= ±0,02 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

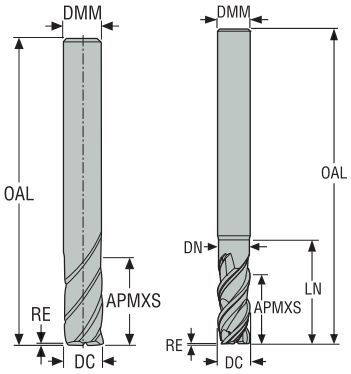
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS553020F1R020.0Z3-SIRA	10194458	1	F	2,0	6,0	3,0	40,0	–	–	0,2	3	Cylindrical	■
JS553030F1R020.0Z3-SIRA	10194459	1	F	3,0	6,0	4,0	40,0	–	–	0,2	3	Cylindrical	■
JS553040F1R020.0Z3-SIRA	10194460	1	F	4,0	6,0	6,0	40,0	–	–	0,2	3	Cylindrical	■
JS553050F1R020.0Z3-SIRA	10194461	1	F	5,0	6,0	7,0	40,0	–	–	0,2	3	Cylindrical	■
JS553060D1R020.0Z3-SIRA	10194462	1	D	6,0	6,0	8,0	40,0	–	–	0,2	3	Cylindrical	■
JS553060D1R050.0Z3-SIRA	10194463	1	D	6,0	6,0	8,0	40,0	–	–	0,5	3	Cylindrical	■
JS553080D1R050.0Z3-SIRA	10194464	1	D	8,0	8,0	11,0	50,0	–	–	0,5	3	Cylindrical	■
JS553100D1R050.0Z3-SIRA	10194465	1	D	10,0	10,0	13,0	57,0	–	–	0,5	3	Cylindrical	■
JS553100D1R100.0Z3-SIRA	10194466	1	D	10,0	10,0	13,0	57,0	–	–	1,0	3	Cylindrical	■
JS553120D1R050.0Z3-SIRA	10194467	1	D	12,0	12,0	15,0	65,0	–	–	0,5	3	Cylindrical	■
JS553120D1R100.0Z3-SIRA	10194468	1	D	12,0	12,0	15,0	65,0	–	–	1,0	3	Cylindrical	■
JS553020G2R050.0Z3-SIRA	02881683	2	G	2,0	6,0	5,0	57,0	8,0	1,9	0,5	3	Cylindrical	■
553030R015Z3.0-SIRON-A	02733908	2	F	3,0	6,0	7,0	50,0	–	–	0,15	3	Cylindrical	■
JS553030G2R050.0Z3-SIRA	02881684	2	G	3,0	6,0	7,0	57,0	11,0	2,85	0,5	3	Cylindrical	■
553040R020Z3.0-SIRON-A	02733911	2	F	4,0	6,0	10,0	55,0	–	–	0,2	3	Cylindrical	■
JS553040G2R050.0Z3-SIRA	02881685	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,5	3	Cylindrical	■
553050R020Z3.0-SIRON-A	02687282	2	F	5,0	6,0	12,0	55,0	–	–	0,2	3	Cylindrical	■
JS553050G2R050.0Z3-SIRA	02881686	2	G	5,0	6,0	10,0	57,0	15,0	4,75	0,5	3	Cylindrical	■
553060R020Z3.0-SIRON-A	02679369	2	D	6,0	6,0	14,0	55,0	–	–	0,2	3	Cylindrical	■
JS553060E2R050.0Z3-SIRA	02881687	2	E	6,0	6,0	14,0	57,0	19,0	5,7	0,5	3	Cylindrical	■
JS553060E2R100.0Z3-SIRA	02881688	2	E	6,0	6,0	14,0	57,0	19,0	5,7	1,0	3	Cylindrical	■
553080R050Z3.0-SIRON-A	02679372	2	D	8,0	8,0	18,0	60,0	–	–	0,5	3	Cylindrical	■
553100R050Z3.0-SIRON-A	02679375	2	D	10,0	10,0	22,0	70,0	–	–	0,5	3	Cylindrical	■
553100R100Z3.0-SIRON-A	02679376	2	D	10,0	10,0	22,0	70,0	–	–	1,0	3	Cylindrical	■
553100R200Z3.0-SIRON-A	02810364	2	D	10,0	10,0	22,0	70,0	–	–	2,0	3	Cylindrical	■
553100R250Z3.0-SIRON-A	02810365	2	D	10,0	10,0	22,0	70,0	–	–	2,5	3	Cylindrical	■
553100R310Z3.0-SIRON-A	02810366	2	D	10,0	10,0	22,0	70,0	–	–	3,1	3	Cylindrical	■
553120R050Z3.0-SIRON-A	02679381	2	D	12,0	12,0	26,0	80,0	–	–	0,5	3	Cylindrical	■
553120R100Z3.0-SIRON-A	02679382	2	D	12,0	12,0	26,0	80,0	–	–	1,0	3	Cylindrical	■
553120R200Z3.0-SIRON-A	02810367	2	D	12,0	12,0	26,0	80,0	–	–	2,0	3	Cylindrical	■
553120R250Z3.0-SIRON-A	02810368	2	D	12,0	12,0	26,0	80,0	–	–	2,5	3	Cylindrical	■
553120R310Z3.0-SIRON-A	02810369	2	D	12,0	12,0	26,0	80,0	–	–	3,1	3	Cylindrical	■

■ **Lagerstandard.**

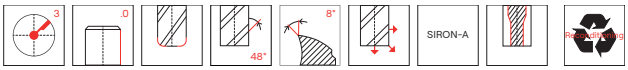
JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius





- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich



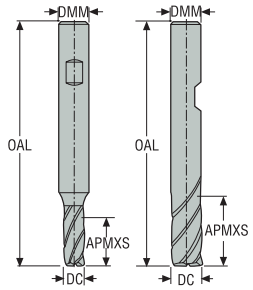
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
553160R050Z3.0-SIRON-A	02679385	2	D	16,0	16,0	34,0	90,0	–	–	0,5	3	Cylindrical	■
553160R100Z3.0-SIRON-A	02679386	2	D	16,0	16,0	34,0	90,0	–	–	1,0	3	Cylindrical	■
553160R200Z3.0-SIRON-A	02810370	2	D	16,0	16,0	34,0	90,0	–	–	2,0	3	Cylindrical	■
553160R250Z3.0-SIRON-A	02810371	2	D	16,0	16,0	34,0	90,0	–	–	2,5	3	Cylindrical	■
553160R310Z3.0-SIRON-A	02810372	2	D	16,0	16,0	34,0	90,0	–	–	3,1	3	Cylindrical	■
553160R400Z3.0-SIRON-A	02810373	2	D	16,0	16,0	34,0	90,0	–	–	4,0	3	Cylindrical	■
553200R050Z3.0-SIRON-A	02679390	2	D	20,0	20,0	42,0	110,0	–	–	0,5	3	Cylindrical	■
553200R100Z3.0-SIRON-A	02679391	2	D	20,0	20,0	42,0	110,0	–	–	1,0	3	Cylindrical	■
JS553200E2R200.0Z3-SIRA	02881689	2	E	20,0	20,0	42,0	110,0	54,0	19,0	2,0	3	Cylindrical	■
553250R050Z3.0-SIRON-A	02679395	2	D	25,0	25,0	52,0	125,0	–	–	0,5	3	Cylindrical	■
553250R100Z3.0-SIRON-A	02679396	2	D	25,0	25,0	52,0	125,0	–	–	1,0	3	Cylindrical	■

■ **Lagerstandard.**

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Weldon – Scharfe Schneide





—Toleranzen:
—DMM=h5
—DC=e7
—Nachschleifen möglich, wenn DC ≥ Ø6 ist



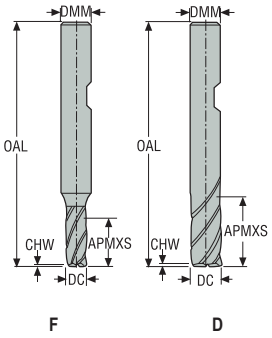
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm			
553020SZ3.0-SIRON-AW	02733936	2	F	2,0	6,0	5,0	50,0	3	Weldon	■
553030SZ3.0-SIRON-AW	02733939	2	F	3,0	6,0	7,0	50,0	3	Weldon	■
553040SZ3.0-SIRON-AW	02733943	2	F	4,0	6,0	10,0	55,0	3	Weldon	■
553050SZ3.0-SIRON-AW	02733945	2	F	5,0	6,0	12,0	55,0	3	Weldon	■
553060SZ3.0-SIRON-AW	02733946	2	D	6,0	6,0	14,0	55,0	3	Weldon	■
553080SZ3.0-SIRON-AW	02733950	2	D	8,0	8,0	18,0	60,0	3	Weldon	■
553100SZ3.0-SIRON-AW	02733952	2	D	10,0	10,0	22,0	70,0	3	Weldon	■

■ **Lagerstandard.**

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Weldon – Fase





—Toleranzen:
—DMM= h5
—DC= e7
—Nachschleifen möglich, wenn DC ≥ Ø6 ist



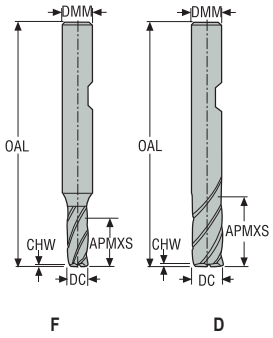
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JS553020F1C.3Z3-SIRA	10041477	1	F	2,0	6,0	3,0	40,0	0,025	3	Weldon	■
JS553030F1C.3Z3-SIRA	10041478	1	F	3,0	6,0	4,0	40,0	0,035	3	Weldon	■
JS553040F1C.3Z3-SIRA	10041479	1	F	4,0	6,0	6,0	40,0	0,045	3	Weldon	■
JS553045F1C.3Z3-SIRA	10041480	1	F	4,5	6,0	6,0	40,0	0,045	3	Weldon	■
JS553050F1C.3Z3-SIRA	10041481	1	F	5,0	6,0	7,0	40,0	0,055	3	Weldon	■
JS553055F1C.3Z3-SIRA	10041482	1	F	5,5	6,0	8,0	40,0	0,055	3	Weldon	■
JS553060D1C.3Z3-SIRA	10041483	1	D	6,0	6,0	8,0	40,0	0,075	3	Weldon	■
JS553080D1C.3Z3-SIRA	10041484	1	D	8,0	8,0	11,0	50,0	0,1	3	Weldon	□
JS553100D1C.3Z3-SIRA	10041485	1	D	10,0	10,0	13,0	57,0	0,125	3	Weldon	□
JS553120D1C.3Z3-SIRA	10041486	1	D	12,0	12,0	15,0	65,0	0,15	3	Weldon	□
553020Z3.0-SIRON-AW	02697423	2	F	2,0	6,0	5,0	50,0	0,025	3	Weldon	□
553025Z3.0-SIRON-AW	02700354	2	F	2,5	6,0	7,0	50,0	0,025	3	Weldon	■
553030Z3.0-SIRON-AW	02700355	2	F	3,0	6,0	7,0	50,0	0,035	3	Weldon	■
553035Z3.0-SIRON-AW	02700357	2	F	3,5	6,0	9,0	55,0	0,035	3	Weldon	■
553040Z3.0-SIRON-AW	02700358	2	F	4,0	6,0	10,0	55,0	0,045	3	Weldon	■
553045Z3.0-SIRON-AW	02700359	2	F	4,5	6,0	12,0	55,0	0,045	3	Weldon	□
553050Z3.0-SIRON-AW	02700360	2	F	5,0	6,0	12,0	55,0	0,055	3	Weldon	■
553055Z3.0-SIRON-AW	02700361	2	F	5,5	6,0	14,0	55,0	0,055	3	Weldon	□
553060Z3.3-SIRON-A	02679367	2	D	6,0	6,0	14,0	55,0	0,075	3	Weldon	■
553075Z3.3-SIRON-A	02733915	2	F	7,5	8,0	18,0	60,0	0,1	3	Weldon	■
553080Z3.3-SIRON-A	02679370	2	D	8,0	8,0	18,0	60,0	0,1	3	Weldon	■
553095Z3.3-SIRON-A	02733919	2	F	9,5	10,0	22,0	70,0	0,125	3	Weldon	■
553100Z3.3-SIRON-A	02679373	2	D	10,0	10,0	22,0	70,0	0,125	3	Weldon	■
553115Z3.3-SIRON-A	02733923	2	F	11,5	12,0	26,0	80,0	0,15	3	Weldon	■
553120Z3.3-SIRON-A	02679379	2	D	12,0	12,0	26,0	80,0	0,15	3	Weldon	■
553140Z3.3-SIRON-A	02733929	2	D	14,0	14,0	30,0	85,0	0,175	3	Weldon	■
553160Z3.3-SIRON-A	02679383	2	D	16,0	16,0	34,0	90,0	0,2	3	Weldon	■
553200Z3.3-SIRON-A	02679388	2	D	20,0	20,0	42,0	110,0	0,25	3	Weldon	■
553250Z3.3-SIRON-A	02679392	2	D	25,0	25,0	52,0	125,0	0,3	3	Weldon	■

□ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Weldon – Fase





—Toleranzen:
—DMM= h5
—DC= e7
—Nachschleifen möglich, wenn DC ≥ Ø6 ist



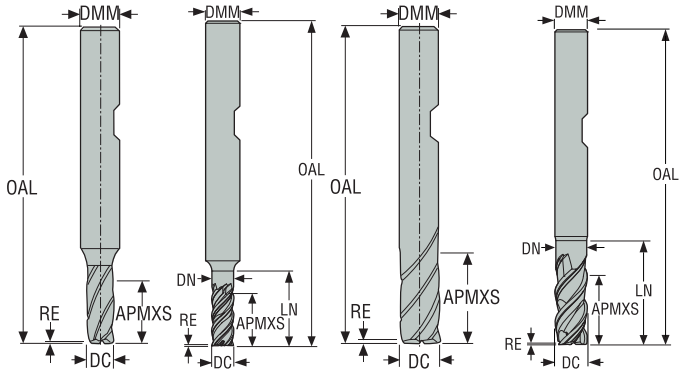
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
553L020Z3.0-SIRON-AW	02734001	3	F	2,0	6,0	7,0	50,0	0,025	3	Weldon	■
553L030Z3.0-SIRON-AW	02734006	3	F	3,0	6,0	10,0	55,0	0,035	3	Weldon	■
553L040Z3.0-SIRON-AW	02734007	3	F	4,0	6,0	14,0	60,0	0,045	3	Weldon	■
553L050Z3.0-SIRON-AW	02734008	3	F	5,0	6,0	18,0	60,0	0,055	3	Weldon	□
553L060Z3.3-SIRON-A	02733980	3	D	6,0	6,0	20,0	65,0	0,075	3	Weldon	■
553L080Z3.3-SIRON-A	02733984	3	D	8,0	8,0	28,0	70,0	0,1	3	Weldon	■
553L100Z3.3-SIRON-A	02733988	3	D	10,0	10,0	35,0	85,0	0,125	3	Weldon	■
553L120Z3.3-SIRON-A	02733993	3	D	12,0	12,0	40,0	95,0	0,15	3	Weldon	■
553L160Z3.3-SIRON-A	02733995	3	D	16,0	16,0	50,0	110,0	0,2	3	Weldon	■
553L200Z3.3-SIRON-A	02733997	3	D	20,0	20,0	60,0	125,0	0,25	3	Weldon	■
553L250Z3.3-SIRON-A	02733999	3	D	25,0	25,0	75,0	150,0	0,3	3	Weldon	■

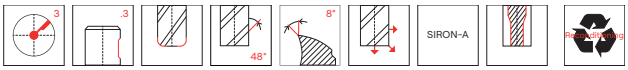
□ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Weldon – Eckenradius







– Toleranzen:
– DMM=h5
– DC=e7
– RE= ±0,02 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

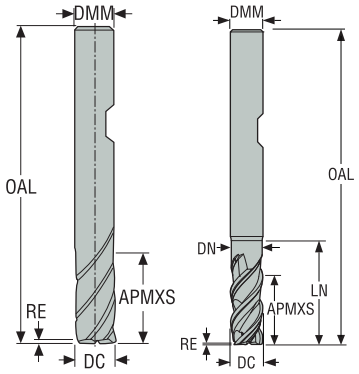
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS553080D1R050.3Z3-SIRA	10194469	1	D	8,0	8,0	11,0	50,0	–	–	0,5	3	Weldon	□
JS553100D1R050.3Z3-SIRA	10194470	1	D	10,0	10,0	13,0	57,0	–	–	0,5	3	Weldon	□
JS553100D1R100.3Z3-SIRA	10194471	1	D	10,0	10,0	13,0	57,0	–	–	1,0	3	Weldon	□
JS553120D1R050.3Z3-SIRA	10194472	1	D	12,0	12,0	15,0	65,0	–	–	0,5	3	Weldon	□
JS553120D1R100.3Z3-SIRA	10194474	1	D	12,0	12,0	15,0	65,0	–	–	1,0	3	Weldon	□
JS553020G2R050.3Z3-SIRA	02881690	2	G	2,0	6,0	5,0	57,0	8,0	1,9	0,5	3	Weldon	□
553030R015Z3.0-SIRON-AW	02733941	2	F	3,0	6,0	7,0	50,0	–	–	0,15	3	Weldon	□
JS553030G2R050.3Z3-SIRA	02881691	2	G	3,0	6,0	7,0	57,0	11,0	2,85	0,5	3	Weldon	■
553040R020Z3.0-SIRON-AW	02733944	2	F	4,0	6,0	10,0	55,0	–	–	0,2	3	Weldon	□
JS553040G2R050.3Z3-SIRA	02881692	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,5	3	Weldon	□
553050R020Z3.0-SIRON-AW	02703763	2	F	5,0	6,0	12,0	55,0	–	–	0,2	3	Weldon	□
JS553050G2R050.3Z3-SIRA	02881693	2	G	5,0	6,0	10,0	57,0	15,0	4,75	0,5	3	Weldon	□
553060R020Z3.0-SIRON-AW	02700364	2	D	6,0	6,0	14,0	55,0	–	–	0,2	3	Weldon	■
JS553060E2R050.3Z3-SIRA	02881694	2	E	6,0	6,0	14,0	57,0	19,0	5,7	0,5	3	Weldon	□
JS553060E2R100.3Z3-SIRA	02881695	2	E	6,0	6,0	14,0	57,0	19,0	5,7	1,0	3	Weldon	■
553080R050Z3.0-SIRON-AW	02700366	2	D	8,0	8,0	18,0	60,0	–	–	0,5	3	Weldon	■
553100R050Z3.0-SIRON-AW	02700369	2	D	10,0	10,0	22,0	70,0	–	–	0,5	3	Weldon	□
553100R100Z3.0-SIRON-AW	02700371	2	D	10,0	10,0	22,0	70,0	–	–	1,0	3	Weldon	□
553100R200Z3.3-SIRON-A	02810422	2	D	10,0	10,0	22,0	70,0	–	–	2,0	3	Weldon	□
553100R250Z3.3-SIRON-A	02810423	2	D	10,0	10,0	22,0	70,0	–	–	2,5	3	Weldon	□
553100R310Z3.3-SIRON-A	02810424	2	D	10,0	10,0	22,0	70,0	–	–	3,1	3	Weldon	□
553120R050Z3.0-SIRON-AW	02700373	2	D	12,0	12,0	26,0	80,0	–	–	0,5	3	Weldon	■
553120R100Z3.0-SIRON-AW	02700374	2	D	12,0	12,0	26,0	80,0	–	–	1,0	3	Weldon	□
553120R200Z3.3-SIRON-A	02810425	2	D	12,0	12,0	26,0	80,0	–	–	2,0	3	Weldon	□
553120R250Z3.3-SIRON-A	02810426	2	D	12,0	12,0	26,0	80,0	–	–	2,5	3	Weldon	□
553120R310Z3.3-SIRON-A	02810427	2	D	12,0	12,0	26,0	80,0	–	–	3,1	3	Weldon	□

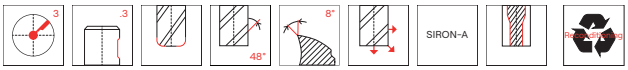
■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Weldon – Eckenradius







– Toleranzen:
– DMM=h5
– DC=e7
– RE= ±0,02 mm
– Nachschleifen möglich

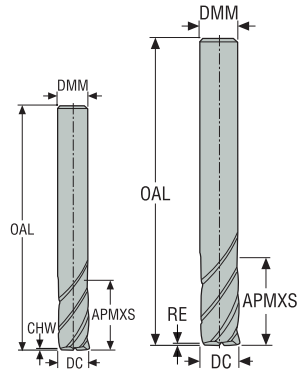
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
553160R050Z3.0-SIRON-AW	02700378	2	D	16,0	16,0	34,0	90,0	–	–	0,5	3	Weldon	□
553160R100Z3.0-SIRON-AW	02700381	2	D	16,0	16,0	34,0	90,0	–	–	1,0	3	Weldon	□
553160R200Z3.3-SIRON-A	02810428	2	D	16,0	16,0	34,0	90,0	–	–	2,0	3	Weldon	□
553160R250Z3.3-SIRON-A	02810429	2	D	16,0	16,0	34,0	90,0	–	–	2,5	3	Weldon	□
553160R310Z3.3-SIRON-A	02810430	2	D	16,0	16,0	34,0	90,0	–	–	3,1	3	Weldon	□
553160R400Z3.3-SIRON-A	02810431	2	D	16,0	16,0	34,0	90,0	–	–	4,0	3	Weldon	□
553200R050Z3.0-SIRON-AW	02700383	2	D	20,0	20,0	42,0	110,0	–	–	0,5	3	Weldon	■
553200R100Z3.0-SIRON-AW	02700384	2	D	20,0	20,0	42,0	110,0	–	–	1,0	3	Weldon	□
JS553200E2R200.3Z3-SIRA	02881696	2	E	20,0	20,0	42,0	110,0	54,0	19,0	2,0	3	Weldon	□
553250R050Z3.0-SIRON-AW	02700386	2	D	25,0	25,0	52,0	125,0	–	–	0,5	3	Weldon	□
553250R100Z3.0-SIRON-AW	02700385	2	D	25,0	25,0	52,0	125,0	–	–	1,0	3	Weldon	□

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

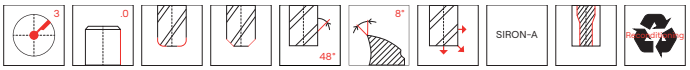
JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius oder Fase – Zoll





—Toleranzen:
—DMM=h5
—DC=e7
—Nachschleifen möglich, wenn DC ≥ Ø.375 ist



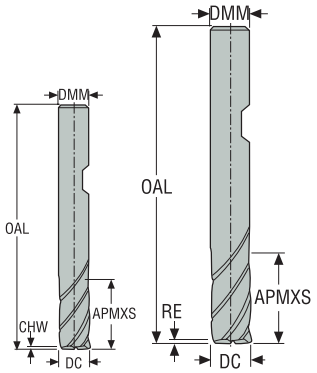
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				Zoll	Zoll	Zoll	Zoll	Zoll	Zoll			
5530125Z3.0-SIRON-A	02712684	2	D	0.125	0.125	0.250	2.000	0.001	–	3	Cylindrical	■
5530187Z3.0-SIRON-A	02712687	2	D	0.188	0.188	0.375	2.000	0.001	–	3	Cylindrical	■
5530250Z3.0-SIRON-A	02712688	2	D	0.250	0.250	0.500	2.500	0.003	–	3	Cylindrical	■
5530250R015Z3.0-SIRON-A	02712689	2	D	0.250	0.250	0.500	2.500	–	0.015	3	Cylindrical	■
5530312Z3.0-SIRON-A	02712690	2	D	0.313	0.313	0.625	2.500	0.004	–	3	Cylindrical	■
5530312R015Z3.0-SIRON-A	02712693	2	D	0.313	0.313	0.625	2.500	–	0.015	3	Cylindrical	■
5530375Z3.0-SIRON-A	02712694	2	D	0.375	0.375	0.750	3.000	0.005	–	3	Cylindrical	■
5530375R015Z3.0-SIRON-A	02712695	2	D	0.375	0.375	0.750	3.000	–	0.015	3	Cylindrical	■
5530375R030Z3.0-SIRON-A	02712696	2	D	0.375	0.375	0.750	3.000	–	0.030	3	Cylindrical	■
5530500Z3.0-SIRON-A	02712699	2	D	0.500	0.500	1.000	3.500	0.006	–	3	Cylindrical	■
5530500R015Z3.0-SIRON-A	02712701	2	D	0.500	0.500	1.000	3.500	–	0.015	3	Cylindrical	■
5530500R030Z3.0-SIRON-A	02712703	2	D	0.500	0.500	1.000	3.500	–	0.030	3	Cylindrical	■

■ **Lagerstandard.**

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Weldon – Eckenradius oder Fase – Zoll





D D

– Toleranzen:
– DMM=h5
– DC=e7



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				Zoll	Zoll	Zoll	Zoll	Zoll	Zoll			
5530500Z3.3-SIRON-A	02712697	2	D	0.500	0.500	1.000	3.500	0.006	–	3	Weldon	■
5530500R015Z3.3-SIRON-A	02712700	2	D	0.500	0.500	1.000	3.500	–	0.015	3	Weldon	■
5530500R030Z3.3-SIRON-A	02712702	2	D	0.500	0.500	1.000	3.500	–	0.030	3	Weldon	■

■ **Lagerstandard.**

Schnittdaten – JS553 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z												v_c
				2	3	4	5	6	8	10	12	14	16	20	25	
P1	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	225 (200 — 250) *740 (660 — 820)*
P2	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	220 (190 — 240) *720 (630 — 780)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	190 (170 — 210) *620 (560 — 680)*
P4	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	165 (150 — 190) *540 (500 — 620)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	160 (140 — 180) *520 (460 — 590)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	180 (160 — 200) *590 (530 — 650)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	170 (150 — 190) *560 (500 — 620)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	160 (140 — 180) *520 (460 — 590)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	145 (130 — 160) *475 (430 — 520)*
P12	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	95 (82 — 100) *310 (270 — 320)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.013 *0,00050*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	115 (100 — 120) *375 (330 — 390)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	95 (82 — 100) *310 (270 — 320)*
M3	E	0.400 *0,400*	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	60 (47 — 69) *195 (160 — 220)*
M4	E	0.400 *0,400*	1.0 *1,0*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	45 (36 — 53) *150 (120 — 170)*
M5	E	0.400 *0,400*	1.0 *1,0*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	37 (30 — 44) *120 (99 — 140)*
K1	E	0.400 *0,400*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	165 (160 — 190) *540 (530 — 620)*
K2	E	0.400 *0,400*	1.2 *1,2*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	145 (140 — 170) *475 (460 — 550)*
K3	E	0.400 *0,400*	1.2 *1,2*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	125 (120 — 140) *410 (400 — 450)*
K4	E	0.400 *0,400*	1.2 *1,2*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	120 (110 — 140) *395 (370 — 450)*
K5	E	0.400 *0,400*	1.1 *1,1*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	155 (140 — 170) *510 (460 — 550)*
K6	E	0.400 *0,400*	1.1 *1,1*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	220 (190 — 250) *720 (630 — 820)*
K7	E	0.400 *0,400*	1.1 *1,1*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	195 (170 — 220) *640 (560 — 720)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS553 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	3	4	5	6	8	10	12	14	16	20	25	
N1	E	0.500 *0,500*	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	620 (520 — 720) *2025 (1800 — 2300)*
N2	E	0.500 *0,500*	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	400 (340 — 460) *1300 (1200 — 1500)*
N3	E	0.500 *0,500*	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	265 (230 — 300) *870 (760 — 980)*
N11	E	0.500 *0,500*	1.1 *1,1*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	310 (260 — 350) *1025 (860 — 1100)*
S1	E	0.150 *0,150*	0.50 *0,50*	0.017 *0,00065*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	43 (26 — 60) *140 (86 — 190)*
S2	E	0.150 *0,150*	0.50 *0,50*	0.017 *0,00065*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	35 (21 — 48) *115 (69 — 150)*
S3	E	0.150 *0,150*	0.50 *0,50*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	30 (19 — 42) *100 (63 — 130)*
S11	E	0.400 *0,400*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	110 (78 — 130) *360 (260 — 420)*
S12	E	0.400 *0,400*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	85 (60 — 100) *280 (200 — 320)*
S13	E	0.400 *0,400*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	65 (48 — 84) *215 (160 — 270)*
H5	M/A/D	0.200 *0,200*	0.90 *0,90*	0.013 *0,00050*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	75 (62 — 91) *245 (210 — 290)*
H8	M/A/D	0.200 *0,200*	0.90 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (65 — 96) *260 (220 — 310)*
H21	M/A/D	0.200 *0,200*	0.90 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (65 — 96) *260 (220 — 310)*
H31	M/A/D	0.200 *0,200*	0.90 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	60 (49 — 72) *195 (170 — 230)*
TS1	A	0.500 *0,500*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	290 (180 — 400) *950 (600 — 1300)*
TP1	A	0.500 *0,500*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	300 (180 — 410) *980 (600 — 1300)*
GR1	A	0.500 *0,500*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	580 (470 — 690) *1900 (1600 — 2200)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS553 Nutfräsen

SMG		a_p/DC	f_z												v_c
			2	3	4	5	6	8	10	12	14	16	20	25	
P1	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	195 (170 — 220)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*640 (560 — 720)*
P2	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	190 (170 — 210)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*620 (560 — 680)*
P3	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	165 (140 — 180)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*540 (460 — 590)*
P4	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	145 (130 — 160)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*475 (430 — 520)*
P5	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	135 (120 — 150)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*445 (400 — 490)*
P6	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	155 (140 — 170)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*510 (460 — 550)*
P7	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	145 (130 — 160)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*475 (430 — 520)*
P8	M/A/D/E	1.0	0.014	0.020	0.028	0.034	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.17	135 (120 — 150)
		1,0	*0,00055*	*0,00080*	*0,0011*	*0,0013*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0065*	*445 (400 — 490)*
P11	M/A/D/E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	130 (120 — 140)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*425 (400 — 450)*
P12	M/A/D/E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.11	80 (69 — 87)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0044*	*260 (230 — 280)*
M1	E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	95 (85 — 100)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*310 (280 — 320)*
M2	E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.11	80 (69 — 87)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0044*	*260 (230 — 280)*
M3	E	0.70	0.0080	0.012	0.016	0.020	0.025	0.032	0.040	0.050	0.055	0.065	0.080	0.095	48 (39 — 58)
		0,70	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0016*	*0,0020*	*0,0022*	*0,0026*	*0,0032*	*0,0038*	*155 (130 — 190)*
M4	E	0.70	0.0080	0.012	0.016	0.020	0.025	0.032	0.040	0.050	0.055	0.065	0.075	0.085	36 (30 — 43)
		0,70	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0016*	*0,0020*	*0,0022*	*0,0026*	*0,0030*	*0,0034*	*120 (99 — 140)*
M5	E	0.70	0.0080	0.012	0.016	0.020	0.025	0.032	0.040	0.050	0.055	0.065	0.075	0.085	30 (25 — 36)
		0,70	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0016*	*0,0020*	*0,0022*	*0,0026*	*0,0030*	*0,0034*	*100 (83 — 110)*
K1	E	1.0	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	145 (140 — 170)
		1,0	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*475 (460 — 550)*
K2	E	1.0	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	125 (120 — 150)
		1,0	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*410 (400 — 490)*
K3	E	1.0	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	110 (110 — 120)
		1,0	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*360 (370 — 390)*
K4	E	1.0	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	105 (96 — 120)
		1,0	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*345 (320 — 390)*
K5	E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	135 (120 — 150)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*445 (400 — 490)*
K6	E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	200 (180 — 230)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*660 (600 — 750)*
K7	E	0.80	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	175 (150 — 190)
		0,80	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*570 (500 — 620)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS553 Nutfräsen

SMG		a_p/DC	f_z												v_c
			2	3	4	5	6	8	10	12	14	16	20	25	
N1	E	0.70 *0,70*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	580 (490 — 670) *1900 (1700 — 2100)*
N2	E	0.70 *0,70*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	375 (320 — 430) *1225 (1100 — 1400)*
N3	E	0.70 *0,70*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	250 (210 — 290) *820 (690 — 950)*
N11	E	0.60 *0,60*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	290 (250 — 330) *950 (830 — 1000)*
S1	E	0.30 *0,30*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	34 (21 — 47) *110 (69 — 150)*
S2	E	0.30 *0,30*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	27 (17 — 38) *90 (56 — 120)*
S3	E	0.30 *0,30*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	23 (15 — 32) *75 (50 — 100)*
S11	E	0.50 *0,50*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	85 (63 — 110) *280 (210 — 360)*
S12	E	0.50 *0,50*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	65 (48 — 86) *215 (160 — 280)*
S13	E	0.50 *0,50*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	55 (39 — 69) *180 (130 — 220)*
H5	M/A/D	0.50 *0,50*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52 — 77) *215 (180 — 250)*
H8	M/A/D	0.50 *0,50*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52 — 77) *215 (180 — 250)*
H11	M/A/D	0.50 *0,50*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	80 (66 — 98) *260 (220 — 320)*
H12	M/A/D	1.0 *1,0*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	65 (52 — 77) *215 (180 — 250)*
H21	M/A/D	0.50 *0,50*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52 — 77) *215 (180 — 250)*
TS1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	245 (150 — 340) *800 (500 — 1100)*
TP1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	250 (160 — 350) *820 (530 — 1100)*
GR1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	490 (400 — 580) *1600 (1400 — 1900)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
v_c = m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS553 Eckfräsen – Zoll

SMG		a_e/DC	a_p/DC	f_z						v_c
				1/8	3/16	1/4	5/16	3/8	1/2	
P1	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	225 (200 — 250) *740 (660 — 820)*
P2	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	220 (190 — 240) *720 (630 — 780)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	190 (170 — 210) *620 (560 — 680)*
P4	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	165 (150 — 190) *540 (500 — 620)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	160 (140 — 180) *520 (460 — 590)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	180 (160 — 200) *590 (530 — 650)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	170 (150 — 190) *560 (500 — 620)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	160 (140 — 180) *520 (460 — 590)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	145 (130 — 160) *475 (430 — 520)*
P12	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	95 (82 — 100) *310 (270 — 320)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	115 (100 — 120) *375 (330 — 390)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	95 (82 — 100) *310 (270 — 320)*
M3	E	0.400 *0,400*	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	60 (47 — 69) *195 (160 — 220)*
M4	E	0.400 *0,400*	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	45 (36 — 53) *150 (120 — 170)*
M5	E	0.400 *0,400*	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	37 (30 — 44) *120 (99 — 140)*
K1	E	0.400 *0,400*	1.2 *1,2*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	165 (160 — 190) *540 (530 — 620)*
K2	E	0.400 *0,400*	1.2 *1,2*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	145 (140 — 170) *475 (460 — 550)*
K3	E	0.400 *0,400*	1.2 *1,2*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	125 (120 — 140) *410 (400 — 450)*
K4	E	0.400 *0,400*	1.2 *1,2*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	120 (110 — 140) *395 (370 — 450)*
K5	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	155 (140 — 170) *510 (460 — 550)*
K6	E	0.400 *0,400*	1.1 *1,1*	0.028 *0,0011*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	220 (190 — 250) *720 (630 — 820)*
K7	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	195 (170 — 220) *640 (560 — 720)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS553 Eckfräsen – Zoll

SMG		a_e/DC	a_p/DC	f_z						v_c
				1/8	3/16	1/4	5/16	3/8	1/2	
N1	E	0.500 *0,500*	1.0 *1,0*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	620 (520 — 720) *2025 (1800 — 2300)*
N2	E	0.500 *0,500*	1.0 *1,0*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	400 (340 — 460) *1300 (1200 — 1500)*
N3	E	0.500 *0,500*	1.0 *1,0*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	265 (230 — 300) *870 (760 — 980)*
N11	E	0.500 *0,500*	1.1 *1,1*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	310 (260 — 350) *1025 (860 — 1100)*
S1	E	0.150 *0,150*	0.50 *0,50*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	43 (26 — 60) *140 (86 — 190)*
S2	E	0.150 *0,150*	0.50 *0,50*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	35 (21 — 48) *115 (69 — 150)*
S3	E	0.150 *0,150*	0.50 *0,50*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	30 (19 — 42) *100 (63 — 130)*
S11	E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	110 (78 — 130) *360 (260 — 420)*
S12	E	0.400 *0,400*	1.0 *1,0*	0.019 *0,00075*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	85 (60 — 100) *280 (200 — 320)*
S13	E	0.400 *0,400*	1.0 *1,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	65 (48 — 84) *215 (160 — 270)*
H5	M/A/D	0.200 *0,200*	0.90 *0,90*	0.020 *0,00080*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	75 (62 — 91) *245 (210 — 290)*
H8	M/A/D	0.200 *0,200*	0.90 *0,90*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	80 (65 — 96) *260 (220 — 310)*
H21	M/A/D	0.200 *0,200*	0.90 *0,90*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	80 (65 — 96) *260 (220 — 310)*
H31	M/A/D	0.200 *0,200*	0.90 *0,90*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	60 (49 — 72) *195 (170 — 230)*
TS1	A	0.500 *0,500*	1.2 *1,2*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	290 (180 — 400) *950 (600 — 1300)*
TP1	A	0.500 *0,500*	1.2 *1,2*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	300 (180 — 410) *980 (600 — 1300)*
GR1	A	0.500 *0,500*	1.2 *1,2*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	580 (470 — 690) *1900 (1600 — 2200)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
v_c = m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS553 Nutfräsen – Zoll

SMG		a_p/DC	f_z						v_c
			1/8	3/16	1/4	5/16	3/8	1/2	
P1	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	195 (170 — 220) *640 (560 — 720)*
P2	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	190 (170 — 210) *620 (560 — 680)*
P3	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	165 (140 — 180) *540 (460 — 590)*
P4	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	145 (130 — 160) *475 (430 — 520)*
P5	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	135 (120 — 150) *445 (400 — 490)*
P6	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	155 (140 — 170) *510 (460 — 550)*
P7	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	145 (130 — 160) *475 (430 — 520)*
P8	M/A/D/E	1.0 *1,0*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	135 (120 — 150) *445 (400 — 490)*
P11	M/A/D/E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	130 (120 — 140) *425 (400 — 450)*
P12	M/A/D/E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	80 (69 — 87) *260 (230 — 280)*
M1	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	95 (85 — 100) *310 (280 — 320)*
M2	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	80 (69 — 87) *260 (230 — 280)*
M3	E	0.70 *0,70*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	48 (39 — 58) *155 (130 — 190)*
M4	E	0.70 *0,70*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	36 (30 — 43) *120 (99 — 140)*
M5	E	0.70 *0,70*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	30 (25 — 36) *100 (83 — 110)*
K1	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	145 (140 — 170) *475 (460 — 550)*
K2	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	125 (120 — 150) *410 (400 — 490)*
K3	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	110 (110 — 120) *360 (370 — 390)*
K4	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	105 (96 — 120) *345 (320 — 390)*
K5	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	135 (120 — 150) *445 (400 — 490)*
K6	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	200 (180 — 230) *660 (600 — 750)*
K7	E	0.80 *0,80*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	175 (150 — 190) *570 (500 — 620)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS553 Nutfräsen – Zoll

SMG		a_p/DC	f_z						v_c
			1/8	3/16	1/4	5/16	3/8	1/2	
N1	E	0.70 *0,70*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	580 (490 — 670) *1900 (1700 — 2100)*
N2	E	0.70 *0,70*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	375 (320 — 430) *1225 (1100 — 1400)*
N3	E	0.70 *0,70*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	250 (210 — 290) *820 (690 — 950)*
N11	E	0.60 *0,60*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	290 (250 — 330) *950 (830 — 1000)*
S1	E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	34 (21 — 47) *110 (69 — 150)*
S2	E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	27 (17 — 38) *90 (56 — 120)*
S3	E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	23 (15 — 32) *75 (50 — 100)*
S11	E	0.50 *0,50*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	85 (63 — 110) *280 (210 — 360)*
S12	E	0.50 *0,50*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	65 (48 — 86) *215 (160 — 280)*
S13	E	0.50 *0,50*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	55 (39 — 69) *180 (130 — 220)*
H5	M/A/D	0.50 *0,50*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	65 (52 — 77) *215 (180 — 250)*
H8	M/A/D	0.50 *0,50*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	65 (52 — 77) *215 (180 — 250)*
H21	M/A/D	0.50 *0,50*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	65 (52 — 77) *215 (180 — 250)*
H31	M/A/D	0.50 *0,50*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	49 (39 — 58) *160 (130 — 190)*
TS1	A	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	245 (150 — 340) *800 (500 — 1100)*
TP1	A	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	250 (160 — 350) *820 (530 — 1100)*
GR1	A	1.0 *1,0*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	490 (400 — 580) *1600 (1400 — 1900)*

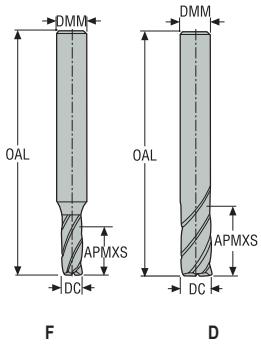
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
v_c = m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

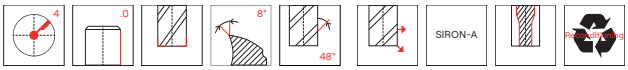
JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Scharfe Schneide





—Toleranzen:
—DMM=h5
—DC=e7
—Nachschleifen möglich, wenn DC ≥ Ø6 ist



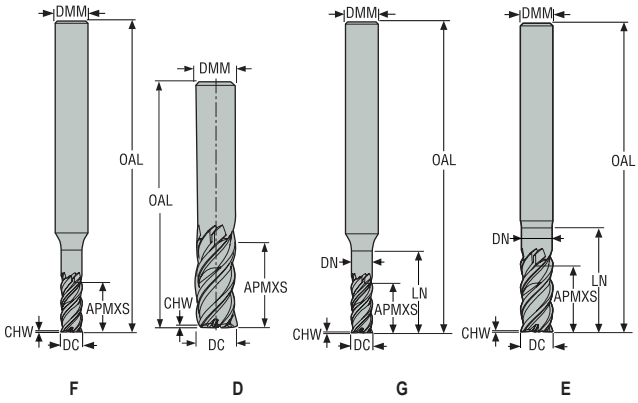
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm			
554030SZ4.0-SIRON-A	02733453	2	F	3,0	6,0	7,0	50,0	4	Cylindrical	■
554040SZ4.0-SIRON-A	02733458	2	F	4,0	6,0	10,0	55,0	4	Cylindrical	■
554050SZ4.0-SIRON-A	02733812	2	F	5,0	6,0	12,0	55,0	4	Cylindrical	■
554060SZ4.0-SIRON-A	02733814	2	D	6,0	6,0	14,0	55,0	4	Cylindrical	■
554080SZ4.0-SIRON-A	02733815	2	D	8,0	8,0	18,0	60,0	4	Cylindrical	■
554100SZ4.0-SIRON-A	02733816	2	D	10,0	10,0	22,0	70,0	4	Cylindrical	■

■ **Lagerstandard.**

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Fase





– Toleranzen:
– DMM=h5
– DC=e7
– Nachschleifen möglich, wenn DC ≥ Ø6 ist



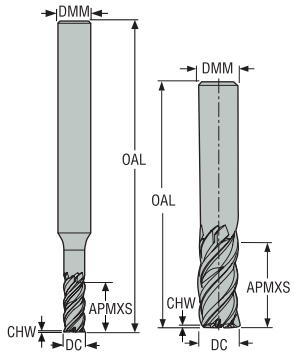
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS554030F1C.0Z4-SIRA	10194615	1	F	3,0	6,0	4,0	40,0	–	–	0,035	4	Cylindrical	■
JS554040F1C.0Z4-SIRA	10041454	1	F	4,0	6,0	6,0	40,0	–	–	0,045	4	Cylindrical	■
JS554050F1C.0Z4-SIRA	10194616	1	F	5,0	6,0	7,0	40,0	–	–	0,055	4	Cylindrical	■
JS554060D1C.0Z4-SIRA	10041455	1	D	6,0	6,0	8,0	40,0	–	–	0,075	4	Cylindrical	■
JS554080D1C.0Z4-SIRA	10041456	1	D	8,0	8,0	11,0	50,0	–	–	0,1	4	Cylindrical	■
JS554100D1C.0Z4-SIRA	10041457	1	D	10,0	10,0	13,0	57,0	–	–	0,125	4	Cylindrical	■
JS554120D1C.0Z4-SIRA	10041458	1	D	12,0	12,0	15,0	65,0	–	–	0,15	4	Cylindrical	■
JS554160D1C.0Z4-SIRA	10041459	1	D	16,0	16,0	19,0	75,0	–	–	0,2	4	Cylindrical	■
554030Z4.0-SIRON-A	02733455	2	F	3,0	6,0	7,0	50,0	–	–	0,035	4	Cylindrical	■
JS554030G2C.0Z4-SIRA	03029956	2	G	3,0	6,0	8,0	57,0	10,0	2,85	0,035	4	Cylindrical	■
554040Z4.0-SIRON-A	02733459	2	F	4,0	6,0	10,0	55,0	–	–	0,045	4	Cylindrical	■
JS554040G2C.0Z4-SIRA	03029957	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,045	4	Cylindrical	■
554050Z4.0-SIRON-A	02733813	2	F	5,0	6,0	12,0	55,0	–	–	0,055	4	Cylindrical	■
JS554050G2C.0Z4-SIRA	03029958	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,055	4	Cylindrical	■
554060Z4.0-SIRON-A	02679503	2	D	6,0	6,0	14,0	55,0	–	–	0,075	4	Cylindrical	■
JS554060E2C.0Z4-SIRA	03029959	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,075	4	Cylindrical	■
554080Z4.0-SIRON-A	02679512	2	D	8,0	8,0	18,0	60,0	–	–	0,1	4	Cylindrical	■
JS554080E2C.0Z4-SIRA	03029961	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,1	4	Cylindrical	■
554100Z4.0-SIRON-A	02679537	2	D	10,0	10,0	22,0	70,0	–	–	0,125	4	Cylindrical	■
JS554100E2C.0Z4-SIRA	03029963	2	E	10,0	10,0	22,0	72,0	29,0	9,5	0,125	4	Cylindrical	■
554120Z4.0-SIRON-A	02679548	2	D	12,0	12,0	26,0	80,0	–	–	0,15	4	Cylindrical	■
JS554120E2C.0Z4-SIRA	03029966	2	E	12,0	12,0	26,0	83,0	35,0	11,4	0,15	4	Cylindrical	■
554160Z4.0-SIRON-A	02679560	2	D	16,0	16,0	34,0	90,0	–	–	0,2	4	Cylindrical	■
JS554160E2C.0Z4-SIRA	03029970	2	E	16,0	16,0	34,0	92,0	42,0	15,2	0,2	4	Cylindrical	■
554200Z4.0-SIRON-A	02679566	2	D	20,0	20,0	42,0	100,0	–	–	0,25	4	Cylindrical	■
JS554200E2C.0Z4-SIRA	03029972	2	E	20,0	20,0	42,0	109,0	54,0	19,0	0,25	4	Cylindrical	■
554250Z4.0-SIRON-A	02679573	2	D	25,0	25,0	52,0	125,0	–	–	0,3	4	Cylindrical	■

■ **Lagerstandard.**

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Fase





—Toleranzen:
—DMM=h5
—DC=e7
—Nachschleifen möglich, wenn DC ≥ Ø6 ist



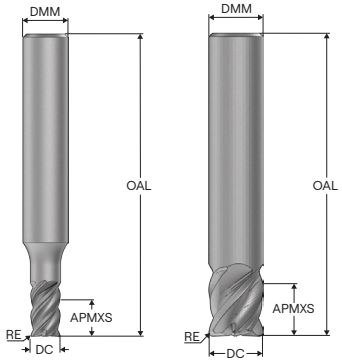
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
554L030Z4.0-SIRON-A	02733818	3	F	3,0	6,0	12,0	55,0	0,035	4	Cylindrical	■
554L040Z4.0-SIRON-A	02733823	3	F	4,0	6,0	16,0	60,0	0,045	4	Cylindrical	■
554L050Z4.0-SIRON-A	02733825	3	F	5,0	6,0	20,0	65,0	0,055	4	Cylindrical	■
554L060Z4.0-SIRON-A	02733828	3	D	6,0	6,0	23,0	65,0	0,075	4	Cylindrical	■
554L080Z4.0-SIRON-A	02733830	3	D	8,0	8,0	32,0	75,0	0,1	4	Cylindrical	■
554L100Z4.0-SIRON-A	02733832	3	D	10,0	10,0	40,0	85,0	0,125	4	Cylindrical	■
554L120Z4.0-SIRON-A	02733834	3	D	12,0	12,0	45,0	100,0	0,15	4	Cylindrical	■
554L160Z4.0-SIRON-A	02733836	3	D	16,0	16,0	55,0	115,0	0,2	4	Cylindrical	■
554L200Z4.0-SIRON-A	02733838	3	D	20,0	20,0	65,0	125,0	0,25	4	Cylindrical	■
554L250Z4.0-SIRON-A	02733841	3	D	25,0	25,0	85,0	150,0	0,3	4	Cylindrical	■

■ **Lagerstandard.**

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius





F D



– Toleranzen:
– DMM= h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

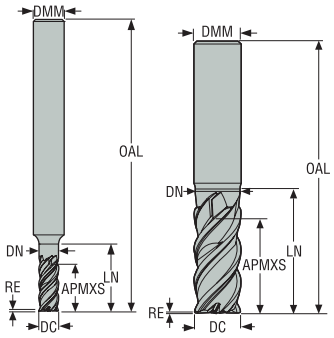
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JS554030F1R020.0Z4-SIRA	10194617	1	F	3,0	6,0	4,0	40,0	0,2	4	Cylindrical	■
JS554040F1R020.0Z4-SIRA	10194618	1	F	4,0	6,0	6,0	40,0	0,2	4	Cylindrical	■
JS554050F1R020.0Z4-SIRA	10194619	1	F	5,0	6,0	7,0	40,0	0,2	4	Cylindrical	■
JS554060D1R020.0Z4-SIRA	10194620	1	D	6,0	6,0	8,0	40,0	0,2	4	Cylindrical	■
JS554060D1R050.0Z4-SIRA	10194621	1	D	6,0	6,0	8,0	40,0	0,5	4	Cylindrical	■
JS554080D1R050.0Z4-SIRA	10194622	1	D	8,0	8,0	11,0	50,0	0,5	4	Cylindrical	■
JS554100D1R050.0Z4-SIRA	10194623	1	D	10,0	10,0	13,0	57,0	0,5	4	Cylindrical	■
JS554100D1R100.0Z4-SIRA	10194624	1	D	10,0	10,0	13,0	57,0	1,0	4	Cylindrical	■
JS554120D1R050.0Z4-SIRA	10194625	1	D	12,0	12,0	15,0	65,0	0,5	4	Cylindrical	■
JS554120D1R100.0Z4-SIRA	10194626	1	D	12,0	12,0	15,0	65,0	1,0	4	Cylindrical	■
JS554160D1R050.0Z4-SIRA	10194627	1	D	16,0	16,0	19,0	75,0	0,5	4	Cylindrical	■
JS554160D1R100.0Z4-SIRA	10194628	1	D	16,0	16,0	19,0	75,0	1,0	4	Cylindrical	■
554060R020Z4.0-SIRON-A	02679507	2	D	6,0	6,0	14,0	55,0	0,2	4	Cylindrical	■
554080R050Z4.0-SIRON-A	02679514	2	D	8,0	8,0	18,0	60,0	0,5	4	Cylindrical	■
554100R050Z4.0-SIRON-A	02679540	2	D	10,0	10,0	22,0	70,0	0,5	4	Cylindrical	■
554100R100Z4.0-SIRON-A	02679544	2	D	10,0	10,0	22,0	70,0	1,0	4	Cylindrical	■
554120R050Z4.0-SIRON-A	02679552	2	D	12,0	12,0	26,0	80,0	0,5	4	Cylindrical	■
554120R100Z4.0-SIRON-A	02679557	2	D	12,0	12,0	26,0	80,0	1,0	4	Cylindrical	■
554160R050Z4.0-SIRON-A	02679562	2	D	16,0	16,0	34,0	90,0	0,5	4	Cylindrical	■
554160R100Z4.0-SIRON-A	02679564	2	D	16,0	16,0	34,0	90,0	1,0	4	Cylindrical	■
554160R200Z4.0-SIRON-A	02810437	2	D	16,0	16,0	34,0	90,0	2,0	4	Cylindrical	■
554160R310Z4.0-SIRON-A	02810439	2	D	16,0	16,0	34,0	90,0	3,1	4	Cylindrical	■
554160R400Z4.0-SIRON-A	02810441	2	D	16,0	16,0	34,0	90,0	4,0	4	Cylindrical	■
554200R050Z4.0-SIRON-A	02679568	2	D	20,0	20,0	42,0	100,0	0,5	4	Cylindrical	■
554200R100Z4.0-SIRON-A	02679571	2	D	20,0	20,0	42,0	100,0	1,0	4	Cylindrical	■
554200R250Z4.0-SIRON-A	02810443	2	D	20,0	20,0	42,0	100,0	2,5	4	Cylindrical	■
554200R310Z4.0-SIRON-A	02810445	2	D	20,0	20,0	42,0	100,0	3,1	4	Cylindrical	■
554200R400Z4.0-SIRON-A	02810447	2	D	20,0	20,0	42,0	100,0	4,0	4	Cylindrical	■
554250R050Z4.0-SIRON-A	02679575	2	D	25,0	25,0	52,0	125,0	0,5	4	Cylindrical	■
554250R100Z4.0-SIRON-A	02679577	2	D	25,0	25,0	52,0	125,0	1,0	4	Cylindrical	■
554250R310Z4.0-SIRON-A	02810449	2	D	25,0	25,0	52,0	125,0	3,1	4	Cylindrical	■
554250R400Z4.0-SIRON-A	02810452	2	D	25,0	25,0	52,0	125,0	4,0	4	Cylindrical	■

■ **Lagerstandard.**

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius





—Toleranzen:
—DMM= h5
—DC= e7
—RE= ±0,02 mm
—Nachschleifen möglich, wenn DC ≥ Ø6 ist



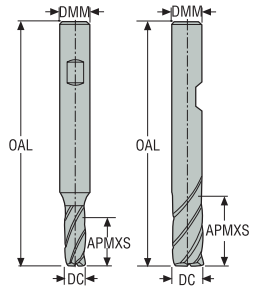
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS554030G2R015.0Z4-SIRA	02881697	2	G	3,0	6,0	7,0	57,0	10,0	2,85	0,15	4	Cylindrical	■
JS554040G2R020.0Z4-SIRA	02881698	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,2	4	Cylindrical	■
JS554050G2R020.0Z4-SIRA	02881699	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,2	4	Cylindrical	■
JS554060E2R020.0Z4-SIRA	03029960	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,2	4	Cylindrical	■
JS554060E2R050.0Z4-SIRA	02881700	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,5	4	Cylindrical	■
JS554060E2R100.0Z4-SIRA	03029948	2	E	6,0	6,0	14,0	57,0	18,0	5,7	1,0	4	Cylindrical	■
JS554080E2R050.0Z4-SIRA	03029962	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,5	4	Cylindrical	■
JS554080E2R100.0Z4-SIRA	02881701	2	E	8,0	8,0	18,0	63,0	25,0	7,6	1,0	4	Cylindrical	■
JS554100E2R050.0Z4-SIRA	03029964	2	E	10,0	10,0	22,0	72,0	29,0	9,5	0,5	4	Cylindrical	■
JS554100E2R100.0Z4-SIRA	03029965	2	E	10,0	10,0	22,0	72,0	29,0	9,5	1,0	4	Cylindrical	■
JS554100E2R200.0Z4-SIRA	02881702	2	E	10,0	10,0	22,0	72,0	29,0	9,5	2,0	4	Cylindrical	■
JS554100E2R250.0Z4-SIRA	03029949	2	E	10,0	10,0	22,0	72,0	29,0	9,5	2,5	4	Cylindrical	■
JS554120E2R050.0Z4-SIRA	03029968	2	E	12,0	12,0	26,0	83,0	35,0	11,4	0,5	4	Cylindrical	■
JS554120E2R100.0Z4-SIRA	03029969	2	E	12,0	12,0	26,0	83,0	35,0	11,4	1,0	4	Cylindrical	■
JS554120E2R200.0Z4-SIRA	02881703	2	E	12,0	12,0	26,0	83,0	35,0	11,4	2,0	4	Cylindrical	■
JS554120E2R250.0Z4-SIRA	02881704	2	E	12,0	12,0	26,0	83,0	35,0	11,4	2,5	4	Cylindrical	■
JS554120E2R300.0Z4-SIRA	03029950	2	E	12,0	12,0	26,0	83,0	35,0	11,4	3,0	4	Cylindrical	■
JS554160E2R050.0Z4-SIRA	03029971	2	E	16,0	16,0	34,0	92,0	42,0	15,2	0,5	4	Cylindrical	■
JS554160E2R600.0Z4-SIRA	03093685	2	E	16,0	16,0	34,0	92,0	42,0	15,2	6,0	4	Cylindrical	■
JS554200E2R200.0Z4-SIRA	02881705	2	E	20,0	20,0	42,0	110,0	54,0	19,0	2,0	4	Cylindrical	■
JS554200E2R600.0Z4-SIRA	03029951	2	E	20,0	20,0	42,0	109,0	54,0	19,0	6,0	4	Cylindrical	■
JS554250E2R600.0Z4-SIRA	03093686	2	E	25,0	25,0	52,0	125,0	65,0	23,8	6,0	4	Cylindrical	■

■ **Lagerstandard.**

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Weldon – Scharfe Schneide





– Toleranzen:
– DMM=h5
– DC=e7
– Nachschleifen möglich, wenn DC ≥ Ø6 ist



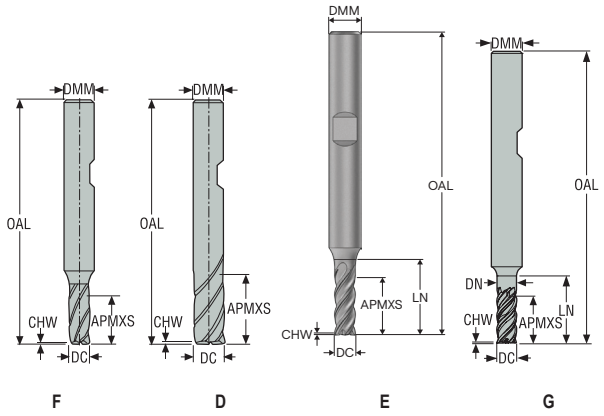
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm			
554030SZ4.0-SIRON-AW	02733844	2	F	3,0	6,0	7,0	50,0	4	Weldon	☐
554040SZ4.0-SIRON-AW	02733846	2	F	4,0	6,0	10,0	55,0	4	Weldon	☐
554050SZ4.0-SIRON-AW	02733847	2	F	5,0	6,0	12,0	55,0	4	Weldon	☐
554060SZ4.0-SIRON-AW	02733848	2	D	6,0	6,0	14,0	55,0	4	Weldon	☐
554080SZ4.0-SIRON-AW	02733849	2	D	8,0	8,0	18,0	60,0	4	Weldon	☐
554100SZ4.0-SIRON-AW	02733850	2	D	10,0	10,0	22,0	70,0	4	Weldon	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Weldon – Fase







—Toleranzen:
—DMM=h5
—DC=e7
—Nachschleifen möglich, wenn DC ≥ Ø6 ist

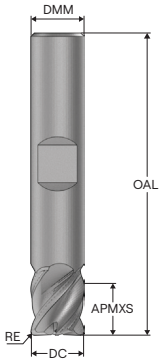
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS554040F1C.3Z4-SIRA	10041460	1	F	4,0	6,0	6,0	40,0	–	–	0,045	4	Weldon	■
JS554060D1C.3Z4-SIRA	10041461	1	D	6,0	6,0	8,0	40,0	–	–	0,075	4	Weldon	■
JS554080D1C.3Z4-SIRA	10041462	1	D	8,0	8,0	11,0	50,0	–	–	0,1	4	Weldon	□
JS554100D1C.3Z4-SIRA	10041463	1	D	10,0	10,0	13,0	57,0	–	–	0,125	4	Weldon	□
JS554120D1C.3Z4-SIRA	10041464	1	D	12,0	12,0	15,0	65,0	–	–	0,15	4	Weldon	□
JS554160D1C.3Z4-SIRA	10041465	1	D	16,0	16,0	19,0	75,0	–	–	0,2	4	Weldon	□
554030Z4.3-SIRON-A	02733450	2	F	3,0	6,0	7,0	50,0	–	–	0,035	4	Weldon	■
JS554030G2C.3Z4-SIRA	03029973	2	G	3,0	6,0	8,0	57,0	10,0	2,85	0,035	4	Weldon	□
554040Z4.3-SIRON-A	02733456	2	F	4,0	6,0	10,0	55,0	–	–	0,045	4	Weldon	■
JS554040G2C.3Z4-SIRA	03029974	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,045	4	Weldon	■
554050Z4.3-SIRON-A	02733461	2	F	5,0	6,0	12,0	55,0	–	–	0,055	4	Weldon	■
JS554050G2C.3Z4-SIRA	03029975	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,055	4	Weldon	□
554060Z4.3-SIRON-A	02679502	2	D	6,0	6,0	14,0	55,0	–	–	0,075	4	Weldon	■
JS554060E2C.3Z4-SIRA	03029976	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,075	4	Weldon	■
554080Z4.3-SIRON-A	02679511	2	D	8,0	8,0	18,0	60,0	–	–	0,1	4	Weldon	■
JS554080E2C.3Z4-SIRA	03029978	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,1	4	Weldon	■
JS554100E2C.3Z4-SIRA	03029980	2	E	10,0	10,0	22,0	72,0	29,0	9,5	0,125	4	Weldon	■
554100Z4.3-SIRON-A	02679535	2	D	10,0	10,0	22,0	70,0	–	–	0,125	4	Weldon	■
JS554120E2C.3Z4-SIRA	03029983	2	E	12,0	12,0	26,0	83,0	35,0	11,4	0,15	4	Weldon	■
554120Z4.3-SIRON-A	02679547	2	D	12,0	12,0	26,0	80,0	–	–	0,15	4	Weldon	■
JS554160E2C.3Z4-SIRA	03029986	2	E	16,0	16,0	34,0	92,0	42,0	15,2	0,2	4	Weldon	■
554160Z4.3-SIRON-A	02679559	2	D	16,0	16,0	34,0	90,0	–	–	0,2	4	Weldon	■
JS554200E2C.3Z4-SIRA	03029988	2	E	20,0	20,0	42,0	109,0	54,0	19,0	0,25	4	Weldon	■
554200Z4.3-SIRON-A	02679565	2	D	20,0	20,0	42,0	100,0	–	–	0,25	4	Weldon	■
554250Z4.3-SIRON-A	02679572	2	D	25,0	25,0	52,0	125,0	–	–	0,3	4	Weldon	■
554L030Z4.3-SIRON-A	02733817	3	F	3,0	6,0	12,0	55,0	–	–	0,035	4	Weldon	■
554L040Z4.3-SIRON-A	02733820	3	F	4,0	6,0	16,0	60,0	–	–	0,045	4	Weldon	■
554L050Z4.3-SIRON-A	02733824	3	F	5,0	6,0	20,0	65,0	–	–	0,055	4	Weldon	■
554L060Z4.3-SIRON-A	02733827	3	D	6,0	6,0	23,0	65,0	–	–	0,075	4	Weldon	■
554L080Z4.3-SIRON-A	02733829	3	D	8,0	8,0	32,0	75,0	–	–	0,1	4	Weldon	■
554L100Z4.3-SIRON-A	02733831	3	D	10,0	10,0	40,0	85,0	–	–	0,125	4	Weldon	■
554L120Z4.3-SIRON-A	02733833	3	D	12,0	12,0	45,0	100,0	–	–	0,15	4	Weldon	■
554L160Z4.3-SIRON-A	02733835	3	D	16,0	16,0	55,0	115,0	–	–	0,2	4	Weldon	■
554L200Z4.3-SIRON-A	02733837	3	D	20,0	20,0	65,0	125,0	–	–	0,25	4	Weldon	■
554L250Z4.3-SIRON-A	02733839	3	D	25,0	25,0	85,0	150,0	–	–	0,3	4	Weldon	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Weldon – Eckenradius





D



– Toleranzen:
– DMM= h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich

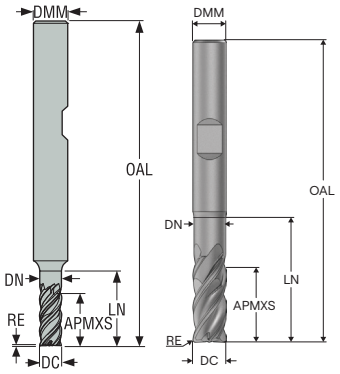
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JS554080D1R050.3Z4-SIRA	10194629	1	D	8,0	8,0	11,0	50,0	0,5	4	Weldon	□
JS554100D1R050.3Z4-SIRA	10194630	1	D	10,0	10,0	13,0	57,0	0,5	4	Weldon	□
JS554100D1R100.3Z4-SIRA	10194631	1	D	10,0	10,0	13,0	57,0	1,0	4	Weldon	□
JS554120D1R050.3Z4-SIRA	10194632	1	D	12,0	12,0	15,0	65,0	0,5	4	Weldon	□
JS554120D1R100.3Z4-SIRA	10194633	1	D	12,0	12,0	15,0	65,0	1,0	4	Weldon	□
JS554160D1R050.3Z4-SIRA	10194634	1	D	16,0	16,0	19,0	75,0	0,5	4	Weldon	□
JS554160D1R100.3Z4-SIRA	10194635	1	D	16,0	16,0	19,0	75,0	1,0	4	Weldon	□
554060R020Z4.3-SIRON-A	02679506	2	D	6,0	6,0	14,0	55,0	0,2	4	Weldon	■
554080R050Z4.3-SIRON-A	02679513	2	D	8,0	8,0	18,0	60,0	0,5	4	Weldon	■
554100R050Z4.3-SIRON-A	02679539	2	D	10,0	10,0	22,0	70,0	0,5	4	Weldon	■
554100R100Z4.3-SIRON-A	02679542	2	D	10,0	10,0	22,0	70,0	1,0	4	Weldon	■
554120R050Z4.3-SIRON-A	02679549	2	D	12,0	12,0	26,0	80,0	0,5	4	Weldon	■
554120R100Z4.3-SIRON-A	02679554	2	D	12,0	12,0	26,0	80,0	1,0	4	Weldon	■
554160R050Z4.3-SIRON-A	02679561	2	D	16,0	16,0	34,0	90,0	0,5	4	Weldon	■
554160R100Z4.3-SIRON-A	02679563	2	D	16,0	16,0	34,0	90,0	1,0	4	Weldon	■
554160R200Z4.3-SIRON-A	02810436	2	D	16,0	16,0	34,0	90,0	2,0	4	Weldon	■
554160R310Z4.3-SIRON-A	02810438	2	D	16,0	16,0	34,0	90,0	3,1	4	Weldon	■
554160R400Z4.3-SIRON-A	02810440	2	D	16,0	16,0	34,0	90,0	4,0	4	Weldon	■
554200R050Z4.3-SIRON-A	02679567	2	D	20,0	20,0	42,0	100,0	0,5	4	Weldon	■
554200R100Z4.3-SIRON-A	02679570	2	D	20,0	20,0	42,0	100,0	1,0	4	Weldon	■
554200R250Z4.3-SIRON-A	02810442	2	D	20,0	20,0	42,0	100,0	2,5	4	Weldon	■
554200R310Z4.3-SIRON-A	02810444	2	D	20,0	20,0	42,0	100,0	3,1	4	Weldon	■
554200R400Z4.3-SIRON-A	02810446	2	D	20,0	20,0	42,0	100,0	4,0	4	Weldon	■
554250R050Z4.3-SIRON-A	02679574	2	D	25,0	25,0	52,0	125,0	0,5	4	Weldon	■
554250R100Z4.3-SIRON-A	02679576	2	D	25,0	25,0	52,0	125,0	1,0	4	Weldon	■
554250R310Z4.3-SIRON-A	02810448	2	D	25,0	25,0	52,0	125,0	3,1	4	Weldon	■
554250R400Z4.3-SIRON-A	02810451	2	D	25,0	25,0	52,0	125,0	4,0	4	Weldon	■

■ **Lagerstandard.**

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Weldon – Eckenradius





—Toleranzen:
—DMM= h5
—DC= e7
—RE= ±0,02 mm
—Nachschleifen möglich, wenn DC ≥ Ø6 ist



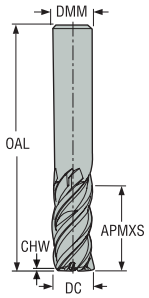
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS554030G2R015.3Z4-SIRA	02881706	2	G	3,0	6,0	7,0	57,0	10,0	2,85	0,15	4	Weldon	□
JS554040G2R020.3Z4-SIRA	02881946	2	G	4,0	6,0	10,0	57,0	13,0	3,8	0,2	4	Weldon	■
JS554050G2R020.3Z4-SIRA	02881708	2	G	5,0	6,0	12,0	57,0	16,0	4,75	0,2	4	Weldon	□
JS554060E2R020.3Z4-SIRA	03029977	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,2	4	Weldon	■
JS554060E2R050.3Z4-SIRA	02881709	2	E	6,0	6,0	14,0	57,0	18,0	5,7	0,5	4	Weldon	□
JS554060E2R100.3Z4-SIRA	03029952	2	E	6,0	6,0	14,0	57,0	18,0	5,7	1,0	4	Weldon	□
JS554080E2R050.3Z4-SIRA	03029979	2	E	8,0	8,0	18,0	63,0	25,0	7,6	0,5	4	Weldon	□
JS554080E2R100.3Z4-SIRA	02881710	2	E	8,0	8,0	18,0	63,0	25,0	7,6	1,0	4	Weldon	□
JS554100E2R050.3Z4-SIRA	03029981	2	E	10,0	10,0	22,0	72,0	29,0	9,5	0,5	4	Weldon	■
JS554100E2R100.3Z4-SIRA	03029982	2	E	10,0	10,0	22,0	72,0	29,0	9,5	1,0	4	Weldon	□
JS554100E2R200.3Z4-SIRA	02881711	2	E	10,0	10,0	22,0	72,0	29,0	9,5	2,0	4	Weldon	■
JS554100E2R250.3Z4-SIRA	03029953	2	E	10,0	10,0	22,0	72,0	29,0	9,5	2,5	4	Weldon	□
JS554120E2R050.3Z4-SIRA	03029984	2	E	12,0	12,0	26,0	83,0	35,0	11,4	0,5	4	Weldon	■
JS554120E2R100.3Z4-SIRA	03029985	2	E	12,0	12,0	26,0	83,0	35,0	11,4	1,0	4	Weldon	□
JS554120E2R200.3Z4-SIRA	02881712	2	E	12,0	12,0	26,0	83,0	35,0	11,4	2,0	4	Weldon	□
JS554120E2R250.3Z4-SIRA	02881713	2	E	12,0	12,0	26,0	83,0	35,0	11,4	2,5	4	Weldon	□
JS554120E2R300.3Z4-SIRA	03029954	2	E	12,0	12,0	26,0	83,0	35,0	11,4	3,0	4	Weldon	□
JS554160E2R050.3Z4-SIRA	03029987	2	E	16,0	16,0	34,0	92,0	42,0	15,2	0,5	4	Weldon	■
JS554160E2R600.3Z4-SIRA	03093687	2	E	16,0	16,0	34,0	92,0	42,0	15,2	6,0	4	Weldon	□
JS554200E2R200.3Z4-SIRA	02881714	2	E	20,0	20,0	42,0	110,0	54,0	19,0	2,0	4	Weldon	□
JS554200E2R600.3Z4-SIRA	03029955	2	E	20,0	20,0	42,0	109,0	54,0	19,0	6,0	4	Weldon	□
JS554250E2R600.3Z4-SIRA	03093688	2	E	25,0	25,0	52,0	125,0	65,0	23,8	6,0	4	Weldon	□

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Fase – Zoll





D

—Toleranzen:
—DMM=h5
—DC=e7
—Nachschleifen möglich, wenn DC ≥ Ø.375 ist



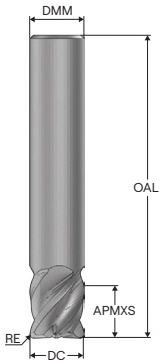
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
				Zoll	Zoll	Zoll	Zoll	Zoll			
5540250Z4.0-SIRON-A	02711329	2	D	0.250	0.250	0.500	2.500	0.003	4	Cylindrical	■
5540312Z4.0-SIRON-A	02711340	2	D	0.313	0.313	0.625	2.500	0.004	4	Cylindrical	■
5540375Z4.0-SIRON-A	02711344	2	D	0.375	0.375	0.750	3.000	0.005	4	Cylindrical	■
5540500Z4.0-SIRON-A	02711611	2	D	0.500	0.500	1.000	3.500	0.006	4	Cylindrical	■
5540625Z4.0-SIRON-A	02711626	2	D	0.625	0.625	1.250	3.750	0.008	4	Cylindrical	■
5540750Z4.0-SIRON-A	02711643	2	D	0.750	0.750	1.500	4.000	0.010	4	Cylindrical	■
5541000Z4.0-SIRON-A	02711660	2	D	1.000	1.000	2.000	5.000	0.012	4	Cylindrical	■

■ **Lagerstandard.**

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius – Zoll





D



—Toleranzen:
—DMM=h5
—DC=e7
—RE= ±.0008 *Zoll*
—Nachschleifen möglich, wenn DC ≥ Ø.375 ist

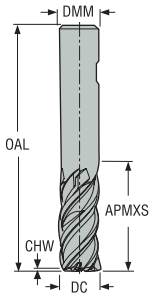
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				Zoll	Zoll	Zoll	Zoll	Zoll			
5540250R015Z4.0-SIRON-A	02711335	2	D	0.250	0.250	0.500	2.500	0.015	4	Cylindrical	■
5540312R015Z4.0-SIRON-A	02711341	2	D	0.313	0.313	0.625	2.500	0.015	4	Cylindrical	■
5540375R015Z4.0-SIRON-A	02711588	2	D	0.375	0.375	0.750	3.000	0.015	4	Cylindrical	■
5540375R030Z4.0-SIRON-A	02711589	2	D	0.375	0.375	0.750	3.000	0.030	4	Cylindrical	■
5540500R015Z4.0-SIRON-A	02711614	2	D	0.500	0.500	1.000	3.500	0.015	4	Cylindrical	■
5540500R030Z4.0-SIRON-A	02711616	2	D	0.500	0.500	1.000	3.500	0.030	4	Cylindrical	■
5540500R125Z4.0-SIRON-A	02842370	2	D	0.500	0.500	1.000	3.500	0.125	4	Cylindrical	■
5540625R015Z4.0-SIRON-A	02711629	2	D	0.625	0.625	1.250	3.750	0.015	4	Cylindrical	■
5540625R030Z4.0-SIRON-A	02711631	2	D	0.625	0.625	1.250	3.750	0.030	4	Cylindrical	■
5540625R125Z4.0-SIRON-A	02842371	2	D	0.625	0.625	1.250	3.750	0.125	4	Cylindrical	■
5540750R030Z4.0-SIRON-A	02711647	2	D	0.750	0.750	1.500	4.000	0.030	4	Cylindrical	■
5540750R060Z4.0-SIRON-A	02711655	2	D	0.750	0.750	1.500	4.000	0.060	4	Cylindrical	■

■ Lagerstandard.

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Weldon – Fase – Zoll





D

—Toleranzen:
—DMM=h5
—DC=e7
—Nachschleifen möglich



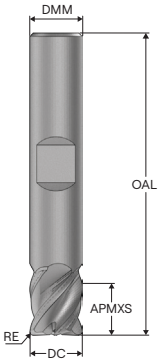
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
				Zoll	Zoll	Zoll	Zoll	Zoll			
5540500Z4.3-SIRON-A	02711608	2	D	0.500	0.500	1.000	3.500	0.006	4	Weldon	■
5540750Z4.3-SIRON-A	02711632	2	D	0.750	0.750	1.500	4.000	0.010	4	Weldon	■

■ **Lagerstandard.**

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Weldon – Eckenradius – Zoll





D



—Toleranzen:
—DMM=h5
—DC=e7
—RE= ±.0008 *Zoll*
—Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				Zoll	Zoll	Zoll	Zoll	Zoll			
5540500R015Z4.3-SIRON-A	02711613	2	D	0.500	0.500	1.000	3.500	0.015	4	Weldon	■
5540500R030Z4.3-SIRON-A	02711615	2	D	0.500	0.500	1.000	3.500	0.030	4	Weldon	■
5540500R125Z4.3-SIRON-A	02856456	2	D	0.500	0.500	1.000	3.500	0.125	4	Weldon	□
5540625R125Z4.3-SIRON-A	02856457	2	D	0.625	0.625	1.250	3.750	0.125	4	Weldon	□
5541000R060Z4.3-SIRON-A	02711663	2	D	1.000	1.000	2.000	5.000	0.060	4	Weldon	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JS554 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z										v_c
				3	4	5	6	8	10	12	16	20	25	
P1	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	215 (190 — 240) *710 (630 — 780)*
P2	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	210 (190 — 240) *690 (630 — 780)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	185 (160 — 200) *610 (530 — 650)*
P4	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	160 (140 — 180) *520 (460 — 590)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	155 (140 — 170) *510 (460 — 550)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	175 (160 — 200) *570 (530 — 650)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	165 (150 — 180) *540 (500 — 590)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	155 (140 — 170) *510 (460 — 550)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	140 (130 — 150) *460 (430 — 490)*
P12	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79 — 100) *295 (260 — 320)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	110 (96 — 120) *360 (320 — 390)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79 — 100) *295 (260 — 320)*
M3	E	0.400 *0,400*	0.90 *0,90*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	55 (45 — 66) *180 (150 — 210)*
M4	E	0.400 *0,400*	0.90 *0,90*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	43 (35 — 51) *140 (120 — 160)*
M5	E	0.400 *0,400*	0.90 *0,90*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	36 (29 — 42) *120 (96 — 130)*
K1	E	0.400 *0,400*	1.2 *1,2*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	175 (160 — 190) *570 (530 — 620)*
K2	E	0.400 *0,400*	1.2 *1,2*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	155 (140 — 170) *510 (460 — 550)*
K3	E	0.400 *0,400*	1.2 *1,2*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	130 (120 — 140) *425 (400 — 450)*
K4	E	0.400 *0,400*	1.2 *1,2*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	125 (110 — 140) *410 (370 — 450)*
K5	E	0.400 *0,400*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	155 (140 — 170) *510 (460 — 550)*
K6	E	0.400 *0,400*	1.0 *1,0*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	220 (190 — 250) *720 (630 — 820)*
K7	E	0.400 *0,400*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	195 (170 — 220) *640 (560 — 720)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS554 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z										v_c
				3	4	5	6	8	10	12	16	20	25	
N1	E	0.500 *0,500*	0.90 *0,90*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	610 (510 — 710) *2000 (1700 — 2300)*
N2	E	0.500 *0,500*	0.90 *0,90*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	390 (330 — 450) *1275 (1100 — 1400)*
N11	E	0.500 *0,500*	1.1 *1,1*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	320 (270 — 370) *1050 (890 — 1200)*
S11	E	0.400 *0,400*	0.70 *0,70*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	100 (72 — 120) *330 (240 — 390)*
S12	E	0.400 *0,400*	0.70 *0,70*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	75 (56 — 99) *245 (190 — 320)*
S13	E	0.400 *0,400*	0.70 *0,70*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	60 (44 — 78) *195 (150 — 250)*
H5	M/A/D	0.200 *0,200*	0.90 *0,90*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	75 (59 — 88) *245 (200 — 280)*
H8	M/A/D	0.200 *0,200*	0.90 *0,90*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	80 (63 — 93) *260 (210 — 300)*
H11	M/A/D	0.200 *0,200*	0.90 *0,90*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	95 (75 — 110) *310 (250 — 360)*
H12	M/A/D	0.200 *0,200*	0.90 *0,90*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	90 (73 — 100) *295 (240 — 320)*
H21	M/A/D	0.200 *0,200*	0.90 *0,90*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	155 (110 — 190) *510 (370 — 620)*
TS1	A	0.500 *0,500*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	285 (180 — 400) *940 (600 — 1300)*
TP1	A	0.500 *0,500*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	295 (180 — 410) *970 (600 — 1300)*
GR1	A	0.500 *0,500*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	580 (470 — 690) *1900 (1600 — 2200)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS554 Nutfräsen

SMG		a_p/DC	f_z										v_c
			3	4	5	6	8	10	12	16	20	25	
P1	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	195 (170 — 220)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*640 (560 — 720)*
P2	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	190 (170 — 210)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*620 (560 — 680)*
P3	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	165 (140 — 180)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*540 (460 — 590)*
P4	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	145 (130 — 160)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*475 (430 — 520)*
P5	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	135 (120 — 150)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*445 (400 — 490)*
P6	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	155 (140 — 170)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*510 (460 — 550)*
P7	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	145 (130 — 160)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*475 (430 — 520)*
P8	M/A/D/E	1.0	0.018	0.024	0.030	0.036	0.048	0.060	0.070	0.095	0.12	0.15	135 (120 — 150)
		1,0	*0,00070*	*0,00095*	*0,0012*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0060*	*445 (400 — 490)*
P11	M/A/D/E	0.80	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.065	0.080	0.10	130 (120 — 140)
		0,80	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0040*	*425 (400 — 450)*
P12	M/A/D/E	0.80	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.065	0.080	0.10	80 (69 — 87)
		0,80	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0040*	*260 (230 — 280)*
M1	E	0.80	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.065	0.080	0.10	95 (85 — 100)
		0,80	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0040*	*310 (280 — 320)*
M2	E	0.80	0.012	0.016	0.020	0.024	0.032	0.040	0.048	0.065	0.080	0.10	80 (69 — 87)
		0,80	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0026*	*0,0032*	*0,0040*	*260 (230 — 280)*
M3	E	0.60	0.0095	0.013	0.016	0.019	0.025	0.032	0.038	0.050	0.065	0.080	48 (39 — 57)
		0,60	*0,00038*	*0,00050*	*0,00065*	*0,00075*	*0,0010*	*0,0013*	*0,0015*	*0,0020*	*0,0026*	*0,0032*	*155 (130 — 180)*
M4	E	0.60	0.0095	0.013	0.016	0.019	0.025	0.032	0.038	0.050	0.065	0.080	36 (29 — 43)
		0,60	*0,00038*	*0,00050*	*0,00065*	*0,00075*	*0,0010*	*0,0013*	*0,0015*	*0,0020*	*0,0026*	*0,0032*	*120 (96 — 140)*
M5	E	0.60	0.0095	0.013	0.016	0.019	0.025	0.032	0.038	0.050	0.065	0.080	30 (25 — 36)
		0,60	*0,00038*	*0,00050*	*0,00065*	*0,00075*	*0,0010*	*0,0013*	*0,0015*	*0,0020*	*0,0026*	*0,0032*	*100 (83 — 110)*
K1	E	1.0	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	155 (140 — 170)
		1,0	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*510 (460 — 550)*
K2	E	1.0	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	135 (120 — 150)
		1,0	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*445 (400 — 490)*
K3	E	1.0	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	115 (110 — 120)
		1,0	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*375 (370 — 390)*
K4	E	1.0	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	110 (96 — 120)
		1,0	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*360 (320 — 390)*
K5	E	0.70	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	135 (120 — 150)
		0,70	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*445 (400 — 490)*
K6	E	0.70	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	200 (180 — 220)
		0,70	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*660 (600 — 720)*
K7	E	0.70	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.080	0.10	0.13	175 (150 — 190)
		0,70	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0050*	*570 (500 — 620)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS554 Nutfräsen

SMG		a_p/DC	f_z										v_c
			3	4	5	6	8	10	12	16	20	25	
N1	E	0.50 *0,50*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	570 (480 — 670) *1875 (1600 — 2100)*
N2	E	0.50 *0,50*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	370 (310 — 430) *1225 (1100 — 1400)*
N3	E	0.50 *0,50*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	245 (210 — 280) *800 (690 — 910)*
N11	E	0.60 *0,60*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	290 (250 — 330) *950 (830 — 1000)*
S1	E	0.30 *0,30*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	30 (25 — 34) *100 (83 — 110)*
S2	E	0.30 *0,30*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	27 (17 — 38) *90 (56 — 120)*
S3	E	0.30 *0,30*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	23 (15 — 32) *75 (50 — 100)*
S11	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	85 (63 — 110) *280 (210 — 360)*
S12	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	65 (48 — 86) *215 (160 — 280)*
S13	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	50 (38 — 66) *165 (130 — 210)*
H5	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52 — 76) *215 (180 — 240)*
H8	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	65 (52 — 76) *215 (180 — 240)*
H11	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	80 (66 — 97) *260 (220 — 310)*
H12	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	75 (60 — 89) *245 (200 — 290)*
H21	M/A/D	0.40 *0,40*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	125 (90 — 160) *410 (300 — 520)*
TS1	A	0.70 *0,70*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	240 (150 — 330) *790 (500 — 1000)*
TP1	A	0.70 *0,70*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	250 (150 — 340) *820 (500 — 1100)*
GR1	A	0.80 *0,80*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	485 (390 — 580) *1600 (1300 — 1900)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS554 Eckfräsen/Schruppen – Zoll

SMG		a_e/DC	a_p/DC	f_z							v_c
				1/4	5/16	3/8	1/2	5/8	3/4	1	
P1	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	215 (190 — 240) *710 (630 — 780)*
P2	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	210 (190 — 240) *690 (630 — 780)*
P3	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	185 (160 — 200) *610 (530 — 650)*
P4	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.18 *0,0070*	160 (140 — 180) *520 (460 — 590)*
P5	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.18 *0,0070*	155 (140 — 170) *510 (460 — 550)*
P6	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.18 *0,0070*	175 (160 — 200) *570 (530 — 650)*
P7	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.18 *0,0070*	165 (150 — 180) *540 (500 — 590)*
P8	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	155 (140 — 170) *510 (460 — 550)*
P11	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	140 (130 — 150) *460 (430 — 490)*
P12	M/A/D/E	0.400 *0,400*	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79 — 100) *295 (260 — 320)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	110 (96 — 120) *360 (320 — 390)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79 — 100) *295 (260 — 320)*
M3	E	0.400 *0,400*	0.90 *0,90*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	55 (45 — 66) *180 (150 — 210)*
M4	E	0.400 *0,400*	0.90 *0,90*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	43 (35 — 51) *140 (120 — 160)*
M5	E	0.400 *0,400*	0.90 *0,90*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	36 (29 — 42) *120 (96 — 130)*
K1	E	0.400 *0,400*	1.2 *1,2*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	175 (160 — 190) *570 (530 — 620)*
K2	E	0.400 *0,400*	1.2 *1,2*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	155 (140 — 170) *510 (460 — 550)*
K3	E	0.400 *0,400*	1.2 *1,2*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	130 (120 — 140) *425 (400 — 450)*
K4	E	0.400 *0,400*	1.2 *1,2*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	125 (110 — 140) *410 (370 — 450)*
K5	E	0.400 *0,400*	1.0 *1,0*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	155 (140 — 170) *510 (460 — 550)*
K6	E	0.400 *0,400*	1.0 *1,0*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	220 (190 — 250) *720 (630 — 820)*
K7	E	0.400 *0,400*	1.0 *1,0*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	195 (170 — 220) *640 (560 — 720)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS554 Eckfräsen/Schruppen – Zoll

SMG		a_e/DC	a_p/DC	f_z							v_c
				1/4	5/16	3/8	1/2	5/8	3/4	1	
N1	E	0.500 *0,500*	0.90 *0,90*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	610 (510 — 710) *2000 (1700 — 2300)*
N2	E	0.500 *0,500*	0.90 *0,90*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	390 (330 — 450) *1275 (1100 — 1400)*
N3	E	0.500 *0,500*	0.90 *0,90*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	260 (220 — 300) *850 (730 — 980)*
N11	E	0.500 *0,500*	1.1 *1,1*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	320 (270 — 370) *1050 (890 — 1200)*
S1	E	0.150 *0,150*	0.50 *0,50*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.17 *0,0065*	38 (32 — 44) *125 (110 — 140)*
S2	E	0.150 *0,150*	0.50 *0,50*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.17 *0,0065*	35 (21 — 48) *115 (69 — 150)*
S3	E	0.150 *0,150*	0.50 *0,50*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.16 *0,0065*	30 (19 — 42) *100 (63 — 130)*
S11	E	0.400 *0,400*	0.70 *0,70*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	100 (72 — 120) *330 (240 — 390)*
S12	E	0.400 *0,400*	0.70 *0,70*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	75 (56 — 99) *245 (190 — 320)*
S13	E	0.400 *0,400*	0.70 *0,70*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	60 (44 — 78) *195 (150 — 250)*
H5	M/A/D	0.200 *0,200*	0.90 *0,90*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.15 *0,0060*	75 (59 — 88) *245 (200 — 280)*
H8	M/A/D	0.200 *0,200*	0.90 *0,90*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	80 (63 — 93) *260 (210 — 300)*
H21	M/A/D	0.200 *0,200*	0.90 *0,90*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	155 (110 — 190) *510 (370 — 620)*
H31	M/A/D	0.200 *0,200*	0.90 *0,90*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.080 *0,0032*	0.095 *0,0038*	60 (48 — 71) *195 (160 — 230)*
TS1	A	0.500 *0,500*	1.0 *1,0*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	285 (180 — 400) *940 (600 — 1300)*
TP1	A	0.500 *0,500*	1.0 *1,0*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	295 (180 — 410) *970 (600 — 1300)*
GR1	A	0.500 *0,500*	1.1 *1,1*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	580 (470 — 690) *1900 (1600 — 2200)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS554 Nutfräsen – Zoll

SMG		a_p/DC	f_z							v_c
			1/4	5/16	3/8	1/2	5/8	3/4	1	
P1	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	195 (170 — 220) *640 (560 — 720)*
P2	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	190 (170 — 210) *620 (560 — 680)*
P3	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	165 (140 — 180) *540 (460 — 590)*
P4	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	145 (130 — 160) *475 (430 — 520)*
P5	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	135 (120 — 150) *445 (400 — 490)*
P6	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	155 (140 — 170) *510 (460 — 550)*
P7	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	145 (130 — 160) *475 (430 — 520)*
P8	M/A/D/E	1.0 *1,0*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	135 (120 — 150) *445 (400 — 490)*
P11	M/A/D/E	0.80 *0,80*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	130 (120 — 140) *425 (400 — 450)*
P12	M/A/D/E	0.80 *0,80*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	80 (69 — 87) *260 (230 — 280)*
M1	E	0.80 *0,80*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	95 (85 — 100) *310 (280 — 320)*
M2	E	0.80 *0,80*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	80 (69 — 87) *260 (230 — 280)*
M3	E	0.60 *0,60*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	48 (39 — 57) *155 (130 — 180)*
M4	E	0.60 *0,60*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	36 (29 — 43) *120 (96 — 140)*
M5	E	0.60 *0,60*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	30 (25 — 36) *100 (83 — 110)*
K1	E	1.0 *1,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	155 (140 — 170) *510 (460 — 550)*
K2	E	1.0 *1,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	135 (120 — 150) *445 (400 — 490)*
K3	E	1.0 *1,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	115 (110 — 120) *375 (370 — 390)*
K4	E	1.0 *1,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	110 (96 — 120) *360 (320 — 390)*
K5	E	0.70 *0,70*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	135 (120 — 150) *445 (400 — 490)*
K6	E	0.70 *0,70*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	200 (180 — 220) *660 (600 — 720)*
K7	E	0.70 *0,70*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	175 (150 — 190) *570 (500 — 620)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS554 Nutfräsen – Zoll

SMG		a_p/DC	f_z							v_c
			1/4	5/16	3/8	1/2	5/8	3/4	1	
N1	E	0.50 *0,50*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	570 (480 — 670) *1875 (1600 — 2100)*
N2	E	0.50 *0,50*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	370 (310 — 430) *1225 (1100 — 1400)*
N3	E	0.50 *0,50*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	245 (210 — 280) *800 (690 — 910)*
N11	E	0.60 *0,60*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	290 (250 — 330) *950 (830 — 1000)*
S1	E	0.30 *0,30*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	30 (25 — 34) *100 (83 — 110)*
S2	E	0.30 *0,30*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	27 (17 — 38) *90 (56 — 120)*
S3	E	0.30 *0,30*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	23 (15 — 32) *75 (50 — 100)*
S11	E	0.50 *0,50*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	85 (63 — 110) *280 (210 — 360)*
S12	E	0.50 *0,50*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	65 (48 — 86) *215 (160 — 280)*
S13	E	0.50 *0,50*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	50 (38 — 66) *165 (130 — 210)*
H5	M/A/D	0.40 *0,40*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	65 (52 — 76) *215 (180 — 240)*
H8	M/A/D	0.40 *0,40*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	65 (52 — 76) *215 (180 — 240)*
H21	M/A/D	0.40 *0,40*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	125 (90 — 160) *410 (300 — 520)*
H31	M/A/D	0.40 *0,40*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	48 (39 — 57) *155 (130 — 180)*
TS1	A	0.70 *0,70*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	240 (150 — 330) *790 (500 — 1000)*
TP1	A	0.70 *0,70*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	250 (150 — 340) *820 (500 — 1100)*
GR1	A	0.80 *0,80*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	485 (390 — 580) *1600 (1300 — 1900)*

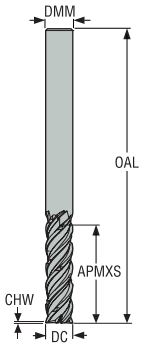
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JS554-3C

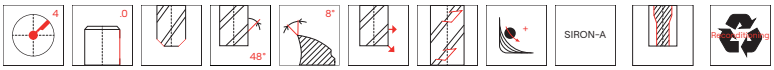
Dynamisches Fräsen – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Fase





D

- Toleranzen:
- DMM= h5
- DC= e7
- Nachschleifen möglich



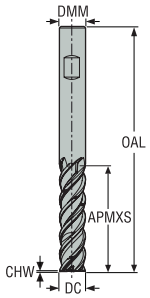
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JS554060D3C.0Z4C-SIRA	02810475	3	D	■	6,0	6,0	23,0	65,0	0,075	4	Cylindrical	■
JS554080D3C.0Z4C-SIRA	02810477	3	D	■	8,0	8,0	32,0	75,0	0,1	4	Cylindrical	■
JS554100D3C.0Z4C-SIRA	02810479	3	D	■	10,0	10,0	40,0	85,0	0,125	4	Cylindrical	■
JS554120D3C.0Z4C-SIRA	02810481	3	D	■	12,0	12,0	45,0	100,0	0,15	4	Cylindrical	■
JS554160D3C.0Z4C-SIRA	02810483	3	D	■	16,0	16,0	55,0	115,0	0,2	4	Cylindrical	■
JS554200D3C.0Z4C-SIRA	02810485	3	D	■	20,0	20,0	65,0	125,0	0,25	4	Cylindrical	■
JS554250D3C.0Z4C-SIRA	02810486	3	D	■	25,0	25,0	85,0	150,0	0,3	4	Cylindrical	■

■ **Lagerstandard.**

JS554-3C

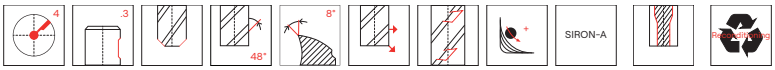
Dynamisches Fräsen – Universell – Eckfräser – 4 Schneiden – Weldon – Fase





D

—Toleranzen:
—DMM= h5
—DC= e7
—Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JS554060D3C.3Z4C-SIRA	02810474	3	D	■	6,0	6,0	23,0	65,0	0,075	4	Weldon	■
JS554080D3C.3Z4C-SIRA	02810476	3	D	■	8,0	8,0	32,0	75,0	0,1	4	Weldon	■
JS554100D3C.3Z4C-SIRA	02810478	3	D	■	10,0	10,0	40,0	85,0	0,125	4	Weldon	■
JS554120D3C.3Z4C-SIRA	02810480	3	D	■	12,0	12,0	45,0	100,0	0,15	4	Weldon	■
JS554160D3C.3Z4C-SIRA	02810482	3	D	■	16,0	16,0	55,0	115,0	0,2	4	Weldon	■
JS554200D3C.3Z4C-SIRA	02810484	3	D	■	20,0	20,0	65,0	125,0	0,25	4	Weldon	■
JS554250D3C.3Z4C-SIRA	02810487	3	D	■	25,0	25,0	85,0	150,0	0,3	4	Weldon	■

■ **Lagerstandard.**

Schnittdaten – JS554-3C Dynamisches Fräsen

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
P1	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	350 (320 — 380) *1150 (1100 — 1200)*
P2	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	340 (310 — 370) *1125 (1100 — 1200)*
P3	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	295 (270 — 320) *970 (890 — 1000)*
P4	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	260 (240 — 280) *850 (790 — 910)*
P5	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	250 (230 — 270) *820 (760 — 880)*
P6	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	280 (260 — 300) *920 (860 — 980)*
P7	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	265 (240 — 290) *870 (790 — 950)*
P8	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	250 (230 — 270) *820 (760 — 880)*
P11	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	245 (230 — 270) *800 (760 — 880)*
P12	M/A/D/E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	150 (140 — 160) *490 (460 — 520)*
M1	E	0.100 *0,100*	3.6 *3,6*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	180 (160 — 210) *590 (530 — 680)*
M2	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	150 (130 — 170) *490 (430 — 550)*
M3	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	100 (90 — 100) *330 (300 — 320)*
M4	E	0.100 *0,100*	3.6 *3,6*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	75 (70 — 85) *245 (230 — 270)*
M5	E	0.100 *0,100*	3.6 *3,6*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	65 (59 — 71) *215 (200 — 230)*
K1	E	0.100 *0,100*	3.6 *3,6*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	340 (310 — 370) *1125 (1100 — 1200)*
K2	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	185 (160 — 210) *610 (530 — 680)*
K3	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	255 (240 — 280) *840 (790 — 910)*
K4	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	245 (220 — 260) *800 (730 — 850)*
K5	E	0.100 *0,100*	3.6 *3,6*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	150 (140 — 160) *490 (460 — 520)*
K6	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	215 (200 — 230) *710 (660 — 750)*
K7	E	0.100 *0,100*	3.6 *3,6*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	190 (180 — 200) *620 (600 — 650)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS554-3C Dynamisches Fräsen

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
N1	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	750 (650 — 840) *2450 (2200 — 2700)*
N2	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	480 (420 — 540) *1575 (1400 — 1700)*
N3	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	320 (280 — 360) *1050 (920 — 1100)*
N11	E	0.100 *0,100*	3.6 *3,6*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	375 (330 — 420) *1225 (1100 — 1300)*
S1	E	0.0500 *0,0500*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	50 (40 — 60) *165 (140 — 190)*
S2	E	0.0500 *0,0500*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	40 (33 — 48) *130 (110 — 150)*
S3	E	0.0500 *0,0500*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	25 (20 — 29) *80 (66 — 95)*
S11	E	0.100 *0,100*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	195 (130 — 220) *640 (430 — 720)*
S12	E	0.100 *0,100*	3.6 *3,6*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	150 (100 — 160) *490 (330 — 520)*
S13	E	0.100 *0,100*	3.6 *3,6*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	120 (80 — 130) *395 (270 — 420)*
H5	M/A/D	0.0500 *0,0500*	3.6 *3,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	200 (190 — 220) *660 (630 — 720)*
H8	M/A/D	0.0500 *0,0500*	3.6 *3,6*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	210 (190 — 220) *690 (630 — 720)*
H11	M/A/D	0.0500 *0,0500*	3.6 *3,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	255 (240 — 280) *840 (790 — 910)*
H12	M/A/D	0.100 *0,100*	3.6 *3,6*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	205 (190 — 220) *670 (630 — 720)*
H21	M/A/D	0.0500 *0,0500*	3.6 *3,6*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	210 (190 — 220) *690 (630 — 720)*

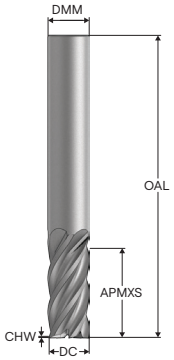
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

ST5551

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Zylindrisch – Fase





– Toleranzen:
– DMM=h5
– DC=e7
– Nachschleifen möglich



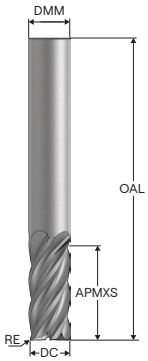
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	CHW	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm			
ST5551-060D2C.0Z5	SIRA	10303332	2	D	6,0	6,0	14,0	58,0	0,075	5	Cylindrical	■
ST5551-080D2C.0Z5	SIRA	10303333	2	D	8,0	8,0	18,0	64,0	0,1	5	Cylindrical	■
ST5551-100D2C.0Z5	SIRA	10303334	2	D	10,0	10,0	22,0	73,0	0,125	5	Cylindrical	■
ST5551-120D2C.0Z5	SIRA	10303335	2	D	12,0	12,0	26,0	84,0	0,15	5	Cylindrical	■
ST5551-160D2C.0Z5	SIRA	10303336	2	D	16,0	16,0	34,0	95,0	0,2	5	Cylindrical	■
ST5551-200D2C.0Z5	SIRA	10303337	2	D	20,0	20,0	42,0	109,0	0,25	5	Cylindrical	■
ST5551-250D2C.0Z5	SIRA	10303338	2	D	25,0	25,0	52,0	125,0	0,3	5	Cylindrical	■
ST5551-060D3C.0Z5	SIRA	10303339	3	D	6,0	6,0	23,0	64,0	0,075	5	Cylindrical	■
ST5551-080D3C.0Z5	SIRA	10303340	3	D	8,0	8,0	32,0	73,0	0,1	5	Cylindrical	■
ST5551-100D3C.0Z5	SIRA	10303341	3	D	10,0	10,0	40,0	85,0	0,125	5	Cylindrical	■
ST5551-120D3C.0Z5	SIRA	10303342	3	D	12,0	12,0	45,0	100,0	0,15	5	Cylindrical	■
ST5551-160D3C.0Z5	SIRA	10303343	3	D	16,0	16,0	55,0	115,0	0,2	5	Cylindrical	■
ST5551-200D3C.0Z5	SIRA	10303344	3	D	20,0	20,0	65,0	125,0	0,25	5	Cylindrical	■
ST5551-250D3C.0Z5	SIRA	10303345	3	D	25,0	25,0	85,0	155,0	0,3	5	Cylindrical	■

■ **Lagerstandard.**

ST5551

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Zylindrisch – Eckenradius





- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich



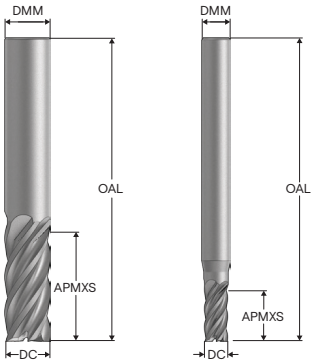
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
ST5551-060D2R050.0Z5	SIRA	10303346	2	D	6,0	6,0	14,0	58,0	0,5	5	Cylindrical	■
ST5551-080D2R050.0Z5	SIRA	10303347	2	D	8,0	8,0	18,0	64,0	0,5	5	Cylindrical	■
ST5551-100D2R050.0Z5	SIRA	10303348	2	D	10,0	10,0	22,0	73,0	0,5	5	Cylindrical	■
ST5551-120D2R050.0Z5	SIRA	10303349	2	D	12,0	12,0	26,0	84,0	0,5	5	Cylindrical	■
ST5551-120D2R100.0Z5	SIRA	10303350	2	D	12,0	12,0	26,0	84,0	1,0	5	Cylindrical	■
ST5551-160D2R050.0Z5	SIRA	10303351	2	D	16,0	16,0	34,0	95,0	0,5	5	Cylindrical	■
ST5551-160D2R100.0Z5	SIRA	10303352	2	D	16,0	16,0	34,0	95,0	1,0	5	Cylindrical	■
ST5551-200D2R050.0Z5	SIRA	10303353	2	D	20,0	20,0	42,0	109,0	0,5	5	Cylindrical	■
ST5551-200D2R100.0Z5	SIRA	10303354	2	D	20,0	20,0	42,0	109,0	1,0	5	Cylindrical	■
ST5551-250D2R050.0Z5	SIRA	10303355	2	D	25,0	25,0	52,0	125,0	0,5	5	Cylindrical	■
ST5551-250D2R100.0Z5	SIRA	10303356	2	D	25,0	25,0	52,0	125,0	1,0	5	Cylindrical	■
ST5551-060D3R050.0Z5	SIRA	10303357	3	D	6,0	6,0	23,0	64,0	0,5	5	Cylindrical	■
ST5551-080D3R050.0Z5	SIRA	10303358	3	D	8,0	8,0	32,0	73,0	0,5	5	Cylindrical	■
ST5551-100D3R050.0Z5	SIRA	10303359	3	D	10,0	10,0	40,0	85,0	0,5	5	Cylindrical	■
ST5551-120D3R050.0Z5	SIRA	10303360	3	D	12,0	12,0	45,0	100,0	0,5	5	Cylindrical	■
ST5551-120D3R100.0Z5	SIRA	10303361	3	D	12,0	12,0	45,0	100,0	1,0	5	Cylindrical	■
ST5551-160D3R050.0Z5	SIRA	10303362	3	D	16,0	16,0	55,0	115,0	0,5	5	Cylindrical	■
ST5551-160D3R100.0Z5	SIRA	10303363	3	D	16,0	16,0	55,0	115,0	1,0	5	Cylindrical	■
ST5551-200D3R050.0Z5	SIRA	10303364	3	D	20,0	20,0	65,0	125,0	0,5	5	Cylindrical	■
ST5551-200D3R100.0Z5	SIRA	10303365	3	D	20,0	20,0	65,0	125,0	1,0	5	Cylindrical	■
ST5551-250D3R050.0Z5	SIRA	10303366	3	D	25,0	25,0	85,0	155,0	0,5	5	Cylindrical	■
ST5551-250D3R100.0Z5	SIRA	10303367	3	D	25,0	25,0	85,0	155,0	1,0	5	Cylindrical	■

■ Lagerstandard.

ST5551

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Zylindrisch – Scharfe Schneide – Zoll





—Toleranzen:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—Nachschleifen möglich, wenn DC ≥ Ø.250 ist



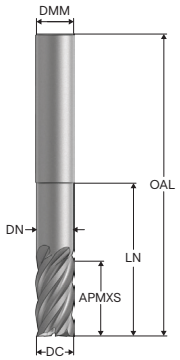
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll			
ST5551-.250D1S.0Z5	SIRA	10303040	1	D	0.250	0.250	0.375	2.000	5	Cylindrical	■
ST5551-.375D1S.0Z5	SIRA	10303041	1	D	0.375	0.375	0.500	2.500	5	Cylindrical	■
ST5551-.500D1S.0Z5	SIRA	10303042	1	D	0.500	0.500	0.625	3.000	5	Cylindrical	■
ST5551-.625D1S.0Z5	SIRA	10303043	1	D	0.625	0.625	0.750	3.000	5	Cylindrical	■
ST5551-.750D1S.0Z5	SIRA	10303044	1	D	0.750	0.750	0.875	3.000	5	Cylindrical	■
ST5551-.125D2S.0Z5	SIRA	10303045	2	D	0.125	0.125	0.250	1.500	5	Cylindrical	■
ST5551-.156F2S.0Z5	SIRA	10303046	2	F	0.156	0.188	0.313	2.000	5	Cylindrical	■
ST5551-.188D2S.0Z5	SIRA	10303047	2	D	0.188	0.188	0.313	2.000	5	Cylindrical	■
ST5551-.219F2S.0Z5	SIRA	10303048	2	F	0.219	0.250	0.375	2.000	5	Cylindrical	■
ST5551-.313D2S.0Z5	SIRA	10303049	2	D	0.313	0.313	0.750	2.500	5	Cylindrical	■
ST5551-.375D2S.0Z5	SIRA	10303050	2	D	0.375	0.375	0.875	2.500	5	Cylindrical	■
ST5551-.500D2S.0Z5	SIRA	10303051	2	D	0.500	0.500	1.000	3.000	5	Cylindrical	■
ST5551-.625D2S.0Z5	SIRA	10303052	2	D	0.625	0.625	1.250	3.500	5	Cylindrical	■
ST5551-.750D2S.0Z5	SIRA	10303053	2	D	0.750	0.750	1.500	4.000	5	Cylindrical	■
ST5551-.188D3S.0Z5	SIRA	10303054	3	D	0.188	0.188	0.563	2.000	5	Cylindrical	■
ST5551-.219F3S.0Z5	SIRA	10303055	3	F	0.219	0.250	0.750	2.500	5	Cylindrical	■
ST5551-.250D3S.0Z5	SIRA	10303056	3	D	0.250	0.250	0.750	2.500	5	Cylindrical	■
ST5551-.500D3S.0Z5	SIRA	10303057	3	D	0.500	0.500	1.250	3.000	5	Cylindrical	■
ST5551-.125D4S.0Z5	SIRA	10303059	4	D	0.125	0.125	0.500	1.500	5	Cylindrical	■
ST5551-.156F4S.0Z5	SIRA	10303060	4	F	0.156	0.188	0.563	2.000	5	Cylindrical	■
ST5551-.625D4S.0Z5	SIRA	10303065	4	D	0.625	0.625	1.625	3.500	5	Cylindrical	■
ST5551-.625D5S.0Z5	SIRA	10303070	5	D	0.625	0.625	2.125	4.000	5	Cylindrical	■

■ **Lagerstandard.**

ST5551

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Zylindrisch – Scharfe Schneide – Zoll





—Toleranzen:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—Nachschleifen möglich



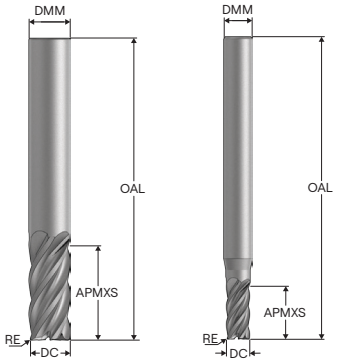
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll	Zoll			
ST5551-.750E3S.0Z5	SIRA	10303058	3	E	0.750	0.750	1.125	5.000	2.500	0.720	5	Cylindrical	■
ST5551-.250E4S.0Z5	SIRA	10303061	4	E	0.250	0.250	0.500	3.000	1.000	0.240	5	Cylindrical	■
ST5551-.375E4S.0Z5	SIRA	10303062	4	E	0.375	0.375	0.750	3.000	1.500	0.360	5	Cylindrical	■
ST5551-.500E4S.0Z5	SIRA	10303063	4	E	0.500	0.500	1.000	4.000	2.000	0.480	5	Cylindrical	■
ST5551-.625E4S.0Z5	SIRA	10303064	4	E	0.625	0.625	1.250	5.000	2.500	0.600	5	Cylindrical	■
ST5551-.750E4S.0Z5	SIRA	10303066	4	E	0.750	0.750	1.500	5.000	3.000	0.720	5	Cylindrical	■
ST5551-.250E5S.0Z5	SIRA	10303067	5	E	0.250	0.250	0.500	4.000	1.250	0.240	5	Cylindrical	■
ST5551-.375E5S.0Z5	SIRA	10303068	5	E	0.375	0.375	0.500	4.000	2.125	0.360	5	Cylindrical	■
ST5551-.625E5S.0Z5	SIRA	10303069	5	E	0.625	0.625	0.750	6.000	3.375	0.600	5	Cylindrical	■
ST5551-.750E5S.0Z5	SIRA	10303071	5	E	0.750	0.750	1.125	6.000	4.125	0.720	5	Cylindrical	■
ST5551-.500E6S.0Z5	SIRA	10303072	6	E	0.500	0.500	0.625	5.000	3.125	0.480	5	Cylindrical	■
ST5551-.250E8S.0Z5	SIRA	10303073	8	E	0.250	0.250	0.500	4.000	2.125	0.240	5	Cylindrical	■
ST5551-.375E8S.0Z5	SIRA	10303074	8	E	0.375	0.375	0.500	6.000	3.125	0.360	5	Cylindrical	■
ST5551-.500E8S.0Z5	SIRA	10303075	8	E	0.500	0.500	0.625	6.000	4.125	0.480	5	Cylindrical	■

■ **Lagerstandard.**

ST5551

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Zylindrisch – Eckenradius – Zoll





—Toleranzen:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Nachschleifen möglich, wenn DC ≥ Ø.250 ist



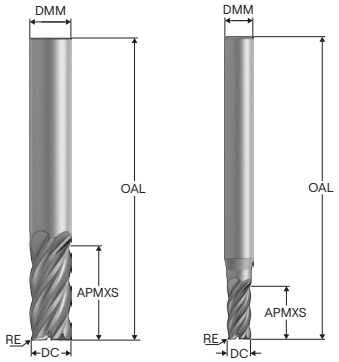
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll			
ST5551-.250D1R015.0Z5	SIRA	10303076	1	D	0.250	0.250	0.375	2.000	0.015	5	Cylindrical	■
ST5551-.250D1R030.0Z5	SIRA	10303077	1	D	0.250	0.250	0.375	2.000	0.030	5	Cylindrical	■
ST5551-.250D1R045.0Z5	SIRA	10303078	1	D	0.250	0.250	0.375	2.000	0.045	5	Cylindrical	■
ST5551-.375D1R015.0Z5	SIRA	10303079	1	D	0.375	0.375	0.500	2.500	0.015	5	Cylindrical	■
ST5551-.375D1R030.0Z5	SIRA	10303080	1	D	0.375	0.375	0.500	2.500	0.030	5	Cylindrical	■
ST5551-.375D1R045.0Z5	SIRA	10303081	1	D	0.375	0.375	0.500	2.500	0.045	5	Cylindrical	■
ST5551-.500D1R015.0Z5	SIRA	10303082	1	D	0.500	0.500	0.625	3.000	0.015	5	Cylindrical	■
ST5551-.500D1R030.0Z5	SIRA	10303083	1	D	0.500	0.500	0.625	3.000	0.030	5	Cylindrical	■
ST5551-.500D1R045.0Z5	SIRA	10303084	1	D	0.500	0.500	0.625	3.000	0.045	5	Cylindrical	■
ST5551-.500D1R060.0Z5	SIRA	10303085	1	D	0.500	0.500	0.625	3.000	0.060	5	Cylindrical	■
ST5551-.500D1R120.0Z5	SIRA	10303086	1	D	0.500	0.500	0.625	3.000	0.120	5	Cylindrical	■
ST5551-.625D1R015.0Z5	SIRA	10303087	1	D	0.625	0.625	0.750	3.000	0.015	5	Cylindrical	■
ST5551-.625D1R030.0Z5	SIRA	10303088	1	D	0.625	0.625	0.750	3.000	0.030	5	Cylindrical	■
ST5551-.625D1R060.0Z5	SIRA	10303089	1	D	0.625	0.625	0.750	3.000	0.060	5	Cylindrical	■
ST5551-.625D1R120.0Z5	SIRA	10303090	1	D	0.625	0.625	0.750	3.000	0.120	5	Cylindrical	■
ST5551-.750D1R030.0Z5	SIRA	10303091	1	D	0.750	0.750	0.875	3.000	0.030	5	Cylindrical	■
ST5551-.750D1R060.0Z5	SIRA	10303092	1	D	0.750	0.750	0.875	3.000	0.060	5	Cylindrical	■
ST5551-.750D1R120.0Z5	SIRA	10303093	1	D	0.750	0.750	0.875	3.000	0.120	5	Cylindrical	■
ST5551-.125D2R010.0Z5	SIRA	10303094	2	D	0.125	0.125	0.250	1.500	0.010	5	Cylindrical	■
ST5551-.156F2R010.0Z5	SIRA	10303095	2	F	0.156	0.188	0.313	2.000	0.010	5	Cylindrical	■
ST5551-.188D2R010.0Z5	SIRA	10303096	2	D	0.188	0.188	0.313	2.000	0.010	5	Cylindrical	■
ST5551-.219F2R010.0Z5	SIRA	10303097	2	F	0.219	0.250	0.375	2.000	0.010	5	Cylindrical	■
ST5551-.313D2R015.0Z5	SIRA	10303098	2	D	0.313	0.313	0.750	2.500	0.015	5	Cylindrical	■
ST5551-.375D2R015.0Z5	SIRA	10303099	2	D	0.375	0.375	0.875	2.500	0.015	5	Cylindrical	■
ST5551-.375D2R030.0Z5	SIRA	10303100	2	D	0.375	0.375	0.875	2.500	0.030	5	Cylindrical	■
ST5551-.375D2R045.0Z5	SIRA	10303101	2	D	0.375	0.375	0.875	2.500	0.045	5	Cylindrical	■
ST5551-.375D2R060.0Z5	SIRA	10303102	2	D	0.375	0.375	0.875	2.500	0.060	5	Cylindrical	■
ST5551-.500D2R015.0Z5	SIRA	10303103	2	D	0.500	0.500	1.000	3.000	0.015	5	Cylindrical	■
ST5551-.500D2R030.0Z5	SIRA	10303104	2	D	0.500	0.500	1.000	3.000	0.030	5	Cylindrical	■
ST5551-.500D2R060.0Z5	SIRA	10303105	2	D	0.500	0.500	1.000	3.000	0.060	5	Cylindrical	■
ST5551-.625D2R015.0Z5	SIRA	10303106	2	D	0.625	0.625	1.250	3.500	0.015	5	Cylindrical	■
ST5551-.625D2R030.0Z5	SIRA	10303107	2	D	0.625	0.625	1.250	3.500	0.030	5	Cylindrical	■
ST5551-.625D2R045.0Z5	SIRA	10303108	2	D	0.625	0.625	1.250	3.500	0.045	5	Cylindrical	■
ST5551-.625D2R060.0Z5	SIRA	10303109	2	D	0.625	0.625	1.250	3.500	0.060	5	Cylindrical	■
ST5551-.625D2R090.0Z5	SIRA	10303110	2	D	0.625	0.625	1.250	3.500	0.090	5	Cylindrical	■
ST5551-.625D2R125.0Z5	SIRA	10303111	2	D	0.625	0.625	1.250	3.500	0.125	5	Cylindrical	■

■ **Lagerstandard.**

ST5551

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Zylindrisch – Eckenradius – Zoll





—Toleranzen:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Nachschleifen möglich, wenn DC ≥ Ø.250 ist



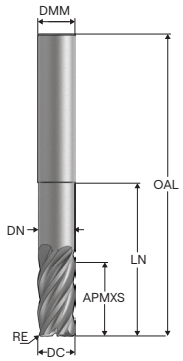
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll			
ST5551-.750D2R030.0Z5	SIRA	10303112	2	D	0.750	0.750	1.500	4.000	0.030	5	Cylindrical	■
ST5551-.750D2R060.0Z5	SIRA	10303113	2	D	0.750	0.750	1.500	4.000	0.060	5	Cylindrical	■
ST5551-.750D2R090.0Z5	SIRA	10303114	2	D	0.750	0.750	1.500	4.000	0.090	5	Cylindrical	■
ST5551-.750D2R125.0Z5	SIRA	10303115	2	D	0.750	0.750	1.500	4.000	0.125	5	Cylindrical	■
ST5551-1.00D2R015.0Z5	SIRA	10303116	2	D	1.000	1.000	1.750	4.000	0.015	5	Cylindrical	■
ST5551-1.00D2R030.0Z5	SIRA	10303117	2	D	1.000	1.000	1.750	4.000	0.030	5	Cylindrical	■
ST5551-1.00D2R060.0Z5	SIRA	10303118	2	D	1.000	1.000	1.750	4.000	0.060	5	Cylindrical	■
ST5551-.188D3R010.0Z5	SIRA	10303119	3	D	0.188	0.188	0.563	2.000	0.010	5	Cylindrical	■
ST5551-.219F3R010.0Z5	SIRA	10303120	3	F	0.219	0.250	0.750	2.500	0.010	5	Cylindrical	■
ST5551-.250D3R015.0Z5	SIRA	10303121	3	D	0.250	0.250	0.750	2.500	0.015	5	Cylindrical	■
ST5551-.250D3R030.0Z5	SIRA	10303122	3	D	0.250	0.250	0.750	2.500	0.030	5	Cylindrical	■
ST5551-.250D3R045.0Z5	SIRA	10303123	3	D	0.250	0.250	0.750	2.500	0.045	5	Cylindrical	■
ST5551-.375D3R030.0Z5	SIRA	10303124	3	D	0.375	0.375	1.250	3.000	0.030	5	Cylindrical	■
ST5551-.500D3R015.0Z5	SIRA	10303125	3	D	0.500	0.500	1.250	3.000	0.015	5	Cylindrical	■
ST5551-.500D3R030.0Z5	SIRA	10303126	3	D	0.500	0.500	1.250	3.000	0.030	5	Cylindrical	■
ST5551-.500D3R045.0Z5	SIRA	10303127	3	D	0.500	0.500	1.250	3.000	0.045	5	Cylindrical	■
ST5551-.500D3R060.0Z5	SIRA	10303128	3	D	0.500	0.500	1.250	3.000	0.060	5	Cylindrical	■
ST5551-.500D3R090.0Z5	SIRA	10303129	3	D	0.500	0.500	1.250	3.000	0.090	5	Cylindrical	■
ST5551-.500D3R125.0Z5	SIRA	10303130	3	D	0.500	0.500	1.250	3.000	0.125	5	Cylindrical	■
ST5551-.750D3R030.0Z5	SIRA	10303134	3	D	0.750	0.750	1.625	4.000	0.030	5	Cylindrical	■
ST5551-.125D4R010.0Z5	SIRA	10303138	4	D	0.125	0.125	0.500	1.500	0.010	5	Cylindrical	■
ST5551-.156F4R010.0Z5	SIRA	10303139	4	F	0.156	0.188	0.563	2.000	0.010	5	Cylindrical	■
ST5551-.250D4R015.0Z5	SIRA	10303142	4	D	0.250	0.250	1.000	3.000	0.015	5	Cylindrical	■
ST5551-.375D4R030.0Z5	SIRA	10303147	4	D	0.375	0.375	1.500	4.000	0.030	5	Cylindrical	■
ST5551-.500D4R030.0Z5	SIRA	10303152	4	D	0.500	0.500	1.625	4.000	0.030	5	Cylindrical	■
ST5551-.750D4R030.0Z5	SIRA	10303158	4	D	0.750	0.750	2.250	5.000	0.030	5	Cylindrical	■
ST5551-.500D5R030.0Z5	SIRA	10303165	5	D	0.500	0.500	2.000	4.000	0.030	5	Cylindrical	■
ST5551-.750D5R030.0Z5	SIRA	10303171	5	D	0.750	0.750	2.750	5.000	0.030	5	Cylindrical	■

■ Lagerstandard.

ST5551

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Zylindrisch – Eckenradius – Zoll





– Toleranzen:
– DMM= -.0001"/-.0004"
– DC= + .000" / - .002"
– RE= ±.0008"
– Nachschleifen möglich



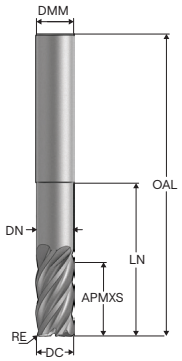
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zoll			
ST5551-.250E4R015.0Z5	SIRA	10303140	4	E	0.250	0.250	0.500	3.000	1.000	0.240	0.015	5	Cylindrical	■
ST5551-.250E4R030.0Z5	SIRA	10303141	4	E	0.250	0.250	0.500	3.000	1.000	0.240	0.030	5	Cylindrical	■
ST5551-.375E4R015.0Z5	SIRA	10303143	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.015	5	Cylindrical	■
ST5551-.375E4R030.0Z5	SIRA	10303144	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.030	5	Cylindrical	■
ST5551-.375E4R045.0Z5	SIRA	10303145	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.045	5	Cylindrical	■
ST5551-.375E4R060.0Z5	SIRA	10303146	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.060	5	Cylindrical	■
ST5551-.500E4R015.0Z5	SIRA	10303148	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.015	5	Cylindrical	■
ST5551-.500E4R030.0Z5	SIRA	10303149	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.030	5	Cylindrical	■
ST5551-.500E4R060.0Z5	SIRA	10303150	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.060	5	Cylindrical	■
ST5551-.500E4R120.0Z5	SIRA	10303151	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.120	5	Cylindrical	■
ST5551-.625E4R030.0Z5	SIRA	10303153	4	E	0.625	0.625	1.250	5.000	2.500	0.600	0.030	5	Cylindrical	■
ST5551-.625E4R060.0Z5	SIRA	10303154	4	E	0.625	0.625	1.250	5.000	2.500	0.600	0.060	5	Cylindrical	■
ST5551-.250E5R015.0Z5	SIRA	10303159	5	E	0.250	0.250	0.500	4.000	1.250	0.240	0.015	5	Cylindrical	■
ST5551-.250E5R030.0Z5	SIRA	10303160	5	E	0.250	0.250	0.500	4.000	1.250	0.240	0.030	5	Cylindrical	■
ST5551-.375E5R015.0Z5	SIRA	10303161	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.015	5	Cylindrical	■
ST5551-.375E5R030.0Z5	SIRA	10303162	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.030	5	Cylindrical	■
ST5551-.375E5R045.0Z5	SIRA	10303163	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.045	5	Cylindrical	■
ST5551-.375E5R060.0Z5	SIRA	10303164	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.060	5	Cylindrical	■
ST5551-.625E5R030.0Z5	SIRA	10303166	5	E	0.625	0.625	0.750	6.000	3.375	0.600	0.030	5	Cylindrical	■
ST5551-.625E5R060.0Z5	SIRA	10303167	5	E	0.625	0.625	0.750	6.000	3.375	0.600	0.060	5	Cylindrical	■
ST5551-.500E6R015.0Z5	SIRA	10303172	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.015	5	Cylindrical	■
ST5551-.500E6R030.0Z5	SIRA	10303173	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.030	5	Cylindrical	■
ST5551-.500E6R060.0Z5	SIRA	10303174	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.060	5	Cylindrical	■
ST5551-.500E6R120.0Z5	SIRA	10303175	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.120	5	Cylindrical	■
ST5551-.250E8R015.0Z5	SIRA	10303176	8	E	0.250	0.250	0.500	4.000	2.125	0.240	0.015	5	Cylindrical	■
ST5551-.250E8R030.0Z5	SIRA	10303177	8	E	0.250	0.250	0.500	4.000	2.125	0.240	0.030	5	Cylindrical	■
ST5551-.375E8R015.0Z5	SIRA	10303178	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.015	5	Cylindrical	■
ST5551-.375E8R030.0Z5	SIRA	10303179	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.030	5	Cylindrical	■
ST5551-.375E8R045.0Z5	SIRA	10303180	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.045	5	Cylindrical	■
ST5551-.375E8R060.0Z5	SIRA	10303181	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.060	5	Cylindrical	■
ST5551-.500E8R015.0Z5	SIRA	10303182	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.015	5	Cylindrical	■
ST5551-.500E8R030.0Z5	SIRA	10303183	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.030	5	Cylindrical	■
ST5551-.500E8R060.0Z5	SIRA	10303184	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.060	5	Cylindrical	■
ST5551-.500E8R120.0Z5	SIRA	10303185	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.120	5	Cylindrical	■

■ **Lagerstandard.**

ST5551

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Zylindrisch – Eckenradius – Zoll





—Toleranzen:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Nachschleifen möglich



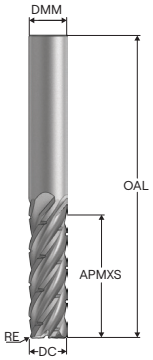
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zoll			
ST5551-.750E3R030.0Z5	SIRA	10303131	3	E	0.750	0.750	1.125	5.000	2.500	0.720	0.030	5	Cylindrical	■
ST5551-.750E3R060.0Z5	SIRA	10303132	3	E	0.750	0.750	1.125	5.000	2.500	0.720	0.060	5	Cylindrical	■
ST5551-.750E3R120.0Z5	SIRA	10303133	3	E	0.750	0.750	1.125	5.000	2.500	0.720	0.120	5	Cylindrical	■
ST5551-1.00E3R030.0Z5	SIRA	10303135	3	E	1.000	1.000	1.250	6.000	3.500	0.960	0.030	5	Cylindrical	■
ST5551-1.00E3R060.0Z5	SIRA	10303136	3	E	1.000	1.000	1.250	6.000	3.500	0.960	0.060	5	Cylindrical	■
ST5551-1.00E3R120.0Z5	SIRA	10303137	3	E	1.000	1.000	1.250	6.000	3.500	0.960	0.120	5	Cylindrical	■
ST5551-.750E4R030.0Z5	SIRA	10303155	4	E	0.750	0.750	1.500	5.000	3.000	0.720	0.030	5	Cylindrical	■
ST5551-.750E4R060.0Z5	SIRA	10303156	4	E	0.750	0.750	1.500	5.000	3.000	0.720	0.060	5	Cylindrical	■
ST5551-.750E4R120.0Z5	SIRA	10303157	4	E	0.750	0.750	1.500	5.000	3.000	0.720	0.120	5	Cylindrical	■
ST5551-.750E5R030.0Z5	SIRA	10303168	5	E	0.750	0.750	1.125	6.000	4.125	0.720	0.030	5	Cylindrical	■
ST5551-.750E5R060.0Z5	SIRA	10303169	5	E	0.750	0.750	1.125	6.000	4.125	0.720	0.060	5	Cylindrical	■
ST5551-.750E5R120.0Z5	SIRA	10303170	5	E	0.750	0.750	1.132	6.000	4.125	0.720	0.120	5	Cylindrical	■

■ **Lagerstandard.**

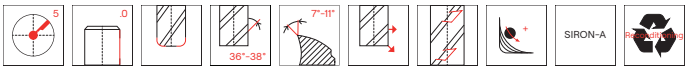
ST5551

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Zylindrisch – Eckenradius – Zoll





– Toleranzen:
– DMM= -.0001"/-.0004"
– DC= + .000" / - .002"
– RE= ±.0008"
– Nachschleifen möglich



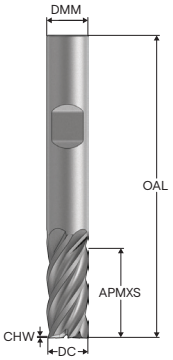
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
						Zoll	Zoll	Zoll	Zoll	Zoll			
ST5551-.250D3R015.0Z5C	SIRA	10303186	3	D	■	0.250	0.250	0.750	2.500	0.015	5	Cylindrical	■
ST5551-.375D3R030.0Z5C	SIRA	10303187	3	D	■	0.375	0.375	1.250	3.000	0.030	5	Cylindrical	■
ST5551-.500D3R030.0Z5C	SIRA	10303188	3	D	■	0.500	0.500	1.250	3.000	0.030	5	Cylindrical	■
ST5551-.625D3R030.0Z5C	SIRA	10303189	3	D	■	0.625	0.625	1.375	3.500	0.030	5	Cylindrical	■
ST5551-.750D3R030.0Z5C	SIRA	10303190	3	D	■	0.750	0.750	1.625	4.000	0.030	5	Cylindrical	■
ST5551-.500D4R030.0Z5C	SIRA	10303191	4	D	■	0.500	0.500	1.625	4.000	0.030	5	Cylindrical	■
ST5551-.750D4R030.0Z5C	SIRA	10303192	4	D	■	0.750	0.750	2.250	5.000	0.030	5	Cylindrical	■
ST5551-.625D5R030.0Z5C	SIRA	10303193	5	D	■	0.625	0.625	2.125	4.000	0.030	5	Cylindrical	■

■ **Lagerstandard.**

ST5551

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Weldon – Fase





—Toleranzen:
—DMM=h5
—DC=e7
—Nachschleifen möglich



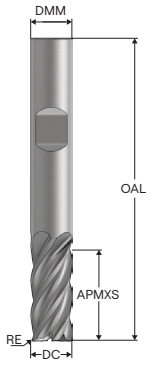
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
ST5551-060D2C.3Z5	SIRA	10303368	2	D	6,0	6,0	14,0	58,0	0,075	5	Weldon	☐
ST5551-080D2C.3Z5	SIRA	10303369	2	D	8,0	8,0	18,0	64,0	0,1	5	Weldon	☐
ST5551-100D2C.3Z5	SIRA	10303370	2	D	10,0	10,0	22,0	73,0	0,125	5	Weldon	☐
ST5551-120D2C.3Z5	SIRA	10303371	2	D	12,0	12,0	26,0	84,0	0,15	5	Weldon	☐
ST5551-160D2C.3Z5	SIRA	10303372	2	D	16,0	16,0	34,0	95,0	0,2	5	Weldon	☐
ST5551-200D2C.3Z5	SIRA	10303373	2	D	20,0	20,0	42,0	109,0	0,25	5	Weldon	☐
ST5551-250D2C.3Z5	SIRA	10303374	2	D	25,0	25,0	52,0	125,0	0,3	5	Weldon	☐
ST5551-060D3C.3Z5	SIRA	10303375	3	D	6,0	6,0	23,0	64,0	0,075	5	Weldon	☐
ST5551-080D3C.3Z5	SIRA	10303376	3	D	8,0	8,0	32,0	73,0	0,1	5	Weldon	☐
ST5551-100D3C.3Z5	SIRA	10303377	3	D	10,0	10,0	40,0	85,0	0,125	5	Weldon	☐
ST5551-120D3C.3Z5	SIRA	10303378	3	D	12,0	12,0	45,0	100,0	0,15	5	Weldon	☐
ST5551-160D3C.3Z5	SIRA	10303379	3	D	16,0	16,0	55,0	115,0	0,2	5	Weldon	☐
ST5551-200D3C.3Z5	SIRA	10303380	3	D	20,0	20,0	65,0	125,0	0,25	5	Weldon	☐
ST5551-250D3C.3Z5	SIRA	10303381	3	D	25,0	25,0	85,0	155,0	0,3	5	Weldon	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

ST5551

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Weldon – Eckenradius





- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich



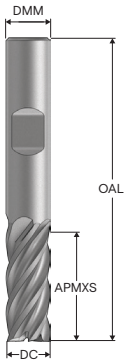
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
ST5551-060D2R050.3Z5	SIRA	10303382	2	D	6,0	6,0	14,0	58,0	0,5	5	Weldon	☐
ST5551-080D2R050.3Z5	SIRA	10303383	2	D	8,0	8,0	18,0	64,0	0,5	5	Weldon	☐
ST5551-100D2R050.3Z5	SIRA	10303384	2	D	10,0	10,0	22,0	73,0	0,5	5	Weldon	☐
ST5551-120D2R050.3Z5	SIRA	10303385	2	D	12,0	12,0	26,0	84,0	0,5	5	Weldon	☐
ST5551-120D2R100.3Z5	SIRA	10303386	2	D	12,0	12,0	26,0	84,0	1,0	5	Weldon	☐
ST5551-160D2R050.3Z5	SIRA	10303387	2	D	16,0	16,0	34,0	95,0	0,5	5	Weldon	☐
ST5551-160D2R100.3Z5	SIRA	10303388	2	D	16,0	16,0	34,0	95,0	1,0	5	Weldon	☐
ST5551-200D2R050.3Z5	SIRA	10303389	2	D	20,0	20,0	42,0	109,0	0,5	5	Weldon	☐
ST5551-200D2R100.3Z5	SIRA	10303390	2	D	20,0	20,0	42,0	109,0	1,0	5	Weldon	☐
ST5551-250D2R050.3Z5	SIRA	10303391	2	D	25,0	25,0	52,0	125,0	0,5	5	Weldon	☐
ST5551-250D2R100.3Z5	SIRA	10303392	2	D	25,0	25,0	52,0	125,0	1,0	5	Weldon	☐
ST5551-060D3R050.3Z5	SIRA	10303393	3	D	6,0	6,0	23,0	64,0	0,5	5	Weldon	☐
ST5551-080D3R050.3Z5	SIRA	10303394	3	D	8,0	8,0	32,0	73,0	0,5	5	Weldon	☐
ST5551-100D3R050.3Z5	SIRA	10303395	3	D	10,0	10,0	40,0	85,0	0,5	5	Weldon	☐
ST5551-120D3R050.3Z5	SIRA	10303396	3	D	12,0	12,0	45,0	100,0	0,5	5	Weldon	☐
ST5551-120D3R100.3Z5	SIRA	10303397	3	D	12,0	12,0	45,0	100,0	1,0	5	Weldon	☐
ST5551-160D3R050.3Z5	SIRA	10303398	3	D	16,0	16,0	55,0	115,0	0,5	5	Weldon	☐
ST5551-160D3R100.3Z5	SIRA	10303399	3	D	16,0	16,0	55,0	115,0	1,0	5	Weldon	☐
ST5551-200D3R050.3Z5	SIRA	10303400	3	D	20,0	20,0	65,0	125,0	0,5	5	Weldon	☐
ST5551-200D3R100.3Z5	SIRA	10303401	3	D	20,0	20,0	65,0	125,0	1,0	5	Weldon	☐
ST5551-250D3R050.3Z5	SIRA	10303402	3	D	25,0	25,0	85,0	155,0	0,5	5	Weldon	☐
ST5551-250D3R100.3Z5	SIRA	10303403	3	D	25,0	25,0	85,0	155,0	1,0	5	Weldon	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

ST5551

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Weldon – Scharfe Schneide – Zoll





—Toleranzen:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—Nachschleifen möglich



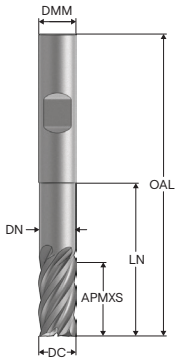
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					Zoll	Zoll	Zoll	Zoll			
ST5551-.250D1S.3Z5	SIRA	10303194	1	D	0.250	0.250	0.375	2.000	5	Weldon	☐
ST5551-.375D1S.3Z5	SIRA	10303195	1	D	0.375	0.375	0.500	2.500	5	Weldon	☐
ST5551-.500D1S.3Z5	SIRA	10303196	1	D	0.500	0.500	0.625	3.000	5	Weldon	☐
ST5551-.625D1S.3Z5	SIRA	10303197	1	D	0.625	0.625	0.750	3.000	5	Weldon	☐
ST5551-.750D1S.3Z5	SIRA	10303198	1	D	0.750	0.750	0.875	3.000	5	Weldon	☐
ST5551-.313D2S.3Z5	SIRA	10303199	2	D	0.313	0.313	0.750	2.500	5	Weldon	☐
ST5551-.375D2S.3Z5	SIRA	10303200	2	D	0.375	0.375	0.875	2.500	5	Weldon	☐
ST5551-.500D2S.3Z5	SIRA	10303201	2	D	0.500	0.500	1.000	3.000	5	Weldon	☐
ST5551-.625D2S.3Z5	SIRA	10303202	2	D	0.625	0.625	1.250	3.500	5	Weldon	☐
ST5551-.750D2S.3Z5	SIRA	10303203	2	D	0.750	0.750	1.500	4.000	5	Weldon	☐
ST5551-.250D3S.3Z5	SIRA	10303204	3	D	0.250	0.250	0.750	2.500	5	Weldon	☐
ST5551-.500D3S.3Z5	SIRA	10303205	3	D	0.500	0.500	1.250	3.000	5	Weldon	☐
ST5551-.625D4S.3Z5	SIRA	10303211	4	D	0.625	0.625	1.625	3.500	5	Weldon	☐
ST5551-.625D5S.3Z5	SIRA	10303216	5	D	0.625	0.625	2.125	4.000	5	Weldon	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

ST5551

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Weldon – Scharfe Schneide – Zoll





—Toleranzen:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—Nachschleifen möglich



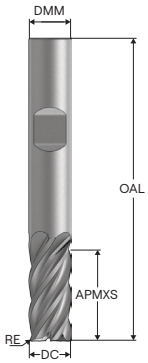
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll	Zoll			
ST5551-.750E3S.3Z5	SIRA	10303206	3	E	0.750	0.750	1.125	5.000	2.500	0.720	5	Weldon	☐
ST5551-.250E4S.3Z5	SIRA	10303207	4	E	0.250	0.250	0.500	3.000	1.000	0.240	5	Weldon	☐
ST5551-.375E4S.3Z5	SIRA	10303208	4	E	0.375	0.375	0.750	3.000	1.500	0.360	5	Weldon	☐
ST5551-.500E4S.3Z5	SIRA	10303209	4	E	0.500	0.500	1.000	4.000	2.000	0.480	5	Weldon	☐
ST5551-.625E4S.3Z5	SIRA	10303210	4	E	0.625	0.625	1.250	5.000	2.500	0.600	5	Weldon	☐
ST5551-.750E4S.3Z5	SIRA	10303212	4	E	0.750	0.750	1.500	5.000	3.000	0.720	5	Weldon	☐
ST5551-.250E5S.3Z5	SIRA	10303213	5	E	0.250	0.250	0.500	4.000	1.250	0.240	5	Weldon	☐
ST5551-.375E5S.3Z5	SIRA	10303214	5	E	0.375	0.375	0.500	4.000	2.125	0.360	5	Weldon	☐
ST5551-.625E5S.3Z5	SIRA	10303215	5	E	0.625	0.625	0.750	6.000	3.375	0.600	5	Weldon	☐
ST5551-.750E5S.3Z5	SIRA	10303217	5	E	0.750	0.750	1.125	6.000	4.125	0.720	5	Weldon	☐
ST5551-.500E6S.3Z5	SIRA	10303218	6	E	0.500	0.500	0.625	5.000	3.125	0.480	5	Weldon	☐
ST5551-.250E8S.3Z5	SIRA	10303219	8	E	0.250	0.250	0.500	4.000	2.125	0.240	5	Weldon	☐
ST5551-.375E8S.3Z5	SIRA	10303220	8	E	0.375	0.375	0.500	6.000	3.125	0.360	5	Weldon	☐
ST5551-.500E8S.3Z5	SIRA	10303221	8	E	0.500	0.500	0.625	6.000	4.109	0.480	5	Weldon	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

ST5551

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Weldon – Eckenradius – Zoll





– Toleranzen:
– DMM= -.0001"/-.0004"
– DC= + .000" / - .002"
– RE= ±.0008"
– Nachschleifen möglich



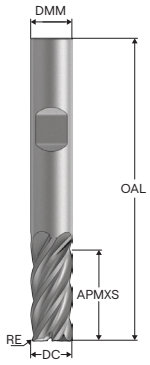
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	RE	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll	Zoll			
ST5551-.250D1R015.3Z5	SIRA	10303222	1	D	0.250	0.250	0.375	2.000	0.015	5	Weldon	□
ST5551-.250D1R030.3Z5	SIRA	10303223	1	D	0.250	0.250	0.375	2.000	0.030	5	Weldon	□
ST5551-.250D1R045.3Z5	SIRA	10303224	1	D	0.250	0.250	0.375	2.000	0.045	5	Weldon	□
ST5551-.375D1R015.3Z5	SIRA	10303225	1	D	0.375	0.375	0.500	2.500	0.015	5	Weldon	□
ST5551-.375D1R030.3Z5	SIRA	10303226	1	D	0.375	0.375	0.500	2.500	0.030	5	Weldon	□
ST5551-.375D1R045.3Z5	SIRA	10303227	1	D	0.375	0.375	0.500	2.500	0.045	5	Weldon	□
ST5551-.500D1R015.3Z5	SIRA	10303228	1	D	0.500	0.500	0.625	3.000	0.015	5	Weldon	□
ST5551-.500D1R030.3Z5	SIRA	10303231	1	D	0.500	0.500	0.625	3.000	0.030	5	Weldon	□
ST5551-.500D1R045.3Z5	SIRA	10303229	1	D	0.500	0.500	0.625	3.000	0.045	5	Weldon	□
ST5551-.500D1R060.3Z5	SIRA	10303232	1	D	0.500	0.500	0.625	3.000	0.060	5	Weldon	□
ST5551-.500D1R120.3Z5	SIRA	10303230	1	D	0.500	0.500	0.625	3.000	0.120	5	Weldon	□
ST5551-.625D1R015.3Z5	SIRA	10303233	1	D	0.625	0.625	0.750	3.000	0.015	5	Weldon	□
ST5551-.625D1R030.3Z5	SIRA	10303235	1	D	0.625	0.625	0.750	3.000	0.030	5	Weldon	□
ST5551-.625D1R060.3Z5	SIRA	10303236	1	D	0.625	0.625	0.750	3.000	0.060	5	Weldon	□
ST5551-.625D1R120.3Z5	SIRA	10303234	1	D	0.625	0.625	0.750	3.000	0.120	5	Weldon	□
ST5551-.750D1R030.3Z5	SIRA	10303237	1	D	0.750	0.750	0.875	3.000	0.030	5	Weldon	□
ST5551-.750D1R060.3Z5	SIRA	10303238	1	D	0.750	0.750	0.875	3.000	0.060	5	Weldon	□
ST5551-.750D1R120.3Z5	SIRA	10303239	1	D	0.750	0.750	0.875	3.000	0.120	5	Weldon	□
ST5551-.313D2R015.3Z5	SIRA	10303240	2	D	0.313	0.313	0.750	2.500	0.015	5	Weldon	□
ST5551-.375D2R015.3Z5	SIRA	10303241	2	D	0.375	0.375	0.875	2.500	0.015	5	Weldon	□
ST5551-.375D2R030.3Z5	SIRA	10303242	2	D	0.375	0.375	0.875	2.500	0.030	5	Weldon	□
ST5551-.375D2R045.3Z5	SIRA	10303243	2	D	0.375	0.375	0.875	2.500	0.045	5	Weldon	□
ST5551-.375D2R060.3Z5	SIRA	10303244	2	D	0.375	0.375	0.875	2.500	0.060	5	Weldon	□
ST5551-.500D2R015.3Z5	SIRA	10303245	2	D	0.500	0.500	1.000	3.000	0.015	5	Weldon	□
ST5551-.500D2R030.3Z5	SIRA	10303246	2	D	0.500	0.500	1.000	3.000	0.030	5	Weldon	□
ST5551-.500D2R060.3Z5	SIRA	10303247	2	D	0.500	0.500	1.000	3.000	0.060	5	Weldon	□
ST5551-.625D2R015.3Z5	SIRA	10303248	2	D	0.625	0.625	1.250	3.500	0.015	5	Weldon	□
ST5551-.625D2R030.3Z5	SIRA	10303249	2	D	0.625	0.625	1.250	3.500	0.030	5	Weldon	□
ST5551-.625D2R045.3Z5	SIRA	10303250	2	D	0.625	0.625	1.250	3.500	0.045	5	Weldon	□
ST5551-.625D2R060.3Z5	SIRA	10303251	2	D	0.625	0.625	1.250	3.500	0.060	5	Weldon	□
ST5551-.625D2R090.3Z5	SIRA	10303252	2	D	0.625	0.625	1.250	3.500	0.090	5	Weldon	□
ST5551-.625D2R125.3Z5	SIRA	10303253	2	D	0.625	0.625	1.250	3.500	0.125	5	Weldon	□
ST5551-.750D2R030.3Z5	SIRA	10303254	2	D	0.750	0.750	1.500	4.000	0.030	5	Weldon	□
ST5551-.750D2R060.3Z5	SIRA	10303255	2	D	0.750	0.750	1.500	4.000	0.060	5	Weldon	□
ST5551-.750D2R090.3Z5	SIRA	10303256	2	D	0.750	0.750	1.500	4.000	0.090	5	Weldon	□
ST5551-.750D2R125.3Z5	SIRA	10303257	2	D	0.750	0.750	1.500	4.000	0.125	5	Weldon	□

□ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

ST5551

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Weldon – Eckenradius – Zoll





– Toleranzen:
– DMM= -.0001"/-.0004"
– DC= + .000" / - .002"
– RE= ±.0008"
– Nachschleifen möglich



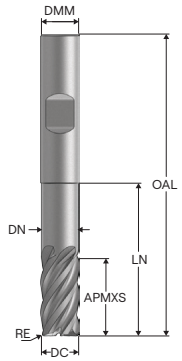
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	RE	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll	Zoll			
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ST5551-1.00D2R030.3Z5	SIRA	10303259	2	D	1.000	1.000	1.750	4.000	0.030	5	Weldon	☐
ST5551-1.00D2R060.3Z5	SIRA	10303260	2	D	1.000	1.000	1.750	4.000	0.060	5	Weldon	☐
ST5551-.250D3R015.3Z5	SIRA	10303261	3	D	0.250	0.250	0.750	2.500	0.015	5	Weldon	☐
ST5551-.250D3R030.3Z5	SIRA	10303262	3	D	0.250	0.250	0.750	2.500	0.030	5	Weldon	☐
ST5551-.250D3R045.3Z5	SIRA	10303263	3	D	0.250	0.250	0.750	2.500	0.045	5	Weldon	☐
ST5551-.375D3R030.3Z5	SIRA	10303264	3	D	0.375	0.375	1.250	3.000	0.030	5	Weldon	☐
ST5551-.500D3R015.3Z5	SIRA	10303265	3	D	0.500	0.500	1.250	3.000	0.015	5	Weldon	☐
ST5551-.500D3R030.3Z5	SIRA	10303266	3	D	0.500	0.500	1.250	3.000	0.030	5	Weldon	☐
ST5551-.500D3R045.3Z5	SIRA	10303267	3	D	0.500	0.500	1.250	3.000	0.045	5	Weldon	☐
ST5551-.500D3R060.3Z5	SIRA	10303268	3	D	0.500	0.500	1.250	3.000	0.060	5	Weldon	☐
ST5551-.500D3R090.3Z5	SIRA	10303269	3	D	0.500	0.500	1.250	3.000	0.090	5	Weldon	☐
ST5551-.500D3R125.3Z5	SIRA	10303270	3	D	0.500	0.500	1.250	3.000	0.125	5	Weldon	☐
ST5551-.750D3R030.3Z5	SIRA	10303274	3	D	0.750	0.750	1.625	4.000	0.030	5	Weldon	☐
ST5551-.250D4R015.3Z5	SIRA	10303280	4	D	0.250	0.250	1.000	3.000	0.015	5	Weldon	☐
ST5551-.375D4R030.3Z5	SIRA	10303285	4	D	0.375	0.375	1.500	4.000	0.030	5	Weldon	☐
ST5551-.500D4R030.3Z5	SIRA	10303290	4	D	0.500	0.500	1.625	4.000	0.030	5	Weldon	☐
ST5551-.750D4R030.3Z5	SIRA	10303296	4	D	0.750	0.750	2.250	5.000	0.030	5	Weldon	☐
ST5551-.500D5R030.3Z5	SIRA	10303303	5	D	0.500	0.500	2.000	4.000	0.030	5	Weldon	☐
ST5551-.750D5R030.3Z5	SIRA	10303309	5	D	0.750	0.750	2.750	5.000	0.030	5	Weldon	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

ST5551

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Weldon – Eckenradius – Zoll





—Toleranzen:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Nachschleifen möglich



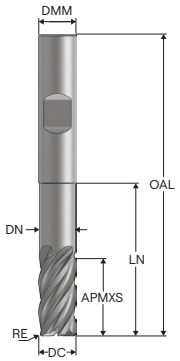
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zoll			
ST5551-.750E3R030.3Z5	SIRA	10303271	3	E	0.750	0.750	1.125	5.000	2.500	0.720	0.030	5	Weldon	□
ST5551-.750E3R060.3Z5	SIRA	10303272	3	E	0.750	0.750	1.125	5.000	2.500	0.720	0.060	5	Weldon	□
ST5551-.750E3R120.3Z5	SIRA	10303273	3	E	0.750	0.750	1.125	5.000	2.500	0.720	0.120	5	Weldon	□
ST5551-1.00E3R030.3Z5	SIRA	10303275	3	E	1.000	1.000	1.250	6.000	3.500	0.960	0.030	5	Weldon	□
ST5551-1.00E3R060.3Z5	SIRA	10303276	3	E	1.000	1.000	1.250	6.000	3.500	0.960	0.060	5	Weldon	□
ST5551-1.00E3R120.3Z5	SIRA	10303277	3	E	1.000	1.000	1.250	6.000	3.500	0.960	0.120	5	Weldon	□
ST5551-.250E4R015.3Z5	SIRA	10303278	4	E	0.250	0.250	0.500	3.000	1.000	0.240	0.015	5	Weldon	□
ST5551-.250E4R030.3Z5	SIRA	10303279	4	E	0.250	0.250	0.500	3.000	1.000	0.240	0.030	5	Weldon	□
ST5551-.375E4R015.3Z5	SIRA	10303281	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.015	5	Weldon	□
ST5551-.375E4R030.3Z5	SIRA	10303282	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.030	5	Weldon	□
ST5551-.375E4R045.3Z5	SIRA	10303283	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.045	5	Weldon	□
ST5551-.375E4R060.3Z5	SIRA	10303284	4	E	0.375	0.375	0.750	3.000	1.500	0.360	0.060	5	Weldon	□
ST5551-.500E4R015.3Z5	SIRA	10303286	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.015	5	Weldon	□
ST5551-.500E4R030.3Z5	SIRA	10303287	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.030	5	Weldon	□
ST5551-.500E4R060.3Z5	SIRA	10303288	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.060	5	Weldon	□
ST5551-.500E4R120.3Z5	SIRA	10303289	4	E	0.500	0.500	1.000	4.000	2.000	0.480	0.120	5	Weldon	□
ST5551-.625E4R030.3Z5	SIRA	10303291	4	E	0.625	0.625	1.250	5.000	2.500	0.600	0.030	5	Weldon	□
ST5551-.625E4R060.3Z5	SIRA	10303292	4	E	0.625	0.625	1.250	5.000	2.500	0.600	0.060	5	Weldon	□
ST5551-.750E4R030.3Z5	SIRA	10303293	4	E	0.750	0.750	1.500	5.000	3.000	0.720	0.030	5	Weldon	□
ST5551-.750E4R060.3Z5	SIRA	10303294	4	E	0.750	0.750	1.500	5.000	3.000	0.720	0.060	5	Weldon	□
ST5551-.750E4R120.3Z5	SIRA	10303295	4	E	0.750	0.750	1.500	5.000	3.000	0.720	0.120	5	Weldon	□

□ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

ST5551

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Weldon – Eckenradius – Zoll





—Toleranzen:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Nachschleifen möglich



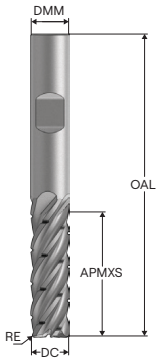
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zoll			
ST5551-.250E5R015.3Z5	SIRA	10303297	5	E	0.250	0.250	0.500	4.000	1.250	0.240	0.015	5	Weldon	☐
ST5551-.250E5R030.3Z5	SIRA	10303298	5	E	0.250	0.250	0.500	4.000	1.250	0.240	0.030	5	Weldon	☐
ST5551-.375E5R015.3Z5	SIRA	10303299	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.015	5	Weldon	☐
ST5551-.375E5R030.3Z5	SIRA	10303300	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.030	5	Weldon	☐
ST5551-.375E5R045.3Z5	SIRA	10303301	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.045	5	Weldon	☐
ST5551-.375E5R060.3Z5	SIRA	10303302	5	E	0.375	0.375	0.500	4.000	2.125	0.360	0.060	5	Weldon	☐
ST5551-.625E5R030.3Z5	SIRA	10303304	5	E	0.625	0.625	0.750	6.000	3.375	0.600	0.030	5	Weldon	☐
ST5551-.625E5R060.3Z5	SIRA	10303305	5	E	0.625	0.625	0.750	6.000	3.375	0.600	0.060	5	Weldon	☐
ST5551-.750E5R030.3Z5	SIRA	10303306	5	E	0.750	0.750	1.125	6.000	4.125	0.720	0.030	5	Weldon	☐
ST5551-.750E5R060.3Z5	SIRA	10303307	5	E	0.750	0.750	1.125	6.000	4.125	0.720	0.060	5	Weldon	☐
ST5551-.750E5R120.3Z5	SIRA	10303308	5	E	0.750	0.750	1.125	6.000	4.125	0.720	0.120	5	Weldon	☐
ST5551-.500E6R015.3Z5	SIRA	10303310	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.015	5	Weldon	☐
ST5551-.500E6R030.3Z5	SIRA	10303311	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.030	5	Weldon	☐
ST5551-.500E6R060.3Z5	SIRA	10303312	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.060	5	Weldon	☐
ST5551-.500E6R120.3Z5	SIRA	10303313	6	E	0.500	0.500	0.625	5.000	3.125	0.480	0.120	5	Weldon	☐
ST5551-.250E8R015.3Z5	SIRA	10303314	8	E	0.250	0.250	0.500	4.000	2.125	0.240	0.015	5	Weldon	☐
ST5551-.250E8R030.3Z5	SIRA	10303315	8	E	0.250	0.250	0.500	4.000	2.125	0.240	0.030	5	Weldon	☐
ST5551-.375E8R015.3Z5	SIRA	10303316	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.015	5	Weldon	☐
ST5551-.375E8R030.3Z5	SIRA	10303317	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.030	5	Weldon	☐
ST5551-.375E8R045.3Z5	SIRA	10303318	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.045	5	Weldon	☐
ST5551-.375E8R060.3Z5	SIRA	10303319	8	E	0.375	0.375	0.500	6.000	3.125	0.360	0.060	5	Weldon	☐
ST5551-.500E8R015.3Z5	SIRA	10303320	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.015	5	Weldon	☐
ST5551-.500E8R030.3Z5	SIRA	10303321	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.030	5	Weldon	☐
ST5551-.500E8R060.3Z5	SIRA	10303322	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.060	5	Weldon	☐
ST5551-.500E8R120.3Z5	SIRA	10303323	8	E	0.500	0.500	0.625	6.000	4.125	0.480	0.120	5	Weldon	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

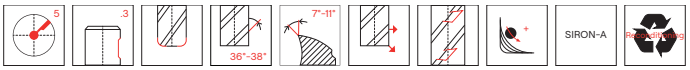
ST5551

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Weldon – Eckenradius – Zoll





- Toleranzen:
- DMM= -.0001"/-.0004"
- DC= + .000" / - .002"
- RE= ±.0008"
- Nachschleifen möglich



Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	Spanteiler	DC	DMM	APMXS	OAL	RE	PCEDC	Aufnahmen	Lagerstandard
						Zoll	Zoll	Zoll	Zoll	Zoll			
ST5551-.250D3R015.3Z5C	SIRA	10303324	3	D	■	0.250	0.250	0.750	2.500	0.015	5	Weldon	□
ST5551-.375D3R030.3Z5C	SIRA	10303325	3	D	■	0.375	0.375	1.250	3.000	0.030	5	Weldon	□
ST5551-.500D3R030.3Z5C	SIRA	10303326	3	D	■	0.500	0.500	1.250	3.000	0.030	5	Weldon	□
ST5551-.625D3R030.3Z5C	SIRA	10303327	3	D	■	0.625	0.625	1.375	3.500	0.030	5	Weldon	□
ST5551-.750D3R030.3Z5C	SIRA	10303328	3	D	■	0.750	0.750	1.625	4.000	0.030	5	Weldon	□
ST5551-.500D4R030.3Z5C	SIRA	10303329	4	D	■	0.500	0.500	1.625	4.000	0.030	5	Weldon	□
ST5551-.750D4R030.3Z5C	SIRA	10303330	4	D	■	0.750	0.750	2.250	5.000	0.030	5	Weldon	□
ST5551-.625D5R030.3Z5C	SIRA	10303331	5	D	■	0.625	0.625	2.125	4.000	0.030	5	Weldon	□

□ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – ST5551 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
P1	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,038 *0.0015*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	175 (140 — 210) *570 (460 — 680)*
P2	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,040 *0.0016*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	170 (140 — 210) *560 (460 — 680)*
P3	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	150 (120 — 180) *490 (400 — 590)*
P4	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,036 *0.0014*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	130 (110 — 160) *425 (370 — 520)*
P5	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	125 (97 — 150) *410 (320 — 490)*
P6	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	140 (110 — 170) *460 (370 — 550)*
P7	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	135 (110 — 160) *445 (370 — 520)*
P8	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	125 (97 — 150) *410 (320 — 490)*
P11	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	0,095 *0.0038*	120 (110 — 140) *395 (370 — 450)*
P12	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,020 *0.00080*	0,028 *0.0011*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	75 (66 — 88) *245 (220 — 280)*
M1	E	0,30 *0.30*	2,0 *2.0*	0,034 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	140 (120 — 160) *460 (400 — 520)*
M2	E	0,30 *0.30*	2,0 *2.0*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	0,095 *0.0038*	115 (99 — 130) *375 (330 — 420)*
M3	E	0,30 *0.30*	2,0 *2.0*	0,024 *0.00095*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	90 (79 — 100) *295 (260 — 320)*
M4	E	0,30 *0.30*	2,0 *2.0*	0,022 *0.00085*	0,028 *0.0011*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	70 (60 — 80) *230 (200 — 260)*
M5	E	0,30 *0.30*	2,0 *2.0*	0,022 *0.00085*	0,028 *0.0011*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	60 (50 — 67) *195 (170 — 210)*
K1	E	0,30 *0.30*	2,0 *2.0*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	150 (120 — 180) *490 (400 — 590)*
K2	E	0,30 *0.30*	2,0 *2.0*	0,034 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	130 (110 — 160) *425 (370 — 520)*
K3	E	0,30 *0.30*	2,0 *2.0*	0,034 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	110 (85 — 140) *360 (280 — 450)*
K4	E	0,30 *0.30*	2,0 *2.0*	0,034 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	105 (81 — 130) *345 (270 — 420)*
K5	E	0,30 *0.30*	2,0 *2.0*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	0,095 *0.0038*	65 (50 — 81) *215 (170 — 260)*
K6	E	0,30 *0.30*	2,0 *2.0*	0,034 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	110 (85 — 130) *360 (280 — 420)*
K7	E	0,30 *0.30*	2,0 *2.0*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	0,095 *0.0038*	95 (75 — 120) *310 (250 — 390)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – ST5551 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
N1	E	0,30 *0.30*	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	385 (300 — 470) *1275 (990 — 1500)*
N2	E	0,30 *0.30*	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	250 (190 — 300) *820 (630 — 980)*
N3	E	0,30 *0.30*	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	165 (130 — 200) *540 (430 — 650)*
N11	E	0,30 *0.30*	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	220 (170 — 270) *720 (560 — 880)*
S1	E	0,24 *0.24*	2,0 *2.0*	0,024 *0.00095*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	47 (36 — 76) *155 (120 — 240)*
S2	E	0,24 *0.24*	2,0 *2.0*	0,024 *0.00095*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	38 (29 — 61) *125 (96 — 200)*
S3	E	0,24 *0.24*	2,0 *2.0*	0,022 *0.00085*	0,030 *0.0012*	0,038 *0.0015*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,070 *0.0028*	33 (25 — 53) *110 (83 — 170)*
S11	E	0,24 *0.24*	2,0 *2.0*	0,028 *0.0011*	0,036 *0.0014*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,090 *0.0036*	65 (50 — 100) *215 (170 — 320)*
S12	E	0,24 *0.24*	2,0 *2.0*	0,028 *0.0011*	0,036 *0.0014*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,090 *0.0036*	50 (39 — 82) *165 (130 — 260)*
S13	E	0,24 *0.24*	2,0 *2.0*	0,024 *0.00095*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	40 (31 — 65) *130 (110 — 210)*
H5	M/A/D	0,15 *0.15*	2,0 *2.0*	0,022 *0.00085*	0,028 *0.0011*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	115 (86 — 140) *375 (290 — 450)*
H8	M/A/D	0,15 *0.15*	2,0 *2.0*	0,016 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	120 (89 — 140) *395 (300 — 450)*
H11	M/A/D	0,15 *0.15*	2,0 *2.0*	0,022 *0.00085*	0,028 *0.0011*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	145 (110 — 180) *475 (370 — 590)*
H12	M/A/D	0,15 *0.15*	2,0 *2.0*	0,016 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	140 (110 — 170) *460 (370 — 550)*
H21	M/A/D	0,15 *0.15*	2,0 *2.0*	0,016 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	120 (89 — 140) *395 (300 — 450)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – ST5551 Eckfräsen dynamisches Fräsen a_e/DC = 0,10

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
P1	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	215 (170 — 260) *710 (560 — 850)*
P2	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	210 (170 — 260) *690 (560 — 850)*
P3	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	180 (140 — 220) *590 (460 — 720)*
P4	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	160 (130 — 190) *520 (430 — 620)*
P5	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	155 (120 — 180) *510 (400 — 590)*
P6	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,15 *0.0060*	0,18 *0.0070*	170 (140 — 210) *560 (460 — 680)*
P7	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,15 *0.0060*	0,18 *0.0070*	160 (130 — 200) *520 (430 — 650)*
P8	M/A/D/E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	155 (120 — 180) *510 (400 — 590)*
P11	M/A/D/E	2,0 *2.0*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	145 (130 — 160) *475 (430 — 520)*
P12	M/A/D/E	2,0 *2.0*	0,032 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	90 (78 — 100) *295 (260 — 320)*
M1	E	2,0 *2.0*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	170 (150 — 190) *560 (500 — 620)*
M2	E	2,0 *2.0*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (120 — 150) *460 (400 — 490)*
M3	E	2,0 *2.0*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	110 (93 — 120) *360 (310 — 390)*
M4	E	2,0 *2.0*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	80 (71 — 94) *260 (240 — 300)*
M5	E	2,0 *2.0*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	70 (59 — 79) *230 (200 — 250)*
K1	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,18 *0.0070*	180 (140 — 220) *590 (460 — 720)*
K2	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,14 *0.0055*	0,16 *0.0065*	155 (120 — 190) *510 (400 — 620)*
K3	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,14 *0.0055*	0,16 *0.0065*	135 (110 — 160) *445 (370 — 520)*
K4	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,14 *0.0055*	0,16 *0.0065*	125 (97 — 160) *410 (320 — 520)*
K5	E	2,0 *2.0*	0,046 *0.0018*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	75 (58 — 96) *245 (200 — 310)*
K6	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,14 *0.0055*	0,16 *0.0065*	130 (110 — 160) *425 (370 — 520)*
K7	E	2,0 *2.0*	0,046 *0.0018*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	115 (88 — 140) *375 (290 — 450)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – ST5551 Eckfräsen dynamisches Fräsen a_e/DC = 0,10

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
N1	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	495 (380 — 610) *1625 (1300 — 2000)*
N2	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	320 (250 — 390) *1050 (830 — 1200)*
N3	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	215 (170 — 260) *710 (560 — 850)*
N11	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	285 (220 — 350) *940 (730 — 1100)*
S1	E	2,0 *2.0*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	55 (41 — 86) *180 (140 — 280)*
S2	E	2,0 *2.0*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	43 (33 — 70) *140 (110 — 220)*
S3	E	2,0 *2.0*	0,032 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	37 (28 — 60) *120 (92 — 190)*
S11	E	2,0 *2.0*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	75 (58 — 120) *245 (200 — 390)*
S12	E	2,0 *2.0*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	60 (45 — 96) *195 (150 — 310)*
S13	E	2,0 *2.0*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	46 (35 — 74) *150 (120 — 240)*
H5	M/A/D	2,0 *2.0*	0,025 *0.0010*	0,034 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	120 (91 — 150) *395 (300 — 490)*
H8	M/A/D	2,0 *2.0*	0,019 *0.00075*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	0,060 *0.0024*	125 (94 — 150) *410 (310 — 490)*
H11	M/A/D	2,0 *2.0*	0,025 *0.0010*	0,034 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	155 (120 — 190) *510 (400 — 620)*
H12	M/A/D	2,0 *2.0*	0,019 *0.00075*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	0,060 *0.0024*	145 (110 — 180) *475 (370 — 590)*
H21	M/A/D	2,0 *2.0*	0,019 *0.00075*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	0,060 *0.0024*	125 (94 — 150) *410 (310 — 490)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – ST5551 Eckfräsen – Zoll

SMG		a_e/DC	a_p/DC	f_z											v_c
				1/8	5/32	3/16	7/32	1/4	5/16	3/8	1/2	5/8	3/4	1	
P1	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,020 *0.00080*	0,026 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	175 (140 — 210) *570 (460 — 680)*
P2	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	170 (140 — 210) *560 (460 — 680)*
P3	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,020 *0.00080*	0,025 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	150 (120 — 180) *490 (400 — 590)*
P4	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,019 *0.00075*	0,024 *0.00095*	0,030 *0.0012*	0,034 *0.0013*	0,038 *0.0015*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	130 (110 — 160) *425 (370 — 520)*
P5	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,034 *0.0013*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	125 (97 — 150) *410 (320 — 490)*
P6	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,034 *0.0013*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	140 (110 — 170) *460 (370 — 550)*
P7	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,019 *0.00075*	0,024 *0.00095*	0,028 *0.0011*	0,034 *0.0013*	0,038 *0.0015*	0,048 *0.0019*	0,055 *0.0022*	0,075 *0.0030*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	135 (110 — 160) *445 (370 — 520)*
P8	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,020 *0.00080*	0,025 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	125 (97 — 150) *410 (320 — 490)*
P11	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,016 *0.00065*	0,020 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	0,080 *0.0032*	0,095 *0.0038*	120 (110 — 140) *395 (370 — 450)*
P12	M/A/D/E	0,30 *0.30*	2,0 *2.0*	0,011 *0.00044*	0,014 *0.00055*	0,016 *0.00065*	0,019 *0.00075*	0,022 *0.00085*	0,028 *0.0011*	0,032 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	75 (66 — 88) *245 (220 — 280)*
M1	E	0,30 *0.30*	2,0 *2.0*	0,018 *0.00070*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	0,11 *0.0044*	140 (120 — 160) *460 (400 — 520)*
M2	E	0,30 *0.30*	2,0 *2.0*	0,016 *0.00065*	0,020 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	0,095 *0.0038*	115 (99 — 130) *375 (330 — 420)*
M3	E	0,30 *0.30*	2,0 *2.0*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	0,080 *0.0032*	90 (79 — 100) *295 (260 — 320)*
M4	E	0,30 *0.30*	2,0 *2.0*	0,011 *0.00044*	0,014 *0.00055*	0,017 *0.00065*	0,020 *0.00080*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	70 (60 — 80) *230 (200 — 260)*
M5	E	0,30 *0.30*	2,0 *2.0*	0,011 *0.00044*	0,014 *0.00055*	0,017 *0.00065*	0,020 *0.00080*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	60 (50 — 67) *195 (170 — 210)*
K1	E	0,30 *0.30*	2,0 *2.0*	0,019 *0.00075*	0,024 *0.00095*	0,030 *0.0012*	0,034 *0.0013*	0,038 *0.0015*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	150 (120 — 180) *490 (400 — 590)*
K2	E	0,30 *0.30*	2,0 *2.0*	0,018 *0.00070*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	0,11 *0.0044*	130 (110 — 160) *425 (370 — 520)*
K3	E	0,30 *0.30*	2,0 *2.0*	0,018 *0.00070*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	0,11 *0.0044*	110 (85 — 140) *360 (280 — 450)*
K4	E	0,30 *0.30*	2,0 *2.0*	0,018 *0.00070*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	0,11 *0.0044*	105 (81 — 130) *345 (270 — 420)*
K5	E	0,30 *0.30*	2,0 *2.0*	0,016 *0.00065*	0,020 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	0,080 *0.0032*	0,095 *0.0038*	65 (50 — 81) *215 (170 — 260)*
K6	E	0,30 *0.30*	2,0 *2.0*	0,018 *0.00070*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	0,11 *0.0044*	110 (85 — 130) *360 (280 — 420)*
K7	E	0,30 *0.30*	2,0 *2.0*	0,016 *0.00065*	0,020 *0.00080*	0,024 *0.00095*	0,028 *0.0011*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	0,080 *0.0032*	0,095 *0.0038*	95 (75 — 120) *310 (250 — 390)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – ST5551 Eckfräsen – Zoll

SMG		a_e/DC	a_p/DC	f_z											v_c
				1/8	5/32	3/16	7/32	1/4	5/16	3/8	1/2	5/8	3/4	1	
N1	E	0,30 *0.30*	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	385 (300 — 470) *1275 (990 — 1500)*
N2	E	0,30 *0.30*	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	250 (190 — 300) *820 (630 — 980)*
N3	E	0,30 *0.30*	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	165 (130 — 200) *540 (430 — 650)*
N11	E	0,30 *0.30*	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	220 (170 — 270) *720 (560 — 880)*
S1	E	0,24 *0.24*	2,0 *2.0*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,022 *0.00085*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	0,075 *0.0030*	47 (36 — 76) *155 (120 — 240)*
S2	E	0,24 *0.24*	2,0 *2.0*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,022 *0.00085*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	0,075 *0.0030*	38 (29 — 61) *125 (96 — 200)*
S3	E	0,24 *0.24*	2,0 *2.0*	0,012 *0.00048*	0,015 *0.00060*	0,018 *0.00070*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*	0,036 *0.0014*	0,046 *0.0018*	0,055 *0.0022*	0,060 *0.0024*	0,070 *0.0028*	33 (25 — 53) *110 (83 — 170)*
S11	E	0,24 *0.24*	2,0 *2.0*	0,015 *0.00060*	0,018 *0.00070*	0,022 *0.00085*	0,025 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,090 *0.0036*	65 (50 — 100) *215 (170 — 320)*
S12	E	0,24 *0.24*	2,0 *2.0*	0,015 *0.00060*	0,018 *0.00070*	0,022 *0.00085*	0,025 *0.0010*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,090 *0.0036*	50 (39 — 82) *165 (130 — 260)*
S13	E	0,24 *0.24*	2,0 *2.0*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,022 *0.00085*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,050 *0.0020*	0,060 *0.0024*	0,065 *0.0026*	0,075 *0.0030*	40 (31 — 65) *130 (110 — 210)*
H5	M/A/D	0,15 *0.15*	2,0 *2.0*	0,011 *0.00044*	0,014 *0.00055*	0,017 *0.00065*	0,020 *0.00080*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	115 (86 — 140) *375 (290 — 450)*
H8	M/A/D	0,15 *0.15*	2,0 *2.0*	0,0085 *0.00034*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	120 (89 — 140) *395 (300 — 450)*
H11	M/A/D	0,15 *0.15*	2,0 *2.0*	0,011 *0.00044*	0,014 *0.00055*	0,017 *0.00065*	0,020 *0.00080*	0,022 *0.00085*	0,028 *0.0011*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	145 (110 — 180) *475 (370 — 590)*
H12	M/A/D	0,15 *0.15*	2,0 *2.0*	0,0085 *0.00034*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	140 (110 — 170) *460 (370 — 550)*
H21	M/A/D	0,15 *0.15*	2,0 *2.0*	0,0085 *0.00034*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	120 (89 — 140) *395 (300 — 450)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – ST5551 Eckfräsen dynamisches Fräsen a_e/DC = 0,10 – Zoll

SMG		a_p/DC	f_z											v_c
			1/8	5/32	3/16	7/32	1/4	5/16	3/8	1/2	5/8	3/4	1	
P1	M/A/D/E	2,0	0,025	0,032	0,038	0,044	0,050	0,065	0,075	0,10	0,13	0,15	0,19	215 (170 — 260)
		2.0	*0.0010*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*0.0026*	*0.0030*	*0.0040*	*0.0050*	*0.0060*	*0.0075*	*710 (560 — 850)*
P2	M/A/D/E	2,0	0,025	0,032	0,038	0,044	0,050	0,065	0,075	0,10	0,13	0,15	0,20	210 (170 — 260)
		2.0	*0.0010*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*0.0026*	*0.0030*	*0.0040*	*0.0050*	*0.0060*	*0.0080*	*690 (560 — 850)*
P3	M/A/D/E	2,0	0,025	0,032	0,038	0,044	0,050	0,065	0,075	0,10	0,13	0,15	0,19	180 (140 — 220)
		2.0	*0.0010*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*0.0026*	*0.0030*	*0.0040*	*0.0050*	*0.0060*	*0.0075*	*590 (460 — 720)*
P4	M/A/D/E	2,0	0,025	0,032	0,038	0,044	0,050	0,065	0,075	0,10	0,13	0,15	0,18	160 (130 — 190)
		2.0	*0.0010*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*0.0026*	*0.0030*	*0.0040*	*0.0050*	*0.0060*	*0.0070*	*520 (430 — 620)*
P5	M/A/D/E	2,0	0,025	0,032	0,038	0,044	0,050	0,065	0,075	0,10	0,13	0,15	0,18	155 (120 — 180)
		2.0	*0.0010*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*0.0026*	*0.0030*	*0.0040*	*0.0050*	*0.0060*	*0.0070*	*510 (400 — 590)*
P6	M/A/D/E	2,0	0,025	0,032	0,038	0,044	0,050	0,065	0,075	0,10	0,13	0,15	0,18	170 (140 — 210)
		2.0	*0.0010*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*0.0026*	*0.0030*	*0.0040*	*0.0050*	*0.0060*	*0.0070*	*560 (460 — 680)*
P7	M/A/D/E	2,0	0,025	0,032	0,038	0,044	0,050	0,065	0,075	0,10	0,13	0,15	0,18	160 (130 — 200)
		2.0	*0.0010*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*0.0026*	*0.0030*	*0.0040*	*0.0050*	*0.0060*	*0.0070*	*520 (430 — 650)*
P8	M/A/D/E	2,0	0,025	0,032	0,038	0,044	0,050	0,065	0,075	0,10	0,13	0,15	0,19	155 (120 — 180)
		2.0	*0.0010*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*0.0026*	*0.0030*	*0.0040*	*0.0050*	*0.0060*	*0.0075*	*510 (400 — 590)*
P11	M/A/D/E	2,0	0,022	0,028	0,034	0,038	0,044	0,055	0,065	0,090	0,11	0,13	0,15	145 (130 — 160)
		2.0	*0.00085*	*0.0011*	*0.0013*	*0.0015*	*0.0017*	*0.0022*	*0.0026*	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*475 (430 — 520)*
P12	M/A/D/E	2,0	0,017	0,020	0,025	0,030	0,034	0,042	0,050	0,065	0,075	0,085	0,10	90 (78 — 100)
		2.0	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0013*	*0.0017*	*0.0020*	*0.0026*	*0.0030*	*0.0034*	*0.0040*	*295 (260 — 320)*
M1	E	2,0	0,022	0,028	0,034	0,038	0,044	0,055	0,065	0,090	0,11	0,13	0,16	170 (150 — 190)
		2.0	*0.00085*	*0.0011*	*0.0013*	*0.0015*	*0.0017*	*0.0022*	*0.0026*	*0.0036*	*0.0044*	*0.0050*	*0.0065*	*560 (500 — 620)*
M2	E	2,0	0,022	0,028	0,034	0,038	0,044	0,055	0,065	0,090	0,11	0,13	0,15	140 (120 — 150)
		2.0	*0.00085*	*0.0011*	*0.0013*	*0.0015*	*0.0017*	*0.0022*	*0.0026*	*0.0036*	*0.0044*	*0.0050*	*0.0060*	*460 (400 — 490)*
M3	E	2,0	0,020	0,024	0,030	0,034	0,040	0,048	0,060	0,075	0,090	0,10	0,12	110 (93 — 120)
		2.0	*0.00080*	*0.00095*	*0.0012*	*0.0013*	*0.0016*	*0.0019*	*0.0024*	*0.0030*	*0.0036*	*0.0040*	*0.0048*	*360 (310 — 390)*
M4	E	2,0	0,017	0,022	0,026	0,030	0,034	0,042	0,050	0,065	0,080	0,090	0,10	80 (71 — 94)
		2.0	*0.00065*	*0.00085*	*0.0010*	*0.0012*	*0.0013*	*0.0017*	*0.0020*	*0.0026*	*0.0032*	*0.0036*	*0.0040*	*260 (240 — 300)*
M5	E	2,0	0,017	0,022	0,026	0,030	0,034	0,042	0,050	0,065	0,080	0,090	0,10	70 (59 — 79)
		2.0	*0.00065*	*0.00085*	*0.0010*	*0.0012*	*0.0013*	*0.0017*	*0.0020*	*0.0026*	*0.0032*	*0.0036*	*0.0040*	*230 (200 — 250)*
K1	E	2,0	0,025	0,032	0,038	0,044	0,050	0,065	0,075	0,10	0,13	0,15	0,18	180 (140 — 220)
		2.0	*0.0010*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*0.0026*	*0.0030*	*0.0040*	*0.0050*	*0.0060*	*0.0070*	*590 (460 — 720)*
K2	E	2,0	0,025	0,032	0,038	0,044	0,050	0,065	0,075	0,10	0,13	0,14	0,17	155 (120 — 190)
		2.0	*0.0010*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*0.0026*	*0.0030*	*0.0040*	*0.0050*	*0.0055*	*0.0065*	*510 (400 — 620)*
K3	E	2,0	0,025	0,032	0,038	0,044	0,050	0,065	0,075	0,10	0,13	0,14	0,17	135 (110 — 160)
		2.0	*0.0010*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*0.0026*	*0.0030*	*0.0040*	*0.0050*	*0.0055*	*0.0065*	*445 (370 — 520)*
K4	E	2,0	0,025	0,032	0,038	0,044	0,050	0,065	0,075	0,10	0,13	0,14	0,17	125 (97 — 160)
		2.0	*0.0010*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*0.0026*	*0.0030*	*0.0040*	*0.0050*	*0.0055*	*0.0065*	*410 (320 — 520)*
K5	E	2,0	0,024	0,030	0,036	0,042	0,048	0,060	0,075	0,095	0,11	0,13	0,15	75 (58 — 96)
		2.0	*0.00095*	*0.0012*	*0.0014*	*0.0017*	*0.0019*	*0.0024*	*0.0030*	*0.0038*	*0.0044*	*0.0050*	*0.0060*	*245 (200 — 310)*
K6	E	2,0	0,025	0,032	0,038	0,044	0,050	0,065	0,075	0,10	0,13	0,14	0,17	130 (110 — 160)
		2.0	*0.0010*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*0.0026*	*0.0030*	*0.0040*	*0.0050*	*0.0055*	*0.0065*	*425 (370 — 520)*
K7	E	2,0	0,024	0,030	0,036	0,042	0,048	0,060	0,075	0,095	0,11	0,13	0,15	115 (88 — 140)
		2.0	*0.00095*	*0.0012*	*0.0014*	*0.0017*	*0.0019*	*0.0024*	*0.0030*	*0.0038*	*0.0044*	*0.0050*	*0.0060*	*375 (290 — 450)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – ST5551 Eckfräsen dynamisches Fräsen a_e/DC = 0,10 – Zoll

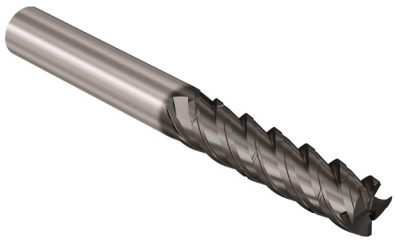
SMG		a_p/DC	f_z											v_c
			1/8	5/32	3/16	7/32	1/4	5/16	3/8	1/2	5/8	3/4	1	
N1	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*	495 (380 — 610) *1625 (1300 — 2000)*
N2	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*	320 (250 — 390) *1050 (830 — 1200)*
N3	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*	215 (170 — 260) *710 (560 — 850)*
N11	E	2,0 *2.0*	0,025 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,20 *0.0080*	285 (220 — 350) *940 (730 — 1100)*
S1	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	55 (41 — 86) *180 (140 — 280)*
S2	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	43 (33 — 70) *140 (110 — 220)*
S3	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,025 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,085 *0.0034*	0,10 *0.0040*	37 (28 — 60) *120 (92 — 190)*
S11	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*	75 (58 — 120) *245 (200 — 390)*
S12	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*	60 (45 — 96) *195 (150 — 310)*
S13	E	2,0 *2.0*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,030 *0.0012*	0,034 *0.0013*	0,044 *0.0017*	0,050 *0.0020*	0,070 *0.0028*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	46 (35 — 74) *150 (120 — 240)*
H5	M/A/D	2,0 *2.0*	0,013 *0.00050*	0,017 *0.00065*	0,020 *0.00080*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	120 (91 — 150) *395 (300 — 490)*
H8	M/A/D	2,0 *2.0*	0,010 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,020 *0.00080*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,046 *0.0018*	0,050 *0.0020*	0,060 *0.0024*	125 (94 — 150) *410 (310 — 490)*
H11	M/A/D	2,0 *2.0*	0,013 *0.00050*	0,017 *0.00065*	0,020 *0.00080*	0,024 *0.00095*	0,026 *0.0010*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	155 (120 — 190) *510 (400 — 620)*
H12	M/A/D	2,0 *2.0*	0,010 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,020 *0.00080*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,046 *0.0018*	0,050 *0.0020*	0,060 *0.0024*	145 (110 — 180) *475 (370 — 590)*
H21	M/A/D	2,0 *2.0*	0,010 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,018 *0.00070*	0,020 *0.00080*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,046 *0.0018*	0,050 *0.0020*	0,060 *0.0024*	125 (94 — 150) *410 (310 — 490)*

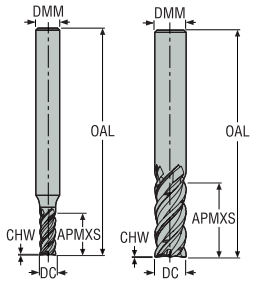
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JS564

Dynamisches Fräsen – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Fase





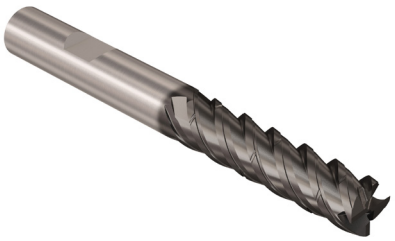
– Toleranzen:
– DMM = h5
– DC= e7
– Nachschleifen möglich, wenn DC ≥ Ø8 ist

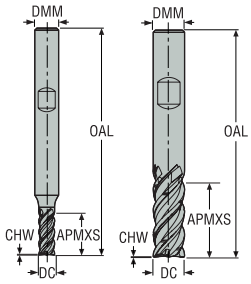
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JS564030F2C.0Z4C-NXT	03067338	2	F	■	3,0	6,0	7,0	57,0	0,04	4	Cylindrical	■
JS564040F2C.0Z4C-NXT	03067339	2	F	■	4,0	6,0	10,0	57,0	0,05	4	Cylindrical	■
JS564050F2C.0Z4C-NXT	03067340	2	F	■	5,0	6,0	12,5	57,0	0,06	4	Cylindrical	■
JS564060D2C.0Z4C-NXT	03067341	2	D	■	6,0	6,0	15,0	57,0	0,075	4	Cylindrical	■
JS564080D2C.0Z4C-NXT	03067342	2	D	■	8,0	8,0	20,0	63,0	0,1	4	Cylindrical	■
JS564100D2C.0Z4C-NXT	03067343	2	D	■	10,0	10,0	25,0	72,0	0,125	4	Cylindrical	■
JS564120D2C.0Z4C-NXT	03067344	2	D	■	12,0	12,0	30,0	83,0	0,15	4	Cylindrical	■
JS564160D2C.0Z4C-NXT	03067345	2	D	■	16,0	16,0	40,0	99,0	0,2	4	Cylindrical	■
JS564200D2C.0Z4C-NXT	03067346	2	D	■	20,0	20,0	50,0	114,0	0,25	4	Cylindrical	■
JS564060D3C.0Z4C-NXT	03067347	3	D	■	6,0	6,0	23,0	64,0	0,075	4	Cylindrical	■
JS564080D3C.0Z4C-NXT	03067348	3	D	■	8,0	8,0	32,0	74,0	0,1	4	Cylindrical	■
JS564100D3C.0Z4C-NXT	03067349	3	D	■	10,0	10,0	40,0	88,0	0,125	4	Cylindrical	■
JS564120D3C.0Z4C-NXT	03067350	3	D	■	12,0	12,0	45,0	99,0	0,15	4	Cylindrical	■
JS564160D3C.0Z4C-NXT	03067351	3	D	■	16,0	16,0	55,0	114,0	0,2	4	Cylindrical	■
JS564200D3C.0Z4C-NXT	03067352	3	D	■	20,0	20,0	65,0	126,0	0,25	4	Cylindrical	■
JS564060D4C.0Z4C-NXT	10273179	4	D	■	6,0	6,0	30,0	80,0	0,075	4	Cylindrical	■
JS564080D4C.0Z4C-NXT	10273180	4	D	■	8,0	8,0	40,0	85,0	0,1	4	Cylindrical	■
JS564100D4C.0Z4C-NXT	10273181	4	D	■	10,0	10,0	50,0	100,0	0,125	4	Cylindrical	■
JS564120D4C.0Z4C-NXT	10273182	4	D	■	12,0	12,0	60,0	115,0	0,15	4	Cylindrical	■
JS564160D4C.0Z4C-NXT	10273183	4	D	■	16,0	16,0	80,0	150,0	0,2	4	Cylindrical	■
JS564200D4C.0Z4C-NXT	10273184	4	D	■	20,0	20,0	100,0	175,0	0,25	4	Cylindrical	■
JS564250D4C.0Z4C-NXT	10273185	4	D	■	25,0	25,0	125,0	205,0	0,3	4	Cylindrical	■

■ **Lagerstandard.**

JS564

Dynamisches Fräsen – Universell – Eckfräser – 4 Schneiden – Weldon – Fase





F D

—Toleranzen:
—DMM = h5
—DC= e7
—Nachschleifen möglich, wenn DC ≥ Ø8 ist

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JS564030F2C.3Z4C-NXT	03067353	2	F	■	3,0	6,0	7,0	57,0	0,04	4	Weldon	■
JS564040F2C.3Z4C-NXT	03067354	2	F	■	4,0	6,0	10,0	57,0	0,05	4	Weldon	■
JS564050F2C.3Z4C-NXT	03067355	2	F	■	5,0	6,0	12,5	57,0	0,06	4	Weldon	■
JS564060D2C.3Z4C-NXT	03067356	2	D	■	6,0	6,0	15,0	57,0	0,075	4	Weldon	■
JS564080D2C.3Z4C-NXT	03067357	2	D	■	8,0	8,0	20,0	63,0	0,1	4	Weldon	■
JS564100D2C.3Z4C-NXT	03067358	2	D	■	10,0	10,0	25,0	72,0	0,125	4	Weldon	■
JS564120D2C.3Z4C-NXT	03067359	2	D	■	12,0	12,0	30,0	83,0	0,15	4	Weldon	■
JS564160D2C.3Z4C-NXT	03067360	2	D	■	16,0	16,0	40,0	99,0	0,2	4	Weldon	■
JS564200D2C.3Z4C-NXT	03067361	2	D	■	20,0	20,0	50,0	114,0	0,25	4	Weldon	■
JS564060D3C.3Z4C-NXT	03067362	3	D	■	6,0	6,0	23,0	64,0	0,075	4	Weldon	■
JS564080D3C.3Z4C-NXT	03067363	3	D	■	8,0	8,0	32,0	74,0	0,1	4	Weldon	■
JS564100D3C.3Z4C-NXT	03067364	3	D	■	10,0	10,0	40,0	88,0	0,125	4	Weldon	■
JS564120D3C.3Z4C-NXT	03067365	3	D	■	12,0	12,0	45,0	99,0	0,15	4	Weldon	■
JS564160D3C.3Z4C-NXT	03067366	3	D	■	16,0	16,0	55,0	114,0	0,2	4	Weldon	■
JS564200D3C.3Z4C-NXT	03067367	3	D	■	20,0	20,0	65,0	126,0	0,25	4	Weldon	■
JS564060D4C.3Z4C-NXT	10273186	4	D	■	6,0	6,0	30,0	80,0	0,075	4	Weldon	□
JS564080D4C.3Z4C-NXT	10273187	4	D	■	8,0	8,0	40,0	85,0	0,1	4	Weldon	□
JS564100D4C.3Z4C-NXT	10273188	4	D	■	10,0	10,0	50,0	100,0	0,125	4	Weldon	□
JS564120D4C.3Z4C-NXT	10273189	4	D	■	12,0	12,0	60,0	115,0	0,15	4	Weldon	□
JS564160D4C.3Z4C-NXT	10273190	4	D	■	16,0	16,0	80,0	150,0	0,2	4	Weldon	□
JS564200D4C.3Z4C-NXT	10273191	4	D	■	20,0	20,0	100,0	175,0	0,25	4	Weldon	□
JS564250D4C.3Z4C-NXT	10273192	4	D	■	25,0	25,0	125,0	205,0	0,3	4	Weldon	■

■ **Lagerstandard.**

Schnittdaten – JS564 Eckfräsen dynamisches Fräsen

SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
P1	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	305 (270 — 340) *1000 (890 — 1100)*
P2	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	295 (260 — 330) *970 (860 — 1000)*
P3	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	260 (230 — 290) *850 (760 — 950)*
P4	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	230 (200 — 250) *750 (660 — 820)*
P5	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	215 (190 — 240) *710 (630 — 780)*
P6	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	240 (210 — 270) *790 (690 — 880)*
P7	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	230 (200 — 250) *750 (660 — 820)*
P8	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	215 (190 — 240) *710 (630 — 780)*
P11	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.22 *0,0085*	0.25 *0,010*	200 (180 — 220) *660 (600 — 720)*
P12	E/M/A/D	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (120 — 140) *425 (400 — 450)*
M1	E	0.150 *0,150*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	195 (170 — 210) *640 (560 — 680)*
M2	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	160 (140 — 170) *520 (460 — 550)*
M3	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 140) *425 (370 — 450)*
M4	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 140) *425 (370 — 450)*
M5	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	110 (92 — 120) *360 (310 — 390)*
K1	E	0.150 *0,150*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	260 (230 — 290) *850 (760 — 950)*
K2	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	230 (200 — 250) *750 (660 — 820)*
K3	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	195 (170 — 210) *640 (560 — 680)*
K4	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	185 (170 — 200) *610 (560 — 650)*
K5	E	0.150 *0,150*	2.4 *2,4*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	115 (99 — 120) *375 (330 — 390)*
K6	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	165 (150 — 180) *540 (500 — 590)*
K7	E	0.150 *0,150*	2.4 *2,4*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	145 (130 — 160) *475 (430 — 520)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS564 Eckfräsen dynamisches Fräsen

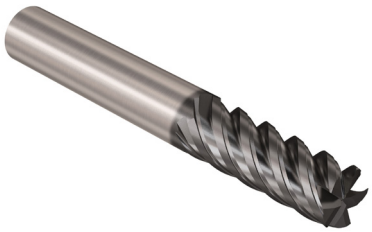
SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
N1	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	700 (600 — 790) *2300 (2000 — 2500)*
N2	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	450 (390 — 510) *1475 (1300 — 1600)*
N3	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	500 (400 — 590) *1650 (1400 — 1900)*
N11	E	0.150 *0,150*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	350 (300 — 390) *1150 (990 — 1200)*
S1	E	0.0300 *0,0300*	2.4 *2,4*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	60 (37 — 86) *195 (130 — 280)*
S2	E	0.0300 *0,0300*	2.4 *2,4*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	50 (30 — 69) *165 (99 — 220)*
S3	E	0.0300 *0,0300*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	43 (26 — 60) *140 (86 — 190)*
S11	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	160 (140 — 180) *520 (460 — 590)*
S12	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 140) *410 (370 — 450)*
S13	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 140) *410 (370 — 450)*
H8	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	160 (140 — 180) *520 (460 — 590)*
H21	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	160 (140 — 180) *520 (460 — 590)*
H31	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.018 *0,00070*	0.024 *0,00095*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	125 (110 — 140) *410 (370 — 450)*

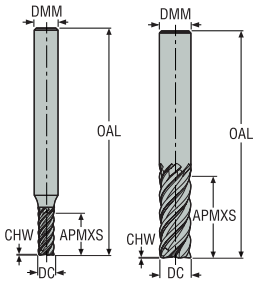
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

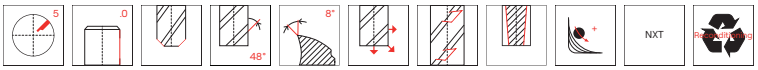
JS565

Dynamisches Fräsen – Universell – Eckfräser – 5 Schneiden – Zylindrisch – Fase





– Toleranzen:
– DMM = h5
– DC= e7
– Nachschleifen möglich, wenn DC ≥ Ø8 ist



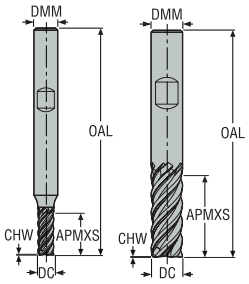
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JS565040F2C.0Z5-NXT	03067369	2	F	–	4,0	6,0	10,0	57,0	0,05	5	Cylindrical	■
JS565040F2C.0Z5C-NXT	03067378	2	F	■	4,0	6,0	10,0	57,0	0,05	5	Cylindrical	■
JS565050F2C.0Z5-NXT	03067370	2	F	–	5,0	6,0	12,5	57,0	0,06	5	Cylindrical	■
JS565050F2C.0Z5C-NXT	03067379	2	F	■	5,0	6,0	12,5	57,0	0,06	5	Cylindrical	■
JS565060D2C.0Z5-NXT	03067371	2	D	–	6,0	6,0	15,0	57,0	0,075	5	Cylindrical	■
JS565060D2C.0Z5C-NXT	03067380	2	D	■	6,0	6,0	15,0	57,0	0,075	5	Cylindrical	■
JS565080D2C.0Z5-NXT	03067372	2	D	–	8,0	8,0	20,0	63,0	0,1	5	Cylindrical	■
JS565080D2C.0Z5C-NXT	03067381	2	D	■	8,0	8,0	20,0	63,0	0,1	5	Cylindrical	■
JS565100D2C.0Z5-NXT	03067373	2	D	–	10,0	10,0	25,0	72,0	0,125	5	Cylindrical	■
JS565100D2C.0Z5C-NXT	03067382	2	D	■	10,0	10,0	25,0	72,0	0,125	5	Cylindrical	■
JS565120D2C.0Z5-NXT	03067374	2	D	–	12,0	12,0	30,0	83,0	0,15	5	Cylindrical	■
JS565120D2C.0Z5C-NXT	03067383	2	D	■	12,0	12,0	30,0	83,0	0,15	5	Cylindrical	■
JS565160D2C.0Z5-NXT	03067375	2	D	–	16,0	16,0	40,0	99,0	0,2	5	Cylindrical	■
JS565160D2C.0Z5C-NXT	03067384	2	D	■	16,0	16,0	40,0	99,0	0,2	5	Cylindrical	■
JS565200D2C.0Z5-NXT	03067376	2	D	–	20,0	20,0	50,0	114,0	0,25	5	Cylindrical	■
JS565200D2C.0Z5C-NXT	03067385	2	D	■	20,0	20,0	50,0	114,0	0,25	5	Cylindrical	■
JS565060D3C.0Z5C-NXT	03067386	3	D	■	6,0	6,0	23,0	64,0	0,075	5	Cylindrical	■
JS565080D3C.0Z5C-NXT	03067387	3	D	■	8,0	8,0	32,0	74,0	0,1	5	Cylindrical	■
JS565100D3C.0Z5C-NXT	03067388	3	D	■	10,0	10,0	40,0	88,0	0,125	5	Cylindrical	■
JS565120D3C.0Z5C-NXT	03067389	3	D	■	12,0	12,0	45,0	99,0	0,15	5	Cylindrical	■
JS565160D3C.0Z5C-NXT	03067390	3	D	■	16,0	16,0	55,0	114,0	0,2	5	Cylindrical	■
JS565200D3C.0Z5C-NXT	03067391	3	D	■	20,0	20,0	65,0	126,0	0,25	5	Cylindrical	■
JS565060D4C.0Z5C-NXT	10273193	4	D	■	6,0	6,0	30,0	80,0	0,075	5	Cylindrical	■
JS565080D4C.0Z5C-NXT	10273194	4	D	■	8,0	8,0	40,0	85,0	0,1	5	Cylindrical	■
JS565100D4C.0Z5C-NXT	10273195	4	D	■	10,0	10,0	50,0	100,0	0,125	5	Cylindrical	■
JS565120D4C.0Z5C-NXT	10273196	4	D	■	12,0	12,0	60,0	115,0	0,15	5	Cylindrical	■
JS565160D4C.0Z5C-NXT	10273197	4	D	■	16,0	16,0	80,0	150,0	0,2	5	Cylindrical	■
JS565200D4C.0Z5C-NXT	10273198	4	D	■	20,0	20,0	100,0	175,0	0,25	5	Cylindrical	■
JS565250D4C.0Z5C-NXT	10273199	4	D	■	25,0	25,0	125,0	205,0	0,3	5	Cylindrical	■

■ **Lagerstandard.**

JS565

Dynamisches Fräsen – Universell – Eckfräser – 5 Schneiden – Weldon – Fase





—Toleranzen:
—DMM = h5
—DC= e7
—Nachschleifen möglich, wenn DC ≥ Ø8 ist

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JS565040F2C.3Z5-NXT	03067393	2	F	–	4,0	6,0	10,0	57,0	0,05	5	Weldon	■
JS565040F2C.3Z5C-NXT	03067402	2	F	■	4,0	6,0	10,0	57,0	0,05	5	Weldon	■
JS565050F2C.3Z5-NXT	03067394	2	F	–	5,0	6,0	12,5	57,0	0,06	5	Weldon	■
JS565050F2C.3Z5C-NXT	03067403	2	F	■	5,0	6,0	12,5	57,0	0,06	5	Weldon	■
JS565060D2C.3Z5-NXT	03067395	2	D	–	6,0	6,0	15,0	57,0	0,075	5	Weldon	■
JS565060D2C.3Z5C-NXT	03067404	2	D	■	6,0	6,0	15,0	57,0	0,075	5	Weldon	■
JS565080D2C.3Z5-NXT	03067396	2	D	–	8,0	8,0	20,0	63,0	0,1	5	Weldon	■
JS565080D2C.3Z5C-NXT	03067405	2	D	■	8,0	8,0	20,0	63,0	0,1	5	Weldon	■
JS565100D2C.3Z5-NXT	03067397	2	D	–	10,0	10,0	25,0	72,0	0,125	5	Weldon	■
JS565100D2C.3Z5C-NXT	03067406	2	D	■	10,0	10,0	25,0	72,0	0,125	5	Weldon	■
JS565120D2C.3Z5-NXT	03067398	2	D	–	12,0	12,0	30,0	83,0	0,15	5	Weldon	■
JS565120D2C.3Z5C-NXT	03067407	2	D	■	12,0	12,0	30,0	83,0	0,15	5	Weldon	■
JS565160D2C.3Z5-NXT	03067399	2	D	–	16,0	16,0	40,0	99,0	0,2	5	Weldon	■
JS565160D2C.3Z5C-NXT	03067408	2	D	■	16,0	16,0	40,0	99,0	0,2	5	Weldon	■
JS565200D2C.3Z5-NXT	03067400	2	D	–	20,0	20,0	50,0	114,0	0,25	5	Weldon	■
JS565200D2C.3Z5C-NXT	03067409	2	D	■	20,0	20,0	50,0	114,0	0,25	5	Weldon	■
JS565060D3C.3Z5C-NXT	03067410	3	D	■	6,0	6,0	23,0	64,0	0,075	5	Weldon	■
JS565080D3C.3Z5C-NXT	03067411	3	D	■	8,0	8,0	32,0	74,0	0,1	5	Weldon	■
JS565100D3C.3Z5C-NXT	03067412	3	D	■	10,0	10,0	40,0	88,0	0,125	5	Weldon	■
JS565120D3C.3Z5C-NXT	03067413	3	D	■	12,0	12,0	45,0	99,0	0,15	5	Weldon	■
JS565160D3C.3Z5C-NXT	03067414	3	D	■	16,0	16,0	55,0	114,0	0,2	5	Weldon	■
JS565200D3C.3Z5C-NXT	03067415	3	D	■	20,0	20,0	65,0	126,0	0,25	5	Weldon	■
JS565060D4C.3Z5C-NXT	10273200	4	D	■	6,0	6,0	30,0	80,0	0,075	5	Weldon	□
JS565080D4C.3Z5C-NXT	10273201	4	D	■	8,0	8,0	40,0	85,0	0,1	5	Weldon	□
JS565100D4C.3Z5C-NXT	10273202	4	D	■	10,0	10,0	50,0	100,0	0,125	5	Weldon	□
JS565120D4C.3Z5C-NXT	10273203	4	D	■	12,0	12,0	60,0	115,0	0,15	5	Weldon	□
JS565160D4C.3Z5C-NXT	10273204	4	D	■	16,0	16,0	80,0	150,0	0,2	5	Weldon	□
JS565200D4C.3Z5C-NXT	10273205	4	D	■	20,0	20,0	100,0	175,0	0,25	5	Weldon	□
JS565250D4C.3Z5C-NXT	10273206	4	D	■	25,0	25,0	125,0	205,0	0,3	5	Weldon	■

■ Lagerstandard.

Schnittdaten – JS565 Eckfräsen dynamisches Fräsen

SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
P1	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	325 (270 — 340) *1075 (890 — 1100)*
P2	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	315 (260 — 330) *1025 (860 — 1000)*
P3	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	280 (230 — 290) *920 (760 — 950)*
P4	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	245 (200 — 250) *800 (660 — 820)*
P5	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	230 (190 — 240) *750 (630 — 780)*
P6	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	260 (210 — 270) *850 (690 — 880)*
P7	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	245 (200 — 250) *800 (660 — 820)*
P8	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.22 *0,0085*	230 (190 — 240) *750 (630 — 780)*
P11	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	225 (190 — 230) *740 (630 — 750)*
P12	E/M/A/D	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	140 (120 — 140) *460 (400 — 450)*
M1	E	0.100 *0,100*	2.4 *2,4*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	205 (180 — 210) *670 (600 — 680)*
M2	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	170 (140 — 170) *560 (460 — 550)*
M3	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 140) *425 (370 — 450)*
M4	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 140) *425 (370 — 450)*
M5	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	110 (92 — 120) *360 (310 — 390)*
K1	E	0.100 *0,100*	2.4 *2,4*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	275 (230 — 290) *900 (760 — 950)*
K2	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	245 (200 — 250) *800 (660 — 820)*
K3	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	205 (170 — 210) *670 (560 — 680)*
K4	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	200 (170 — 200) *660 (560 — 650)*
K5	E	0.100 *0,100*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	120 (98 — 120) *395 (330 — 390)*
K6	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	175 (150 — 180) *570 (500 — 590)*
K7	E	0.100 *0,100*	2.4 *2,4*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	155 (130 — 160) *510 (430 — 520)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS565 Eckfräsen dynamisches Fräsen

SMG		a_e/DC	a_p/DC	f_z								v_c
				4	5	6	8	10	12	16	20	
N1	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	740 (600 — 790) *2425 (2000 — 2500)*
N2	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	475 (390 — 510) *1550 (1300 — 1600)*
N3	E	0.100 *0,100*	2.4 *2,4*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	500 (400 — 590) *1650 (1400 — 1900)*
N11	E	0.100 *0,100*	2.4 *2,4*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	370 (300 — 390) *1225 (990 — 1200)*
S1	E	0.0300 *0,0300*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	60 (38 — 86) *195 (130 — 280)*
S2	E	0.0300 *0,0300*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	50 (30 — 70) *165 (99 — 220)*
S3	E	0.0300 *0,0300*	2.4 *2,4*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	43 (27 — 60) *140 (89 — 190)*
S11	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	160 (140 — 180) *520 (460 — 590)*
S12	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 140) *410 (370 — 450)*
S13	E	0.0800 *0,0800*	2.4 *2,4*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 140) *410 (370 — 450)*
H8	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	160 (140 — 180) *520 (460 — 590)*
H21	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.024 *0,00095*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	155 (140 — 180) *510 (460 — 590)*
H31	M/A/D	0.0500 *0,0500*	2.4 *2,4*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	120 (110 — 140) *395 (370 — 450)*

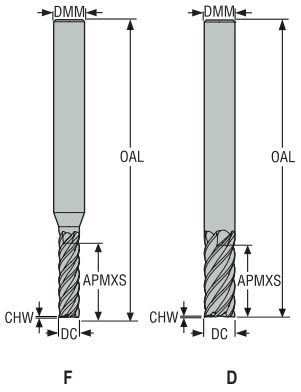
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

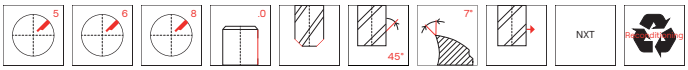
JS520

Hochleistungsfräser – Universell – Eckfräser – 5-8 Schneiden – Zylindrisch – Fase





– Toleranzen:
– DMM=h5
– DC=e7
– Nachschleifen möglich, wenn DC ≥ Ø6 ist



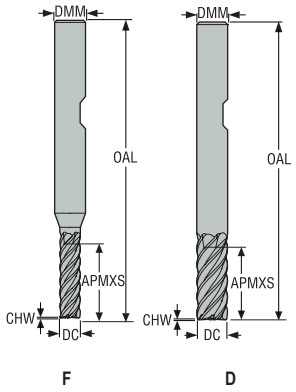
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JS520040F2C.0Z5-NXT	02927474	2	F	4,0	6,0	10,0	57,0	0,04	5	Cylindrical	■
JS520050F2C.0Z5-NXT	02927476	2	F	5,0	6,0	12,0	57,0	0,05	5	Cylindrical	■
JS520060D2C.0Z5-NXT	02927478	2	D	6,0	6,0	15,0	57,0	0,06	5	Cylindrical	■
JS520060D2C.0Z6-NXT	02927479	2	D	6,0	6,0	15,0	57,0	0,06	6	Cylindrical	■
JS520080D2C.0Z5-NXT	02927482	2	D	8,0	8,0	20,0	63,0	0,08	5	Cylindrical	■
JS520080D2C.0Z6-NXT	02927483	2	D	8,0	8,0	20,0	63,0	0,08	6	Cylindrical	■
JS520100D2C.0Z6-NXT	02927486	2	D	10,0	10,0	25,0	72,0	0,1	6	Cylindrical	■
JS520120D2C.0Z6-NXT	02927488	2	D	12,0	12,0	25,0	83,0	0,12	6	Cylindrical	■
JS520140D2C.0Z6-NXT	02927490	2	D	14,0	14,0	30,0	83,0	0,14	6	Cylindrical	■
JS520160D2C.0Z6-NXT	02927491	2	D	16,0	16,0	30,0	92,0	0,16	6	Cylindrical	■
JS520160D2C.0Z8-NXT	02927492	2	D	16,0	16,0	30,0	92,0	0,16	8	Cylindrical	■
JS520200D2C.0Z8-NXT	02927495	2	D	20,0	20,0	35,0	104,0	0,2	8	Cylindrical	■
JS520250D2C.0Z8-NXT	02927497	2	D	25,0	25,0	50,0	125,0	0,25	8	Cylindrical	■
JS520040F3C.0Z5-NXT	02927475	3	F	4,0	6,0	15,0	57,0	0,04	5	Cylindrical	■
JS520050F3C.0Z5-NXT	02927477	3	F	5,0	6,0	19,0	57,0	0,05	5	Cylindrical	■
JS520060D3C.0Z5-NXT	02927480	3	D	6,0	6,0	20,0	63,0	0,06	5	Cylindrical	■
JS520060D3C.0Z6-NXT	02927481	3	D	6,0	6,0	20,0	63,0	0,06	6	Cylindrical	■
JS520080D3C.0Z5-NXT	02927484	3	D	8,0	8,0	30,0	80,0	0,08	5	Cylindrical	■
JS520080D3C.0Z6-NXT	02927485	3	D	8,0	8,0	30,0	80,0	0,08	6	Cylindrical	■
JS520100D3C.0Z6-NXT	02927487	3	D	10,0	10,0	40,0	89,0	0,1	6	Cylindrical	■
JS520120D3C.0Z6-NXT	02927489	3	D	12,0	12,0	45,0	100,0	0,12	6	Cylindrical	■
JS520160D3C.0Z6-NXT	02927493	3	D	16,0	16,0	65,0	125,0	0,16	6	Cylindrical	■
JS520160D3C.0Z8-NXT	02927494	3	D	16,0	16,0	65,0	125,0	0,16	8	Cylindrical	■
JS520200D3C.0Z8-NXT	02927496	3	D	20,0	20,0	65,0	125,0	0,2	8	Cylindrical	■
JS520250D3C.0Z8-NXT	02927498	3	D	25,0	25,0	75,0	150,0	0,25	8	Cylindrical	■

■ **Lagerstandard.**

JS520

Hochleistungsfräser – Universell – Eckfräser – 5-8 Schneiden – Weldon – Fase





—Toleranzen:
—DMM=h5
—DC=e7
—Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JS520040F2C.3Z5-NXT	02927499	2	F	4,0	6,0	10,0	57,0	0,04	5	Weldon	□
JS520050F2C.3Z5-NXT	02927501	2	F	5,0	6,0	12,0	57,0	0,05	5	Weldon	□
JS520060D2C.3Z5-NXT	02927503	2	D	6,0	6,0	15,0	57,0	0,06	5	Weldon	□
JS520060D2C.3Z6-NXT	02927504	2	D	6,0	6,0	15,0	57,0	0,06	6	Weldon	□
JS520080D2C.3Z5-NXT	02927507	2	D	8,0	8,0	20,0	63,0	0,08	5	Weldon	□
JS520080D2C.3Z6-NXT	02927508	2	D	8,0	8,0	20,0	63,0	0,08	6	Weldon	■
JS520100D2C.3Z6-NXT	02927511	2	D	10,0	10,0	25,0	72,0	0,1	6	Weldon	■
JS520120D2C.3Z6-NXT	02927513	2	D	12,0	12,0	25,0	83,0	0,12	6	Weldon	■
JS520140D2C.3Z6-NXT	02927515	2	D	14,0	14,0	30,0	83,0	0,14	6	Weldon	□
JS520160D2C.3Z6-NXT	02927516	2	D	16,0	16,0	30,0	92,0	0,16	6	Weldon	□
JS520160D2C.3Z8-NXT	02927517	2	D	16,0	16,0	30,0	92,0	0,16	8	Weldon	■
JS520200D2C.3Z8-NXT	02927520	2	D	20,0	20,0	35,0	104,0	0,2	8	Weldon	■
JS520250D2C.3Z8-NXT	02927522	2	D	25,0	25,0	50,0	125,0	0,25	8	Weldon	■
JS520040F3C.3Z5-NXT	02927500	3	F	4,0	6,0	15,0	57,0	0,04	5	Weldon	□
JS520050F3C.3Z5-NXT	02927502	3	F	5,0	6,0	19,0	57,0	0,05	5	Weldon	□
JS520060D3C.3Z5-NXT	02927505	3	D	6,0	6,0	20,0	63,0	0,06	5	Weldon	□
JS520060D3C.3Z6-NXT	02927506	3	D	6,0	6,0	20,0	63,0	0,06	6	Weldon	□
JS520080D3C.3Z5-NXT	02927509	3	D	8,0	8,0	30,0	80,0	0,08	5	Weldon	□
JS520080D3C.3Z6-NXT	02927510	3	D	8,0	8,0	30,0	80,0	0,08	6	Weldon	□
JS520100D3C.3Z6-NXT	02927512	3	D	10,0	10,0	40,0	89,0	0,1	6	Weldon	□
JS520120D3C.3Z6-NXT	02927514	3	D	12,0	12,0	45,0	100,0	0,12	6	Weldon	□
JS520160D3C.3Z6-NXT	02927518	3	D	16,0	16,0	65,0	125,0	0,16	6	Weldon	□
JS520160D3C.3Z8-NXT	02927519	3	D	16,0	16,0	65,0	125,0	0,16	8	Weldon	□
JS520200D3C.3Z8-NXT	02927521	3	D	20,0	20,0	65,0	125,0	0,2	8	Weldon	■
JS520250D3C.3Z8-NXT	02927523	3	D	25,0	25,0	75,0	150,0	0,25	8	Weldon	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JS520 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z										v_c
				4	5	6	8	10	12	14	16	20	25	
P1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	180 (120 — 250) *590 (400 — 820)*
P2	E/M/A	0.100 *0,100*	2.0 *2,0*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	175 (110 — 240) *570 (370 — 780)*
P3	E/M/A	0.100 *0,100*	2.0 *2,0*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	155 (95 — 210) *510 (320 — 680)*
P4	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	135 (84 — 180) *445 (280 — 590)*
P5	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	130 (81 — 180) *425 (270 — 590)*
P6	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	145 (90 — 200) *475 (300 — 650)*
P7	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	140 (85 — 190) *460 (280 — 620)*
P8	E/M/A	0.100 *0,100*	2.0 *2,0*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	130 (80 — 170) *425 (270 — 550)*
P11	E/M/A	0.100 *0,100*	2.0 *2,0*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.17 *0,0065*	0.20 *0,0080*	0.22 *0,0085*	195 (160 — 230) *640 (530 — 750)*
P12	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	125 (100 — 140) *410 (330 — 450)*
M1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	150 (130 — 180) *490 (430 — 590)*
M2	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	125 (100 — 150) *410 (330 — 490)*
M3	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	100 (75 — 120) *330 (250 — 390)*
M4	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	75 (58 — 96) *245 (200 — 310)*
M5	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	65 (49 — 80) *215 (170 — 260)*
K1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	175 (110 — 240) *570 (370 — 780)*
K2	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	155 (97 — 210) *510 (320 — 680)*
K3	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	135 (82 — 180) *445 (270 — 590)*
K4	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	125 (79 — 170) *410 (260 — 550)*
K5	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	75 (48 — 100) *245 (160 — 320)*
K6	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	110 (69 — 150) *360 (230 — 490)*
K7	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	100 (62 — 130) *330 (210 — 420)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS520 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z										v_c
				4	5	6	8	10	12	14	16	20	25	
N1	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	500 (450 — 550) *1650 (1500 — 1800)*
N2	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	320 (290 — 350) *1050 (960 — 1100)*
N3	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	215 (200 — 230) *710 (660 — 750)*
N11	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	400 (350 — 450) *1300 (1200 — 1400)*
S1	E/M/A	0.0600 *0,0600*	2.0 *2,0*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	75 (63 — 86) *245 (210 — 280)*
S2	E/M/A	0.0600 *0,0600*	2.0 *2,0*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	60 (50 — 70) *195 (170 — 220)*
S3	E/M/A	0.0600 *0,0600*	2.0 *2,0*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	40 (30 — 49) *130 (99 — 160)*
S11	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	105 (92 — 110) *345 (310 — 360)*
S12	E/M/A	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	80 (71 — 90) *260 (240 — 290)*
S13	E/M/A	0.100 *0,100*	2.0 *2,0*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	65 (56 — 71) *215 (190 — 230)*
H5	M/A	0.0600 *0,0600*	2.0 *2,0*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	125 (64 — 180) *410 (210 — 590)*
H8	M/A	0.0600 *0,0600*	2.0 *2,0*	0.024 *0,00095*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	130 (66 — 190) *425 (220 — 620)*
H11	M/A	0.0600 *0,0600*	2.0 *2,0*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	160 (81 — 240) *520 (270 — 780)*
H12	M/A	0.0600 *0,0600*	2.0 *2,0*	0.024 *0,00095*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	150 (76 — 220) *490 (250 — 720)*
H21	M/A	0.0600 *0,0600*	2.0 *2,0*	0.024 *0,00095*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	130 (66 — 190) *425 (220 — 620)*
H31	M/A	0.0600 *0,0600*	2.0 *2,0*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	100 (51 — 150) *330 (170 — 490)*
TS1	A/D	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	500 (450 — 550) *1650 (1500 — 1800)*
TP1	A/D	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	395 (350 — 440) *1300 (1200 — 1400)*
GR1	A/D	0.100 *0,100*	2.0 *2,0*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	500 (450 — 550) *1650 (1500 — 1800)*

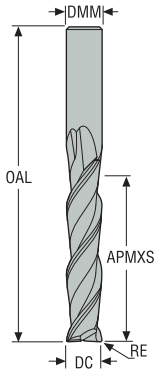
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

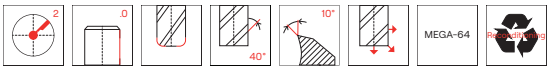
JS522

Hochleistungsfräser – Universell – Eckfräser – 2 Schneiden – Hohe Schulter – Zylindrisch – Eckenradius





D



- Toleranzen:
- Rundlaufabweichung = Ø6-Ø8 <0,01, Ø10-Ø12 <0,015, Ø16-Ø32 <0,02
- DMM = h5
- DC= -0,02/-0,04 mm
- RE= 0,1+0,1 mm, RE= 0,5 ±0,03 mm
  RE= 3,1 ±0,05 mm, RE= 4 ±0,05 mm
  RE= 6 ±0,05 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
522060R010Z2.0-MEGA-64	02747756	4	D	6,0	6,0	30,0	80,0	0,1	2	Cylindrical	■
522080R010Z2.0-MEGA-64	02747763	4	D	8,0	8,0	40,0	85,0	0,1	2	Cylindrical	■
522100R010Z2.0-MEGA-64	02747765	4	D	10,0	10,0	50,0	100,0	0,1	2	Cylindrical	■
522120R010Z2.0-MEGA-64	02747766	4	D	12,0	12,0	60,0	115,0	0,1	2	Cylindrical	■
522160R050Z2.0-MEGA-64	02747767	4	D	16,0	16,0	80,0	150,0	0,5	2	Cylindrical	■
522160R310Z2.0-MEGA-64	02747768	4	D	16,0	16,0	80,0	150,0	3,1	2	Cylindrical	■
JS522160D4R600.0Z2-M64	03093681	4	D	16,0	16,0	80,0	150,0	6,0	2	Cylindrical	■
522200R050Z2.0-MEGA-64	02747769	4	D	20,0	20,0	100,0	175,0	0,5	2	Cylindrical	■
522200R310Z2.0-MEGA-64	02747770	4	D	20,0	20,0	100,0	175,0	3,1	2	Cylindrical	■
JS522200D4R600.0Z2-M64	03093682	4	D	20,0	20,0	100,0	175,0	6,0	2	Cylindrical	■
522250R050Z2.0-MEGA-64	02747771	4	D	25,0	25,0	125,0	205,0	0,5	2	Cylindrical	■
522250R310Z2.0-MEGA-64	02747772	4	D	25,0	25,0	125,0	205,0	3,1	2	Cylindrical	■
522250R400Z2.0-MEGA-64	02747773	4	D	25,0	25,0	125,0	205,0	4,0	2	Cylindrical	■
JS522250D4R600.0Z2-M64	03093683	4	D	25,0	25,0	125,0	205,0	6,0	2	Cylindrical	■
522320R050Z2.0-MEGA-64	02747774	4	D	32,0	32,0	160,0	245,0	0,5	2	Cylindrical	■
522320R400Z2.0-MEGA-64	02747775	4	D	32,0	32,0	160,0	245,0	4,0	2	Cylindrical	■
JS522320D4R600.0Z2-M64	03093684	4	D	32,0	32,0	160,0	245,0	6,0	2	Cylindrical	■

■ **Lagerstandard.**

*JS522 Schlichtfräser mit langer Schneide sorgt für exzellente Oberflächengüten und Rechtwinkligkeit bei hohen Schultern.

Schnittdaten – JS522 Eckfräsen/Vorschlichten

SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	16	20	25	32	
P1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	160 (140 — 170) *520 (460 — 550)*
P2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	155 (140 — 170) *510 (460 — 550)*
P3	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	165 (150 — 180) *540 (500 — 590)*
P4	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	145 (130 — 160) *475 (430 — 520)*
P5	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	140 (130 — 160) *460 (430 — 520)*
P6	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	120 (110 — 140) *395 (370 — 450)*
P7	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	115 (95 — 130) *375 (320 — 420)*
P8	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	105 (89 — 120) *345 (300 — 390)*
P11	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	0.22 *0,0085*	105 (87 — 120) *345 (290 — 390)*
P12	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	65 (55 — 75) *215 (190 — 240)*
M1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	110 (86 — 130) *360 (290 — 420)*
M2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	90 (71 — 110) *295 (240 — 360)*
M3	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	80 (61 — 100) *260 (210 — 320)*
M4	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	60 (47 — 76) *195 (160 — 240)*
M5	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	50 (39 — 63) *165 (130 — 200)*
K1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	120 (100 — 130) *395 (330 — 420)*
K2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	105 (87 — 120) *345 (290 — 390)*
K3	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	90 (74 — 100) *295 (250 — 320)*
K4	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	85 (71 — 98) *280 (240 — 320)*
K5	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	100 (81 — 120) *330 (270 — 390)*
K6	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	150 (120 — 170) *490 (400 — 550)*
K7	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	130 (110 — 150) *425 (370 — 490)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS522 Eckfräsen/Vorschlichten

SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	16	20	25	32	
N1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	400 (310 — 500) *1300 (1100 — 1600)*
N2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	300 (210 — 400) *980 (690 — 1300)*
N3	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	200 (140 — 260) *660 (460 — 850)*
N11	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	300 (260 — 350) *980 (860 — 1100)*
S1	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	48 (39 — 57) *155 (130 — 180)*
S2	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	39 (31 — 46) *130 (110 — 150)*
S3	E/M/A	0.0300 *0,0300*	4.0 *4,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	42 (32 — 51) *140 (110 — 160)*
S11	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	125 (100 — 140) *410 (330 — 450)*
S12	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	95 (77 — 110) *310 (260 — 360)*
S13	E/M/A	0.0500 *0,0500*	4.0 *4,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	75 (61 — 90) *245 (210 — 290)*
TS1	A/D	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	500 (410 — 600) *1650 (1400 — 1900)*
TP1	A/D	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	400 (310 — 500) *1300 (1100 — 1600)*
GR1	A/D	0.0500 *0,0500*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	500 (410 — 600) *1650 (1400 — 1900)*

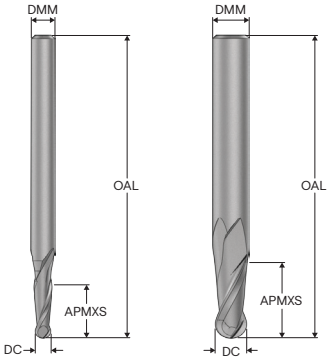
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

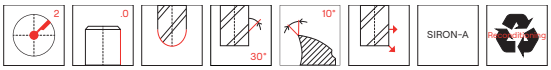
C5321

Allgemeine Anwendung – Universell – Kugelkopf – 2 Schneiden – Zylindrisch





– Toleranzen:
– DMM=h5
– DC= h10
– RE= ±0,01 mm
– Nachschleifen möglich, wenn DC ≥ Ø10 ist



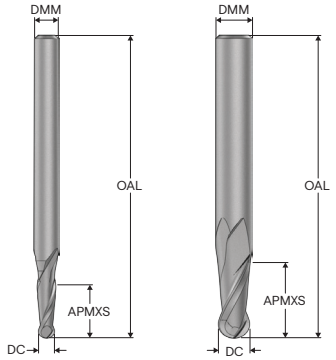
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	RE	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm			
C5321-060D1B.0Z2	SIRA	10268679	1	D	6,0	6,0	9,0	57,0	3,0	2	Cylindrical	■
C5321-020F2B.0Z2	SIRA	10268669	2	F	2,0	3,0	4,0	38,0	1,0	2	Cylindrical	■
C5321-030D2B.0Z2	SIRA	10268672	2	D	3,0	3,0	6,0	38,0	1,5	2	Cylindrical	■
C5321-040D2B.0Z2	SIRA	10268675	2	D	4,0	4,0	8,0	50,0	2,0	2	Cylindrical	■
C5321-050F2B.0Z2	SIRA	10268677	2	F	5,0	6,0	10,0	57,0	2,5	2	Cylindrical	■
C5321-060D2B.0Z2	SIRA	10268680	2	D	6,0	6,0	12,0	57,0	3,0	2	Cylindrical	■
C5321-080D2B.0Z2	SIRA	10268682	2	D	8,0	8,0	16,0	63,0	4,0	2	Cylindrical	■
C5321-090F2B.0Z2	SIRA	10268684	2	F	9,0	10,0	22,0	72,0	4,5	2	Cylindrical	■
C5321-100D2B.0Z2	SIRA	10268685	2	D	10,0	10,0	22,0	72,0	5,0	2	Cylindrical	■
C5321-120D2B.0Z2	SIRA	10268687	2	D	12,0	12,0	25,0	83,0	6,0	2	Cylindrical	■
C5321-015F3B.0Z2	SIRA	10268668	3	F	1,5	3,0	4,5	38,0	0,75	2	Cylindrical	■
C5321-020F3B.0Z2	SIRA	10268670	3	F	2,0	3,0	6,3	38,0	1,0	2	Cylindrical	■
C5321-035F3B.0Z2	SIRA	10268674	3	F	3,5	4,0	12,0	50,0	1,75	2	Cylindrical	■
C5321-050F3B.0Z2	SIRA	10268678	3	F	5,0	6,0	16,0	57,0	2,5	2	Cylindrical	■
C5321-060D3B.0Z2	SIRA	10268681	3	D	6,0	6,0	19,0	63,0	3,0	2	Cylindrical	■
C5321-080D3B.0Z2	SIRA	10268683	3	D	8,0	8,0	20,0	63,0	4,0	2	Cylindrical	■
C5321-010F4B.0Z2	SIRA	10268667	4	F	1,0	3,0	4,0	38,0	0,5	2	Cylindrical	■
C5321-030D4B.0Z2	SIRA	10268673	4	D	3,0	3,0	12,0	38,0	1,5	2	Cylindrical	■
C5321-040D4B.0Z2	SIRA	10268676	4	D	4,0	4,0	14,0	50,0	2,0	2	Cylindrical	■
C5321-100D4B.0Z2	SIRA	10268686	4	D	10,0	10,0	35,0	89,0	5,0	2	Cylindrical	■
C5321-120D4B.0Z2	SIRA	10268688	4	D	12,0	12,0	50,0	100,0	6,0	2	Cylindrical	■

■ **Lagerstandard.**

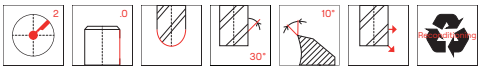
C5321

Allgemeine Anwendung – Universell – Kugelkopf – 2 Schneiden – Zylindrisch – Zoll





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—DC > Ø7/64" = +.000"/-.002"
—RE= ±.0005"
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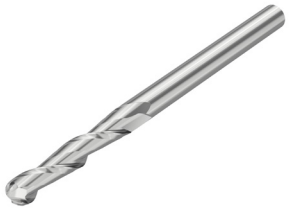


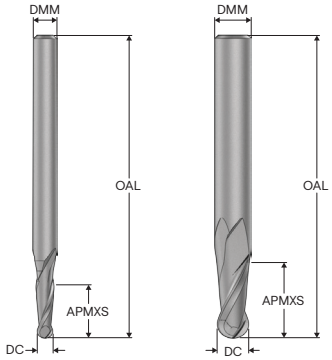
Bezeichnung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	RE	PCEDC	Aufnahmen	Lagerstandard
				Zoll	Zoll	Zoll	Zoll	Zoll			
C5321-.500D1B.0Z2	10268913	1	D	0.500	0.500	0.625	2.500	0.250	2	Cylindrical	■
C5321-1.000D1B.0Z2	10268923	1	D	1.000	1.000	1.500	4.000	0.500	2	Cylindrical	■
C5321-.016F2B.0Z2	10268878	2	F	0.016	0.125	0.031	1.500	0.008	2	Cylindrical	■
C5321-.047F2B.0Z2	10268881	2	F	0.047	0.125	0.109	1.500	0.023	2	Cylindrical	■
C5321-.063F2B.0Z2	10268883	2	F	0.063	0.125	0.125	1.500	0.031	2	Cylindrical	■
C5321-.078F2B.0Z2	10268886	2	F	0.078	0.125	0.188	1.500	0.039	2	Cylindrical	■
C5321-.094F2B.0Z2	10268888	2	F	0.094	0.125	0.188	1.500	0.047	2	Cylindrical	■
C5321-.125D2B.0Z2	10268891	2	D	0.125	0.125	0.250	1.500	0.063	2	Cylindrical	■
C5321-.188D2B.0Z2	10268896	2	D	0.188	0.188	0.375	2.000	0.094	2	Cylindrical	■
C5321-.250D2B.0Z2	10268899	2	D	0.250	0.250	0.500	2.000	0.125	2	Cylindrical	■
C5321-.375D2B.0Z2	10268908	2	D	0.375	0.375	0.625	2.000	0.188	2	Cylindrical	■
C5321-.500D2B.0Z2	10268914	2	D	0.500	0.500	1.000	3.000	0.250	2	Cylindrical	■
C5321-.625D2B.0Z2	10268919	2	D	0.625	0.625	1.250	3.500	0.313	2	Cylindrical	■
C5321-.750D2B.0Z2	10268921	2	D	0.750	0.750	1.500	4.000	0.375	2	Cylindrical	■
C5321-.031F3B.0Z2	10268879	3	F	0.031	0.125	0.078	1.500	0.016	2	Cylindrical	■
C5321-.047F3B.0Z2	10268882	3	F	0.047	0.125	0.125	1.500	0.023	2	Cylindrical	■
C5321-.063F3B.0Z2	10268884	3	F	0.063	0.125	0.188	1.500	0.031	2	Cylindrical	■
C5321-.078F3B.0Z2	10268887	3	F	0.078	0.125	0.250	1.500	0.039	2	Cylindrical	■
C5321-.094F3B.0Z2	10268889	3	F	0.094	0.125	0.281	1.500	0.047	2	Cylindrical	■
C5321-.156F3B.0Z2	10268895	3	F	0.156	0.188	0.500	2.000	0.078	2	Cylindrical	■
C5321-.188D3B.0Z2	10268897	3	D	0.188	0.188	0.625	2.000	0.094	2	Cylindrical	■
C5321-.250D3B.0Z2	10268900	3	D	0.250	0.250	0.750	2.500	0.125	2	Cylindrical	■
C5321-.313D3B.0Z2	10268905	3	D	0.313	0.313	0.813	2.500	0.156	2	Cylindrical	■
C5321-.375D3B.0Z2	10268909	3	D	0.375	0.375	1.000	2.500	0.188	2	Cylindrical	■
C5321-.500D3B.0Z2	10268915	3	D	0.500	0.500	1.000	4.000	0.250	2	Cylindrical	■
C5321-.750D3B.0Z2	10268922	3	D	0.750	0.750	2.000	6.000	0.375	2	Cylindrical	■

■ **Lagerstandard.**

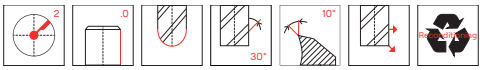
C5321

Allgemeine Anwendung – Universell – Kugelkopf – 2 Schneiden – Zylindrisch – Zoll





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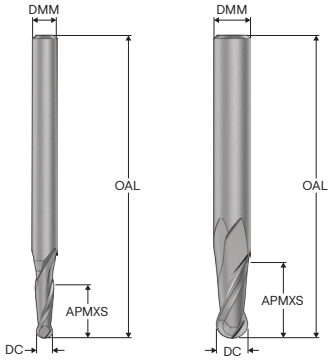
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				Zoll	Zoll	Zoll	Zoll	Zoll			
C5321-.031F4B.0Z2	10268880	4	F	0.031	0.125	0.094	1.500	0.016	2	Cylindrical	■
C5321-.063F4B.0Z2	10268885	4	F	0.063	0.125	0.250	1.500	0.031	2	Cylindrical	■
C5321-.094F4B.0Z2	10268890	4	F	0.094	0.125	0.375	1.500	0.047	2	Cylindrical	■
C5321-.125D4B.0Z2	10268892	4	D	0.125	0.125	0.500	1.500	0.063	2	Cylindrical	■
C5321-.188D4B.0Z2	10268898	4	D	0.188	0.188	1.000	3.000	0.094	2	Cylindrical	■
C5321-.250D4B.0Z2	10268901	4	D	0.250	0.250	1.000	3.000	0.125	2	Cylindrical	■
C5321-.375D4B.0Z2	10268910	4	D	0.375	0.375	1.000	3.000	0.188	2	Cylindrical	■
C5321-.500D4B.0Z2	10268916	4	D	0.500	0.500	1.500	6.000	0.250	2	Cylindrical	■
C5321-.125D5B.0Z2	10268893	5	D	0.125	0.125	0.625	2.000	0.063	2	Cylindrical	■
C5321-.250D5B.0Z2	10268902	5	D	0.250	0.250	1.000	4.000	0.125	2	Cylindrical	■
C5321-.313D5B.0Z2	10268906	5	D	0.313	0.313	1.000	4.000	0.156	2	Cylindrical	■
C5321-.500D5B.0Z2	10268917	5	D	0.500	0.500	2.000	4.000	0.250	2	Cylindrical	■
C5321-.125D6B.0Z2	10268894	6	D	0.125	0.125	0.750	3.000	0.063	2	Cylindrical	■
C5321-.250D6B.0Z2	10268903	6	D	0.250	0.250	1.500	4.000	0.125	2	Cylindrical	■
C5321-.375D6B.0Z2	10268911	6	D	0.375	0.375	1.500	6.000	0.188	2	Cylindrical	■
C5321-.500D6B.0Z2	10268918	6	D	0.500	0.500	3.000	6.000	0.250	2	Cylindrical	■
C5321-.375D7B.0Z2	10268912	7	D	0.375	0.375	2.000	4.000	0.188	2	Cylindrical	■

■ **Lagerstandard.**

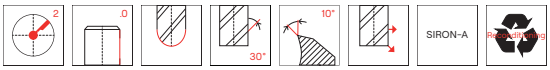
C5321

Allgemeine Anwendung – Universell – Kugelkopf – 2 Schneiden – Zylindrisch – Zoll





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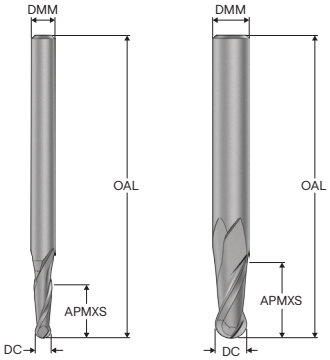
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	RE	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll	Zoll			
C5321-.500D1B.0Z2	SIRA	10268630	1	D	0.500	0.500	0.625	2.500	0.250	2	Cylindrical	■
C5321-.750D1B.0Z2	SIRA	10268637	1	D	0.750	0.750	1.000	3.000	0.375	2	Cylindrical	■
C5321-.016F2B.0Z2	SIRA	10268595	2	F	0.016	0.125	0.031	1.500	0.008	2	Cylindrical	■
C5321-.047F2B.0Z2	SIRA	10268598	2	F	0.047	0.125	0.109	1.500	0.023	2	Cylindrical	■
C5321-.063F2B.0Z2	SIRA	10268600	2	F	0.063	0.125	0.125	1.500	0.031	2	Cylindrical	■
C5321-.078F2B.0Z2	SIRA	10268603	2	F	0.078	0.125	0.188	1.500	0.039	2	Cylindrical	■
C5321-.094F2B.0Z2	SIRA	10268605	2	F	0.094	0.125	0.188	1.500	0.047	2	Cylindrical	■
C5321-.125D2B.0Z2	SIRA	10268608	2	D	0.125	0.125	0.250	1.500	0.063	2	Cylindrical	■
C5321-.188D2B.0Z2	SIRA	10268613	2	D	0.188	0.188	0.375	2.000	0.094	2	Cylindrical	■
C5321-.250D2B.0Z2	SIRA	10268616	2	D	0.250	0.250	0.500	2.000	0.125	2	Cylindrical	■
C5321-.375D2B.0Z2	SIRA	10268625	2	D	0.375	0.375	0.625	2.000	0.188	2	Cylindrical	■
C5321-.500D2B.0Z2	SIRA	10268631	2	D	0.500	0.500	1.000	3.000	0.250	2	Cylindrical	■
C5321-.625D2B.0Z2	SIRA	10268636	2	D	0.625	0.625	1.250	3.500	0.313	2	Cylindrical	■
C5321-.750D2B.0Z2	SIRA	10268638	2	D	0.750	0.750	1.500	4.000	0.375	2	Cylindrical	■
C5321-.031F3B.0Z2	SIRA	10268596	3	F	0.031	0.125	0.078	1.500	0.016	2	Cylindrical	■
C5321-.047F3B.0Z2	SIRA	10268599	3	F	0.047	0.125	0.125	1.500	0.023	2	Cylindrical	■
C5321-.063F3B.0Z2	SIRA	10268601	3	F	0.063	0.125	0.188	1.500	0.031	2	Cylindrical	■
C5321-.078F3B.0Z2	SIRA	10268604	3	F	0.078	0.125	0.250	1.500	0.039	2	Cylindrical	■
C5321-.094F3B.0Z2	SIRA	10268606	3	F	0.094	0.125	0.281	1.500	0.047	2	Cylindrical	■
C5321-.156F3B.0Z2	SIRA	10268612	3	F	0.156	0.188	0.500	2.000	0.078	2	Cylindrical	■
C5321-.188D3B.0Z2	SIRA	10268614	3	D	0.188	0.188	0.625	2.000	0.094	2	Cylindrical	■
C5321-.250D3B.0Z2	SIRA	10268617	3	D	0.250	0.250	0.750	2.500	0.125	2	Cylindrical	■
C5321-.313D3B.0Z2	SIRA	10268622	3	D	0.313	0.313	0.813	2.500	0.156	2	Cylindrical	■
C5321-.375D3B.0Z2	SIRA	10268626	3	D	0.375	0.375	1.000	2.500	0.188	2	Cylindrical	■
C5321-.500D3B.0Z2	SIRA	10268632	3	D	0.500	0.500	1.000	4.000	0.250	2	Cylindrical	■
C5321-.750D3B.0Z2	SIRA	10268639	3	D	0.750	0.750	2.000	6.000	0.375	2	Cylindrical	■

■ **Lagerstandard.**

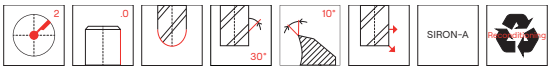
C5321

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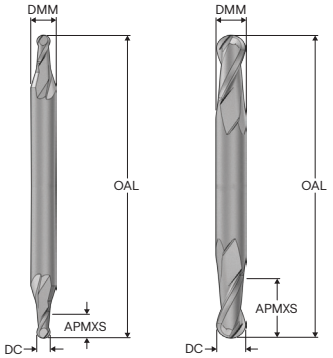
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	RE	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll	Zoll			
C5321-.031F4B.0Z2	SIRA	10268597	4	F	0.031	0.125	0.094	1.500	0.016	2	Cylindrical	■
C5321-.063F4B.0Z2	SIRA	10268602	4	F	0.063	0.125	0.250	1.500	0.031	2	Cylindrical	■
C5321-.094F4B.0Z2	SIRA	10268607	4	F	0.094	0.125	0.375	1.500	0.047	2	Cylindrical	■
C5321-.125D4B.0Z2	SIRA	10268609	4	D	0.125	0.125	0.500	1.500	0.063	2	Cylindrical	■
C5321-.188D4B.0Z2	SIRA	10268615	4	D	0.188	0.188	1.000	3.000	0.094	2	Cylindrical	■
C5321-.250D4B.0Z2	SIRA	10268618	4	D	0.250	0.250	1.000	3.000	0.125	2	Cylindrical	■
C5321-.375D4B.0Z2	SIRA	10268627	4	D	0.375	0.375	1.000	3.000	0.188	2	Cylindrical	■
C5321-.500D4B.0Z2	SIRA	10268633	4	D	0.500	0.500	1.500	6.000	0.250	2	Cylindrical	■
C5321-.125D5B.0Z2	SIRA	10268610	5	D	0.125	0.125	0.625	2.000	0.063	2	Cylindrical	■
C5321-.250D5B.0Z2	SIRA	10268619	5	D	0.250	0.250	1.000	4.000	0.125	2	Cylindrical	■
C5321-.313D5B.0Z2	SIRA	10268623	5	D	0.313	0.313	1.000	4.000	0.156	2	Cylindrical	■
C5321-.500D5B.0Z2	SIRA	10268634	5	D	0.500	0.500	2.000	4.000	0.250	2	Cylindrical	■
C5321-.125D6B.0Z2	SIRA	10268611	6	D	0.125	0.125	0.750	3.000	0.063	2	Cylindrical	■
C5321-.250D6B.0Z2	SIRA	10268620	6	D	0.250	0.250	1.500	4.000	0.125	2	Cylindrical	■
C5321-.375D6B.0Z2	SIRA	10268628	6	D	0.375	0.375	1.500	6.000	0.188	2	Cylindrical	■
C5321-.500D6B.0Z2	SIRA	10268635	6	D	0.500	0.500	3.000	6.000	0.250	2	Cylindrical	■
C5321-.313D7B.0Z2	SIRA	10268624	7	D	0.313	0.313	1.625	4.000	0.156	2	Cylindrical	■
C5321-.375D7B.0Z2	SIRA	10268629	7	D	0.375	0.375	2.000	4.000	0.188	2	Cylindrical	■

■ **Lagerstandard.**

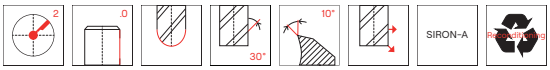
C5321

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Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	RE	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll	Zoll			
C5321-.031F2B.0Z2D	SIRA	10268656	2	F	0.031	0.125	0.063	1.500	0.016	2	Cylindrical	■
C5321-.047F2B.0Z2D	SIRA	10268657	2	F	0.047	0.125	0.094	1.500	0.023	2	Cylindrical	■
C5321-.063F2B.0Z2D	SIRA	10268658	2	F	0.063	0.125	0.125	1.500	0.031	2	Cylindrical	■
C5321-.078F2B.0Z2D	SIRA	10268659	2	F	0.078	0.125	0.125	1.500	0.039	2	Cylindrical	■
C5321-.094F2B.0Z2D	SIRA	10268660	2	F	0.094	0.125	0.188	1.500	0.047	2	Cylindrical	■
C5321-.125D2B.0Z2D	SIRA	10268661	2	D	0.125	0.125	0.250	1.500	0.063	2	Cylindrical	■
C5321-.188D2B.0Z2D	SIRA	10268662	2	D	0.188	0.188	0.375	2.000	0.094	2	Cylindrical	■
C5321-.250D2B.0Z2D	SIRA	10268663	2	D	0.250	0.250	0.500	2.500	0.125	2	Cylindrical	■
C5321-.313D2B.0Z2D	SIRA	10268664	2	D	0.313	0.313	0.500	2.500	0.156	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – C5321 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	1,5	2	3	3,5	4	5	6	8	9	10	12	
P1	E	0,10 *0.10*	1,0 *1.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,048 *0.0019*	150 (135 — 165) *490 (440— 540)*
P2	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	58 (45— 70) *190 (147 — 230)*
P3	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	85 (70 — 95) *279 (246 — 312)*
P4	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	100 (90 — 110) *330 (295 — 360)*
P5	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	68 (50 — 75) *223 (165 — 245)*
P6	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	87 (77 — 100) *285 (250 — 330)*
P7	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	65 (55 — 75) *213 (180 — 245)*
P8	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	65 (50 — 75) *213 (165 — 245)*
P11	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	85 (70 — 95) *280 (230 — 310)*
P12	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,0038 *0.00015*	0,005 *0.00020*	0,0075 *0.00030*	0,009 *0.00036*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,02 *0.00080*	0,022 *0.00085*	0,025 *0.0010*	0,03 *0.0012*	55 (45— 65) *180 (147 — 213)*
M1	E	0,10 *0.10*	1,0 *1.0*	0,0038 *0.00015*	0,0055 *0.00022*	0,0075 *0.00030*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,019 *0.00075*	0,022 *0.00085*	0,03 *0.0012*	0,034 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	93 (83 — 100) *305 (270 — 360)*
M2	E	0,10 *0.10*	1,0 *1.0*	0,0038 *0.00015*	0,0055 *0.00022*	0,0075 *0.00030*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,019 *0.00075*	0,022 *0.00085*	0,03 *0.0012*	0,034 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	60 (50 — 70) *200 (165 — 230)*
M3	E	0,10 *0.10*	1,0 *1.0*	0,0038 *0.00015*	0,0055 *0.00022*	0,0075 *0.00030*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,019 *0.00075*	0,022 *0.00085*	0,03 *0.0012*	0,034 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	55 (45 —65) *180 (147 — 213)*
M4	E	0,10 *0.10*	1,0 *1.0*	0,0038 *0.00015*	0,0055 *0.00022*	0,0075 *0.00030*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,019 *0.00075*	0,022 *0.00085*	0,03 *0.0012*	0,034 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	45 (35 — 55) *147 (115 — 180)*
M5	E	0,10 *0.10*	1,0 *1.0*	0,0034 *0.00013*	0,005 *0.00020*	0,0065 *0.00026*	0,01 *0.00040*	0,012 *0.00048*	0,013 *0.00050*	0,017 *0.00065*	0,02 *0.00080*	0,026 *0.0010*	0,03 *0.0012*	0,034 *0.0013*	0,04 *0.0016*	35 (20 — 45) *114 (65 — 147)*
K1	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	80 (70 — 90) *260 (230 — 290)*
K2	E	0,10 *0.10*	1,0 *1.0*	0,0044 *0.00017*	0,0065 *0.00026*	0,0085 *0.00034*	0,013 *0.00050*	0,015 *0.00060*	0,017 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,034 *0.0013*	0,04 *0.0016*	0,044 *0.0017*	0,05 *0.0020*	87 (75 — 100) *285 (245 — 330)*
K3	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	65 (55 — 75) *213 (180 — 245)*
K4	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	50 (35 — 65) *165 (115 — 213)*
K5	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	45 (30 — 55) *147 (100 — 180)*
K6	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	77 (65 — 85) *250 (210 — 280)*
K7	E	0,10 *0.10*	1,0 *1.0*	0,0032 *0.00013*	0,0048 *0.00019*	0,0065 *0.00026*	0,0095 *0.00038*	0,011 *0.00044*	0,013 *0.00050*	0,016 *0.00065*	0,019 *0.00075*	0,026 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	0,038 *0.0015*	77 (60 — 90) *250 (200 — 290)*
S1	E	0,10 *0.10*	1,0 *1.0*	0,004 *0.00016*	0,006 *0.00024*	0,008 *0.00032*	0,012 *0.00048*	0,014 *0.00055*	0,016 *0.00065*	0,02 *0.00080*	0,024 *0.00095*	0,032 *0.0013*	0,036 *0.0014*	0,04 *0.0016*	0,048 *0.0019*	50 (35 — 60) *165 (115 — 200)*
S2	E	0,10 *0.10*	1,0 *1.0*	0,0028 *0.00011*	0,004 *0.00016*	0,0055 *0.00022*	0,008 *0.00032*	0,0095 *0.00038*	0,011 *0.00044*	0,014 *0.00055*	0,016 *0.00065*	0,022 *0.00085*	0,025 *0.0010*	0,028 *0.0011*	0,032 *0.0013*	25 (15 — 35) *82 (50 — 115)*
S3	E	0,10 *0.10*	1,0 *1.0*	0,0017 *0.000065*	0,0026 *0.00010*	0,0034 *0.00013*	0,005 *0.00020*	0,006 *0.00024*	0,007 *0.00028*	0,0085 *0.00034*	0,01 *0.00040*	0,014 *0.00055*	0,015 *0.00060*	0,017 *0.00065*	0,02 *0.00080*	11 (7,5 — 16) *35 (25 — 52)*
S11	E	0,10 *0.10*	1,0 *1.0*	0,0038 *0.00015*	0,0055 *0.00022*	0,0075 *0.00030*	0,011 *0.00044*	0,013 *0.00050*	0,015 *0.00060*	0,019 *0.00075*	0,022 *0.00085*	0,03 *0.0012*	0,034 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	110 (95— 120) *360 (311 — 390)*
S12	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,0038 *0.00015*	0,005 *0.00020*	0,0075 *0.00030*	0,009 *0.00036*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,02 *0.00080*	0,022 *0.00085*	0,025 *0.0010*	0,03 *0.0012*	77 (60 — 90) *250 (190 — 290)*
S13	E	0,10 *0.10*	1,0 *1.0*	0,0025 *0.00010*	0,0038 *0.00015*	0,005 *0.00020*	0,0075 *0.00030*	0,009 *0.00036*	0,01 *0.00040*	0,013 *0.00050*	0,015 *0.00060*	0,02 *0.00080*	0,022 *0.00085*	0,025 *0.0010*	0,03 *0.0012*	30 (20 — 40) *100 (65 — 130)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – C5321 Eckfräsen/Schruppen – Zoll

SMG		a_e/DC	a_p/DC	f_z												v_c
				1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	
P1	E	0,10	1,0	0,0032	0,0065	0,013	0,016	0,019	0,022	0,026	0,032	0,038	0,05	0,06	0,065	0,08	150 (135 — 165)
		0.10	*1.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00075*	*0.00085*	*0.0010*	*0.0013*	*0.0015*	*0.0020*	*0.0024*	*0.0026*	*0.0032*	*490 (440— 540)*
P2	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	58 (45— 70)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*190 (147 — 230)*
P3	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	85 (70 — 95)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*279 (246 — 312)*
P4	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	100 (90 — 110)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*330 (295 — 360)*
P5	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	68 (50 — 75)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*223 (165 — 245)*
P6	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	87 (77 — 100)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*285 (250 — 330)*
P7	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	65 (55 — 75)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*213 (180 — 245)*
P8	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	65 (50 — 75)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*213 (165 — 245)*
P11	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	85 (70 — 95)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*280 (230 — 310)*
P12	E	0,10	1,0	0,002	0,004	0,008	0,01	0,012	0,014	0,016	0,02	0,024	0,032	0,038	0,042	0,05	55 (45— 65)
		0.10	*1.0*	*0.000080*	*0.00016*	*0.00032*	*0.00040*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*180 (147 — 213)*
M1	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	93 (83 — 100)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*305 (270 — 360)*
M2	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	60 (50 — 70)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*200 (165 — 230)*
M3	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	55 (45 —65)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*180 (147 — 213)*
M4	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	45 (35 — 55)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*147 (115 — 180)*
M5	E	0,10	1,0	0,0026	0,0055	0,011	0,013	0,016	0,019	0,022	0,026	0,032	0,042	0,048	0,055	0,065	35 (20 — 45)
		0.10	*1.0*	*0.00010*	*0.00022*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0019*	*0.0022*	*0.0026*	*114 (65 — 147)*
K1	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	80 (70 — 90)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*260 (230 — 290)*
K2	E	0,10	1,0	0,0034	0,007	0,014	0,017	0,02	0,024	0,028	0,034	0,042	0,055	0,065	0,07	0,085	87 (75 — 100)
		0.10	*1.0*	*0.00013*	*0.00028*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0011*	*0.0013*	*0.0017*	*0.0022*	*0.0026*	*0.0028*	*0.0034*	*285 (245 — 330)*
K3	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	65 (55 — 75)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*213 (180 — 245)*
K4	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	50 (35 — 65)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*165 (115 — 213)*
K5	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	45 (30 — 55)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*147 (100 — 180)*
K6	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	77 (65 — 85)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*250 (210 — 280)*
K7	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	77 (60 — 90)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*250 (200 — 290)*
S1	E	0,10	1,0	0,0032	0,0065	0,013	0,016	0,019	0,022	0,026	0,032	0,038	0,05	0,06	0,065	0,08	50 (35 — 60)
		0.10	*1.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00075*	*0.00085*	*0.0010*	*0.0013*	*0.0015*	*0.0020*	*0.0024*	*0.0026*	*0.0032*	*165 (115 — 200)*
S2	E	0,10	1,0	0,0022	0,0044	0,009	0,011	0,013	0,015	0,018	0,022	0,026	0,034	0,04	0,044	0,055	25 (15 — 35)
		0.10	*1.0*	*0.000085*	*0.00017*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0017*	*0.0022*	*82 (50 — 115)*
S3	E	0,10	1,0	0,0014	0,0028	0,0055	0,007	0,008	0,0095	0,011	0,014	0,016	0,022	0,025	0,028	0,034	11 (7,5 — 16)
		0.10	*1.0*	*0.000055*	*0.00011*	*0.00022*	*0.00028*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0011*	*0.0013*	*35 (25 — 52)*
S11	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	110 (95— 120)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*360 (311 — 390)*
S12	E	0,10	1,0	0,002	0,004	0,008	0,01	0,012	0,014	0,016	0,02	0,024	0,032	0,038	0,042	0,05	77 (60 — 90)
		0.10	*1.0*	*0.000080*	*0.00016*	*0.00032*	*0.00040*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*250 (190 — 290)*
S13	E	0,10	1,0	0,002	0,004	0,008	0,01	0,012	0,014	0,016	0,02	0,024	0,032	0,038	0,042	0,05	30 (20 — 40)
		0.10	*1.0*	*0.000080*	*0.00016*	*0.00032*	*0.00040*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*100 (65 — 130)*

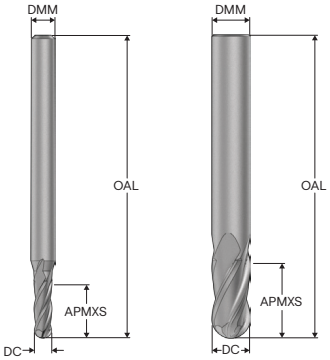
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

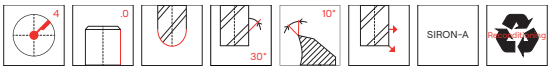
C5341

Allgemeine Anwendung – Universell – Kugelkopf – 4 Schneiden – Zylindrisch





– Toleranzen:
– DMM=h5
– DC= h10
– RE= ±0,01 mm
– Nachschleifen möglich, wenn DC ≥ Ø10 ist



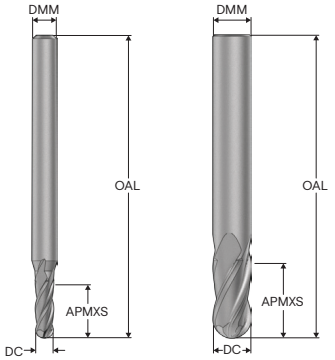
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	RE	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm			
C5341-020F2B.0Z4	SIRA	10268568	2	F	2,0	3,0	4,0	39,0	1,0	4	Cylindrical	■
C5341-030D2B.0Z4	SIRA	10268570	2	D	3,0	3,0	6,0	39,0	1,5	4	Cylindrical	■
C5341-040D2B.0Z4	SIRA	10268573	2	D	4,0	4,0	8,0	50,0	2,0	4	Cylindrical	■
C5341-050F2B.0Z4	SIRA	10268575	2	D	5,0	6,0	10,0	57,0	2,5	4	Cylindrical	■
C5341-060D1B.0Z4	SIRA	10268577	2	D	6,0	6,0	9,0	51,0	3,0	4	Cylindrical	■
C5341-060D2B.0Z4	SIRA	10268578	2	D	6,0	6,0	12,0	57,0	3,0	4	Cylindrical	■
C5341-080D2B.0Z4	SIRA	10268580	2	D	8,0	8,0	16,0	63,0	4,0	4	Cylindrical	■
C5341-090F2B.0Z4	SIRA	10268581	2	F	9,0	10,0	22,0	72,0	4,5	4	Cylindrical	■
C5341-100D2B.0Z4	SIRA	10268582	2	D	10,0	10,0	22,0	73,0	5,0	4	Cylindrical	■
C5341-120D2B.0Z4	SIRA	10268584	2	D	12,0	12,0	25,0	74,0	6,0	4	Cylindrical	■
C5341-160D2B.0Z4	SIRA	10268586	2	D	16,0	16,0	32,0	92,0	8,0	4	Cylindrical	■
C5341-200D2B.0Z4	SIRA	10268588	2	D	20,0	20,0	35,0	104,0	10,0	4	Cylindrical	■
C5341-015F3B.0Z4	SIRA	10268567	3	F	1,5	3,0	4,5	38,0	0,75	4	Cylindrical	■
C5341-020F3B.0Z4	SIRA	10268569	3	F	2,0	3,0	6,3	38,0	1,0	4	Cylindrical	■
C5341-035F3B.0Z4	SIRA	10268572	3	F	3,5	4,0	12,0	50,0	1,5	4	Cylindrical	■
C5341-050F3B.0Z4	SIRA	10268576	3	F	5,0	6,0	16,0	51,0	2,5	4	Cylindrical	■
C5341-060D3B.0Z4	SIRA	10268579	3	D	6,0	6,0	19,0	51,0	3,0	4	Cylindrical	■
C5341-160D3B.0Z4	SIRA	10268587	3	D	16,0	16,0	50,0	115,0	8,0	4	Cylindrical	■
C5341-200D3B.0Z4	SIRA	10268589	3	D	20,0	20,0	60,0	125,0	10,0	4	Cylindrical	■
C5341-010F4B.0Z4	SIRA	10268566	4	F	1,0	3,0	4,0	39,0	0,5	4	Cylindrical	■
C5341-030D4B.0Z4	SIRA	10268571	4	D	3,0	3,0	12,0	39,0	1,5	4	Cylindrical	■
C5341-040D4B.0Z4	SIRA	10268574	4	D	4,0	4,0	14,0	51,0	2,0	4	Cylindrical	■
C5341-100D4B.0Z4	SIRA	10268583	4	D	10,0	10,0	35,0	89,0	5,0	4	Cylindrical	■
C5341-120D4B.0Z4	SIRA	10268585	4	D	12,0	12,0	50,0	100,0	6,0	4	Cylindrical	■

■ **Lagerstandard.**

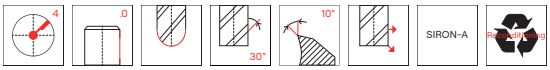
C5341

Allgemeine Anwendung – Universell – Kugelkopf – 4 Schneiden – Zylindrisch – Zoll





—Toleranzen:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—RE= ±.0005"
—Nachschleifen möglich, wenn DC ≥ Ø.375 ist



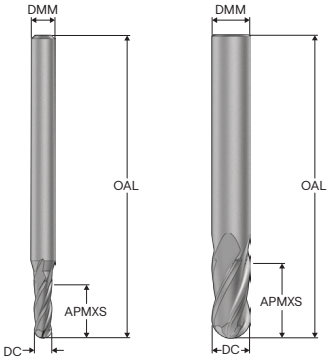
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll			
C5341-.500D1B.0Z4	SIRA	10268532	1	D	0.500	0.500	0.625	2.500	0.250	4	Cylindrical	■
C5341-.625D1B.0Z4	SIRA	10268539	1	D	0.625	0.625	0.750	3.000	0.313	4	Cylindrical	■
C5341-.750D1B.0Z4	SIRA	10268543	1	D	0.750	0.750	1.000	3.000	0.375	4	Cylindrical	■
C5341-.016F2B.0Z4	SIRA	10268474	2	F	0.016	0.125	0.031	1.500	0.008	4	Cylindrical	■
C5341-.047F2B.0Z4	SIRA	10268477	2	F	0.047	0.125	0.109	1.500	0.023	4	Cylindrical	■
C5341-.063F2B.0Z4	SIRA	10268479	2	F	0.063	0.125	0.125	1.500	0.031	4	Cylindrical	■
C5341-.078F2B.0Z4	SIRA	10268483	2	F	0.078	0.125	0.188	1.500	0.039	4	Cylindrical	■
C5341-.094F2B.0Z4	SIRA	10268485	2	F	0.094	0.125	0.188	1.500	0.047	4	Cylindrical	■
C5341-.125D2B.0Z4	SIRA	10268490	2	D	0.125	0.125	0.250	1.500	0.063	4	Cylindrical	■
C5341-.156F2B.0Z4	SIRA	10268497	2	F	0.156	0.188	0.313	2.000	0.078	4	Cylindrical	■
C5341-.188D2B.0Z4	SIRA	10268500	2	D	0.188	0.188	0.375	2.000	0.094	4	Cylindrical	■
C5341-.250D2B.0Z4	SIRA	10268508	2	D	0.250	0.250	0.500	2.000	0.125	4	Cylindrical	■
C5341-.313D2B.0Z4	SIRA	10268515	2	D	0.313	0.313	0.500	2.000	0.156	4	Cylindrical	■
C5341-.375D2B.0Z4	SIRA	10268521	2	D	0.375	0.375	0.625	2.000	0.188	4	Cylindrical	■
C5341-.406F2B.0Z4	SIRA	10268528	2	F	0.406	0.438	1.000	2.750	0.203	4	Cylindrical	■
C5341-.438D2B.0Z4	SIRA	10268529	2	D	0.438	0.438	1.000	2.750	0.219	4	Cylindrical	■
C5341-.500D2B.0Z4	SIRA	10268533	2	D	0.500	0.500	1.000	3.000	0.250	4	Cylindrical	■
C5341-.563D2B.0Z4	SIRA	10268538	2	D	0.563	0.563	1.125	3.500	0.281	4	Cylindrical	■
C5341-.625D2B.0Z4	SIRA	10268540	2	D	0.625	0.625	1.250	3.500	0.313	4	Cylindrical	■
C5341-.750D2B.0Z4	SIRA	10268544	2	D	0.750	0.750	1.500	4.000	0.375	4	Cylindrical	■
C5341-.875D2B.0Z4	SIRA	10268548	2	D	0.875	0.875	1.500	4.000	0.438	4	Cylindrical	■
C5341-1.000D2B.0Z4	SIRA	10268549	2	D	1.000	1.000	1.500	4.000	0.500	4	Cylindrical	■

■ **Lagerstandard.**

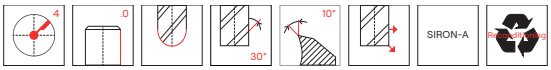
C5341

Allgemeine Anwendung – Universell – Kugelkopf – 4 Schneiden – Zylindrisch – Zoll





—Toleranzen:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—RE= ±.0005"
—Nachschleifen möglich, wenn DC ≥ Ø.375 ist



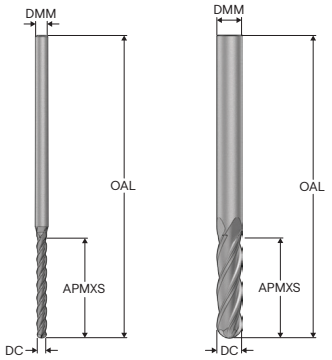
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	RE	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll	Zoll			
C5341-.031F3B.0Z4	SIRA	10268475	3	F	0.031	0.125	0.078	1.500	0.016	4	Cylindrical	■
C5341-.047F3B.0Z4	SIRA	10268478	3	F	0.047	0.125	0.125	1.500	0.023	4	Cylindrical	■
C5341-.063F3B.0Z4	SIRA	10268480	3	F	0.063	0.125	0.188	1.500	0.031	4	Cylindrical	■
C5341-.078F3B.0Z4	SIRA	10268484	3	F	0.078	0.125	0.250	1.500	0.039	4	Cylindrical	■
C5341-.094F3B.0Z4	SIRA	10268486	3	F	0.094	0.125	0.281	1.500	0.047	4	Cylindrical	■
C5341-.109F3B.0Z4	SIRA	10268489	3	F	0.109	0.125	0.375	1.500	0.055	4	Cylindrical	■
C5341-.156F3B.0Z4	SIRA	10268498	3	F	0.156	0.188	0.500	2.000	0.078	4	Cylindrical	■
C5341-.188D3B.0Z4	SIRA	10268501	3	D	0.188	0.188	0.625	2.000	0.094	4	Cylindrical	■
C5341-.203F3B.0Z4	SIRA	10268505	3	F	0.203	0.250	0.625	2.500	0.102	4	Cylindrical	■
C5341-.219F3B.0Z4	SIRA	10268506	3	F	0.219	0.250	0.625	2.500	0.109	4	Cylindrical	■
C5341-.234F3B.0Z4	SIRA	10268507	3	F	0.234	0.250	0.750	2.500	0.117	4	Cylindrical	■
C5341-.250D3B.0Z4	SIRA	10268509	3	D	0.250	0.250	0.750	2.500	0.125	4	Cylindrical	■
C5341-.281F3B.0Z4	SIRA	10268514	3	F	0.281	0.313	0.750	2.500	0.141	4	Cylindrical	■
C5341-.313D3B.0Z4	SIRA	10268516	3	D	0.313	0.313	0.813	2.500	0.156	4	Cylindrical	■
C5341-.328F3B.0Z4	SIRA	10268519	3	F	0.328	0.375	1.000	2.500	0.164	4	Cylindrical	■
C5341-.344F3B.0Z4	SIRA	10268520	3	F	0.344	0.375	1.000	2.500	0.172	4	Cylindrical	■
C5341-.375D3B.0Z4	SIRA	10268522	3	D	0.375	0.375	1.000	2.500	0.188	4	Cylindrical	■
C5341-.438D3B.0Z4	SIRA	10268530	3	D	0.438	0.438	1.000	4.000	0.219	4	Cylindrical	■
C5341-.500D3B.0Z4	SIRA	10268534	3	D	0.500	0.500	1.000	4.000	0.250	4	Cylindrical	■
C5341-.625D3B.0Z4	SIRA	10268541	3	D	0.625	0.625	2.000	6.000	0.313	4	Cylindrical	■
C5341-.750D3B.0Z4	SIRA	10268545	3	D	0.750	0.750	2.000	6.000	0.375	4	Cylindrical	■
C5341-1.000D3B.0Z4	SIRA	10268550	3	D	1.000	1.000	2.000	6.000	0.500	4	Cylindrical	■
C5341-.031F4B.0Z4	SIRA	10268476	4	F	0.031	0.125	0.094	1.500	0.016	4	Cylindrical	■
C5341-.063F4B.0Z4	SIRA	10268481	4	F	0.063	0.125	0.250	1.500	0.031	4	Cylindrical	■
C5341-.094F4B.0Z4	SIRA	10268487	4	F	0.094	0.125	0.375	1.500	0.047	4	Cylindrical	■
C5341-.125D4B.0Z4	SIRA	10268491	4	D	0.125	0.125	0.500	1.500	0.063	4	Cylindrical	■
C5341-.141F4B.0Z4	SIRA	10268496	4	F	0.141	0.188	0.500	2.000	0.070	4	Cylindrical	■
C5341-.172F4B.0Z4	SIRA	10268499	4	F	0.172	0.188	0.625	2.000	0.086	4	Cylindrical	■
C5341-.188D4B.0Z4	SIRA	10268502	4	D	0.188	0.188	1.000	3.000	0.094	4	Cylindrical	■
C5341-.250D4B.0Z4	SIRA	10268510	4	D	0.250	0.250	1.000	3.000	0.125	4	Cylindrical	■
C5341-.313D4B.0Z4	SIRA	10268517	4	D	0.313	0.313	1.000	3.000	0.156	4	Cylindrical	■
C5341-.375D4B.0Z4	SIRA	10268523	4	D	0.375	0.375	1.000	3.000	0.188	4	Cylindrical	■
C5341-.500D4B.0Z4	SIRA	10268535	4	D	0.500	0.500	1.500	6.000	0.250	4	Cylindrical	■
C5341-.750D4B.0Z4	SIRA	10268546	4	D	0.750	0.750	3.000	6.000	0.375	4	Cylindrical	■
C5341-1.000D4B.0Z4	SIRA	10268551	4	D	1.000	1.000	3.000	6.000	0.500	4	Cylindrical	■

■ **Lagerstandard.**

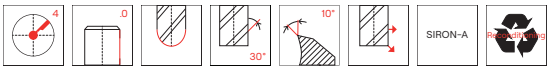
C5341

Allgemeine Anwendung – Universell – Kugelkopf – 4 Schneiden – Zylindrisch – Zoll





– Toleranzen:
– DMM=-.0001"/-.0004"
– DC ≤ Ø7/64" = ±.0005"
– DC > Ø7/64" = +.000"/-.002"
– RE= ±.0005"
– Nachschleifen möglich, wenn DC ≥ Ø.375 ist



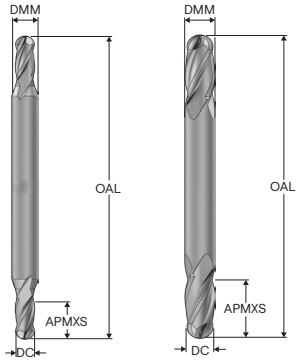
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll			
C5341-.125D5B.0Z4	SIRA	10268492	5	D	0.125	0.125	0.625	2.000	0.063	4	Cylindrical	■
C5341-.188D5B.0Z4	SIRA	10268503	5	D	0.188	0.188	1.000	4.000	0.094	4	Cylindrical	■
C5341-.250D5B.0Z4	SIRA	10268511	5	D	0.250	0.250	1.000	4.000	0.125	4	Cylindrical	■
C5341-.375D5B.0Z4	SIRA	10268524	5	D	0.375	0.375	1.000	4.000	0.188	4	Cylindrical	■
C5341-.500D5B.0Z4	SIRA	10268536	5	D	0.500	0.500	2.000	4.000	0.250	4	Cylindrical	■
C5341-.625D5B.0Z4	SIRA	10268542	5	D	0.625	0.625	3.000	6.000	0.313	4	Cylindrical	■
C5341-.750D5B.0Z4	SIRA	10268547	5	D	0.750	0.750	4.000	6.000	0.375	4	Cylindrical	■
C5341-1.000D5B.0Z4	SIRA	10268552	5	D	1.000	1.000	4.000	7.000	0.500	4	Cylindrical	■
C5341-.125D6B.0Z4	SIRA	10268493	6	D	0.125	0.125	0.750	3.000	0.063	4	Cylindrical	■
C5341-.188D6B.0Z4	SIRA	10268504	6	D	0.188	0.188	1.125	3.000	0.094	4	Cylindrical	■
C5341-.250D6B.0Z4	SIRA	10268512	6	D	0.250	0.250	1.500	4.000	0.125	4	Cylindrical	■
C5341-.313D6B.0Z4	SIRA	10268518	6	D	0.313	0.313	1.500	6.000	0.156	4	Cylindrical	■
C5341-.375D6B.0Z4	SIRA	10268525	6	D	0.375	0.375	1.500	6.000	0.188	4	Cylindrical	■
C5341-.500D6B.0Z4	SIRA	10268537	6	D	0.500	0.500	3.000	6.000	0.250	4	Cylindrical	■
C5341-.125D7B.0Z4	SIRA	10268494	7	D	0.125	0.125	1.000	3.000	0.063	4	Cylindrical	■
C5341-.250D7B.0Z4	SIRA	10268513	7	D	0.250	0.250	1.500	6.000	0.125	4	Cylindrical	■
C5341-.375D7B.0Z4	SIRA	10268526	7	D	0.375	0.375	2.000	4.000	0.188	4	Cylindrical	■
C5341-.063F8B.0Z4	SIRA	10268482	8	F	0.063	0.125	1.000	3.000	0.031	4	Cylindrical	■
C5341-.094F8B.0Z4	SIRA	10268488	8	F	0.094	0.125	1.000	3.000	0.047	4	Cylindrical	■
C5341-.125D8B.0Z4	SIRA	10268495	8	D	0.125	0.125	1.000	4.000	0.063	4	Cylindrical	■
C5341-.375D8B.0Z4	SIRA	10268527	8	D	0.375	0.375	3.000	6.000	0.188	4	Cylindrical	■

■ **Lagerstandard.**

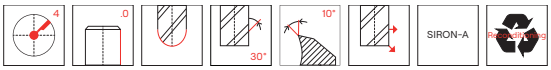
C5341

Allgemeine Anwendung – Universell – Kugelkopf – 4 Schneiden – Zylindrisch – Zoll





—Toleranzen:
—DMM=-.0001"/-.0004"
—DC ≤ Ø7/64" = ±.0005"
—DC > Ø7/64" = +.000"/-.002"
—RE= ±.0005"
—Doppelseitig
—Nachschleifen möglich, wenn DC ≥ Ø.375 ist



Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	RE	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll	Zoll			
C5341-.500D1B.0Z4D	SIRA	10268565	1	D	0.500	0.500	0.625	3.000	0.250	4	Cylindrical	■
C5341-.031F2B.0Z4D	SIRA	10268553	2	F	0.031	0.125	0.063	1.500	0.016	4	Cylindrical	■
C5341-.047F2B.0Z4D	SIRA	10268554	2	F	0.047	0.125	0.094	1.500	0.023	4	Cylindrical	■
C5341-.063F2B.0Z4D	SIRA	10268555	2	F	0.063	0.125	0.125	1.500	0.031	4	Cylindrical	■
C5341-.078F2B.0Z4D	SIRA	10268556	2	F	0.078	0.125	0.125	1.500	0.039	4	Cylindrical	■
C5341-.094F2B.0Z4D	SIRA	10268557	2	F	0.094	0.125	0.188	1.500	0.047	4	Cylindrical	■
C5341-.125D2B.0Z4D	SIRA	10268558	2	D	0.125	0.125	0.250	1.500	0.063	4	Cylindrical	■
C5341-.156F2B.0Z4D	SIRA	10268559	2	F	0.156	0.188	0.313	2.000	0.078	4	Cylindrical	■
C5341-.172F2B.0Z4D	SIRA	10268560	2	F	0.172	0.188	0.313	2.000	0.086	4	Cylindrical	■
C5341-.188D2B.0Z4D	SIRA	10268561	2	D	0.188	0.188	0.375	2.000	0.094	4	Cylindrical	■
C5341-.250D2B.0Z4D	SIRA	10268562	2	D	0.250	0.250	0.500	2.500	0.125	4	Cylindrical	■
C5341-.313D2B.0Z4D	SIRA	10268563	2	D	0.313	0.313	0.500	2.500	0.156	4	Cylindrical	■
C5341-.375D2B.0Z4D	SIRA	10268564	2	D	0.375	0.375	0.563	2.500	0.188	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – C5341 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z														v_c
				1	1,5	2	3	3,5	4	5	6	8	9	10	12	16	20	
P1	E	0,10	1,0	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,024	0,032	0,036	0,04	0,048	0,06	0,07	150 (135 — 165)
		0.10	*1.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0014*	*0.0016*	*0.0019*	*0.0024*	*0.0028*	*490 (440— 540)*
P2	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	58 (45— 70)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*190 (147 — 230)*
P3	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	85 (70 — 95)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*279 (246 — 312)*
P4	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	100 (90 — 110)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*330 (295 — 360)*
P5	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	68 (50 — 75)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*223 (165 — 245)*
P6	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	87 (77 — 100)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*285 (250 — 330)*
P7	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	65 (55 — 75)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*213 (180 — 245)*
P8	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	65 (50 — 75)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*213 (165 — 245)*
P11	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	85 (70 — 95)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*280 (230 — 310)*
P12	E	0,10	1,0	0,0025	0,0038	0,005	0,0075	0,009	0,01	0,013	0,015	0,02	0,022	0,025	0,03	0,038	0,044	55 (45— 65)
		0.10	*1.0*	*0.00010*	*0.00015*	*0.00020*	*0.00030*	*0.00036*	*0.00040*	*0.00050*	*0.00060*	*0.00080*	*0.00085*	*0.0010*	*0.0012*	*0.0015*	*0.0017*	*180 (147 — 213)*
M1	E	0,10	1,0	0,0038	0,0055	0,0075	0,011	0,013	0,015	0,019	0,022	0,03	0,034	0,038	0,044	0,055	0,065	93 (83 — 100)
		0.10	*1.0*	*0.00015*	*0.00022*	*0.00030*	*0.00044*	*0.00050*	*0.00060*	*0.00075*	*0.00085*	*0.0012*	*0.0013*	*0.0015*	*0.0017*	*0.0022*	*0.0026*	*305 (270 — 360)*
M2	E	0,10	1,0	0,0038	0,0055	0,0075	0,011	0,013	0,015	0,019	0,022	0,03	0,034	0,038	0,044	0,055	0,065	60 (50 — 70)
		0.10	*1.0*	*0.00015*	*0.00022*	*0.00030*	*0.00044*	*0.00050*	*0.00060*	*0.00075*	*0.00085*	*0.0012*	*0.0013*	*0.0015*	*0.0017*	*0.0022*	*0.0026*	*200 (165 — 230)*
M3	E	0,10	1,0	0,0038	0,0055	0,0075	0,011	0,013	0,015	0,019	0,022	0,03	0,034	0,038	0,044	0,055	0,065	55 (45 —65)
		0.10	*1.0*	*0.00015*	*0.00022*	*0.00030*	*0.00044*	*0.00050*	*0.00060*	*0.00075*	*0.00085*	*0.0012*	*0.0013*	*0.0015*	*0.0017*	*0.0022*	*0.0026*	*180 (147 — 213)*
M4	E	0,10	1,0	0,0038	0,0055	0,0075	0,011	0,013	0,015	0,019	0,022	0,03	0,034	0,038	0,044	0,055	0,065	45 (35 — 55)
		0.10	*1.0*	*0.00015*	*0.00022*	*0.00030*	*0.00044*	*0.00050*	*0.00060*	*0.00075*	*0.00085*	*0.0012*	*0.0013*	*0.0015*	*0.0017*	*0.0022*	*0.0026*	*147 (115 — 180)*
M5	E	0,10	1,0	0,0034	0,005	0,0065	0,01	0,012	0,013	0,017	0,02	0,026	0,03	0,034	0,04	0,05	0,055	35 (20 — 45)
		0.10	*1.0*	*0.00013*	*0.00020*	*0.00026*	*0.00040*	*0.00048*	*0.00050*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*0.0013*	*0.0016*	*0.0020*	*0.0022*	*114 (65 — 147)*
K1	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	80 (70 — 90)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*260 (230 — 290)*
K2	E	0,10	1,0	0,0044	0,0065	0,0085	0,013	0,015	0,017	0,022	0,026	0,034	0,04	0,044	0,05	0,065	0,075	87 (75 — 100)
		0.10	*1.0*	*0.00017*	*0.00026*	*0.00034*	*0.00050*	*0.00060*	*0.00065*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0017*	*0.0020*	*0.0026*	*0.0030*	*285 (245 — 330)*
K3	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	65 (55 — 75)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*213 (180 — 245)*
K4	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	50 (35 — 65)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*165 (115 — 213)*
K5	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	45 (30 — 55)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*147 (100 — 180)*
K6	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	77 (65 — 85)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*250 (210 — 280)*
K7	E	0,10	1,0	0,0032	0,0048	0,0065	0,0095	0,011	0,013	0,016	0,019	0,026	0,028	0,032	0,038	0,048	0,055	77 (60 — 90)
		0.10	*1.0*	*0.00013*	*0.00019*	*0.00026*	*0.00038*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.0010*	*0.0011*	*0.0013*	*0.0015*	*0.0019*	*0.0022*	*250 (200 — 290)*
S1	E	0,10	1,0	0,004	0,006	0,008	0,012	0,014	0,016	0,02	0,024	0,032	0,036	0,04	0,048	0,06	0,07	50 (35 — 60)
		0.10	*1.0*	*0.00016*	*0.00024*	*0.00032*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0014*	*0.0016*	*0.0019*	*0.0024*	*0.0028*	*165 (115 — 200)*
S2	E	0,10	1,0	0,0028	0,004	0,0055	0,008	0,0095	0,011	0,014	0,016	0,022	0,025	0,028	0,032	0,04	0,046	25 (15 — 35)
		0.10	*1.0*	*0.00011*	*0.00016*	*0.00022*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0011*	*0.0013*	*0.0016*	*0.0018*	*82 (50 — 115)*
S3	E	0,10	1,0	0,0017	0,0026	0,0034	0,005	0,006	0,007	0,0085	0,01	0,014	0,015	0,017	0,02	0,025	0,03	11 (7,5 — 16)
		0.10	*1.0*	*0.000065*	*0.00010*	*0.00013*	*0.00020*	*0.00024*	*0.00028*	*0.00034*	*0.00040*	*0.00055*	*0.00060*	*0.00065*	*0.00080*	*0.0010*	*0.0012*	*35 (25 — 52)*
S11	E	0,10	1,0	0,0038	0,0055	0,0075	0,011	0,013	0,015	0,019	0,022	0,03	0,034	0,038	0,044	0,055	0,065	110 (95— 120)
		0.10	*1.0*	*0.00015*	*0.00022*	*0.00030*	*0.00044*	*0.00050*	*0.00060*	*0.00075*	*0.00085*	*0.0012*	*0.0013*	*0.0015*	*0.0017*	*0.0022*	*0.0026*	*360 (311 — 390)*
S12	E	0,10	1,0	0,0025	0,0038	0,005	0,0075	0,009	0,01	0,013	0,015	0,02	0,022	0,025	0,03	0,038	0,044	77 (60 — 90)
		0.10	*1.0*	*0.00010*	*0.00015*	*0.00020*	*0.00030*	*0.00036*	*0.00040*	*0.00050*	*0.00060*	*0.00080*	*0.00085*	*0.0010*	*0.0012*	*0.0015*	*0.0017*	*250 (190 — 290)*
S13	E	0,10	1,0	0,0025	0,0038	0,005	0,0075	0,009	0,01	0,013	0,015	0,02	0,022	0,025	0,03	0,038	0,044	30 (20 — 40)
		0.10	*1.0*	*0.00010*	*0.00015*	*0.00020*	*0.00030*	*0.00036*	*0.00040*	*0.00050*	*0.00060*	*0.00080*	*0.00085*	*0.0010*	*0.0012*	*0.0015*	*0.0017*	*100 (65 — 130)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – C5341 Eckfräsen/Schruppen – Zoll

SMG		a_e/DC	a_p/DC	f_z													v_c
				1/32	1/16	1/8	1/6	1/5	2/9	1/4	1/3	3/8	1/2	5/8	3/4	1	
P1	E	0,10	1,0	0,0032	0,0065	0,013	0,016	0,019	0,022	0,026	0,032	0,038	0,05	0,06	0,065	0,08	150 (135 — 165)
		0.10	*1.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00075*	*0.00085*	*0.0010*	*0.0013*	*0.0015*	*0.0020*	*0.0024*	*0.0026*	*0.0032*	*490 (440— 540)*
P2	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	58 (45— 70)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*190 (147 — 230)*
P3	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	85 (70 — 95)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*279 (246 — 312)*
P4	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	100 (90 — 110)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*330 (295 — 360)*
P5	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	68 (50 — 75)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*223 (165 — 245)*
P6	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	87 (77 — 100)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*285 (250 — 330)*
P7	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	65 (55 — 75)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*213 (180 — 245)*
P8	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	65 (50 — 75)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*213 (165 — 245)*
P11	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	85 (70 — 95)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*280 (230 — 310)*
P12	E	0,10	1,0	0,002	0,004	0,008	0,01	0,012	0,014	0,016	0,02	0,024	0,032	0,038	0,042	0,05	55 (45— 65)
		0.10	*1.0*	*0.000080*	*0.00016*	*0.00032*	*0.00040*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*180 (147 — 213)*
M1	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	93 (83 — 100)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*305 (270 — 360)*
M2	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	60 (50 — 70)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*200 (165 — 230)*
M3	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	55 (45 —65)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*180 (147 — 213)*
M4	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	45 (35 — 55)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*147 (115 — 180)*
M5	E	0,10	1,0	0,0026	0,0055	0,011	0,013	0,016	0,019	0,022	0,026	0,032	0,042	0,048	0,055	0,065	35 (20 — 45)
		0.10	*1.0*	*0.00010*	*0.00022*	*0.00044*	*0.00050*	*0.00065*	*0.00075*	*0.00085*	*0.0010*	*0.0013*	*0.0017*	*0.0019*	*0.0022*	*0.0026*	*114 (65 — 147)*
K1	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	80 (70 — 90)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*260 (230 — 290)*
K2	E	0,10	1,0	0,0034	0,007	0,014	0,017	0,02	0,024	0,028	0,034	0,042	0,055	0,065	0,07	0,085	87 (75 — 100)
		0.10	*1.0*	*0.00013*	*0.00028*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0011*	*0.0013*	*0.0017*	*0.0022*	*0.0026*	*0.0028*	*0.0034*	*285 (245 — 330)*
K3	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	65 (55 — 75)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*213 (180 — 245)*
K4	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	50 (35 — 65)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*165 (115 — 213)*
K5	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	45 (30 — 55)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*147 (100 — 180)*
K6	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	77 (65 — 85)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*250 (210 — 280)*
K7	E	0,10	1,0	0,0025	0,005	0,01	0,013	0,015	0,018	0,02	0,026	0,03	0,04	0,046	0,055	0,06	77 (60 — 90)
		0.10	*1.0*	*0.00010*	*0.00020*	*0.00040*	*0.00050*	*0.00060*	*0.00070*	*0.00080*	*0.0010*	*0.0012*	*0.0016*	*0.0018*	*0.0022*	*0.0024*	*250 (200 — 290)*
S1	E	0,10	1,0	0,0032	0,0065	0,013	0,016	0,019	0,022	0,026	0,032	0,038	0,05	0,06	0,065	0,08	50 (35 — 60)
		0.10	*1.0*	*0.00013*	*0.00026*	*0.00050*	*0.00065*	*0.00075*	*0.00085*	*0.0010*	*0.0013*	*0.0015*	*0.0020*	*0.0024*	*0.0026*	*0.0032*	*165 (115 — 200)*
S2	E	0,10	1,0	0,0022	0,0044	0,009	0,011	0,013	0,015	0,018	0,022	0,026	0,034	0,04	0,044	0,055	25 (15 — 35)
		0.10	*1.0*	*0.000085*	*0.00017*	*0.00036*	*0.00044*	*0.00050*	*0.00060*	*0.00070*	*0.00085*	*0.0010*	*0.0013*	*0.0016*	*0.0017*	*0.0022*	*82 (50 — 115)*
S3	E	0,10	1,0	0,0014	0,0028	0,0055	0,007	0,008	0,0095	0,011	0,014	0,016	0,022	0,025	0,028	0,034	11 (7,5 — 16)
		0.10	*1.0*	*0.000055*	*0.00011*	*0.00022*	*0.00028*	*0.00032*	*0.00038*	*0.00044*	*0.00055*	*0.00065*	*0.00085*	*0.0010*	*0.0011*	*0.0013*	*35 (25 — 52)*
S11	E	0,10	1,0	0,003	0,006	0,012	0,015	0,018	0,02	0,024	0,03	0,036	0,046	0,055	0,06	0,07	110 (95— 120)
		0.10	*1.0*	*0.00012*	*0.00024*	*0.00048*	*0.00060*	*0.00070*	*0.00080*	*0.00095*	*0.0012*	*0.0014*	*0.0018*	*0.0022*	*0.0024*	*0.0028*	*360 (311 — 390)*
S12	E	0,10	1,0	0,002	0,004	0,008	0,01	0,012	0,014	0,016	0,02	0,024	0,032	0,038	0,042	0,05	77 (60 — 90)
		0.10	*1.0*	*0.000080*	*0.00016*	*0.00032*	*0.00040*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*250 (190 — 290)*
S13	E	0,10	1,0	0,002	0,004	0,008	0,01	0,012	0,014	0,016	0,02	0,024	0,032	0,038	0,042	0,05	30 (20 — 40)
		0.10	*1.0*	*0.000080*	*0.00016*	*0.00032*	*0.00040*	*0.00048*	*0.00055*	*0.00065*	*0.00080*	*0.00095*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*100 (65 — 130)*

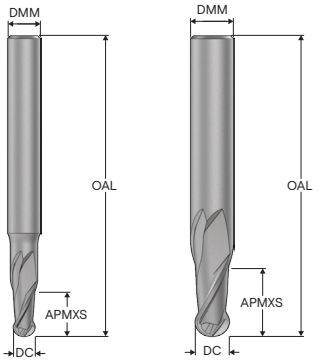
Schnittdaten, siehe Seite 699 - 707

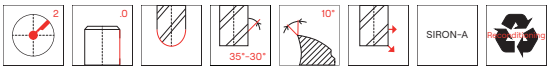
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JSB512

Allgemeine Anwendung – Universell – Kugelkopf – 2 Schneiden – Zylindrisch







– Toleranzen:
– DMM=h5
– DC=e8
– RE= ±0,01 mm
– Nachschleifen möglich, wenn DC ≥ Ø10 ist

Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JSB512020F2B.0Z2	SIRA	10053561	2	F	2,0	3,0	3,0	40,0	1,0	2	Cylindrical	■
JSB512030D2B.0Z2	SIRA	10053562	2	D	3,0	3,0	5,0	40,0	1,5	2	Cylindrical	■
JSB512040D2B.0Z2	SIRA	10053563	2	D	4,0	4,0	6,0	50,0	2,0	2	Cylindrical	■
JSB512050F2B.0Z2	SIRA	10053564	2	F	5,0	6,0	8,0	57,0	2,5	2	Cylindrical	■
JSB512060D2B.0Z2	SIRA	10053565	2	D	6,0	6,0	9,0	57,0	3,0	2	Cylindrical	■
JSB512080D2B.0Z2	SIRA	10053566	2	D	8,0	8,0	12,0	63,0	4,0	2	Cylindrical	■
JSB512100D2B.0Z2	SIRA	10053567	2	D	10,0	10,0	15,0	72,0	5,0	2	Cylindrical	■
JSB512120D2B.0Z2	SIRA	10053568	2	D	12,0	12,0	18,0	83,0	6,0	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JSB512 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	5	6	8	10	12	
P1	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P2	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P3	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P4	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P5	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P6	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P7	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P8	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
P11	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
P12	M/A/D/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
M1	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
M2	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
M3	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
M4	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
M5	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
K1	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
K2	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
K3	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
K4	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
K5	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.012 *0,00048*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	145 (61 — 180) *475 (210 — 590)*
K6	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
K7	A/D/M/E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	150 (63 — 180) *490 (210 — 590)*
N1	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	500 (380 — 620) *1650 (1300 — 2000)*
N11	E/M/A	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	375 (260 — 500) *1225 (860 — 1600)*
S11	E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (66 — 130) *295 (220 — 420)*
S12	E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*
S13	E	0.150 *0,150*	1.2 *1,2*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	90 (63 — 120) *295 (210 — 390)*

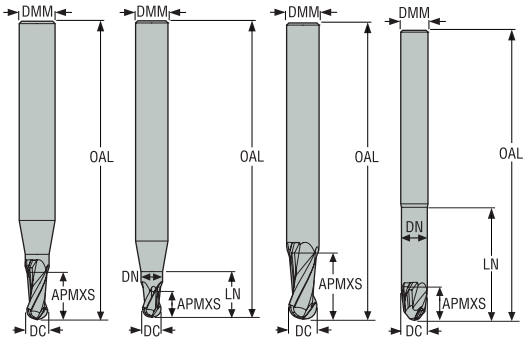
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

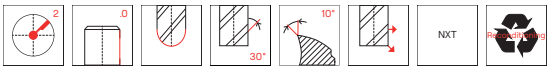
JS532

Hochleistungsfräser – Universell – Kugelkopf – 2 Schneiden – Zylindrisch





– Toleranzen:
– DMM=h5
– DC=e8
– RE= ±0,01 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist



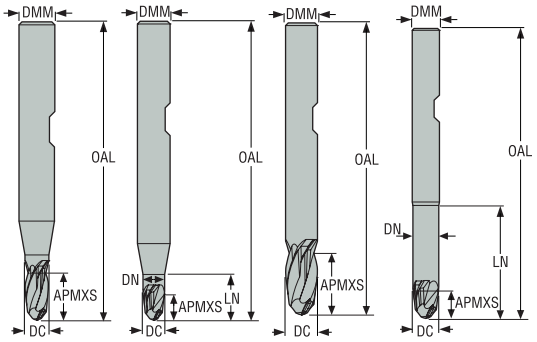
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS532010F1B.0Z2-NXT	02928193	1	F	1,0	3,0	2,0	38,0	–	–	0,5	2	Cylindrical	■
JS532015F1B.0Z2-NXT	02928194	1	F	1,5	3,0	3,0	38,0	–	–	0,75	2	Cylindrical	■
JS532020F1B.0Z2-NXT	02928195	1	F	2,0	3,0	4,0	38,0	–	–	1,0	2	Cylindrical	■
JS532025F1B.0Z2-NXT	02928197	1	F	2,5	3,0	5,0	38,0	–	–	1,25	2	Cylindrical	■
JS532030D1B.0Z2-NXT	02928199	1	D	3,0	3,0	6,0	38,0	–	–	1,5	2	Cylindrical	■
JS532035F1B.0Z2-NXT	02928202	1	F	3,5	6,0	7,0	57,0	–	–	1,75	2	Cylindrical	■
JS532040F1B.0Z2-NXT	02928203	1	F	4,0	6,0	8,0	57,0	–	–	2,0	2	Cylindrical	■
JS532045F1B.0Z2-NXT	02928206	1	F	4,5	6,0	9,0	57,0	–	–	2,25	2	Cylindrical	■
JS532050F1B.0Z2-NXT	02928207	1	F	5,0	6,0	10,0	57,0	–	–	2,5	2	Cylindrical	■
JS532060D1B.0Z2-NXT	02928210	1	D	6,0	6,0	12,0	57,0	–	–	3,0	2	Cylindrical	■
JS532080D1B.0Z2-NXT	02928213	1	D	8,0	8,0	16,0	63,0	–	–	4,0	2	Cylindrical	■
JS532100D1B.0Z2-NXT	02928216	1	D	10,0	10,0	20,0	72,0	–	–	5,0	2	Cylindrical	■
JS532120D1B.0Z2-NXT	02928219	1	D	12,0	12,0	24,0	83,0	–	–	6,0	2	Cylindrical	■
JS532160D1B.0Z2-NXT	02928222	1	D	16,0	16,0	32,0	92,0	–	–	8,0	2	Cylindrical	■
JS532200D1B.0Z2-NXT	02928225	1	D	20,0	20,0	40,0	104,0	–	–	10,0	2	Cylindrical	■
JS532020G2B.0Z2-NXT	02928196	2	G	2,0	3,0	2,0	38,0	8,0	1,9	1,0	2	Cylindrical	■
JS532030E2B.0Z2-NXT	02928200	2	E	3,0	3,0	3,0	38,0	10,0	2,85	1,5	2	Cylindrical	■
JS532040G2B.0Z2-NXT	02928204	2	G	4,0	6,0	4,0	57,0	15,0	3,8	2,0	2	Cylindrical	■
JS532050G2B.0Z2-NXT	02928208	2	G	5,0	6,0	5,0	57,0	20,0	4,8	2,5	2	Cylindrical	■
JS532060E2B.0Z2-NXT	02928211	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	2	Cylindrical	■
JS532080E2B.0Z2-NXT	02928214	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	2	Cylindrical	■
JS532100E2B.0Z2-NXT	02928217	2	E	10,0	10,0	10,0	82,0	40,0	9,5	5,0	2	Cylindrical	■
JS532120E2B.0Z2-NXT	02928220	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	2	Cylindrical	■
JS532160E2B.0Z2-NXT	02928223	2	E	16,0	16,0	16,0	125,0	72,0	15,2	8,0	2	Cylindrical	■
JS532030E3B.0Z2-NXT	02928201	3	E	3,0	3,0	3,0	52,0	20,0	2,85	1,5	2	Cylindrical	■
JS532040G3B.0Z2-NXT	02928205	3	G	4,0	6,0	4,0	63,0	24,0	3,8	2,0	2	Cylindrical	■
JS532050G3B.0Z2-NXT	02928209	3	G	5,0	6,0	5,0	75,0	35,0	4,8	2,5	2	Cylindrical	■
JS532060E3B.0Z2-NXT	02928212	3	E	6,0	6,0	6,0	80,0	42,0	5,7	3,0	2	Cylindrical	■
JS532080E3B.0Z2-NXT	02928215	3	E	8,0	8,0	8,0	100,0	60,0	7,6	4,0	2	Cylindrical	■
JS532100E3B.0Z2-NXT	02928218	3	E	10,0	10,0	10,0	125,0	80,0	9,5	5,0	2	Cylindrical	■
JS532120E3B.0Z2-NXT	02928221	3	E	12,0	12,0	12,0	125,0	75,0	11,4	6,0	2	Cylindrical	■
JS532160E3B.0Z2-NXT	02928224	3	E	16,0	16,0	16,0	150,0	100,0	15,2	8,0	2	Cylindrical	■

■ **Lagerstandard.**

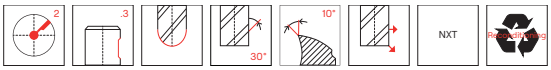
JS532

Hochleistungsfräser – Universell – Kugelkopf – 2 Schneiden – Weldon





– Toleranzen:
– DMM=h5
– DC=e8
– RE= ±0,01 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS532035F1B.3Z2-NXT	02928254	1	F	3,5	6,0	7,0	57,0	–	–	1,75	2	Weldon	■
JS532040F1B.3Z2-NXT	02928255	1	F	4,0	6,0	8,0	57,0	–	–	2,0	2	Weldon	□
JS532045F1B.3Z2-NXT	02928258	1	F	4,5	6,0	9,0	57,0	–	–	2,25	2	Weldon	□
JS532050F1B.3Z2-NXT	02928259	1	F	5,0	6,0	10,0	57,0	–	–	2,5	2	Weldon	□
JS532060D1B.3Z2-NXT	02928263	1	D	6,0	6,0	12,0	57,0	–	–	3,0	2	Weldon	□
JS532080D1B.3Z2-NXT	02928266	1	D	8,0	8,0	16,0	63,0	–	–	4,0	2	Weldon	□
JS532100D1B.3Z2-NXT	02928269	1	D	10,0	10,0	20,0	72,0	–	–	5,0	2	Weldon	□
JS532120D1B.3Z2-NXT	02928272	1	D	12,0	12,0	24,0	83,0	–	–	6,0	2	Weldon	□
JS532160D1B.3Z2-NXT	02928275	1	D	16,0	16,0	32,0	92,0	–	–	8,0	2	Weldon	□
JS532200D1B.3Z2-NXT	02928278	1	D	20,0	20,0	40,0	104,0	–	–	10,0	2	Weldon	□
JS532040G2B.3Z2-NXT	02928256	2	G	4,0	6,0	4,0	57,0	18,0	3,8	2,0	2	Weldon	□
JS532050G2B.3Z2-NXT	02928260	2	G	5,0	6,0	5,0	57,0	18,0	4,8	2,5	2	Weldon	□
JS532060E2B.3Z2-NXT	02928264	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	2	Weldon	□
JS532080E2B.3Z2-NXT	02928267	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	2	Weldon	□
JS532100E2B.3Z2-NXT	02928270	2	E	10,0	10,0	10,0	82,0	40,0	9,5	5,0	2	Weldon	□
JS532120E2B.3Z2-NXT	02928273	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	2	Weldon	□
JS532160E2B.3Z2-NXT	02928276	2	E	16,0	16,0	16,0	125,0	70,0	15,2	8,0	2	Weldon	□
JS532040G3B.3Z2-NXT	02928257	3	G	4,0	6,0	4,0	63,0	24,0	3,8	2,0	2	Weldon	□
JS532050G3B.3Z2-NXT	02928261	3	G	5,0	6,0	5,0	75,0	35,0	4,8	2,5	2	Weldon	□
JS532060E3B.3Z2-NXT	02928265	3	E	6,0	6,0	6,0	80,0	42,0	5,7	3,0	2	Weldon	□
JS532080E3B.3Z2-NXT	02928268	3	E	8,0	8,0	8,0	100,0	60,0	7,6	4,0	2	Weldon	□
JS532100E3B.3Z2-NXT	02928271	3	E	10,0	10,0	10,0	125,0	80,0	9,5	5,0	2	Weldon	□
JS532120E3B.3Z2-NXT	02928274	3	E	12,0	12,0	12,0	125,0	75,0	11,4	6,0	2	Weldon	□
JS532160E3B.3Z2-NXT	02928277	3	E	16,0	16,0	16,0	150,0	100,0	15,2	8,0	2	Weldon	□

□ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JS532 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
P1	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	205 (140 — 180) *670 (460 — 590)*
P2	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	200 (130 — 180) *660 (430 — 590)*
P3	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	170 (110 — 150) *560 (370 — 490)*
P4	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.10 *0,0040*	150 (97 — 130) *490 (320 — 420)*
P5	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	145 (93 — 130) *475 (310 — 420)*
P6	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	160 (110 — 140) *520 (370 — 450)*
P7	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	150 (98 — 140) *490 (330 — 450)*
P8	M/A/D/E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.11 *0,0044*	145 (93 — 130) *475 (310 — 420)*
P11	M/A/D/E	0.100 *0,100*	0.10 *0,10*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	170 (110 — 150) *560 (370 — 490)*
P12	M/A/D/E	0.100 *0,100*	0.10 *0,10*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	100 (64 — 92) *330 (210 — 300)*
M1	E	0.100 *0,100*	0.10 *0,10*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	195 (170 — 220) *640 (560 — 720)*
M2	E	0.100 *0,100*	0.10 *0,10*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	115 (93 — 130) *375 (310 — 420)*
M3	E	0.100 *0,100*	0.10 *0,10*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	95 (73 — 110) *310 (240 — 360)*
M4	E	0.100 *0,100*	0.10 *0,10*	0.0048 *0,00019*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	70 (55 — 85) *230 (190 — 270)*
M5	E	0.100 *0,100*	0.10 *0,10*	0.0048 *0,00019*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	60 (46 — 71) *195 (160 — 230)*
K1	E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	195 (180 — 210) *640 (600 — 680)*
K2	E	0.200 *0,200*	0.20 *0,20*	0.0055 *0,00022*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	170 (160 — 180) *560 (530 — 590)*
K3	E	0.200 *0,200*	0.20 *0,20*	0.0055 *0,00022*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	145 (130 — 150) *475 (430 — 490)*
K4	E	0.200 *0,200*	0.20 *0,20*	0.0055 *0,00022*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	140 (130 — 150) *460 (430 — 490)*
K5	E	0.100 *0,100*	0.10 *0,10*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	165 (150 — 180) *540 (500 — 590)*
K6	E	0.100 *0,100*	0.10 *0,10*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	245 (220 — 270) *800 (730 — 880)*
K7	E	0.100 *0,100*	0.10 *0,10*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	210 (190 — 230) *690 (630 — 750)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS532 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
N1	E	0.200 *0,200*	0.30 *0,30*	0.0080 *0,00032*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	610 (520 — 710) *2000 (1800 — 2300)*
N2	E	0.200 *0,200*	0.30 *0,30*	0.0080 *0,00032*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	395 (330 — 450) *1300 (1100 — 1400)*
N3	E	0.200 *0,200*	0.30 *0,30*	0.0080 *0,00032*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	260 (220 — 300) *850 (730 — 980)*
N11	E	0.200 *0,200*	0.30 *0,30*	0.0050 *0,00020*	0.010 *0,00040*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	415 (370 — 460) *1350 (1300 — 1500)*
S1	E	0.150 *0,150*	0.10 *0,10*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	60 (52 — 72) *195 (180 — 230)*
S2	E	0.150 *0,150*	0.10 *0,10*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	50 (42 — 58) *165 (140 — 190)*
S3	E	0.100 *0,100*	0.10 *0,10*	0.0036 *0,00014*	0.0070 *0,00028*	0.010 *0,00040*	0.014 *0,00055*	0.018 *0,00070*	0.020 *0,00080*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	32 (22 — 42) *105 (73 — 130)*
S11	E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	105 (94 — 110) *345 (310 — 360)*
S12	E	0.200 *0,200*	0.20 *0,20*	0.0060 *0,00024*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	80 (72 — 92) *260 (240 — 300)*
S13	E	0.200 *0,200*	0.20 *0,20*	0.0055 *0,00022*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	0.080 *0,0032*	0.090 *0,0036*	65 (57 — 72) *215 (190 — 230)*
TS1	A	0.200 *0,200*	0.40 *0,40*	0.0075 *0,00030*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.13 *0,0050*	610 (570 — 660) *2000 (1900 — 2100)*
TP1	A	0.200 *0,200*	0.40 *0,40*	0.0075 *0,00030*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.13 *0,0050*	610 (570 — 660) *2000 (1900 — 2100)*
GR1	A	0.200 *0,200*	0.40 *0,40*	0.0075 *0,00030*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.13 *0,0050*	610 (570 — 660) *2000 (1900 — 2100)*

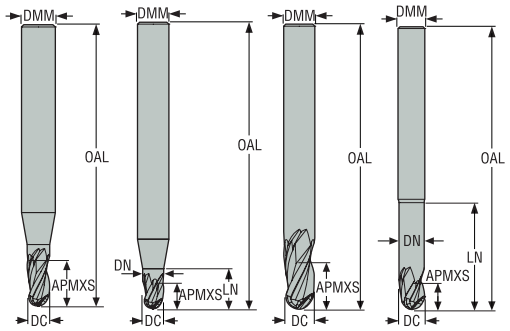
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

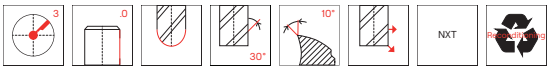
JS533

Hochleistungsfräser – Universell – Kugelkopf – 3 Schneiden – Zylindrisch





– Toleranzen:
– DMM=h5
– DC=e8
– RE= ±0,01 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist



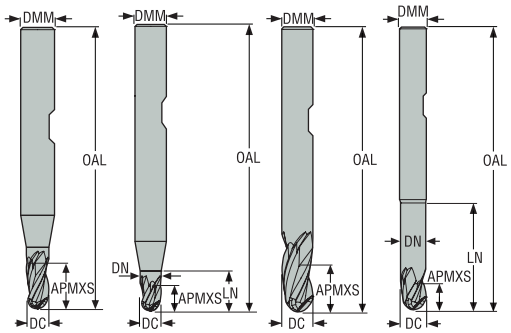
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS533010F1B.0Z3-NXT	02928284	1	F	1,0	3,0	2,0	38,0	–	–	0,5	3	Cylindrical	■
JS533015F1B.0Z3-NXT	02928286	1	F	1,5	3,0	3,0	38,0	–	–	0,75	3	Cylindrical	■
JS533020F1B.0Z3-NXT	02928287	1	F	2,0	3,0	4,0	38,0	–	–	1,0	3	Cylindrical	■
JS533030D1B.0Z3-NXT	02928289	1	D	3,0	3,0	6,0	38,0	–	–	1,5	3	Cylindrical	■
JS533040F1B.0Z3-NXT	02928291	1	F	4,0	6,0	8,0	57,0	–	–	2,0	3	Cylindrical	■
JS533050F1B.0Z3-NXT	02928293	1	F	5,0	6,0	10,0	57,0	–	–	2,5	3	Cylindrical	■
JS533060D1B.0Z3-NXT	02928295	1	D	6,0	6,0	12,0	57,0	–	–	3,0	3	Cylindrical	■
JS533080D1B.0Z3-NXT	02928297	1	D	8,0	8,0	16,0	63,0	–	–	4,0	3	Cylindrical	■
JS533100D1B.0Z3-NXT	02928299	1	D	10,0	10,0	20,0	72,0	–	–	5,0	3	Cylindrical	■
JS533120D1B.0Z3-NXT	02928301	1	D	12,0	12,0	24,0	83,0	–	–	6,0	3	Cylindrical	■
JS533160D1B.0Z3-NXT	02928303	1	D	16,0	16,0	32,0	110,0	–	–	8,0	3	Cylindrical	■
JS533200D1B.0Z3-NXT	02928305	1	D	20,0	20,0	40,0	125,0	–	–	10,0	3	Cylindrical	■
JS533020G2B.0Z3-NXT	02928288	2	G	2,0	3,0	2,0	38,0	7,0	1,9	1,0	3	Cylindrical	■
JS533030E2B.0Z3-NXT	02928290	2	E	3,0	3,0	3,0	38,0	9,0	2,85	1,5	3	Cylindrical	■
JS533040G2B.0Z3-NXT	02928292	2	G	4,0	6,0	4,0	57,0	15,0	3,8	2,0	3	Cylindrical	■
JS533050G2B.0Z3-NXT	02928294	2	G	5,0	6,0	5,0	57,0	15,0	4,8	2,5	3	Cylindrical	■
JS533060E2B.0Z3-NXT	02928296	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	3	Cylindrical	■
JS533080E2B.0Z3-NXT	02928298	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	3	Cylindrical	■
JS533100E2B.0Z3-NXT	02928300	2	E	10,0	10,0	10,0	89,0	40,0	9,5	5,0	3	Cylindrical	■
JS533120E2B.0Z3-NXT	02928302	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	3	Cylindrical	■
JS533160E2B.0Z3-NXT	02928304	2	E	16,0	16,0	16,0	125,0	70,0	15,2	8,0	3	Cylindrical	■

■ **Lagerstandard.**

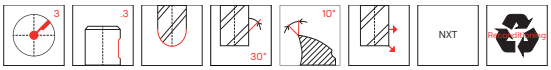
JS533

Hochleistungsfräser – Universell – Kugelkopf – 3 Schneiden – Weldon





– Toleranzen:
– DMM=h5
– DC=e8
– RE= ±0,01 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS533040F1B.3Z3-NXT	02928323	1	F	4,0	6,0	8,0	57,0	–	–	2,0	3	Weldon	☐
JS533050F1B.3Z3-NXT	02928325	1	F	5,0	6,0	10,0	57,0	–	–	2,5	3	Weldon	☐
JS533060D1B.3Z3-NXT	02928326	1	D	6,0	6,0	12,0	57,0	–	–	3,0	3	Weldon	☐
JS533080D1B.3Z3-NXT	02928328	1	D	8,0	8,0	16,0	63,0	–	–	4,0	3	Weldon	☐
JS533100D1B.3Z3-NXT	02928330	1	D	10,0	10,0	20,0	72,0	–	–	5,0	3	Weldon	☐
JS533120D1B.3Z3-NXT	02928332	1	D	12,0	12,0	24,0	83,0	–	–	6,0	3	Weldon	☐
JS533160D1B.3Z3-NXT	02928334	1	D	16,0	16,0	32,0	109,0	–	–	8,0	3	Weldon	☐
JS533200D1B.3Z3-NXT	02928336	1	D	20,0	20,0	40,0	125,0	–	–	10,0	3	Weldon	☐
JS533040G2B.3Z3-NXT	02928324	2	G	4,0	6,0	4,0	57,0	15,0	3,8	2,0	3	Weldon	☐
JS533050G2B.3Z3-NXT	02928341	2	G	5,0	6,0	5,0	57,0	15,0	4,8	2,5	3	Weldon	☐
JS533060E2B.3Z3-NXT	02928327	2	E	6,0	6,0	6,0	63,0	25,0	5,7	3,0	3	Weldon	☐
JS533080E2B.3Z3-NXT	02928329	2	E	8,0	8,0	8,0	80,0	35,0	7,6	4,0	3	Weldon	☐
JS533100E2B.3Z3-NXT	02928331	2	E	10,0	10,0	10,0	89,0	40,0	9,5	5,0	3	Weldon	☐
JS533120E2B.3Z3-NXT	02928333	2	E	12,0	12,0	12,0	100,0	50,0	11,4	6,0	3	Weldon	☐
JS533160E2B.3Z3-NXT	02928335	2	E	16,0	16,0	16,0	122,0	70,0	15,2	8,0	3	Weldon	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JS533 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
P1	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0032 *0,00013*	0.0065 *0,00026*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	200 (180 — 220) *660 (600 — 720)*
P2	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0034 *0,00013*	0.0065 *0,00026*	0.010 *0,00040*	0.013 *0,00050*	0.017 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	195 (170 — 220) *640 (560 — 720)*
P3	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0032 *0,00013*	0.0060 *0,00024*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	165 (150 — 180) *540 (500 — 590)*
P4	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	145 (130 — 160) *475 (430 — 520)*
P5	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	140 (130 — 160) *460 (430 — 520)*
P6	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	155 (140 — 170) *510 (460 — 550)*
P7	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	150 (130 — 160) *490 (430 — 520)*
P8	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0032 *0,00013*	0.0060 *0,00024*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	140 (120 — 150) *460 (400 — 490)*
P11	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0044 *0,00017*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	140 (130 — 160) *460 (430 — 520)*
P12	M/A/D/E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	85 (73 — 97) *280 (240 — 310)*
M1	E	0.0300 *0,0300*	0.80 *0,80*	0.0034 *0,00013*	0.0065 *0,00026*	0.010 *0,00040*	0.013 *0,00050*	0.017 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	125 (99 — 140) *410 (330 — 450)*
M2	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	100 (80 — 120) *330 (270 — 390)*
M3	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	70 (50 — 90) *230 (170 — 290)*
M4	E	0.0300 *0,0300*	0.80 *0,80*	0.0026 *0,00010*	0.0050 *0,00020*	0.0080 *0,00032*	0.011 *0,00044*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	55 (38 — 67) *180 (130 — 210)*
M5	E	0.0300 *0,0300*	0.80 *0,80*	0.0026 *0,00010*	0.0050 *0,00020*	0.0080 *0,00032*	0.011 *0,00044*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	44 (32 — 56) *145 (110 — 180)*
K1	E	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	145 (130 — 160) *475 (430 — 520)*
K2	E	0.0300 *0,0300*	0.80 *0,80*	0.0036 *0,00014*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	125 (110 — 140) *410 (370 — 450)*
K3	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	105 (91 — 110) *345 (300 — 360)*
K4	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	120 (100 — 140) *395 (330 — 450)*
K5	E	0.0300 *0,0300*	0.80 *0,80*	0.0044 *0,00017*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	70 (61 — 84) *230 (210 — 270)*
K6	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	105 (89 — 120) *345 (300 — 390)*
K7	E	0.0300 *0,0300*	0.80 *0,80*	0.0044 *0,00017*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	155 (130 — 180) *510 (430 — 590)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS533 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z											v_c
				1	2	3	4	5	6	8	10	12	16	20	
N1	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	800 (700 — 900) *2625 (2300 — 2900)*
N2	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	510 (450 — 570) *1675 (1500 — 1800)*
N3	E	0.0300 *0,0300*	0.80 *0,80*	0.0050 *0,00020*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	345 (300 — 380) *1125 (990 — 1200)*
N11	E	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	400 (350 — 450) *1300 (1200 — 1400)*
S1	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	100 (90 — 110) *330 (300 — 360)*
S2	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	80 (73 — 88) *260 (240 — 280)*
S11	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	130 (120 — 140) *425 (400 — 450)*
S12	E	0.0300 *0,0300*	0.80 *0,80*	0.0030 *0,00012*	0.0060 *0,00024*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	100 (91 — 110) *330 (300 — 360)*
S13	E	0.0300 *0,0300*	0.80 *0,80*	0.0026 *0,00010*	0.0050 *0,00020*	0.0080 *0,00032*	0.011 *0,00044*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	80 (70 — 85) *260 (230 — 270)*
TS1	A	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	800 (760 — 850) *2625 (2500 — 2700)*
TP1	A	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	800 (760 — 850) *2625 (2500 — 2700)*
GR1	A	0.0300 *0,0300*	0.80 *0,80*	0.0040 *0,00016*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.070 *0,0028*	800 (760 — 850) *2625 (2500 — 2700)*

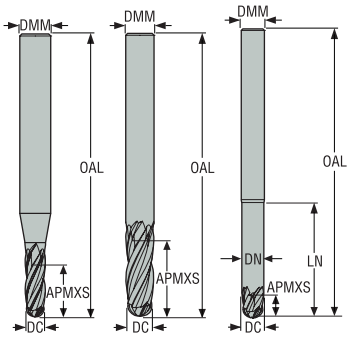
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

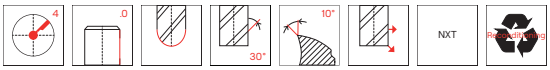
JS534

Hochleistungsfräser – Universell – Kugelkopf – 4 Schneiden – Zylindrisch





– Toleranzen:
– DMM=h5
– DC=e8
– RE= ±0,01 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist



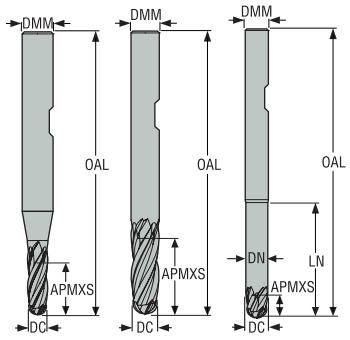
Bezeichnung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Aufnahmen	Lagerstandard
				mm	mm	mm	mm	mm	mm	mm			
JS534020F1B.0Z4-NXT	02928366	1	F	2,0	3,0	6,0	38,0	–	–	1,0	4	Cylindrical	■
JS534030D1B.0Z4-NXT	02928367	1	D	3,0	3,0	9,0	38,0	–	–	1,5	4	Cylindrical	■
JS534040F1B.0Z4-NXT	02928368	1	F	4,0	6,0	12,0	57,0	–	–	2,0	4	Cylindrical	■
JS534050F1B.0Z4-NXT	02928370	1	F	5,0	6,0	15,0	57,0	–	–	2,5	4	Cylindrical	■
JS534060D1B.0Z4-NXT	02928372	1	D	6,0	6,0	18,0	57,0	–	–	3,0	4	Cylindrical	■
JS534080D1B.0Z4-NXT	02928375	1	D	8,0	8,0	24,0	69,0	–	–	4,0	4	Cylindrical	■
JS534100D1B.0Z4-NXT	02928378	1	D	10,0	10,0	30,0	82,0	–	–	5,0	4	Cylindrical	■
JS534120D1B.0Z4-NXT	02928381	1	D	12,0	12,0	36,0	100,0	–	–	6,0	4	Cylindrical	■
JS534160D1B.0Z4-NXT	02928384	1	D	16,0	16,0	48,0	110,0	–	–	8,0	4	Cylindrical	■
JS534200D1B.0Z4-NXT	02928387	1	D	20,0	20,0	60,0	125,0	–	–	10,0	4	Cylindrical	■
JS534040F2B.0Z4-NXT	02928369	2	F	4,0	6,0	20,0	63,0	–	–	2,0	4	Cylindrical	■
JS534050F2B.0Z4-NXT	02928371	2	F	5,0	6,0	25,0	75,0	–	–	2,5	4	Cylindrical	■
JS534060D2B.0Z4-NXT	02928373	2	D	6,0	6,0	30,0	75,0	–	–	3,0	4	Cylindrical	■
JS534080D2B.0Z4-NXT	02928376	2	D	8,0	8,0	40,0	80,0	–	–	4,0	4	Cylindrical	■
JS534100D2B.0Z4-NXT	02928379	2	D	10,0	10,0	50,0	100,0	–	–	5,0	4	Cylindrical	■
JS534120D2B.0Z4-NXT	02928382	2	D	12,0	12,0	60,0	125,0	–	–	6,0	4	Cylindrical	■
JS534160D2B.0Z4-NXT	02928385	2	D	16,0	16,0	80,0	130,0	–	–	8,0	4	Cylindrical	■
JS534060E3B.0Z4-NXT	02928374	3	E	6,0	6,0	6,0	75,0	30,0	5,7	3,0	4	Cylindrical	■
JS534080E3B.0Z4-NXT	02928377	3	E	8,0	8,0	8,0	80,0	40,0	7,6	4,0	4	Cylindrical	■
JS534100E3B.0Z4-NXT	02928380	3	E	10,0	10,0	10,0	100,0	50,0	9,7	5,0	4	Cylindrical	■
JS534120E3B.0Z4-NXT	02928383	3	E	12,0	12,0	12,0	125,0	60,0	11,4	6,0	4	Cylindrical	■
JS534160E3B.0Z4-NXT	02928386	3	E	16,0	16,0	16,0	130,0	80,0	15,2	8,0	4	Cylindrical	■
JS534200E3B.0Z4-NXT	02928388	3	E	20,0	20,0	20,0	150,0	100,0	19,0	10,0	4	Cylindrical	■

■ **Lagerstandard.**

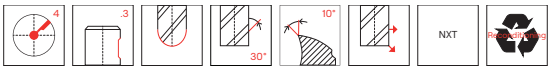
JS534

Hochleistungsfräser – Universell – Kugelkopf – 4 Schneiden – Weldon





– Toleranzen:
– DMM=h5
– DC=e8
– RE= ±0,01 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS534040F1B.3Z4-NXT	02928390	1	F	4,0	6,0	12,0	57,0	–	–	2,0	4	Weldon	☐
JS534050F1B.3Z4-NXT	02928392	1	F	5,0	6,0	15,0	57,0	–	–	2,5	4	Weldon	☐
JS534060D1B.3Z4-NXT	02928394	1	D	6,0	6,0	18,0	57,0	–	–	3,0	4	Weldon	☐
JS534080D1B.3Z4-NXT	02928397	1	D	8,0	8,0	24,0	69,0	–	–	4,0	4	Weldon	☐
JS534100D1B.3Z4-NXT	02928400	1	D	10,0	10,0	30,0	82,0	–	–	5,0	4	Weldon	☐
JS534120D1B.3Z4-NXT	02928403	1	D	12,0	12,0	36,0	100,0	–	–	6,0	4	Weldon	☐
JS534160D1B.3Z4-NXT	02928406	1	D	16,0	16,0	48,0	110,0	–	–	8,0	4	Weldon	☐
JS534200D1B.3Z4-NXT	02928409	1	D	20,0	20,0	60,0	125,0	–	–	10,0	4	Weldon	☐
JS534040F2B.3Z4-NXT	02928391	2	F	4,0	6,0	20,0	63,0	–	–	2,0	4	Weldon	☐
JS534050F2B.3Z4-NXT	02928393	2	F	5,0	6,0	25,0	75,0	–	–	2,5	4	Weldon	☐
JS534060D2B.3Z4-NXT	02928395	2	D	6,0	6,0	30,0	75,0	–	–	3,0	4	Weldon	☐
JS534080D2B.3Z4-NXT	02928398	2	D	8,0	8,0	40,0	80,0	–	–	4,0	4	Weldon	☐
JS534100D2B.3Z4-NXT	02928401	2	D	10,0	10,0	50,0	100,0	–	–	5,0	4	Weldon	☐
JS534120D2B.3Z4-NXT	02928404	2	D	12,0	12,0	60,0	125,0	–	–	6,0	4	Weldon	☐
JS534160D2B.3Z4-NXT	02928407	2	D	16,0	16,0	80,0	130,0	–	–	8,0	4	Weldon	☐
JS534060E3B.3Z4-NXT	02928396	3	E	6,0	6,0	6,0	75,0	30,0	5,7	3,0	4	Weldon	☐
JS534080E3B.3Z4-NXT	02928399	3	E	8,0	8,0	8,0	80,0	40,0	7,6	4,0	4	Weldon	☐
JS534100E3B.3Z4-NXT	02928402	3	E	10,0	10,0	10,0	100,0	50,0	9,7	5,0	4	Weldon	☐
JS534120E3B.3Z4-NXT	02928405	3	E	12,0	12,0	12,0	125,0	60,0	11,4	6,0	4	Weldon	☐
JS534160E3B.3Z4-NXT	02928408	3	E	16,0	16,0	16,0	130,0	80,0	15,2	8,0	4	Weldon	☐
JS534200E3B.3Z4-NXT	02928410	3	E	20,0	20,0	20,0	150,0	100,0	19,0	10,0	4	Weldon	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JS534 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
P1	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	345 (310 — 370) *1125 (1100 — 1200)*
P2	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	335 (300 — 360) *1100 (990 — 1100)*
P3	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0085 *0,00034*	0.012 *0,00048*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	290 (260 — 310) *950 (860 — 1000)*
P4	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	255 (230 — 280) *840 (760 — 910)*
P5	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	245 (220 — 260) *800 (730 — 850)*
P6	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	230 (210 — 250) *750 (690 — 820)*
P7	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	220 (200 — 240) *720 (660 — 780)*
P8	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0085 *0,00034*	0.012 *0,00048*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	205 (190 — 220) *670 (630 — 720)*
P11	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	210 (190 — 230) *690 (630 — 750)*
P12	M/A/D/E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	125 (120 — 130) *410 (400 — 420)*
M1	E	0.0300 *0,0300*	4.0 *4,0*	0.0090 *0,00036*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	180 (160 — 200) *590 (530 — 650)*
M2	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	145 (130 — 160) *475 (430 — 520)*
M3	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	155 (140 — 180) *510 (460 — 590)*
M4	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.010 *0,00040*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	120 (100 — 130) *395 (330 — 420)*
M5	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.010 *0,00040*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	100 (83 — 110) *330 (280 — 360)*
K1	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	245 (220 — 260) *800 (730 — 850)*
K2	E	0.0300 *0,0300*	4.0 *4,0*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	215 (200 — 230) *710 (660 — 750)*
K3	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	180 (160 — 190) *590 (530 — 620)*
K4	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	170 (160 — 180) *560 (530 — 590)*
K5	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	200 (180 — 220) *660 (600 — 720)*
K6	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	295 (260 — 330) *970 (860 — 1000)*
K7	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	260 (230 — 280) *850 (760 — 910)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS534 Kopierfräsen/Schruppen

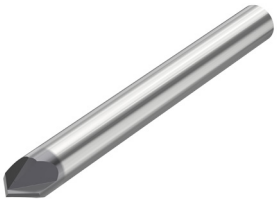
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	1025 (910 — 1100) *3375 (3000 — 3600)*
N2	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	910 (780 — 1000) *2975 (2600 — 3200)*
N3	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	600 (520 — 690) *1975 (1800 — 2200)*
N11	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	500 (440 — 560) *1650 (1500 — 1800)*
S1	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	110 (88 — 110) *360 (290 — 360)*
S2	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	90 (71 — 90) *295 (240 — 290)*
S3	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	85 (63 — 87) *280 (210 — 280)*
S11	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	185 (150 — 180) *610 (500 — 590)*
S12	E	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	140 (120 — 140) *460 (400 — 450)*
S13	E	0.0300 *0,0300*	4.0 *4,0*	0.0070 *0,00028*	0.010 *0,00040*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	110 (91 — 110) *360 (300 — 360)*
TS1	A	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	900 (840 — 960) *2950 (2800 — 3100)*
TP1	A	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	900 (840 — 960) *2950 (2800 — 3100)*
GR1	A	0.0300 *0,0300*	4.0 *4,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	900 (840 — 960) *2950 (2800 — 3100)*

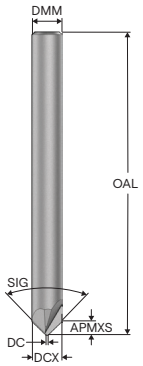
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

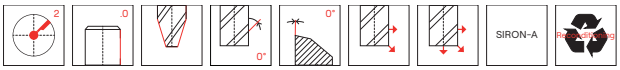
C5021

Allgemeine Anwendung – Universell – Fase – 2-4 Schneiden – Zylindrisch – Zoll





– Toleranzen:
– DMM=-.0001"/-.0004"
– SIG= ±1°
– Nachschleifen möglich, wenn DC ≥ Ø.375 ist



Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll				
C5021-.250N1S.0Z2T30	SIRA	10268641	1	N	0.250	0.035	0.250	0.186	2.500	30,0	2	Cylindrical	■
C5021-.250N1S.0Z2T45	SIRA	10268644	1	N	0.250	0.035	0.250	0.108	2.500	45,0	2	Cylindrical	■
C5021-.375N1S.0Z2T30	SIRA	10268642	1	N	0.375	0.040	0.375	0.290	2.500	30,0	2	Cylindrical	■
C5021-.375N1S.0Z2T45	SIRA	10268645	1	N	0.375	0.040	0.375	0.168	2.500	45,0	2	Cylindrical	■
C5021-.500N1S.0Z2T30	SIRA	10268643	1	N	0.500	0.045	0.500	0.186	3.000	30,0	2	Cylindrical	■
C5021-.500N1S.0Z2T45	SIRA	10268646	1	N	0.500	0.045	0.500	0.228	3.000	45,0	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – C5021 Anfasen – Zoll

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				1/4	3/8	1/2	
P1	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	205 (160 — 230) *670 (530 — 750)*
P2	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	195 (160 — 230) *640 (530 — 750)*
P3	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	165 (130 — 180) *540 (430 — 590)*
P4	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	140 (120 — 160) *460 (400 — 520)*
P5	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	135 (120 — 170) *445 (400 — 550)*
P6	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	160 (120 — 170) *520 (400 — 550)*
P7	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	145 (120 — 180) *475 (400 — 590)*
P8	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	135 (120 — 150) *445 (400 — 490)*
P11	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	85 (69 — 110) *280 (230 — 360)*
P12	E	0,02 *0.02*	0,3 *0.3*	0,032 *0.0013*	0,038 *0.0015*	0,042 *0.0017*	60 (49 — 91) *195 (170 — 290)*
M1	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,06 *0.0024*	0,065 *0.0026*	120 (110 — 150) *395 (370 — 490)*
M2	E	0,02 *0.02*	0,3 *0.3*	0,042 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	80 (65 — 100) *260 (220 — 320)*
M3	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	75 (59 — 100) *245 (200 — 320)*
M4	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	43 (30 — 59) *140 (99 — 190)*
M5	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,06 *0.0024*	36 (19 — 55) *120 (63 — 180)*
K1	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	195 (160 — 240) *640 (530 — 780)*
K2	E	0,02 *0.02*	0,3 *0.3*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	170 (150 — 200) *560 (500 — 650)*
K3	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	145 (130 — 160) *475 (430 — 520)*
K4	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	130 (110 — 150) *425 (370 — 490)*
K5	E	0,02 *0.02*	0,3 *0.3*	0,042 *0.0017*	0,048 *0.0019*	0,055 *0.0022*	85 (65 — 110) *280 (220 — 360)*
K6	E	0,02 *0.02*	0,3 *0.3*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	130 (120 — 160) *425 (400 — 520)*
K7	E	0,02 *0.02*	0,3 *0.3*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	110 (94 — 140) *360 (310 — 450)*

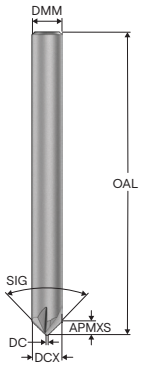
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

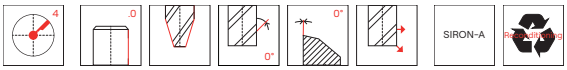
C5041

Allgemeine Anwendung – Universell – Fase – 2-4 Schneiden – Zylindrisch – Zoll





—Toleranzen:
—DMM=-.0001"/-.0004"
—SIG= ±1°
—Nachschleifen möglich, wenn DMM ≥ Ø.375" ist



Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll				
C5041-.250N1S.0Z4T30	SIRA	10268647	1	N	0.250	0.035	0.250	0.186	2.500	30,0	4	Cylindrical	■
C5041-.250N1S.0Z4T45	SIRA	10268652	1	N	0.250	0.035	0.250	0.108	2.500	45,0	4	Cylindrical	■
C5041-.375N1S.0Z4T30	SIRA	10268648	1	N	0.375	0.040	0.375	0.290	2.500	30,0	4	Cylindrical	■
C5041-.375N1S.0Z4T45	SIRA	10268653	1	N	0.375	0.040	0.375	0.168	2.500	45,0	4	Cylindrical	■
C5041-.500N1S.0Z4T30	SIRA	10268649	1	N	0.500	0.045	0.500	0.394	3.000	30,0	4	Cylindrical	■
C5041-.500N1S.0Z4T45	SIRA	10268654	1	N	0.500	0.045	0.500	0.228	3.000	45,0	4	Cylindrical	■
C5041-.750N1S.0Z4T30	SIRA	10268651	1	N	0.750	0.055	0.750	0.602	3.000	30,0	4	Cylindrical	■
C5041-.750N1S.0Z4T45	SIRA	10268655	1	N	0.750	0.055	0.750	0.348	3.000	45,0	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – C5041 Anfasen – Zoll

SMG		a_e/DCX	a_p/DCX	f_z				v_c
				1/4	3/8	1/2	3/4	
P1	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,08 *0.0032*	205 (160 — 230) *670 (530 — 750)*
P2	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	195 (160 — 230) *640 (530 — 750)*
P3	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	165 (130 — 180) *540 (430 — 590)*
P4	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	140 (120 — 160) *460 (400 — 520)*
P5	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	135 (120 — 170) *445 (400 — 550)*
P6	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	160 (120 — 170) *520 (400 — 550)*
P7	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	145 (120 — 180) *475 (400 — 590)*
P8	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	135 (120 — 150) *445 (400 — 490)*
P11	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	85 (69 — 110) *280 (230 — 360)*
P12	E	0,02 *0.02*	0,3 *0.3*	0,032 *0.0013*	0,038 *0.0015*	0,042 *0.0017*	0,05 *0.0020*	60 (49 — 91) *195 (170 — 290)*
M1	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,06 *0.0024*	0,065 *0.0026*	0,08 *0.0032*	120 (110 — 150) *395 (370 — 490)*
M2	E	0,02 *0.02*	0,3 *0.3*	0,042 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	80 (65 — 100) *260 (220 — 320)*
M3	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,08 *0.0032*	75 (59 — 100) *245 (200 — 320)*
M4	E	0,02 *0.02*	0,3 *0.3*	0,05 *0.0020*	0,055 *0.0022*	0,065 *0.0026*	0,08 *0.0032*	43 (30 — 59) *140 (99 — 190)*
M5	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,06 *0.0024*	0,07 *0.0028*	36 (19 — 55) *120 (63 — 180)*
K1	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	195 (160 — 240) *640 (530 — 780)*
K2	E	0,02 *0.02*	0,3 *0.3*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	170 (150 — 200) *560 (500 — 650)*
K3	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	145 (130 — 160) *475 (430 — 520)*
K4	E	0,02 *0.02*	0,3 *0.3*	0,044 *0.0017*	0,05 *0.0020*	0,055 *0.0022*	0,07 *0.0028*	130 (110 — 150) *425 (370 — 490)*
K5	E	0,02 *0.02*	0,3 *0.3*	0,042 *0.0017*	0,048 *0.0019*	0,055 *0.0022*	0,065 *0.0026*	85 (65 — 110) *280 (220 — 360)*
K6	E	0,02 *0.02*	0,3 *0.3*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	0,06 *0.0024*	130 (120 — 160) *425 (400 — 520)*
K7	E	0,02 *0.02*	0,3 *0.3*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	0,06 *0.0024*	110 (94 — 140) *360 (310 — 450)*

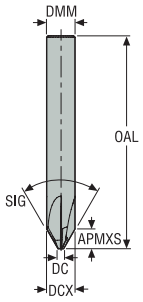
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JS506

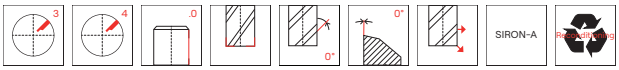
Allgemeine Anwendung – Universell – Fase – 3-4 Schneiden – Zylindrisch





N

– Toleranzen:
– DMM=h5
– SIG= ±0,5°
– Nachschleifen möglich, wenn DMM ≥ Ø6 ist



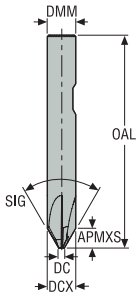
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm				
JS506030N2CZ3.0-SIRA	02881622	2	N	3,0	0,6	3,0	2,0	50,0	30,0	3	Cylindrical	■
JS506040N2CZ3.0-SIRA	02881623	2	N	4,0	0,8	4,0	2,7	50,0	30,0	3	Cylindrical	■
JS506060N2CZ4.0-SIRA	02881624	2	N	6,0	1,2	6,0	4,1	57,0	30,0	4	Cylindrical	■
JS506080N2CZ4.0-SIRA	02881626	2	N	8,0	1,6	8,0	5,5	63,0	30,0	4	Cylindrical	■
JS506100N2CZ4.0-SIRA	02881628	2	N	10,0	2,0	10,0	6,9	72,0	30,0	4	Cylindrical	■
JS506120N2CZ4.0-SIRA	02881630	2	N	12,0	2,4	12,0	8,3	83,0	30,0	4	Cylindrical	■

■ **Lagerstandard.**

JS506

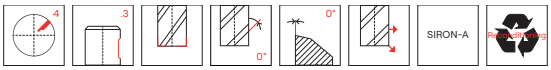
Allgemeine Anwendung – Universell – Fase – 3-4 Schneiden – Weldon





N

—Toleranzen:
—DMM=h5
—SIG= ±0,5°
—Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm				
JS506060N2CZ4.3-SIRA	02881625	2	N	6,0	1,2	6,0	4,1	57,0	30,0	4	Weldon	■
JS506080N2CZ4.3-SIRA	02881627	2	N	8,0	1,6	8,0	5,5	63,0	30,0	4	Weldon	■
JS506100N2CZ4.3-SIRA	02881629	2	N	10,0	2,0	10,0	6,9	72,0	30,0	4	Weldon	■
JS506120N2CZ4.3-SIRA	02881631	2	N	12,0	2,4	12,0	8,3	83,0	30,0	4	Weldon	■

■ **Lagerstandard.**

Schnittdaten – JS506 Anfasen

SMG		a_e/DCX	a_p/DCX	f_z						v_c
				3	4	6	8	10	12	
P1	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	190 (170 — 210) *620 (560 — 680)*
P2	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,036 *0.0014*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,1 *0.0040*	180 (160 — 200) *590 (530 — 650)*
P3	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,025 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	155 (140 — 170) *510 (460 — 550)*
P4	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,025 *0.0010*	0,032 *0.0013*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	140 (130 — 150) *460 (430 — 490)*
P5	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	135 (120 — 150) *445 (400 — 490)*
P6	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	150 (130 — 160) *490 (430 — 520)*
P7	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	140 (130 — 160) *460 (430 — 520)*
P8	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,025 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	130 (120 — 140) *425 (400 — 450)*
P11	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	95 (76 — 110) *310 (250 — 360)*
P12	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,016 *0.00065*	0,022 *0.00085*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	60 (47 — 69) *195 (160 — 220)*
M1	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,036 *0.0014*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,1 *0.0040*	110 (87 — 120) *360 (290 — 390)*
M2	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	90 (72 — 100) *295 (240 — 320)*
M3	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	60 (41 — 75) *195 (140 — 240)*
M4	E/M/A	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	44 (31 — 57) *145 (110 — 180)*
M5	E/M/A	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	37 (26 — 48) *120 (86 — 150)*
K1	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,036 *0.0014*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,1 *0.0040*	185 (160 — 200) *610 (530 — 650)*
K2	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	160 (140 — 180) *520 (460 — 590)*
K3	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	135 (120 — 150) *445 (400 — 490)*
K4	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	130 (120 — 140) *425 (400 — 450)*
K5	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,044 *0.0017*	0,06 *0.0024*	0,07 *0.0028*	0,085 *0.0034*	80 (69 — 89) *260 (230 — 290)*
K6	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	115 (100 — 130) *375 (330 — 420)*
K7	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,044 *0.0017*	0,06 *0.0024*	0,07 *0.0028*	0,085 *0.0034*	100 (88 — 110) *330 (290 — 360)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS506 Anfasen

SMG		a_e/DCX	a_p/DCX	f_z						v_c
				3	4	6	8	10	12	
N1	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	445 (410 — 480) *1450 (1400 — 1500)*
N2	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	285 (260 — 310) *940 (860 — 1000)*
N3	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	190 (180 — 200) *620 (600 — 650)*
N11	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	255 (230 — 270) *840 (760 — 880)*
S1	E	0,02 *0.02*	0,3 *0.3*	0,013 *0.00050*	0,017 *0.00065*	0,026 *0.0010*	0,034 *0.0013*	0,044 *0.0017*	0,05 *0.0020*	42 (14 — 69) *140 (46 — 220)*
S2	E	0,02 *0.02*	0,3 *0.3*	0,013 *0.00050*	0,017 *0.00065*	0,026 *0.0010*	0,034 *0.0013*	0,044 *0.0017*	0,05 *0.0020*	34 (12 — 56) *110 (40 — 180)*
S3	E	0,02 *0.02*	0,3 *0.3*	0,012 *0.00048*	0,016 *0.00065*	0,024 *0.00095*	0,032 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	29 (9,8 — 48) *95 (33 — 150)*
S11	E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	85 (64 — 100) *280 (210 — 320)*
S12	E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	65 (49 — 84) *215 (170 — 270)*
S13	E	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	55 (39 — 66) *180 (130 — 210)*
H5	M/A/D	0,02 *0.02*	0,3 *0.3*	0,012 *0.00048*	0,016 *0.00065*	0,024 *0.00095*	0,032 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	65 (47 — 87) *215 (160 — 280)*
H8	M/A/D	0,02 *0.02*	0,3 *0.3*	0,0095 *0.00038*	0,012 *0.00048*	0,019 *0.00075*	0,025 *0.0010*	0,03 *0.0012*	0,036 *0.0014*	70 (47 — 88) *230 (160 — 280)*
H11	M/A/D	0,02 *0.02*	0,3 *0.3*	0,012 *0.00048*	0,016 *0.00065*	0,024 *0.00095*	0,032 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	85 (60 — 110) *280 (200 — 360)*
H12	M/A/D	0,02 *0.02*	0,3 *0.3*	0,0095 *0.00038*	0,012 *0.00048*	0,019 *0.00075*	0,025 *0.0010*	0,03 *0.0012*	0,036 *0.0014*	80 (55 — 100) *260 (190 — 320)*
H21	M/A/D	0,02 *0.02*	0,3 *0.3*	0,0095 *0.00038*	0,012 *0.00048*	0,019 *0.00075*	0,025 *0.0010*	0,03 *0.0012*	0,036 *0.0014*	70 (47 — 88) *230 (160 — 280)*
TS1	A/D	0,02 *0.02*	0,3 *0.3*	0,03 *0.0012*	0,04 *0.0016*	0,06 *0.0024*	0,08 *0.0032*	0,1 *0.0040*	0,12 *0.0048*	550 (500 — 600) *1800 (1700 — 1900)*
TP1	A/D	0,02 *0.02*	0,3 *0.3*	0,03 *0.0012*	0,04 *0.0016*	0,06 *0.0024*	0,08 *0.0032*	0,1 *0.0040*	0,12 *0.0048*	550 (500 — 600) *1800 (1700 — 1900)*
GR1	A/D	0,02 *0.02*	0,3 *0.3*	0,03 *0.0012*	0,04 *0.0016*	0,06 *0.0024*	0,08 *0.0032*	0,1 *0.0040*	0,12 *0.0048*	550 (500 — 600) *1800 (1700 — 1900)*

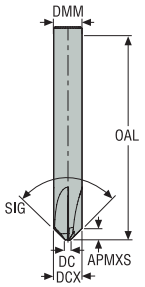
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JS509

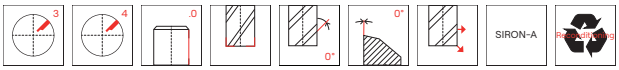
Allgemeine Anwendung – Universell – Fase – 3-4 Schneiden – Zylindrisch





N

– Toleranzen:
– DMM=h5
– SIG= ±0,5°
– Nachschleifen möglich, wenn DMM ≥ Ø6 ist



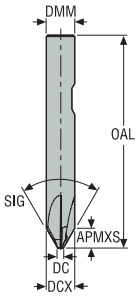
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm				
JS509030N2CZ3.0-SIRA	02881634	2	N	3,0	0,6	3,0	1,2	50,0	45,0	3	Cylindrical	■
JS509040N2CZ3.0-SIRA	02881635	2	N	4,0	0,8	4,0	1,6	50,0	45,0	3	Cylindrical	■
JS509060N2CZ4.0-SIRA	02881636	2	N	6,0	1,2	6,0	2,4	57,0	45,0	4	Cylindrical	■
JS509080N2CZ4.0-SIRA	02881638	2	N	8,0	1,6	8,0	3,2	63,0	45,0	4	Cylindrical	■
JS509100N2CZ4.0-SIRA	02881640	2	N	10,0	2,0	10,0	4,0	72,0	45,0	4	Cylindrical	■
JS509120N2CZ4.0-SIRA	02881642	2	N	12,0	2,4	12,0	4,8	83,0	45,0	4	Cylindrical	■

■ **Lagerstandard.**

JS509

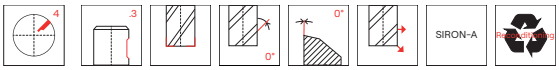
Allgemeine Anwendung – Universell – Fase – 3-4 Schneiden – Weldon





N

—Toleranzen:
—DMM=h5
—SIG= ±0,5°
—Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm				
JS509060N2CZ4.3-SIRA	02881637	2	N	6,0	1,2	6,0	2,4	57,0	45,0	4	Weldon	■
JS509080N2CZ4.3-SIRA	02881639	2	N	8,0	1,6	8,0	3,2	63,0	45,0	4	Weldon	■
JS509100N2CZ4.3-SIRA	02881641	2	N	10,0	2,0	10,0	4,0	72,0	45,0	4	Weldon	■
JS509120N2CZ4.3-SIRA	02881643	2	N	12,0	2,4	12,0	4,8	83,0	45,0	4	Weldon	■

■ **Lagerstandard.**

Schnittdaten – JS509 Anfasen

SMG		a_e/DCX	a_p/DCX	f_z						v_c
				3	4	6	8	10	12	
P1	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	200 (180 — 220) *660 (600 — 720)*
P2	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,036 *0.0014*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,1 *0.0040*	190 (170 — 210) *620 (560 — 680)*
P3	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,025 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	165 (150 — 180) *540 (500 — 590)*
P4	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,025 *0.0010*	0,032 *0.0013*	0,05 *0.0020*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	145 (130 — 160) *475 (430 — 520)*
P5	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	140 (130 — 150) *460 (430 — 490)*
P6	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	160 (140 — 170) *520 (460 — 550)*
P7	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	150 (130 — 160) *490 (430 — 520)*
P8	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,025 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	140 (130 — 150) *460 (430 — 490)*
P11	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	100 (79 — 110) *330 (260 — 360)*
P12	M/A/D/E	0,02 *0.02*	0,3 *0.3*	0,016 *0.00065*	0,022 *0.00085*	0,032 *0.0013*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	60 (49 — 72) *195 (170 — 230)*
M1	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,036 *0.0014*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,1 *0.0040*	115 (92 — 130) *375 (310 — 420)*
M2	E/M/A	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	95 (75 — 110) *310 (250 — 360)*
M3	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	60 (43 — 79) *195 (150 — 250)*
M4	E/M/A	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,03 *0.0012*	0,044 *0.0017*	0,06 *0.0024*	0,075 *0.0030*	0,09 *0.0036*	46 (32 — 60) *150 (110 — 190)*
M5	E/M/A	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,03 *0.0012*	0,044 *0.0017*	0,06 *0.0024*	0,075 *0.0030*	0,09 *0.0036*	39 (27 — 50) *130 (89 — 160)*
K1	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,036 *0.0014*	0,055 *0.0022*	0,07 *0.0028*	0,09 *0.0036*	0,1 *0.0040*	195 (170 — 210) *640 (560 — 680)*
K2	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	170 (150 — 190) *560 (500 — 620)*
K3	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	145 (130 — 160) *475 (430 — 520)*
K4	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	135 (120 — 150) *445 (400 — 490)*
K5	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,044 *0.0017*	0,06 *0.0024*	0,07 *0.0028*	0,085 *0.0034*	85 (72 — 93) *280 (240 — 300)*
K6	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	120 (110 — 130) *395 (370 — 420)*
K7	A/D/M/E	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,044 *0.0017*	0,06 *0.0024*	0,07 *0.0028*	0,085 *0.0034*	105 (92 — 120) *345 (310 — 390)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS509 Anfasen

SMG		a_e/DCX	a_p/DCX	f_z						v_c
				3	4	6	8	10	12	
N1	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	470 (430 — 510) *1550 (1500 — 1600)*
N2	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	300 (280 — 330) *980 (920 — 1000)*
N3	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	200 (190 — 220) *660 (630 — 720)*
N11	E/M/A	0,02 *0.02*	0,3 *0.3*	0,026 *0.0010*	0,034 *0.0013*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0034*	0,1 *0.0040*	265 (250 — 290) *870 (830 — 950)*
S1	E	0,02 *0.02*	0,3 *0.3*	0,013 *0.00050*	0,017 *0.00065*	0,026 *0.0010*	0,036 *0.0014*	0,044 *0.0017*	0,05 *0.0020*	45 (15 — 74) *150 (50 — 240)*
S2	E	0,02 *0.02*	0,3 *0.3*	0,013 *0.00050*	0,017 *0.00065*	0,026 *0.0010*	0,036 *0.0014*	0,044 *0.0017*	0,05 *0.0020*	36 (12 — 59) *120 (40 — 190)*
S3	E	0,02 *0.02*	0,3 *0.3*	0,012 *0.00048*	0,016 *0.00065*	0,024 *0.00095*	0,032 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	31 (11 — 51) *100 (37 — 160)*
S11	E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	90 (67 — 110) *295 (220 — 360)*
S12	E	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	70 (52 — 88) *230 (180 — 280)*
S13	E	0,02 *0.02*	0,3 *0.3*	0,022 *0.00085*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	55 (41 — 69) *180 (140 — 220)*
H5	M/A/D	0,02 *0.02*	0,3 *0.3*	0,012 *0.00048*	0,016 *0.00065*	0,025 *0.0010*	0,034 *0.0013*	0,042 *0.0017*	0,048 *0.0019*	70 (49 — 92) *230 (170 — 300)*
H8	M/A/D	0,02 *0.02*	0,3 *0.3*	0,0095 *0.00038*	0,012 *0.00048*	0,019 *0.00075*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	70 (49 — 92) *230 (170 — 300)*
H11	M/A/D	0,02 *0.02*	0,3 *0.3*	0,012 *0.00048*	0,016 *0.00065*	0,025 *0.0010*	0,034 *0.0013*	0,042 *0.0017*	0,048 *0.0019*	90 (63 — 110) *295 (210 — 360)*
H12	M/A/D	0,02 *0.02*	0,3 *0.3*	0,0095 *0.00038*	0,012 *0.00048*	0,019 *0.00075*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	80 (57 — 100) *260 (190 — 320)*
H21	M/A/D	0,02 *0.02*	0,3 *0.3*	0,0095 *0.00038*	0,012 *0.00048*	0,019 *0.00075*	0,025 *0.0010*	0,032 *0.0013*	0,036 *0.0014*	70 (49 — 92) *230 (170 — 300)*
TS1	A/D	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	470 (430 — 510) *1550 (1500 — 1600)*
TP1	A/D	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	470 (430 — 510) *1550 (1500 — 1600)*
GR1	A/D	0,02 *0.02*	0,3 *0.3*	0,024 *0.00095*	0,032 *0.0013*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	470 (430 — 510) *1550 (1500 — 1600)*

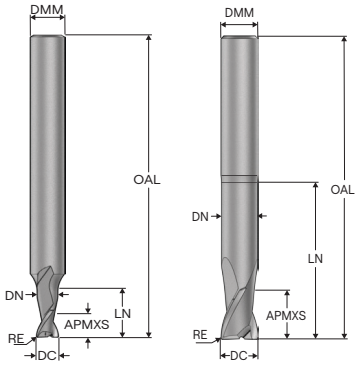
Schnittdaten, siehe Seite 699 - 707

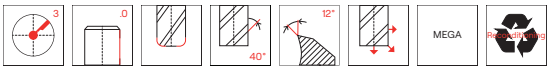
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH910

Hochgeschwindigkeitsfräsen – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius







– Toleranzen:
– DMM= h5
– DC= -0,02/-0,03 mm
– RE= ±0,01 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

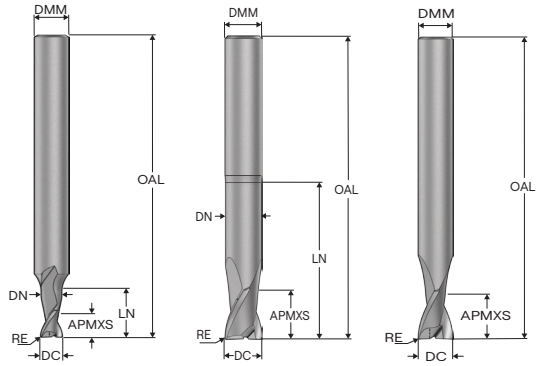
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
910020R020-MEGA	00020058	2	G	2,0	3,0	3,0	40,0	6,0	1,9	0,2	3,5	3	Cylindrical	■
910025R020-MEGA	00020065	2	G	2,5	3,0	4,0	40,0	6,0	2,4	0,2	2,0	3	Cylindrical	■
910030R010-MEGA	00020073	2	E	3,0	3,0	4,0	40,0	7,0	2,8	0,1	–	3	Cylindrical	■
910030R020-MEGA	00020142	2	E	3,0	3,0	4,0	40,0	7,0	2,8	0,2	–	3	Cylindrical	■
910035R020-MEGA	00020144	2	G	3,5	6,0	5,0	50,0	9,0	3,2	0,2	6,0	3	Cylindrical	■
910040R020-MEGA	00020151	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,2	5,0	3	Cylindrical	■
910040R030-MEGA	00020152	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,3	5,0	3	Cylindrical	■
910040R050-MEGA	00020155	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,5	5,0	3	Cylindrical	■
910050R020-MEGA	00020159	2	G	5,0	6,0	6,0	50,0	11,0	4,6	0,2	2,5	3	Cylindrical	■
910060R020-MEGA	00020160	2	E	6,0	6,0	7,0	60,0	14,0	5,6	0,2	–	3	Cylindrical	■
910060R030-MEGA	00020161	2	E	6,0	6,0	7,0	60,0	14,0	5,6	0,3	–	3	Cylindrical	■
910060R050-MEGA	00020162	2	E	6,0	6,0	7,0	60,0	14,0	5,6	0,5	–	3	Cylindrical	■
910080R020-MEGA	00020163	2	E	8,0	8,0	9,0	60,0	18,0	7,4	0,2	–	3	Cylindrical	■
910080R050-MEGA	00020164	2	E	8,0	8,0	9,0	60,0	18,0	7,4	0,5	–	3	Cylindrical	■
910100R020-MEGA	00020165	2	E	10,0	10,0	12,0	70,0	25,0	9,4	0,2	–	3	Cylindrical	■
910100R050-MEGA	00020166	2	E	10,0	10,0	12,0	70,0	25,0	9,4	0,5	–	3	Cylindrical	■
910100R100-MEGA	00020167	2	E	10,0	10,0	12,0	70,0	25,0	9,4	1,0	–	3	Cylindrical	■
910120R050-MEGA	00020168	2	E	12,0	12,0	15,0	80,0	30,0	11,4	0,5	–	3	Cylindrical	■
910120R100-MEGA	00020169	2	E	12,0	12,0	15,0	80,0	30,0	11,4	1,0	–	3	Cylindrical	■

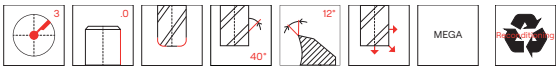
■ **Lagerstandard.**

JH910

Hochgeschwindigkeitsfräsen – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius







—Toleranzen:
—DMM= h5
—DC= -0,02/-0,03 mm
—RE= ±0,01 mm
—Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
910L020-MEGA	00022002	3	G	2,0	3,0	3,0	60,0	10,0	1,9	0,2	2,5	3	Cylindrical	■
910L030-MEGA	00022003	3	E	3,0	3,0	4,0	60,0	14,0	2,8	0,2	–	3	Cylindrical	■
910L040-MEGA	00022004	3	G	4,0	6,0	5,0	65,0	18,0	3,7	0,2	3,0	3	Cylindrical	■
910L050-MEGA	00022005	3	G	5,0	6,0	6,0	65,0	22,0	4,6	0,2	1,5	3	Cylindrical	■
910L060-MEGA	00022006	3	E	6,0	6,0	7,0	80,0	26,0	5,6	0,3	–	3	Cylindrical	■
910L080-MEGA	00022007	3	E	8,0	8,0	9,0	85,0	36,0	7,4	0,5	–	3	Cylindrical	■
910L100-MEGA	00022009	3	E	10,0	10,0	12,0	100,0	45,0	9,4	0,5	–	3	Cylindrical	■
910L120-MEGA	00022011	3	E	12,0	12,0	15,0	125,0	54,0	11,4	0,5	–	3	Cylindrical	■
910L160-MEGA	00022013	3	E	16,0	16,0	18,0	125,0	65,0	15,4	1,0	–	3	Cylindrical	■
910RS070-MEGA	00021772	4	P	7,0	6,0	8,0	100,0	–	–	0,3	–	3	Cylindrical	■
910RS090-MEGA	00021781	4	P	9,0	8,0	11,0	100,0	–	–	0,5	–	3	Cylindrical	■
910RS110-MEGA	00021782	4	P	11,0	10,0	13,0	125,0	–	–	0,5	–	3	Cylindrical	■
910RS130-MEGA	00021784	4	P	13,0	12,0	16,0	150,0	–	–	0,6	–	3	Cylindrical	■
910RS170-MEGA	00021800	4	P	17,0	16,0	20,0	150,0	–	–	0,6	–	3	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH910 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z														v_c
				2	3	4	5	6	7	8	9	10	11	12	13	16	17	
P1	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	455 (410 — 500)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1500 (1400 — 1600)*
P2	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	445 (400 — 490)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1450 (1400 — 1600)*
P3	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	385 (350 — 420)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1275 (1200 — 1300)*
P4	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	335 (300 — 370)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1100 (990 — 1200)*
P5	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	320 (290 — 350)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1050 (960 — 1100)*
P6	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	360 (330 — 400)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1175 (1100 — 1300)*
P7	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	340 (310 — 370)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1125 (1100 — 1200)*
P8	M/E/A	0.0400	1.1	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	320 (290 — 350)
		0,0400	*1,1*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1050 (960 — 1100)*
P11	M/E/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	330 (300 — 360)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1075 (990 — 1100)*
P12	M/E/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	195 (180 — 210)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*640 (600 — 680)*
M1	M/E/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	200 (180 — 220)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*660 (600 — 720)*
M2	M/E/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	160 (150 — 170)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*520 (500 — 550)*
M3	M/E/A	0.0300	0.80	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	110 (91 — 120)
		0,0300	*0,80*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*360 (300 — 390)*
M4	M/E/A	0.0300	0.80	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	80 (68 — 94)
		0,0300	*0,80*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*260 (230 — 300)*
M5	M/E/A	0.0300	0.80	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	70 (57 — 78)
		0,0300	*0,80*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*230 (190 — 250)*
K1	A/E	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	315 (270 — 350)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1025 (890 — 1100)*
K2	A/E	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	270 (240 — 310)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*890 (790 — 1000)*
K3	A/E	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	230 (200 — 260)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*750 (660 — 850)*
K4	A/E	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	220 (190 — 250)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*720 (630 — 820)*
K5	A/E	0.0300	0.80	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	280 (240 — 320)
		0,0300	*0,80*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*920 (790 — 1000)*
K6	A/E	0.0300	0.80	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	415 (350 — 480)
		0,0300	*0,80*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1350 (1200 — 1500)*
K7	A/E	0.0300	0.80	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	355 (300 — 410)
		0,0300	*0,80*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*1175 (990 — 1300)*
S1	E/M/A	0.0300	0.70	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	115 (93 — 130)
		0,0300	*0,70*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*375 (310 — 420)*
S2	E/M/A	0.0300	0.70	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	95 (75 — 110)
		0,0300	*0,70*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*310 (250 — 360)*
S3	E/M/A	0.0200	0.50	0.016	0.024	0.032	0.040	0.048	0.055	0.065	0.070	0.080	0.090	0.095	0.10	0.13	0.14	50 (40 — 59)
		0,0200	*0,50*	*0,00065*	*0,00095*	*0,0013*	*0,0016*	*0,0019*	*0,0022*	*0,0026*	*0,0028*	*0,0032*	*0,0036*	*0,0038*	*0,0040*	*0,0050*	*0,0055*	*165 (140 — 190)*
S11	E/M/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	175 (160 — 190)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*570 (530 — 620)*
S12	E/M/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	135 (120 — 150)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*445 (400 — 490)*
S13	E/M/A	0.0400	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.16	0.17	105 (90 — 110)
		0,0400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0065*	*0,0065*	*345 (300 — 360)*
TP1	A	0.150	1.0	0.020	0.030	0.040	0.050	0.060	0.070	0.080	0.090	0.10	0.11	0.12	0.13	0.15	0.15	205 (180 — 240)
		0,150	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0036*	*0,0040*	*0,0044*	*0,0048*	*0,0050*	*0,0060*	*0,0060*	*670 (600 — 780)*
GR1	A	0.500	1.0	0.024	0.036	0.048	0.060	0.070	0.085	0.095	0.11	0.12	0.13	0.14	0.15	0.18	0.18	610 (510 — 710)
		0,500	*1,0*	*0,00095*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0034*	*0,0038*	*0,0044*	*0,0048*	*0,0050*	*0,0055*	*0,0060*	*0,0070*	*0,0070*	*2000 (1700 — 2300)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JH910 Nutfräsen

SMG		a_p/DC	f_z														v_c
			2	3	4	5	6	7	8	9	10	11	12	13	16	17	
P1	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	255 (230 — 280) *840 (760 — 910)*
P2	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	250 (230 — 270) *820 (760 — 880)*
P3	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	215 (200 — 230) *710 (660 — 750)*
P4	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	190 (170 — 200) *620 (560 — 650)*
P5	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	180 (170 — 190) *590 (560 — 620)*
P6	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	200 (180 — 220) *660 (600 — 720)*
P7	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	190 (170 — 210) *620 (560 — 680)*
P8	M/E/A	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	180 (170 — 190) *590 (560 — 620)*
P11	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	195 (180 — 210) *640 (600 — 680)*
P12	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	115 (110 — 120) *375 (370 — 390)*
M1	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	120 (110 — 130) *395 (370 — 420)*
M2	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	95 (86 — 100) *310 (290 — 320)*
M3	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	60 (51 — 70) *195 (170 — 220)*
M4	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	45 (38 — 52) *150 (130 — 170)*
M5	M/E/A	0.10 *0,10*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	38 (32 — 43) *125 (110 — 140)*
K1	A/E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	175 (160 — 200) *570 (530 — 650)*
K2	A/E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	150 (140 — 170) *490 (460 — 550)*
K3	A/E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	130 (120 — 140) *425 (400 — 450)*
K4	A/E	0.30 *0,30*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	125 (110 — 140) *410 (370 — 450)*
K5	A/E	0.16 *0,16*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	150 (130 — 170) *490 (430 — 550)*
K6	A/E	0.16 *0,16*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	220 (190 — 250) *720 (630 — 820)*
K7	A/E	0.16 *0,16*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	190 (170 — 220) *620 (560 — 720)*
S1	E/M/A	0.15 *0,15*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	60 (50 — 74) *195 (170 — 240)*
S2	E/M/A	0.15 *0,15*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	50 (41 — 60) *165 (140 — 190)*
S3	E/M/A	0.080 *0,080*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	25 (21 — 30) *80 (69 — 98)*
S11	E/M/A	0.24 *0,24*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	100 (85 — 110) *330 (280 — 360)*
S12	E/M/A	0.24 *0,24*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	75 (65 — 84) *245 (220 — 270)*
S13	E/M/A	0.24 *0,24*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.080 *0,0032*	0.085 *0,0034*	60 (51 — 65) *195 (170 — 210)*
TP1	A	0.24 *0,24*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.080 *0,0032*	0.095 *0,0038*	0.10 *0,0040*	150 (130 — 170) *490 (430 — 550)*
GR1	A	0.36 *0,36*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	600 (510 — 700) *1975 (1700 — 2200)*

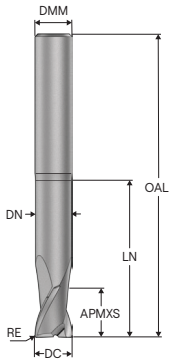
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH930

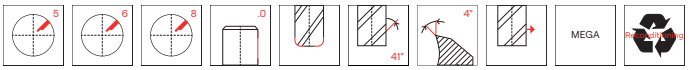
Hochgeschwindigkeitsfräsen – Universell – Eckfräser – 5-8 Schneiden – Zylindrisch – Eckenradius





E

- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,05 mm
- Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
930060R020-MEGA	00022026	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,2	5	Cylindrical	■
930060R050-MEGA	00022027	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,5	5	Cylindrical	■
930080R020-MEGA	00022028	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,2	5	Cylindrical	■
930080R050-MEGA	00022029	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,5	5	Cylindrical	■
930100R030-MEGA	00022030	2	E	10,0	10,0	15,0	70,0	25,0	9,4	0,3	6	Cylindrical	■
930100R100-MEGA	00022031	2	E	10,0	10,0	15,0	70,0	25,0	9,4	1,0	6	Cylindrical	■
930120R050-MEGA	00022033	2	E	12,0	12,0	18,0	80,0	30,0	11,4	0,5	6	Cylindrical	■
930120R100-MEGA	00022034	2	E	12,0	12,0	18,0	80,0	30,0	11,4	1,0	6	Cylindrical	■
930160R050-MEGA	00022035	2	E	16,0	16,0	24,0	90,0	35,0	15,4	0,5	8	Cylindrical	■
930160R100-MEGA	00022040	2	E	16,0	16,0	24,0	90,0	35,0	15,4	1,0	8	Cylindrical	■
930200R050-MEGA	00022044	2	E	20,0	20,0	30,0	100,0	38,0	19,2	0,5	8	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH930 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
P1	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	440 (370 — 490) *1450 (1300 — 1600)*
P2	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	430 (360 — 480) *1400 (1200 — 1500)*
P3	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	375 (320 — 420) *1225 (1100 — 1300)*
P4	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	330 (280 — 370) *1075 (920 — 1200)*
P5	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	315 (270 — 350) *1025 (890 — 1100)*
P6	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	355 (300 — 390) *1175 (990 — 1200)*
P7	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	335 (280 — 370) *1100 (920 — 1200)*
P8	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (270 — 350) *1025 (890 — 1100)*
P11	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	325 (280 — 360) *1075 (920 — 1100)*
P12	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	200 (170 — 220) *660 (560 — 720)*
K1	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	255 (210 — 300) *840 (690 — 980)*
K2	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	225 (180 — 260) *740 (600 — 850)*
K3	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	190 (160 — 220) *620 (530 — 720)*
K4	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	180 (150 — 210) *590 (500 — 680)*
K5	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	205 (160 — 250) *670 (530 — 820)*
K6	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	300 (230 — 370) *980 (760 — 1200)*
K7	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	260 (200 — 320) *850 (660 — 1000)*
S1	E/M/A	0.0300 *0,0300*	0.44 *0,44*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	80 (62 — 100) *260 (210 — 320)*
S2	E/M/A	0.0300 *0,0300*	0.44 *0,44*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	65 (50 — 82) *215 (170 — 260)*
S3	E/M/A	0.0200 *0,0200*	0.70 *0,70*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	41 (31 — 50) *135 (110 — 160)*
S11	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	160 (140 — 180) *520 (460 — 590)*
S12	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	120 (110 — 140) *395 (370 — 450)*
S13	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	95 (81 — 110) *310 (270 — 360)*
H3	M/A	0.0200 *0,0200*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	55 (41 — 71) *180 (140 — 230)*
H5	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	250 (210 — 300) *820 (690 — 980)*
H7	M/A	0.0200 *0,0200*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	55 (41 — 71) *180 (140 — 230)*
H8	M/A	0.0300 *0,0300*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	255 (210 — 300) *840 (690 — 980)*
H11	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	320 (260 — 380) *1050 (860 — 1200)*
H12	M/A	0.0400 *0,0400*	0.70 *0,70*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	270 (220 — 320) *890 (730 — 1000)*
H21	M/A	0.0300 *0,0300*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	255 (210 — 300) *840 (690 — 980)*
H31	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	155 (130 — 180) *510 (430 — 590)*

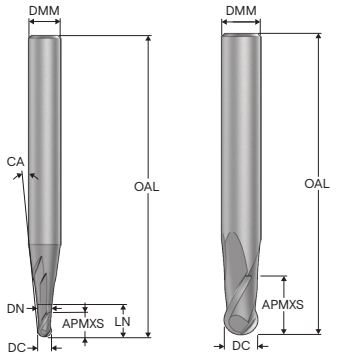
Schnittdaten, siehe Seite 699 - 707

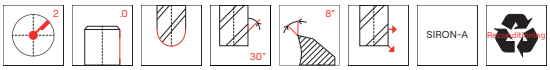
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JHB970

Hochgeschwindigkeitsfräsen – Universell – Kugelkopf – 2 Schneiden – Zylindrisch







—Toleranzen:
—DMM= h5
—DC= -0,02/-0,04 mm
—RE= ±0,01 mm
—Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Beschichtung	Produktnummer	Längenindex		DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm	mm	mm				
JHB970020G1B.0Z2	SIRA	10072058	1	G	2,0	3,0	3,0	50,0	10,0	1,9	1,0	2,5	2	Cylindrical	■
JHB970030D1B.0Z2	SIRA	10072059	1	D	3,0	3,0	4,5	50,0	–	–	1,5	–	2	Cylindrical	■
JHB970040D1B.0Z2	SIRA	10072060	1	D	4,0	4,0	6,0	60,0	–	–	2,0	–	2	Cylindrical	■
JHB970050D1B.0Z2	SIRA	10072061	1	D	5,0	5,0	7,5	60,0	–	–	2,5	–	2	Cylindrical	■
JHB970060D1B.0Z2	SIRA	10072062	1	D	6,0	6,0	9,0	75,0	–	–	3,0	–	2	Cylindrical	■
JHB970020G2B.0Z2	SIRA	10072063	2	G	2,0	6,0	3,0	60,0	4,0	1,9	1,0	8,0	2	Cylindrical	■
JHB970025G2B.0Z2	SIRA	10072064	2	G	2,5	6,0	4,0	60,0	5,0	2,4	1,25	7,5	2	Cylindrical	■
JHB970030G2B.0Z2	SIRA	10072065	2	G	3,0	6,0	4,5	60,0	6,0	2,8	1,5	5,5	2	Cylindrical	■
JHB970035G2B.0Z2	SIRA	10072066	2	G	3,5	6,0	5,0	60,0	7,0	3,2	1,75	4,5	2	Cylindrical	■
JHB970040G2B.0Z2	SIRA	10072067	2	G	4,0	6,0	6,0	60,0	8,0	3,7	2,0	3,0	2	Cylindrical	■
JHB970050G2B.0Z2	SIRA	10072068	2	G	5,0	6,0	7,5	60,0	10,0	4,6	2,5	2,0	2	Cylindrical	■
JHB970060G2B.0Z2	SIRA	10072069	2	G	6,0	8,0	9,0	75,0	12,0	5,6	3,0	2,5	2	Cylindrical	■
JHB970080D2B.0Z2	SIRA	10072070	2	D	8,0	8,0	12,0	75,0	–	–	4,0	–	2	Cylindrical	■
JHB970100D2B.0Z2	SIRA	10072071	2	D	10,0	10,0	15,0	80,0	–	–	5,0	–	2	Cylindrical	■
JHB970120D2B.0Z2	SIRA	10072072	2	D	12,0	12,0	18,0	90,0	–	–	6,0	–	2	Cylindrical	■
JHB970160D2B.0Z2	SIRA	10072073	2	D	16,0	16,0	24,0	100,0	–	–	8,0	–	2	Cylindrical	■
JHB970020G3B.0Z2	SIRA	10072074	3	G	2,0	6,0	3,0	80,0	4,0	1,9	1,0	8,0	2	Cylindrical	■
JHB970030G3B.0Z2	SIRA	10072075	3	G	3,0	6,0	4,5	80,0	6,0	2,8	1,5	5,5	2	Cylindrical	■
JHB970040G3B.0Z2	SIRA	10072076	3	G	4,0	6,0	6,0	80,0	8,0	3,7	2,0	3,0	2	Cylindrical	■
JHB970060G3B.0Z2	SIRA	10072077	3	G	6,0	8,0	9,0	100,0	12,0	5,6	3,0	2,5	2	Cylindrical	■
JHB970080D3B.0Z2	SIRA	10072078	3	D	8,0	8,0	12,0	108,0	–	–	4,0	–	2	Cylindrical	■
JHB970100D3B.0Z2	SIRA	10072079	3	D	10,0	10,0	15,0	125,0	–	–	5,0	–	2	Cylindrical	■
JHB970120D3B.0Z2	SIRA	10072080	3	D	12,0	12,0	18,0	125,0	–	–	6,0	–	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JHB970 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	2.5	3	3.5	4	5	6	8	10	12	16	
P1	M	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.014 *0,00055*	0.016 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	210 (190 — 230) *690 (630 — 750)*
P2	M	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.014 *0,00055*	0.017 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	205 (180 — 230) *670 (600 — 750)*
P3	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	180 (160 — 200) *590 (530 — 650)*
P4	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	155 (140 — 170) *510 (460 — 550)*
P5	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	150 (140 — 170) *490 (460 — 550)*
P6	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	170 (150 — 190) *560 (500 — 620)*
P7	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	160 (140 — 180) *520 (460 — 590)*
P8	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	150 (140 — 170) *490 (460 — 550)*
P11	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	75 (67 — 86) *245 (220 — 280)*
P12	M	0.200 *0,200*	1.0 *1,0*	0.0070 *0,00028*	0.0085 *0,00034*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	48 (42 — 53) *155 (140 — 170)*
M1	E	0.200 *0,200*	1.0 *1,0*	0.0090 *0,00036*	0.011 *0,00044*	0.013 *0,00050*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	90 (80 — 100) *295 (270 — 320)*
M2	E	0.200 *0,200*	1.0 *1,0*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	75 (65 — 85) *245 (220 — 270)*
M3	E	0.150 *0,150*	1.0 *1,0*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	65 (55 — 75) *215 (190 — 240)*
M4	E	0.150 *0,150*	1.0 *1,0*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	49 (42 — 56) *160 (140 — 180)*
M5	E	0.150 *0,150*	1.0 *1,0*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	41 (35 — 47) *135 (120 — 150)*
S1	E	0.100 *0,100*	0.80 *0,80*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	50 (40 — 59) *165 (140 — 190)*
S2	E	0.100 *0,100*	0.80 *0,80*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	40 (33 — 48) *130 (110 — 150)*
S3	E	0.100 *0,100*	0.60 *0,60*	0.0040 *0,00016*	0.0050 *0,00020*	0.0060 *0,00024*	0.0070 *0,00028*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.028 *0,0011*	30 (20 — 39) *100 (66 — 120)*
S11	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	90 (79 — 100) *295 (260 — 320)*
S12	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	70 (61 — 80) *230 (210 — 260)*
S13	E	0.200 *0,200*	1.0 *1,0*	0.0085 *0,00034*	0.011 *0,00044*	0.013 *0,00050*	0.015 *0,00060*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	55 (48 — 63) *180 (160 — 200)*

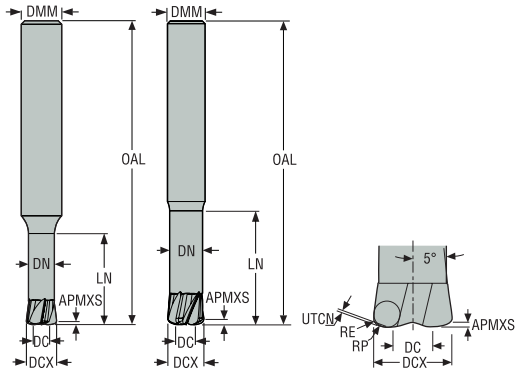
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JHF980

Hochvorschubfräser – Universell – 2-5 Schneiden – Zylindrisch – Eckenradius





– Toleranzen:
– DMM= h5
– DC= -0,02/-0,04 mm
– RE= ±0,05 mm
– CA= Kollisionswinkel
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

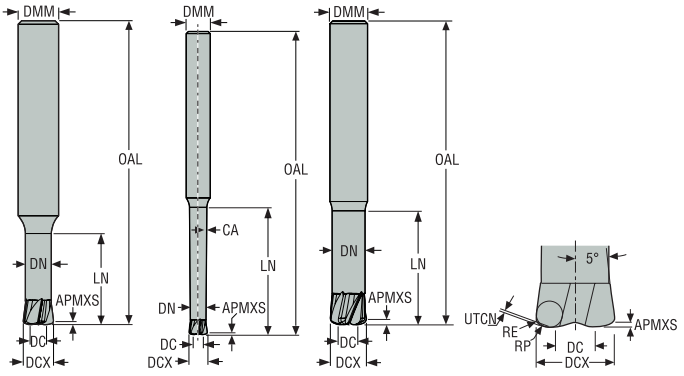
Bezeichnung	Produkt-nummer	Längen-index		DCX	DC	DMM	APMXS	OAL	LN	DN	RE	RP	UTCN	CA°	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm	mm	mm	mm					
980K080Z3-MEGA	02587115	1	E	8,0	4,0	8,0	0,4	70,0	12,0	3,0	0,6	0,935	0,198	–	-5,0	3	Cylindrical	■
JHF980080E1H.0Z5-MEGA	03003384	1	E	8,0	4,0	8,0	0,4	70,0	12,0	7,0	0,6	0,935	0,198	–	-5,0	5	Cylindrical	■
980K100Z3-MEGA	02587117	1	E	10,0	5,0	10,0	0,45	80,0	15,0	3,8	0,8	1,176	0,232	–	-5,0	3	Cylindrical	■
JHF980100E1H.0Z5-MEGA	03003385	1	E	10,0	5,0	10,0	0,45	80,0	15,0	8,8	0,8	1,176	0,232	–	-5,0	5	Cylindrical	■
980K120Z3-MEGA	02587118	1	E	12,0	6,0	12,0	0,5	80,0	18,0	4,6	1,0	1,417	0,265	–	-5,0	3	Cylindrical	■
JHF980120E1H.0Z5-MEGA	03003386	1	E	12,0	6,0	12,0	0,5	80,0	18,0	10,6	1,0	1,417	0,265	–	-5,0	5	Cylindrical	■
980010-MEGA	02587111	2	G	1,0	0,5	6,0	0,07	40,0	3,0	0,7	0,07	0,127	0,028	19,5	-5,0	2	Cylindrical	■
980015-MEGA	02511199	2	G	1,5	0,75	6,0	0,1	40,0	4,5	1,2	0,1	0,183	0,043	14,0	-5,0	2	Cylindrical	■
980020-MEGA	02511221	2	G	2,0	1,0	6,0	0,15	40,0	6,0	1,7	0,15	0,269	0,055	11,0	-5,0	2	Cylindrical	■
980030-MEGA	02511224	2	G	3,0	1,5	6,0	0,2	50,0	9,0	2,6	0,2	0,366	0,085	7,0	-5,0	2	Cylindrical	■
JHF980030G2H.0Z4-MEGA	03003387	2	G	3,0	1,5	6,0	0,2	50,0	9,0	2,6	0,2	0,366	0,085	7,12	-5,0	4	Cylindrical	■
980040-MEGA	02511229	2	G	4,0	2,0	6,0	0,25	60,0	12,0	3,5	0,3	0,503	0,107	4,0	-5,0	2	Cylindrical	■
JHF980040G2H.0Z4-MEGA	03003388	2	G	4,0	2,0	6,0	0,25	60,0	12,0	3,5	0,3	0,503	0,107	4,0	-5,0	4	Cylindrical	■
980050-MEGA	02511233	2	G	5,0	2,5	6,0	0,3	60,0	15,0	4,4	0,4	0,641	0,128	2,0	-5,0	2	Cylindrical	■
JHF980050G2H.0Z4-MEGA	03003389	2	G	5,0	2,5	6,0	0,3	60,0	15,0	4,4	0,4	0,641	0,128	1,77	-5,0	4	Cylindrical	■
980060-MEGA	02511314	2	G	6,0	3,0	8,0	0,35	60,0	18,0	5,2	0,5	0,778	0,15	3,0	-5,0	2	Cylindrical	■
JHF980060G2H.0Z4-MEGA	03003390	2	G	6,0	3,0	8,0	0,35	60,0	18,0	5,2	0,5	0,778	0,15	2,86	-5,0	4	Cylindrical	■
980080-MEGA	02511322	2	E	8,0	4,0	8,0	0,4	70,0	24,0	7,0	0,6	0,935	0,198	–	-5,0	2	Cylindrical	■
JHF980080E2H.0Z5-MEGA	03003391	2	E	8,0	4,0	8,0	0,4	70,0	24,0	7,0	0,6	0,935	0,198	–	-5,0	5	Cylindrical	■
980100-MEGA	02511341	2	E	10,0	5,0	10,0	0,45	80,0	30,0	8,8	0,8	1,176	0,232	–	-5,0	2	Cylindrical	■
980100Z3-MEGA	02511342	2	E	10,0	5,0	10,0	0,45	80,0	30,0	8,8	0,8	1,176	0,232	–	-5,0	3	Cylindrical	■
JHF980100E2H.0Z5-MEGA	03003392	2	E	10,0	5,0	10,0	0,45	80,0	30,0	8,8	0,8	1,176	0,232	–	-5,0	5	Cylindrical	■
980120-MEGA	02511346	2	E	12,0	6,0	12,0	0,5	80,0	36,0	10,6	1,0	1,417	0,265	–	-5,0	2	Cylindrical	■
980120Z3-MEGA	02511347	2	E	12,0	6,0	12,0	0,5	80,0	36,0	10,6	1,0	1,417	0,265	–	-5,0	3	Cylindrical	■
JHF980120E2H.0Z5-MEGA	03003393	2	E	12,0	6,0	12,0	0,5	80,0	36,0	10,6	1,0	1,417	0,265	–	-5,0	5	Cylindrical	■

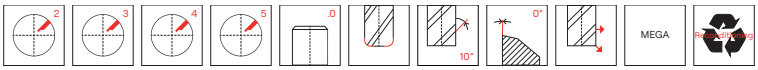
■ **Lagerstandard.**
*UTCN = Theoretische Abweichung

JHF980

Hochvorschubfräser – Universell – 2-5 Schneiden – Zylindrisch – Eckenradius







—Toleranzen:
—DMM= h5
—DC= -0,02/-0,05 mm
—RE= ±0,05 mm
—Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index		DCX	DC	DMM	AP-MXS	OAL	LN	DN	RE	RP	UTCN	CA°	NA°	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm	mm	mm	mm						
980ML010-MEGA	02587113	3	G	1,0	0,5	6,0	0,07	40,0	5,0	0,7	0,07	0,127	0,028	15,5	–	-5,0	2	Cylindrical	■
980ML015-MEGA	02511219	3	G	1,5	0,75	6,0	0,1	40,0	7,5	1,2	0,1	0,183	0,043	10,5	–	-5,0	2	Cylindrical	■
980ML020-MEGA	02511222	3	G	2,0	1,0	6,0	0,15	40,0	10,0	1,7	0,15	0,269	0,055	8,0	–	-5,0	2	Cylindrical	■
JHF980020G3H.0Z4-MEGA	03003394	3	G	2,0	1,0	6,0	0,15	40,0	10,0	1,7	0,15	0,269	0,055	8,46	–	-5,0	4	Cylindrical	■
980ML030-MEGA	02511225	3	G	3,0	1,5	6,0	0,2	50,0	15,0	2,6	0,2	0,366	0,085	5,0	–	-5,0	2	Cylindrical	■
JHF980030G3H.0Z4-MEGA	03003395	3	G	3,0	1,5	6,0	0,2	50,0	15,0	2,6	0,2	0,366	0,085	4,79	–	-5,0	4	Cylindrical	■
980ML040-MEGA	02511231	3	G	4,0	2,0	6,0	0,25	70,0	20,0	3,5	0,3	0,503	0,107	2,5	–	-5,0	2	Cylindrical	■
JHF980040G3H.0Z4-MEGA	03003396	3	G	4,0	2,0	6,0	0,25	70,0	20,0	3,5	0,3	0,503	0,107	2,59	–	-5,0	4	Cylindrical	■
980ML050-MEGA	02511234	3	G	5,0	2,5	6,0	0,3	80,0	25,0	4,4	0,4	0,641	0,128	1,5	–	-5,0	2	Cylindrical	■
JHF980050G3H.0Z4-MEGA	03003397	3	G	5,0	2,5	6,0	0,3	80,0	25,0	4,4	0,4	0,641	0,128	1,12	–	-5,0	4	Cylindrical	■
980ML060-MEGA	02511315	3	G	6,0	3,0	8,0	0,35	80,0	30,0	5,2	0,5	0,778	0,15	2,0	–	-5,0	2	Cylindrical	■
JHF980060G3H.0Z4-MEGA	03003398	3	G	6,0	3,0	8,0	0,35	80,0	30,0	5,2	0,5	0,778	0,15	1,8	–	-5,0	4	Cylindrical	■
980ML080-MEGA	02511338	3	E	8,0	4,0	8,0	0,4	80,0	40,0	7,0	0,6	0,935	0,198	–	–	-5,0	2	Cylindrical	■
JHF980080E3H.0Z5-MEGA	03003399	3	E	8,0	4,0	8,0	0,4	80,0	40,0	7,0	0,6	0,935	0,198	–	–	-5,0	5	Cylindrical	■
980ML100-MEGA	02511344	3	E	10,0	5,0	10,0	0,45	90,0	50,0	8,8	0,8	1,176	0,232	–	–	-5,0	2	Cylindrical	■
JHF980100E3H.0Z5-MEGA	03003400	3	E	10,0	5,0	10,0	0,45	90,0	50,0	8,8	0,8	1,176	0,232	–	–	-5,0	5	Cylindrical	■
980ML120-MEGA	02511348	3	E	12,0	6,0	12,0	0,5	110,0	60,0	10,6	1,0	1,417	0,265	–	–	-5,0	2	Cylindrical	■
JHF980120E3H.0Z5-MEGA	03003401	3	E	12,0	6,0	12,0	0,5	110,0	60,0	10,6	1,0	1,417	0,265	–	–	-5,0	5	Cylindrical	■
980TL010-MEGA	02587114	4	J	1,0	0,5	6,0	0,07	40,0	7,0	0,7	0,07	0,127	0,028	13,0	0,5	-5,0	2	Cylindrical	■
980TL015-MEGA	02511220	4	J	1,5	0,75	6,0	0,1	40,0	10,5	1,2	0,1	0,183	0,043	8,5	0,5	-5,0	2	Cylindrical	■
980TL020-MEGA	02511223	4	J	2,0	1,0	6,0	0,15	50,0	14,0	1,7	0,15	0,269	0,055	6,5	0,5	-5,0	2	Cylindrical	■
980TL030-MEGA	02511226	4	J	3,0	1,5	6,0	0,2	60,0	21,0	2,6	0,2	0,366	0,085	3,5	0,5	-5,0	2	Cylindrical	■
JHF980030J4H.0Z4-MEGA	03003402	4	J	3,0	1,5	6,0	0,2	60,0	21,0	2,6	0,2	0,366	0,085	3,63	0,5	-5,0	4	Cylindrical	■
980TL040-MEGA	02511232	4	J	4,0	2,0	6,0	0,25	80,0	28,0	3,5	0,3	0,503	0,107	2,0	0,5	-5,0	2	Cylindrical	■
JHF980040J4H.0Z4-MEGA	03003403	4	J	4,0	2,0	6,0	0,25	80,0	28,0	3,5	0,3	0,503	0,107	1,93	0,5	-5,0	4	Cylindrical	■
980TL050-MEGA	02511240	4	J	5,0	2,5	6,0	0,3	90,0	35,0	4,4	0,4	0,641	0,128	1,0	0,5	-5,0	2	Cylindrical	■
JHF980050J4H.0Z4-MEGA	03003404	4	J	5,0	2,5	6,0	0,3	90,0	35,0	4,4	0,4	0,641	0,128	0,82	0,5	-5,0	4	Cylindrical	■
980TL060-MEGA	02511321	4	J	6,0	3,0	8,0	0,35	100,0	42,0	5,2	0,5	0,778	0,15	1,5	0,5	-5,0	2	Cylindrical	■
JHF980060J4H.0Z4-MEGA	03003405	4	J	6,0	3,0	8,0	0,35	100,0	42,0	5,2	0,5	0,778	0,15	1,33	0,5	-5,0	4	Cylindrical	■
980TL080-MEGA	02511340	4	E	8,0	4,0	8,0	0,4	100,0	56,0	7,0	0,6	0,935	0,198	–	0,5	-5,0	2	Cylindrical	■
JHF980080E4H.0Z5-MEGA	03003406	4	E	8,0	4,0	8,0	0,4	100,0	56,0	7,0	0,6	0,935	0,198	–	–	-5,0	5	Cylindrical	■
980TL100-MEGA	02511345	4	E	10,0	5,0	10,0	0,45	110,0	70,0	8,8	0,8	1,176	0,232	–	0,5	-5,0	2	Cylindrical	■
JHF980100E4H.0Z5-MEGA	03003407	4	E	10,0	5,0	10,0	0,45	110,0	70,0	8,8	0,8	1,176	0,232	–	–	-5,0	5	Cylindrical	■
980TL120-MEGA	02511349	4	E	12,0	6,0	12,0	0,5	130,0	84,0	10,6	1,0	1,417	0,265	–	0,5	-5,0	2	Cylindrical	■
JHF980120E4H.0Z5-MEGA	03003408	4	E	12,0	6,0	12,0	0,5	130,0	84,0	10,6	1,0	1,417	0,265	–	–	-5,0	5	Cylindrical	■

■ **Lagerstandard.** *UTCN = Theoretische Abweichung

Schnittdaten – JHF980 Eckfräsen

SMG		a_e/DCX	a_p/DCX	f_z										v_c
				1	1.5	2	3	4	5	6	8	10	12	
P1	E/M/A	0.30 *0.30*	0.040 *0.040*	0.050 *0.0020*	0.075 *0.0030*	0.10 *0.0040*	0.15 *0.0060*	0.20 *0.0080*	0.25 *0.010*	0.30 *0.012*	0.40 *0.016*	0.50 *0.020*	0.60 *0.024*	385 (350 — 430) *1275 (1200 — 1400)*
P2	E/M/A	0.30 *0.30*	0.040 *0.040*	0.050 *0.0020*	0.075 *0.0030*	0.10 *0.0040*	0.15 *0.0060*	0.20 *0.0080*	0.25 *0.010*	0.30 *0.012*	0.40 *0.016*	0.50 *0.020*	0.60 *0.024*	375 (340 — 410) *1225 (1200 — 1300)*
P3	E/M/A	0.30 *0.30*	0.040 *0.040*	0.050 *0.0020*	0.075 *0.0030*	0.10 *0.0040*	0.15 *0.0060*	0.20 *0.0080*	0.25 *0.010*	0.30 *0.012*	0.40 *0.016*	0.50 *0.020*	0.60 *0.024*	325 (290 — 360) *1075 (960 — 1100)*
P4	E/M/A	0.30 *0.30*	0.040 *0.040*	0.050 *0.0020*	0.075 *0.0030*	0.10 *0.0040*	0.15 *0.0060*	0.20 *0.0080*	0.25 *0.010*	0.30 *0.012*	0.40 *0.016*	0.50 *0.020*	0.60 *0.024*	285 (260 — 310) *940 (860 — 1000)*
P5	E/M/A	0.30 *0.30*	0.040 *0.040*	0.050 *0.0020*	0.075 *0.0030*	0.10 *0.0040*	0.15 *0.0060*	0.20 *0.0080*	0.25 *0.010*	0.30 *0.012*	0.40 *0.016*	0.50 *0.020*	0.60 *0.024*	275 (250 — 300) *900 (830 — 980)*
P6	E/M/A	0.30 *0.30*	0.040 *0.040*	0.044 *0.0017*	0.070 *0.0028*	0.090 *0.0036*	0.14 *0.0055*	0.18 *0.0070*	0.22 *0.0085*	0.28 *0.011*	0.36 *0.014*	0.44 *0.017*	0.55 *0.022*	215 (190 — 240) *710 (630 — 780)*
P7	E/M/A	0.30 *0.30*	0.040 *0.040*	0.044 *0.0017*	0.070 *0.0028*	0.090 *0.0036*	0.14 *0.0055*	0.18 *0.0070*	0.22 *0.0085*	0.28 *0.011*	0.36 *0.014*	0.44 *0.017*	0.55 *0.022*	205 (180 — 230) *670 (600 — 750)*
P8	E/M/A	0.30 *0.30*	0.040 *0.040*	0.044 *0.0017*	0.070 *0.0028*	0.090 *0.0036*	0.14 *0.0055*	0.18 *0.0070*	0.22 *0.0085*	0.28 *0.011*	0.36 *0.014*	0.44 *0.017*	0.55 *0.022*	190 (170 — 210) *620 (560 — 680)*
P11	E/M/A	0.30 *0.30*	0.040 *0.040*	0.044 *0.0017*	0.070 *0.0028*	0.090 *0.0036*	0.14 *0.0055*	0.18 *0.0070*	0.22 *0.0085*	0.28 *0.011*	0.36 *0.014*	0.44 *0.017*	0.55 *0.022*	195 (170 — 220) *640 (560 — 720)*
P12	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	120 (110 — 130) *395 (370 — 420)*
M1	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	190 (170 — 210) *620 (560 — 680)*
M2	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	150 (140 — 160) *490 (460 — 520)*
M3	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	115 (98 — 130) *375 (330 — 420)*
M4	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	85 (73 — 100) *280 (240 — 320)*
M5	E/M/A	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	70 (61 — 83) *230 (210 — 270)*
K1	E/M/A	0.30 *0.30*	0.040 *0.040*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	225 (200 — 250) *740 (660 — 820)*
K2	E/M/A	0.30 *0.30*	0.040 *0.040*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	195 (170 — 220) *640 (560 — 720)*
K3	E/M/A	0.30 *0.30*	0.040 *0.040*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	165 (150 — 180) *540 (500 — 590)*
K4	E/M/A	0.30 *0.30*	0.040 *0.040*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	155 (140 — 170) *510 (460 — 550)*
K5	E/M/A	0.30 *0.30*	0.040 *0.040*	0.032 *0.0013*	0.050 *0.0020*	0.065 *0.0026*	0.10 *0.0040*	0.13 *0.0050*	0.16 *0.0065*	0.20 *0.0080*	0.26 *0.010*	0.32 *0.013*	0.40 *0.016*	165 (140 — 190) *540 (460 — 620)*
K6	E/M/A	0.30 *0.30*	0.040 *0.040*	0.032 *0.0013*	0.050 *0.0020*	0.065 *0.0026*	0.10 *0.0040*	0.13 *0.0050*	0.16 *0.0065*	0.20 *0.0080*	0.26 *0.010*	0.32 *0.013*	0.40 *0.016*	245 (200 — 290) *800 (660 — 950)*
K7	E/M/A	0.30 *0.30*	0.040 *0.040*	0.032 *0.0013*	0.050 *0.0020*	0.065 *0.0026*	0.10 *0.0040*	0.13 *0.0050*	0.16 *0.0065*	0.20 *0.0080*	0.26 *0.010*	0.32 *0.013*	0.40 *0.016*	210 (170 — 250) *690 (560 — 820)*
S1	E	0.30 *0.30*	0.022 *0.022*	0.024 *0.00095*	0.036 *0.0014*	0.048 *0.0019*	0.070 *0.0028*	0.095 *0.0038*	0.12 *0.0048*	0.14 *0.0055*	0.19 *0.0075*	0.24 *0.0095*	0.28 *0.011*	60 (50 — 74) *195 (170 — 240)*
S2	E	0.30 *0.30*	0.022 *0.022*	0.024 *0.00095*	0.036 *0.0014*	0.048 *0.0019*	0.070 *0.0028*	0.095 *0.0038*	0.12 *0.0048*	0.14 *0.0055*	0.19 *0.0075*	0.24 *0.0095*	0.28 *0.011*	50 (41 — 60) *165 (140 — 190)*
S3	E	0.30 *0.30*	0.022 *0.022*	0.024 *0.00095*	0.036 *0.0014*	0.048 *0.0019*	0.070 *0.0028*	0.095 *0.0038*	0.12 *0.0048*	0.14 *0.0055*	0.19 *0.0075*	0.24 *0.0095*	0.28 *0.011*	37 (25 — 49) *120 (83 — 160)*
S11	E	0.30 *0.30*	0.022 *0.022*	0.036 *0.0014*	0.050 *0.0020*	0.070 *0.0028*	0.10 *0.0040*	0.14 *0.0055*	0.18 *0.0070*	0.20 *0.0080*	0.28 *0.011*	0.36 *0.014*	0.42 *0.017*	175 (160 — 190) *570 (530 — 620)*
S12	E	0.30 *0.30*	0.022 *0.022*	0.036 *0.0014*	0.050 *0.0020*	0.070 *0.0028*	0.10 *0.0040*	0.14 *0.0055*	0.18 *0.0070*	0.20 *0.0080*	0.28 *0.011*	0.36 *0.014*	0.42 *0.017*	135 (120 — 150) *445 (400 — 490)*
S13	E	0.30 *0.30*	0.022 *0.022*	0.036 *0.0014*	0.050 *0.0020*	0.070 *0.0028*	0.10 *0.0040*	0.14 *0.0055*	0.18 *0.0070*	0.20 *0.0080*	0.28 *0.011*	0.36 *0.014*	0.42 *0.017*	105 (90 — 110) *345 (300 — 360)*
H5	M/A/D	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	115 (98 — 130) *375 (330 — 420)*
H8	M/A/D	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	115 (98 — 130) *375 (330 — 420)*
H21	M/A/D	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	115 (98 — 130) *375 (330 — 420)*
H31	M/A/D	0.30 *0.30*	0.036 *0.036*	0.040 *0.0016*	0.060 *0.0024*	0.080 *0.0032*	0.12 *0.0048*	0.16 *0.0065*	0.20 *0.0080*	0.24 *0.0095*	0.32 *0.013*	0.40 *0.016*	0.48 *0.019*	90 (74 — 100) *295 (250 — 320)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JHF980 Nutfräsen

SMG		a_p/DCX	f_z										v_c
			1	1.5	2	3	4	5	6	8	10	12	
P1	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	340 (310 — 370) *1125 (1100 — 1200)*
P2	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	330 (300 — 360) *1075 (990 — 1100)*
P3	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	285 (260 — 310) *940 (860 — 1000)*
P4	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	250 (230 — 270) *820 (760 — 880)*
P5	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	240 (220 — 260) *790 (730 — 850)*
P6	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	185 (160 — 210) *610 (530 — 680)*
P7	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	175 (160 — 200) *570 (530 — 650)*
P8	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	165 (150 — 180) *540 (500 — 590)*
P11	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	170 (150 — 190) *560 (500 — 620)*
P12	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	105 (90 — 110) *345 (300 — 360)*
M1	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	165 (150 — 180) *540 (500 — 590)*
M2	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	130 (120 — 140) *425 (400 — 450)*
M3	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	100 (85 — 110) *330 (280 — 360)*
M4	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	75 (64 — 87) *245 (210 — 280)*
M5	E/M/A	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	65 (53 — 72) *215 (180 — 230)*
K1	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	185 (160 — 210) *610 (530 — 680)*
K2	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	160 (140 — 180) *520 (460 — 590)*
K3	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	135 (120 — 150) *445 (400 — 490)*
K4	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	0.30 *0,012*	0.36 *0,014*	130 (120 — 140) *425 (400 — 450)*
K5	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	135 (110 — 150) *445 (370 — 490)*
K6	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	195 (160 — 230) *640 (530 — 750)*
K7	E/M/A	0.040 *0,040*	0.028 *0,0011*	0.040 *0,0016*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.22 *0,0085*	0.28 *0,011*	0.32 *0,013*	170 (140 — 200) *560 (460 — 650)*
S1	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	50 (42 — 62) *165 (140 — 200)*
S2	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	42 (34 — 50) *140 (120 — 160)*
S3	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	31 (21 — 41) *100 (69 — 130)*
S11	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	155 (140 — 170) *510 (460 — 550)*
S12	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	120 (110 — 130) *395 (370 — 420)*
S13	E	0.022 *0,022*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	95 (82 — 100) *310 (270 — 320)*
H5	M/A/D	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	100 (86 — 110) *330 (290 — 360)*
H8	M/A/D	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	100 (86 — 110) *330 (290 — 360)*
H21	M/A/D	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	100 (86 — 110) *330 (290 — 360)*
H31	M/A/D	0.036 *0,036*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.19 *0,0075*	0.24 *0,0095*	0.28 *0,011*	75 (65 — 88) *245 (220 — 280)*

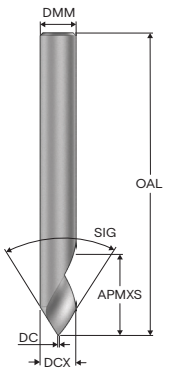
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

J29

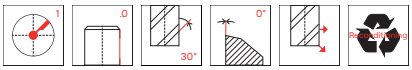
Allgemeine Anwendung – Universell – Gravieren – 1 Schneide – Zylindrisch





D

– Toleranzen:
– DMM=h5
– Nachschleifen möglich, wenn DMM ≥ Ø6 ist



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm				
29030	00029373	2	D	3,0	0,2	3,0	2,6	40,0	30,0	1	Cylindrical	■
29040	00029381	2	D	4,0	0,2	4,0	3,5	50,0	30,0	1	Cylindrical	■
29060	00029396	2	D	6,0	0,2	6,0	5,2	50,0	30,0	1	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – J29 Nutfräsen

SMG		a_p/DC	f_z			v_c
			3	4	6	
P1	E	0.50 *0,50*	0.24 *0,0095*	0.26 *0,010*	0.28 *0,011*	42 (32 — 63) *140 (110 — 200)*
P2	E	0.50 *0,50*	0.24 *0,0095*	0.26 *0,010*	0.30 *0,012*	41 (32 — 61) *135 (110 — 200)*
P3	E	0.50 *0,50*	0.24 *0,0095*	0.25 *0,010*	0.28 *0,011*	36 (28 — 54) *120 (92 — 170)*
P4	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	31 (24 — 47) *100 (79 — 150)*
P5	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
P6	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	34 (26 — 51) *110 (86 — 160)*
P7	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	32 (25 — 48) *105 (83 — 150)*
P8	E	0.50 *0,50*	0.24 *0,0095*	0.25 *0,010*	0.28 *0,011*	30 (23 — 45) *100 (76 — 140)*
P11	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	31 (24 — 46) *100 (79 — 150)*
P12	E	0.50 *0,50*	0.15 *0,0060*	0.16 *0,0065*	0.18 *0,0070*	19 (15 — 29) *60 (50 — 95)*
M1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
M2	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
M3	E	0.50 *0,50*	0.18 *0,0070*	0.19 *0,0075*	0.22 *0,0085*	24 (18 — 35) *80 (60 — 110)*
M4	E	0.50 *0,50*	0.16 *0,0065*	0.17 *0,0065*	0.18 *0,0070*	18 (14 — 27) *60 (46 — 88)*
M5	E	0.50 *0,50*	0.16 *0,0065*	0.17 *0,0065*	0.18 *0,0070*	15 (12 — 22) *49 (40 — 72)*
K1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
K2	E	0.50 *0,50*	0.20 *0,0080*	0.22 *0,0085*	0.24 *0,0095*	26 (21 — 40) *85 (69 — 130)*
K3	E	0.50 *0,50*	0.20 *0,0080*	0.22 *0,0085*	0.24 *0,0095*	22 (17 — 33) *70 (56 — 100)*
K4	E	0.50 *0,50*	0.20 *0,0080*	0.22 *0,0085*	0.24 *0,0095*	21 (17 — 32) *70 (56 — 100)*
K5	E	0.50 *0,50*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	13 (9.8 — 19) *43 (33 — 62)*
K6	E	0.50 *0,50*	0.20 *0,0080*	0.22 *0,0085*	0.24 *0,0095*	19 (15 — 28) *60 (50 — 91)*
K7	E	0.50 *0,50*	0.18 *0,0070*	0.20 *0,0080*	0.22 *0,0085*	16 (13 — 25) *50 (43 — 82)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – J29 Nutfräsen

SMG		a_p/DC	f_z			v_c
			3	4	6	
N1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
N2	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	19 (15 — 29) *60 (50 — 95)*
N3	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	13 (9.8 — 19) *43 (33 — 62)*
N11	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	17 (14 — 26) *55 (46 — 85)*
S1	E	0.50 *0,50*	0.24 *0,0095*	0.26 *0,010*	0.28 *0,011*	43 (33 — 64) *140 (110 — 200)*
S2	E	0.50 *0,50*	0.24 *0,0095*	0.26 *0,010*	0.28 *0,011*	34 (27 — 51) *110 (89 — 160)*
S3	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
S11	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	39 (30 — 59) *130 (99 — 190)*
S12	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
S13	E	0.50 *0,50*	0.19 *0,0075*	0.20 *0,0080*	0.24 *0,0095*	24 (18 — 35) *80 (60 — 110)*
H5	M/A/D	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
H8	M/A/D	0.50 *0,50*	0.17 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	32 (24 — 47) *105 (79 — 150)*
H11	M/A/D	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	39 (30 — 58) *130 (99 — 190)*
H12	M/A/D	0.50 *0,50*	0.12 *0,0048*	0.12 *0,0048*	0.14 *0,0055*	12 (9.1 — 18) *39 (30 — 59)*
H21	M/A/D	0.50 *0,50*	0.17 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	32 (24 — 47) *105 (79 — 150)*
H31	M/A/D	0.50 *0,50*	0.15 *0,0060*	0.16 *0,0065*	0.17 *0,0065*	24 (19 — 36) *80 (63 — 110)*
TS1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
TP1	E	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*
GR1	D	0.50 *0,50*	0.22 *0,0085*	0.24 *0,0095*	0.26 *0,010*	30 (23 — 45) *100 (76 — 140)*

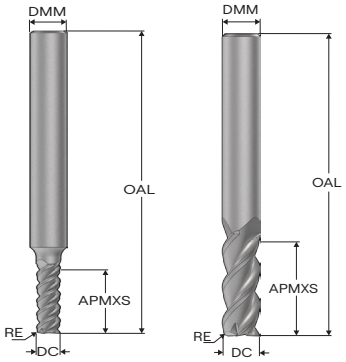
Schnittdaten, siehe Seite 699 - 707

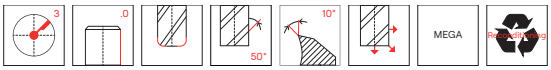
SMG = Seco Werkstoff-Gruppe
Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

J36

Allgemeine Anwendung – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius







- Toleranzen:
- DMM= h5
- DC= Ø2-Ø6= -0,02/-0,034 mm
- DC= Ø8-Ø20= -0,02/-0,044 mm
- RE= Ø2-Ø12= +0,05 mm
- RE= Ø14-Ø20= +0,1 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm				
36020-MEGA	00025621	2	F	2,0	3,0	9,0	40,0	0,1	2,5	3	Cylindrical	■
36030-MEGA	00025626	2	D	3,0	3,0	12,0	40,0	0,1	–	3	Cylindrical	■
36040-MEGA	00025628	2	D	4,0	4,0	14,0	50,0	0,1	–	3	Cylindrical	■
36050-MEGA	00025651	2	D	5,0	5,0	20,0	50,0	0,1	–	3	Cylindrical	■
36060-MEGA	00025663	2	D	6,0	6,0	20,0	65,0	0,1	–	3	Cylindrical	■
36080-MEGA	00025674	2	D	8,0	8,0	20,0	65,0	0,2	–	3	Cylindrical	■
36100-MEGA	00025680	2	D	10,0	10,0	25,0	75,0	0,2	–	3	Cylindrical	■
36120-MEGA	00025681	2	D	12,0	12,0	25,0	75,0	0,2	–	3	Cylindrical	■
36160-MEGA	00025689	2	D	16,0	16,0	30,0	90,0	0,5	–	3	Cylindrical	■
36200-MEGA	00025692	2	D	20,0	20,0	40,0	100,0	0,5	–	3	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – J36 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
P1	E	0.200 *0,200*	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	200 (170 — 220) *660 (560 — 720)*
P2	E	0.200 *0,200*	1.0 *1,0*	0.013 *0,00050*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	190 (170 — 210) *620 (560 — 680)*
P3	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	170 (150 — 190) *560 (500 — 620)*
P4	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	150 (130 — 160) *490 (430 — 520)*
P5	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	140 (130 — 160) *460 (430 — 520)*
P6	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	160 (140 — 180) *520 (460 — 590)*
P7	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	150 (130 — 170) *490 (430 — 550)*
P8	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	140 (130 — 160) *460 (430 — 520)*
P11	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	145 (130 — 160) *475 (430 — 520)*
P12	E	0.200 *0,200*	1.0 *1,0*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	90 (79 — 100) *295 (260 — 320)*
M1	E	0.200 *0,200*	1.0 *1,0*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	115 (92 — 140) *375 (310 — 450)*
M2	E	0.200 *0,200*	1.0 *1,0*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	95 (76 — 110) *310 (250 — 360)*
M3	E	0.100 *0,100*	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	75 (56 — 95) *245 (190 — 310)*
M4	E	0.100 *0,100*	1.0 *1,0*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	60 (43 — 73) *195 (150 — 230)*
M5	E	0.100 *0,100*	1.0 *1,0*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	48 (36 — 60) *155 (120 — 190)*
K1	E	0.200 *0,200*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	140 (130 — 160) *460 (430 — 520)*
K2	E	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	125 (110 — 140) *410 (370 — 450)*
K3	E	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	105 (91 — 120) *345 (300 — 390)*
K4	E	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	100 (87 — 110) *330 (290 — 360)*
K5	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	60 (53 — 69) *195 (180 — 220)*
K6	E	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	90 (76 — 100) *295 (250 — 320)*
K7	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	80 (67 — 89) *260 (220 — 290)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – J36 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E	0.300 *0,300*	1.2 *1,2*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	650 (540 — 750) *2125 (1800 — 2400)*
N2	E	0.300 *0,300*	1.2 *1,2*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	415 (350 — 480) *1350 (1200 — 1500)*
N3	E	0.300 *0,300*	1.2 *1,2*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	275 (240 — 320) *900 (790 — 1000)*
N11	E	0.300 *0,300*	1.0 *1,0*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	305 (260 — 350) *1000 (860 — 1100)*
S1	E	0.120 *0,120*	0.90 *0,90*	0.0055 *0,00022*	0.0080 *0,00032*	0.011 *0,00044*	0.014 *0,00055*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	70 (60 — 83) *230 (200 — 270)*
S2	E	0.120 *0,120*	0.90 *0,90*	0.0055 *0,00022*	0.0080 *0,00032*	0.011 *0,00044*	0.014 *0,00055*	0.016 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	60 (48 — 67) *195 (160 — 210)*
S3	E	0.120 *0,120*	0.90 *0,90*	0.0036 *0,00014*	0.0055 *0,00022*	0.0075 *0,00030*	0.0090 *0,00036*	0.011 *0,00044*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	39 (30 — 48) *130 (99 — 150)*
S11	E	0.300 *0,300*	1.0 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	100 (89 — 110) *330 (300 — 360)*
S12	E	0.300 *0,300*	1.0 *0,90*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	80 (68 — 87) *260 (230 — 280)*
S13	E	0.300 *0,300*	1.0 *0,90*	0.0085 *0,00036*	0.013 *0,00050*	0.017 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	60 (54 — 69) *195 (180 — 220)*
TS1	A	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	500 (460 — 550) *1650 (1600 — 1800)*
TP1	A	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	500 (460 — 550) *1650 (1600 — 1800)*

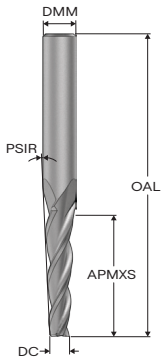
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
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a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

HK

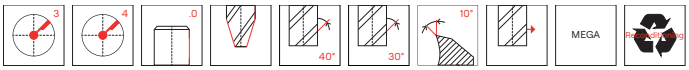
Allgemeine Anwendung – Universell – Konisch – 3-4 Schneiden – Zylindrisch – Scharfe Schneide konisch





N

—Toleranzen:
—DMM= h5
—DC= +0,1/0 mm
—PSIR= ±0,1°
—Nachschleifen möglich



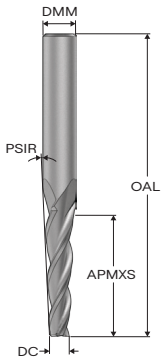
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm				
HK020-040-MEGA	00028666	2	N	6,0	4,0	6,0	20,0	65,0	2,0	3	Cylindrical	■
HK020-050-MEGA	00028669	2	N	8,0	5,0	8,0	30,0	75,0	2,0	3	Cylindrical	■
HK020-100-MEGA	00028694	2	N	12,0	10,0	12,0	28,0	80,0	2,0	4	Cylindrical	■

■ **Lagerstandard.**
Schnittdaten unter My Pages – Vorschlag auf www.secotools.com

HKM-HK

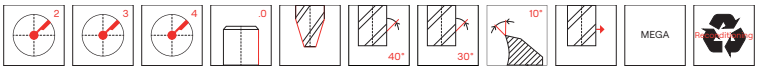
Allgemeine Anwendung – Universell – Konisch – 2-4 Schneiden – Zylindrisch – Scharfe Schneide konisch





N

—Toleranzen:
—DMM= h5
—DC= HKM= +0,07/+0,03 mm
—DC= HK= +0,1/0 mm
—PSIR= ±0,1°
—Nachschleifen möglich, wenn DC ≥ Ø6 ist



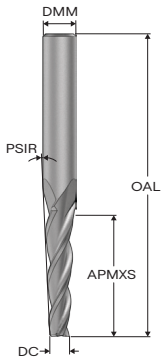
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm				
HKM030-015-MEGA	00028738	2	N	3,0	1,5	3,0	6,0	40,0	3,0	2	Cylindrical	■
HK030-025-MEGA	00028741	2	N	6,0	2,5	6,0	20,0	65,0	3,0	3	Cylindrical	■
HK030-033-MEGA	00028744	2	N	8,0	3,0	8,0	30,0	75,0	3,0	3	Cylindrical	■
HK030-065-MEGA	00028759	2	N	12,0	6,0	12,0	55,0	110,0	3,0	3	Cylindrical	■
HK030-083-MEGA	00028771	2	N	12,0	8,0	12,0	30,0	80,0	3,0	4	Cylindrical	■

■ **Lagerstandard.**
Schnittdaten unter My Pages – Vorschlag auf www.secotools.com

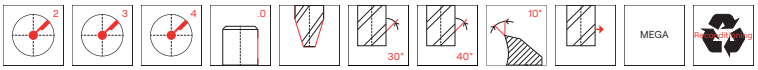
HKM-HK

Allgemeine Anwendung – Universell – Konisch – 2-4 Schneiden – Zylindrisch – Scharfe Schneide konisch





N



—Toleranzen:
—DMM= h5
—DC= HKM= +0,07/+0,03 mm
—DC= HK= +0,1/0 mm
—PSIR= ±0,1°
—Nachschleifen möglich, wenn DC ≥ Ø6 ist

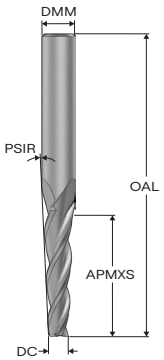
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm				
HKM050-010-MEGA	00028947	2	N	3,0	1,0	3,0	4,0	40,0	5,0	2	Cylindrical	■
HKM050-015-MEGA	00028952	2	N	3,0	1,5	3,0	6,0	40,0	5,0	2	Cylindrical	■
HKM050-020-MEGA	00028954	2	N	4,0	2,0	4,0	10,0	50,0	5,0	2	Cylindrical	■
HKM050-025-MEGA	00028958	2	N	5,0	2,5	5,0	10,0	50,0	5,0	2	Cylindrical	■
HK050-025-MEGA	00028960	2	N	6,0	2,5	6,0	20,0	65,0	5,0	3	Cylindrical	■
HK050-032-MEGA	00028972	2	N	8,0	3,0	8,0	28,0	70,0	5,0	3	Cylindrical	■
HK050-0420-MEGA	00028998	2	N	8,0	4,0	8,0	22,0	65,0	5,0	3	Cylindrical	■
HK050-050-MEGA	00029012	2	N	12,0	5,0	12,0	40,0	100,0	5,0	3	Cylindrical	■
HK050-063-MEGA	00029014	2	N	12,0	6,0	12,0	32,0	90,0	5,0	3	Cylindrical	■
HK050-065-MEGA	00029017	2	N	16,0	6,0	16,0	55,0	110,0	5,0	3	Cylindrical	■
HK050-103-MEGA	00029020	2	N	16,0	10,0	16,0	32,0	90,0	5,0	4	Cylindrical	■
HK050-105-MEGA	00029025	2	N	20,0	10,0	20,0	55,0	115,0	5,0	4	Cylindrical	■

■ **Lagerstandard.**
Schnittdaten unter My Pages – Vorschlag auf www.secotools.com

HK

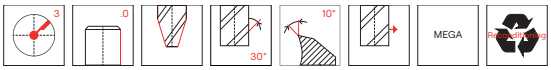
Allgemeine Anwendung – Universell – Konisch – 3 Schneiden – Zylindrisch – Scharfe Schneide konisch





N

—Toleranzen:
—DMM= h5
—DC= +0,1/0 mm
—PSIR= ±0,1°
—Nachschleifen möglich



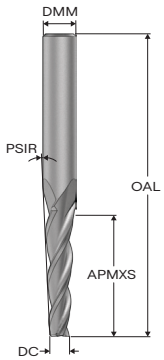
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm				
HK070-025-MEGA	00029030	2	N	8,0	2,5	8,0	22,0	65,0	7,0	3	Cylindrical	■
HK070-050-MEGA	00029034	2	N	12,0	5,0	12,0	28,0	80,0	7,0	3	Cylindrical	■

■ **Lagerstandard.**
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HK

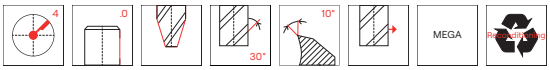
Allgemeine Anwendung – Universell – Konisch – 4 Schneiden – Zylindrisch – Scharfe Schneide konisch





N

—Toleranzen:
—DMM= h5
—DC= +0,1/0 mm
—PSIR= ±0,1°
—Nachschleifen möglich



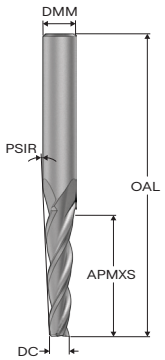
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm				
HK080-083-MEGA	00029041	2	N	18,0	8,0	18,0	35,0	90,0	8,0	4	Cylindrical	■

■ **Lagerstandard.**
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HK

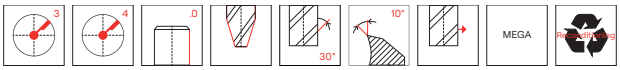
Allgemeine Anwendung – Universell – Konisch – 3-4 Schneiden – Zylindrisch – Scharfe Schneide konisch





N

—Toleranzen:
—DMM= h5
—DC= +0,1/0 mm
—PSIR= ±0,1°
—Nachschleifen möglich



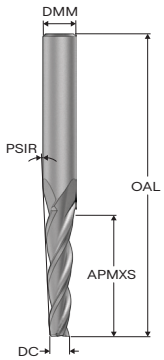
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm				
HK100-025-MEGA	00029052	2	N	10,0	2,5	10,0	20,0	75,0	10,0	3	Cylindrical	■
HK100-030-MEGA	00029066	2	N	14,0	3,0	14,0	30,0	90,0	10,0	3	Cylindrical	■
HK100-050-MEGA	00029069	2	N	16,0	5,0	16,0	30,0	90,0	10,0	3	Cylindrical	■
HK100-080-MEGA	00029083	2	N	20,0	8,0	20,0	32,0	90,0	10,0	4	Cylindrical	■

■ **Lagerstandard.**
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HK

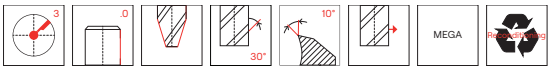
Allgemeine Anwendung – Universell – Konisch – 3 Schneiden – Zylindrisch – Scharfe Schneide konisch





N

—Toleranzen:
—DMM= h5
—DC= +0,1/0 mm
—PSIR= ±0,1°
—Nachschleifen möglich



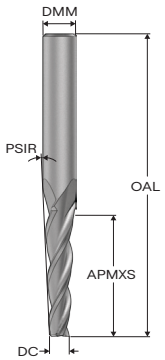
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm				
HK110-020-MEGA	00029110	2	N	10,0	2,0	10,0	20,0	75,0	11,0	3	Cylindrical	■
HK110-050-MEGA	00029117	2	N	14,0	5,0	14,0	20,0	80,0	11,0	3	Cylindrical	■

■ **Lagerstandard.**
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HK

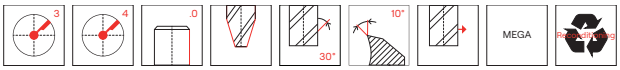
Allgemeine Anwendung – Universell – Konisch – 3-4 Schneiden – Zylindrisch – Scharfe Schneide konisch





N

—Toleranzen:
—DMM= h5
—DC= +0,1/0 mm
—PSIR= ±0,1°
—Nachschleifen möglich



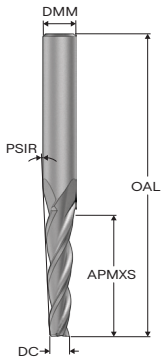
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm				
HK150-025	00029119	2	N	14,0	2,5	14,0	20,0	80,0	15,0	3	Cylindrical	■
HK150-025-MEGA	00029151	2	N	14,0	2,5	14,0	20,0	80,0	15,0	3	Cylindrical	■
HK150-040	00029124	2	N	12,0	4,0	12,0	15,0	65,0	15,0	3	Cylindrical	■
HK150-040-MEGA	00029154	2	N	12,0	4,0	12,0	15,0	65,0	15,0	3	Cylindrical	■
HK150-0651	00029133	2	N	12,0	6,5	12,0	10,0	65,0	15,0	3	Cylindrical	■
HK150-0651-MEGA	00029160	2	N	12,0	6,5	12,0	10,0	65,0	15,0	3	Cylindrical	■
HK150-0652	00029138	2	N	20,0	6,5	20,0	25,0	90,0	15,0	3	Cylindrical	■
HK150-0652-MEGA	00029161	2	N	20,0	6,5	20,0	25,0	90,0	15,0	3	Cylindrical	■
HK150-080	00029149	2	N	20,0	8,0	20,0	20,0	80,0	15,0	4	Cylindrical	■
HK150-080-MEGA	00029162	2	N	20,0	8,0	20,0	20,0	80,0	15,0	4	Cylindrical	■

■ **Lagerstandard.**
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HK

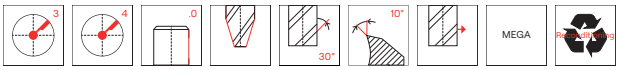
Allgemeine Anwendung – Universell – Konisch – 3-4 Schneiden – Zylindrisch – Scharfe Schneide konisch





N

—Toleranzen:
—DMM= h5
—DC= +0,1/0 mm
—PSIR= ±0,1°
—Nachschleifen möglich



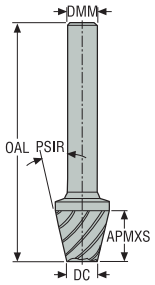
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm				
HK200-025	00029165	2	N	10,0	2,5	10,0	10,0	75,0	20,0	3	Cylindrical	■
HK200-025-MEGA	00029168	2	N	10,0	2,5	10,0	10,0	75,0	20,0	3	Cylindrical	■
HK200-045	00029166	2	N	16,0	4,5	16,0	15,0	90,0	20,0	4	Cylindrical	■
HK200-045-MEGA	00029203	2	N	16,0	4,5	16,0	15,0	90,0	20,0	4	Cylindrical	■

■ **Lagerstandard.**
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HK

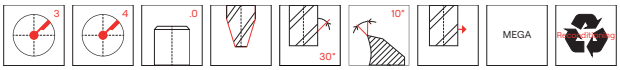
Allgemeine Anwendung – Universell – Konisch – 3-4 Schneiden – Zylindrisch – Scharfe Schneide konisch





N

- Toleranzen:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich



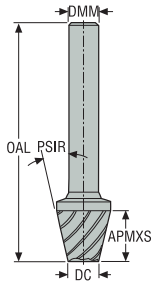
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm				
HK300-025	00029208	2	N	14,5	2,5	10,0	10,0	75,0	30,0	3	Cylindrical	■
HK300-025-MEGA	00029211	2	N	14,5	2,5	10,0	10,0	75,0	30,0	3	Cylindrical	■
HK300-045	00029210	2	N	23,5	4,5	16,0	16,0	90,0	30,0	4	Cylindrical	■
HK300-045-MEGA	00029212	2	N	23,5	4,5	16,0	16,0	90,0	30,0	4	Cylindrical	■

■ **Lagerstandard.**
Schnittdaten unter My Pages – Vorschlag auf www.secotools.com

HK

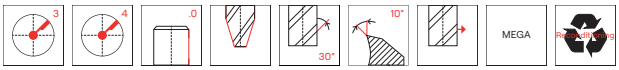
Allgemeine Anwendung – Universell – Konisch – 3-4 Schneiden – Zylindrisch – Scharfe Schneide konisch





N

—Toleranzen:
—DMM= h5
—DC= +0,1/0 mm
—PSIR= ±0,1°
—Nachschleifen möglich



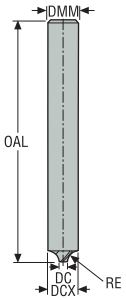
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DCX	DC	DMM	APMXS	OAL	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm				
HK450-025	00029215	2	N	23,0	2,5	12,0	10,0	75,0	45,0	3	Cylindrical	■
HK450-025-MEGA	00029229	2	N	23,0	2,5	12,0	10,0	75,0	45,0	3	Cylindrical	■
HK450-045	00029217	2	N	37,0	4,5	16,0	16,0	90,0	45,0	4	Cylindrical	■
HK450-045-MEGA	00029232	2	N	37,0	4,5	16,0	16,0	90,0	45,0	4	Cylindrical	■

■ **Lagerstandard.**
Schnittdaten unter My Pages – Vorschlag auf www.secotools.com

V31

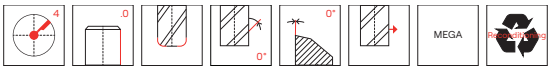
Allgemeine Anwendung – Universell – Konkav – 4 Schneiden – Zylindrisch





D

—Toleranzen:
—DMM= h5
—DC= ±0,04 mm
—RE= ±0,02 mm
—Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DCX	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm			
31100-MEGA	00029307	2	D	6,0	4,0	6,0	1,0	64,0	1,0	4	Cylindrical	■
31200-MEGA	00029315	2	D	8,0	4,0	8,0	2,0	75,0	2,0	4	Cylindrical	■
31300-MEGA	00029326	2	D	10,0	4,0	10,0	3,0	75,0	3,0	4	Cylindrical	■
31400-MEGA	00029328	2	D	12,0	4,0	12,0	4,0	75,0	4,0	4	Cylindrical	■
31050-MEGA	00029285	2	D	6,0	5,0	6,0	0,5	64,0	0,5	4	Cylindrical	■
31150-MEGA	00029313	2	D	8,0	5,0	8,0	1,5	75,0	1,5	4	Cylindrical	■
31250-MEGA	00029324	2	D	10,0	5,0	10,0	2,5	75,0	2,5	4	Cylindrical	■
31350-MEGA	00029327	2	D	12,0	5,0	12,0	3,5	75,0	3,5	4	Cylindrical	■
31500-MEGA	00029330	2	D	16,0	6,0	16,0	5,0	75,0	5,0	4	Cylindrical	■
31600-MEGA	00029331	2	D	20,0	8,0	20,0	6,0	80,0	6,0	4	Cylindrical	■
31999-MEGA	00029335	2	D	28,0	8,0	25,0	10,0	80,0	10,0	4	Cylindrical	■
31800-MEGA	00029333	2	D	25,0	9,0	25,0	8,0	75,0	8,0	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – V31 Eckfräsen/Schruppen

SMG		a_p/DC	f_z								v_c
			6	8	10	12	16	20	25	28	
P1	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	290 (195 — 310) *950 (640 — 1100)*
P2	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,034 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	280 (190 — 305) *910 (620 — 1000)*
P3	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,090 *0,0036*	0,095 *0,0038*	240 (165 — 260) *790 (540 — 850)*
P4	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,090 *0,0036*	0,095 *0,0038*	210 (145 — 230) *680 (475 — 760)*
P5	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0034*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
P6	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	230 (155 — 245) *760 (510 — 800)*
P7	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	215 (145 — 230) *710 (475 — 760)*
P8	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,090 *0,0036*	0,095 *0,0038*	205 (140 — 220) *670 (460 — 730)*
P11	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	210 (140 — 225) *680 (460 — 740)*
M1	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,034 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	255 (170 — 270) *840 (560 — 890)*
M2	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
M3	E/M/A	0,24 *0,24*	0,018 *0,0007*	0,024 *0,00095*	0,030 *0,0012*	0,036 *0,0014*	0,048 *0,0019*	0,060 *0,0024*	0,070 *0,0028*	0,075 *0,003*	150 (105 — 165) *490 (345 — 540)*
M4	E/M/A	0,24 *0,24*	0,016 *0,00065*	0,020 *0,0008*	0,026 *0,0010*	0,032 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	0,060 *0,0024*	0,065 *0,0026*	110 (75 — 120) *360 (250 — 400)*
M5	E/M/A	0,24 *0,24*	0,016 *0,00065*	0,020 *0,0008*	0,026 *0,0010*	0,032 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	0,060 *0,0024*	0,065 *0,0026*	95 (65 — 100) *310 (220 — 320)*
K1	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
K2	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,028 *0,0011*	0,034 *0,0013*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,085 *0,0050*	175 (120 — 190) *570 (400 — 620)*
K3	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,028 *0,0011*	0,034 *0,0013*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,085 *0,0050*	150 (100 — 160) *490 (320 — 530)*
K4	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,028 *0,0011*	0,034 *0,0013*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,085 *0,0050*	140 (95 — 150) *460 (310 — 490)*
K5	E/M/A	0,24 *0,24*	0,018 *0,0007*	0,024 *0,00095*	0,030 *0,0012*	0,036 *0,0014*	0,050 *0,0022*	0,060 *0,0024*	0,070 *0,0028*	0,075 *0,003*	85 (55 — 90) *280 (180 — 300)*
K6	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,028 *0,0011*	0,034 *0,0013*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	0,085 *0,0050*	125 (85 — 135) *410 (280 — 445)*
K7	E/M/A	0,24 *0,24*	0,018 *0,0007*	0,024 *0,00095*	0,030 *0,0012*	0,036 *0,0014*	0,050 *0,0022*	0,060 *0,0024*	0,070 *0,0028*	0,075 *0,003*	105 (70 — 115) *345 (220 — 375)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – V31 Eckfräsen/Schruppen

SMG		a_p/DC	f_z								v_c
			6	8	10	12	16	20	25	28	
N1	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	315 (215 — 340) *1025 (710 — 1125)*
N2	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
N3	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	135 (90 — 145) *445 (300 — 475)*
N11	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
S1	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	205 (140 — 220) *670 (460 — 730)*
S2	E/M/A	0,24 *0,24*	0,024 *0,00095*	0,032 *0,0013*	0,040 *0,0016*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	0,095 *0,0038*	0,10 *0,004*	205 (140 — 220) *670 (460 — 730)*
S3	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
S11	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	265 (180 — 285) *870 (590 — 940)*
S12	E/M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
S13	E/M/A	0,24 *0,24*	0,020 *0,0008*	0,026 *0,0010*	0,032 *0,0013*	0,040 *0,0016*	0,050 *0,0022*	0,065 *0,0026*	0,075 *0,003*	0,080 *0,0032*	155 (105 — 165) *510 (345 — 540)*
H5	M/A	0,24 *0,24*	0,034 *0,0013*	0,046 *0,0018*	0,055 *0,0022*	0,070 *0,0028*	0,090 *0,0036*	0,11 *0,0044*	0,13 *0,0050*	0,14 *0,0055*	275 (185 — 295) *900 (610 — 950)*
H8	M/A	0,24 *0,24*	0,026 *0,0010*	0,034 *0,0013*	0,044 *0,0017*	0,050 *0,0022*	0,070 *0,0028*	0,085 *0,0050*	0,10 *0,004*	0,11 *0,0044*	270 (185 — 290) *890 (610 — 950)*
H21	M/A	0,24 *0,24*	0,026 *0,0010*	0,034 *0,0013*	0,044 *0,0017*	0,050 *0,0022*	0,070 *0,0028*	0,085 *0,0050*	0,10 *0,004*	0,11 *0,0044*	270 (185 — 290) *890 (610 — 950)*
H31	M/A	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
TS1	A/D	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
TP1	A/D	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*
GR1	A/D	0,24 *0,24*	0,022 *0,00085*	0,030 *0,0012*	0,038 *0,0015*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	0,085 *0,0050*	0,095 *0,0038*	205 (135 — 220) *670 (445 — 730)*

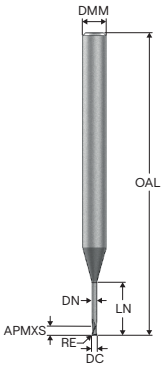
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

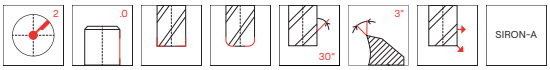
JME542

Mini – Universell – Eckfräser – 2 Schneiden – DMM 4 – Zylindrisch – scharf oder Eckenradius





G



- Toleranzen:
- Rundlaufabweichung = <0,007 mm
- DMM= h5
- DC= Ø0,2-Ø0,4= 0,-0,01 mm
- DC= Ø0,5-Ø3,0= 0,-0,013 mm
- RE= ±0,005 mm

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
JME542002G1S.0Z2-SIRA	03171095	1	G	0,2	4,0	0,3	45,0	0,4	0,18	–	14,41	2	Cylindrical	■
JME542003G1S.0Z2-SIRA	03171096	1	G	0,3	4,0	0,45	45,0	0,6	0,28	–	14,0	2	Cylindrical	■
JME542004G1S.0Z2-SIRA	03171128	1	G	0,4	4,0	0,6	45,0	0,8	0,37	–	13,5	2	Cylindrical	■
JME542005G1R005.0Z2-SIRA	03171097	1	G	0,5	4,0	0,8	45,0	1,0	0,46	0,05	13,17	2	Cylindrical	■
JME542006G1R005.0Z2-SIRA	03171098	1	G	0,6	4,0	0,9	45,0	1,2	0,56	0,05	12,76	2	Cylindrical	■
JME542008G1R005.0Z2-SIRA	03171129	1	G	0,8	4,0	1,2	45,0	1,6	0,76	0,05	11,96	2	Cylindrical	■
JME542010G1R010.0Z2-SIRA	03171099	1	G	1,0	4,0	1,5	50,0	2,0	0,95	0,1	11,22	2	Cylindrical	■
JME542012G1R010.0Z2-SIRA	03171100	1	G	1,2	4,0	1,8	50,0	2,4	1,15	0,1	10,43	2	Cylindrical	■
JME542015G1R015.0Z2-SIRA	03171130	1	G	1,5	4,0	2,3	50,0	3,0	1,45	0,15	9,2	2	Cylindrical	■
JME542005G3R005.0Z2-SIRA	03171102	3	G	0,5	4,0	0,8	45,0	2,5	0,46	0,05	11,03	2	Cylindrical	■
JME542006G3R005.0Z2-SIRA	03171103	3	G	0,6	4,0	0,9	45,0	3,0	0,56	0,05	10,36	2	Cylindrical	■
JME542008G3R005.0Z2-SIRA	03171131	3	G	0,8	4,0	1,2	45,0	4,0	0,76	0,05	9,14	2	Cylindrical	■
JME542010G3R010.0Z2-SIRA	03171104	3	G	1,0	4,0	1,5	50,0	5,0	0,95	0,1	8,09	2	Cylindrical	■
JME542012G3R010.0Z2-SIRA	03171105	3	G	1,2	4,0	1,8	50,0	6,0	1,15	0,1	7,13	2	Cylindrical	■
JME542015G3R015.0Z2-SIRA	03171132	3	G	1,5	4,0	2,3	50,0	7,5	1,45	0,15	5,89	2	Cylindrical	■
JME542020G3R015.0Z2-SIRA	03171106	3	G	2,0	4,0	3,0	50,0	10,0	1,94	0,15	4,14	2	Cylindrical	■
JME542025G3R015.0Z2-SIRA	03171108	3	G	2,5	4,0	3,8	50,0	12,5	2,4	0,15	2,79	2	Cylindrical	■
JME542030G3R015.0Z2-SIRA	03171134	3	G	3,0	4,0	4,5	60,0	15,0	2,85	0,15	1,67	2	Cylindrical	■
JME542005G4R005.0Z2-SIRA	03171109	4	G	0,5	4,0	0,8	45,0	4,0	0,46	0,05	9,49	2	Cylindrical	■
JME542006G4R005.0Z2-SIRA	03171110	4	G	0,6	4,0	0,9	45,0	5,0	0,56	0,05	8,56	2	Cylindrical	■
JME542008G4R005.0Z2-SIRA	03171135	4	G	0,8	4,0	1,2	45,0	7,0	0,76	0,05	7,05	2	Cylindrical	■
JME542010G4R010.0Z2-SIRA	03171111	4	G	1,0	4,0	1,5	50,0	8,5	0,95	0,1	6,1	2	Cylindrical	■
JME542012G4R010.0Z2-SIRA	03171112	4	G	1,2	4,0	1,8	50,0	10,0	1,15	0,1	5,27	2	Cylindrical	■
JME542015G4R015.0Z2-SIRA	03171136	4	G	1,5	4,0	2,3	50,0	12,0	1,45	0,15	4,29	2	Cylindrical	■
JME542020G4R015.0Z2-SIRA	03171113	4	G	2,0	4,0	3,0	60,0	16,0	1,94	0,15	2,9	2	Cylindrical	■
JME542030G4R015.0Z2-SIRA	03171137	4	G	3,0	4,0	4,5	70,0	24,0	2,85	0,15	1,1	2	Cylindrical	■
JME542015G5R015.0Z2-SIRA	03171115	5	G	1,5	4,0	2,3	60,0	15,0	1,45	0,15	3,64	2	Cylindrical	■
JME542020G5R015.0Z2-SIRA	03171116	5	G	2,0	4,0	3,0	60,0	20,0	1,94	0,15	2,41	2	Cylindrical	■
JME542030G5R015.0Z2-SIRA	03171117	5	G	3,0	4,0	4,5	70,0	30,0	2,85	0,15	0,9	2	Cylindrical	■
JME542015G6R015.0Z2-SIRA	03171118	6	G	1,5	4,0	2,3	70,0	22,5	1,45	0,15	2,64	2	Cylindrical	■
JME542020G6R015.0Z2-SIRA	03171139	6	G	2,0	4,0	3,0	70,0	30,0	1,94	0,15	1,7	2	Cylindrical	■
JME542030G6R015.0Z2-SIRA	03171120	6	G	3,0	4,0	4,5	90,0	45,0	2,85	0,15	0,61	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JME542 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	415 (370 — 460) *1350 (1300 — 1500)*
P2	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	405 (360 — 440) *1325 (1200 — 1400)*
P3	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	350 (310 — 380) *1150 (1100 — 1200)*
P4	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	305 (280 — 340) *1000 (920 — 1100)*
P5	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 320) *950 (860 — 1000)*
P6	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	330 (300 — 360) *1075 (990 — 1100)*
P7	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	310 (280 — 340) *1025 (920 — 1100)*
P8	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 320) *950 (860 — 1000)*
P11	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	300 (270 — 330) *980 (890 — 1000)*
P12	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (160 — 190) *570 (530 — 620)*
M1	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (190 — 260) *720 (630 — 850)*
M2	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	180 (150 — 210) *590 (500 — 680)*
M3	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	180 (150 — 210) *590 (500 — 680)*
M4	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	135 (110 — 150) *445 (370 — 490)*
M5	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	110 (92 — 130) *360 (310 — 420)*
N1	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	570 (500 — 640) *1875 (1700 — 2000)*
N2	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	570 (500 — 640) *1875 (1700 — 2000)*
N3	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	380 (340 — 420) *1250 (1200 — 1300)*
N11	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0050 *0,00020*	0.0075 *0,00030*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.046 *0,0018*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	510 (440 — 580) *1675 (1500 — 1900)*
S11	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860 — 1000)*
S12	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	225 (200 — 250) *740 (660 — 820)*
S13	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (160 — 200) *570 (530 — 650)*
H3	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90 — 140) *395 (300 — 450)*
H5	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
H7	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90 — 140) *395 (300 — 450)*
H8	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
H11	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 360) *1075 (960 — 1100)*
H12	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (270 — 330) *970 (890 — 1000)*
H21	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
H31	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	195 (170 — 210) *640 (560 — 680)*
GR1	A	0.500 *0,500*	0.50 *0,50*	0.0030 *0,00012*	0.0044 *0,00017*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	405 (350 — 460) *1325 (1200 — 1500)*

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JME542 Nutfräsen

SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	255 (230 — 280)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*840 (760 — 910)*
P2	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	250 (230 — 270)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*820 (760 — 880)*
P3	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	215 (200 — 230)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*710 (660 — 750)*
P4	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 650)*
P5	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (560 — 650)*
P6	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	200 (180 — 220)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*660 (600 — 720)*
P7	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 210)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 680)*
P8	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (560 — 650)*
P11	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	185 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*610 (560 — 650)*
P12	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.022	0.022	0.026	0.028	110 (98 — 120)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00085*	*0,00085*	*0,0010*	*0,0011*	*360 (330 — 390)*
M1	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	135 (120 — 160)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*445 (400 — 520)*
M2	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (91 — 130)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (300 — 420)*
M3	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (91 — 130)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (300 — 420)*
M4	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.036	80 (68 — 97)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0014*	*260 (230 — 310)*
M5	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.036	70 (57 — 81)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0014*	*230 (190 — 260)*
N1	E/M/A	0.24	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	400 (350 — 440)
		0,24	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*1300 (1200 — 1400)*
N2	E/M/A	0.24	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	400 (350 — 440)
		0,24	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*1300 (1200 — 1400)*
N3	E/M/A	0.24	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	265 (240 — 290)
		0,24	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*870 (790 — 950)*
N11	E/M/A	0.24	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.048	0.050	350 (300 — 400)
		0,24	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0019*	*0,0020*	*1150 (990 — 1300)*
S11	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (160 — 200)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (530 — 650)*
S12	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	140 (120 — 150)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*460 (400 — 490)*
S13	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.036	110 (93 — 120)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0014*	*360 (310 — 390)*
H3	M/A	0.095	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.022	0.024	0.030	0.036	80 (61 — 100)
		0,095	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*260 (210 — 320)*
H5	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H7	M/A	0.095	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.022	0.024	0.030	0.036	80 (61 — 100)
		0,095	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*260 (210 — 320)*
H8	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H11	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	205 (180 — 230)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*670 (600 — 750)*
H12	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 210)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 680)*
H21	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H31	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.036	120 (110 — 130)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0014*	*395 (370 — 420)*
GR1	A	0.50	0.0020	0.0030	0.0040	0.0050	0.0060	0.0080	0.010	0.012	0.018	0.020	0.025	0.030	350 (300 — 400)
		0,50	*0,000080*	*0,00012*	*0,00016*	*0,00020*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00070*	*0,00080*	*0,0010*	*0,0012*	*1150 (990 — 1300)*

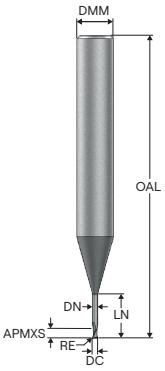
Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JME562

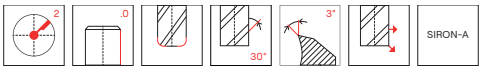
Mini – Universell – Eckfräser – 2 Schneiden – DMM 6 – Zylindrisch – Eckenradius





G

—Toleranzen:
—Rundlaufabweichung = <0,007 mm
—DMM= h5
—DC= 0,-0,013 mm
—RE= ±0,005 mm



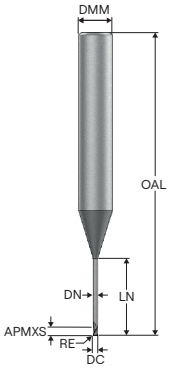
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
JME562005G2R005.0Z2-SIRA	03171145	2	G	0,5	6,0	0,8	50,0	1,5	0,46	0,05	13,48	2	Cylindrical	■
JME562006G2R005.0Z2-SIRA	03171146	2	G	0,6	6,0	0,9	50,0	2,0	0,56	0,05	12,9	2	Cylindrical	■
JME562008G2R005.0Z2-SIRA	03171147	2	G	0,8	6,0	1,2	50,0	2,5	0,76	0,05	12,28	2	Cylindrical	■
JME562010G2R010.0Z2-SIRA	03171148	2	G	1,0	6,0	1,5	50,0	4,0	0,95	0,1	10,85	2	Cylindrical	■
JME562012G2R010.0Z2-SIRA	03171150	2	G	1,2	6,0	1,8	50,0	4,5	1,15	0,1	10,31	2	Cylindrical	■
JME562015G2R015.0Z2-SIRA	03171151	2	G	1,5	6,0	2,3	50,0	5,0	1,45	0,15	9,67	2	Cylindrical	■
JME562018G2R015.0Z2-SIRA	03171152	2	G	1,8	6,0	2,7	50,0	5,4	1,75	0,15	9,12	2	Cylindrical	■
JME562020G2R015.0Z2-SIRA	03171153	2	G	2,0	6,0	3,0	50,0	6,0	1,94	0,15	8,53	2	Cylindrical	■
JME562025G2R015.0Z2-SIRA	03171154	2	G	2,5	6,0	3,8	60,0	7,5	2,4	0,15	7,15	2	Cylindrical	■
JME562030G2R015.0Z2-SIRA	03171155	2	G	3,0	6,0	4,5	60,0	9,0	2,85	0,15	5,81	2	Cylindrical	■
JME562005G4R005.0Z2-SIRA	03171156	4	G	0,5	6,0	0,8	50,0	3,5	0,46	0,05	11,54	2	Cylindrical	■
JME562006G4R005.0Z2-SIRA	03171157	4	G	0,6	6,0	0,9	50,0	4,2	0,56	0,05	10,93	2	Cylindrical	■
JME562008G4R005.0Z2-SIRA	03171158	4	G	0,8	6,0	1,2	50,0	5,6	0,76	0,05	9,81	2	Cylindrical	■
JME562010G4R010.0Z2-SIRA	03171159	4	G	1,0	6,0	1,5	50,0	7,0	0,95	0,1	8,86	2	Cylindrical	■
JME562012G4R010.0Z2-SIRA	03171160	4	G	1,2	6,0	1,8	50,0	8,4	1,15	0,1	8,0	2	Cylindrical	■
JME562015G4R015.0Z2-SIRA	03171162	4	G	1,5	6,0	2,3	50,0	10,5	1,45	0,15	6,86	2	Cylindrical	■
JME562020G4R015.0Z2-SIRA	03171163	4	G	2,0	6,0	3,0	60,0	14,0	1,94	0,15	5,36	2	Cylindrical	■
JME562030G4R015.0Z2-SIRA	03171165	4	G	3,0	6,0	4,5	70,0	21,0	2,85	0,15	3,22	2	Cylindrical	■
JME562005G5R005.0Z2-SIRA	03171166	5	G	0,5	6,0	0,8	50,0	5,0	0,46	0,05	10,42	2	Cylindrical	■
JME562006G5R005.0Z2-SIRA	03171167	5	G	0,6	6,0	0,9	50,0	6,0	0,56	0,05	9,71	2	Cylindrical	■
JME562008G5R005.0Z2-SIRA	03171168	5	G	0,8	6,0	1,2	50,0	8,0	0,76	0,05	8,48	2	Cylindrical	■
JME562010G5R010.0Z2-SIRA	03171169	5	G	1,0	6,0	1,5	50,0	10,0	0,95	0,1	7,48	2	Cylindrical	■
JME562012G5R010.0Z2-SIRA	03171170	5	G	1,2	6,0	1,8	50,0	12,0	1,15	0,1	6,62	2	Cylindrical	■
JME562015G5R015.0Z2-SIRA	03171171	5	G	1,5	6,0	2,3	60,0	15,0	1,45	0,15	5,54	2	Cylindrical	■
JME562020G5R015.0Z2-SIRA	03171172	5	G	2,0	6,0	3,0	60,0	20,0	1,94	0,15	4,19	2	Cylindrical	■
JME562030G5R015.0Z2-SIRA	03171174	5	G	3,0	6,0	4,5	70,0	30,0	2,85	0,15	2,41	2	Cylindrical	■

■ **Lagerstandard.**

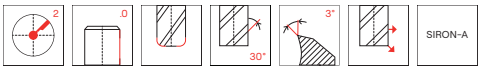
JME562

Mini – Universell – Eckfräser – 2 Schneiden – DMM 6 – Zylindrisch – Eckenradius





G



– Toleranzen:
– Rundlaufabweichung = <0,007 mm
– DMM= h5
– DC= 0,-0,013 mm
– RE= ±0,005 mm

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
JME562010G6R010.0Z2-SIRA	03171175	6	G	1,0	6,0	1,5	60,0	15,0	0,95	0,1	5,94	2	Cylindrical	■
JME562012G6R010.0Z2-SIRA	03171176	6	G	1,2	6,0	1,8	60,0	18,0	1,15	0,1	5,14	2	Cylindrical	■
JME562015G6R015.0Z2-SIRA	03171177	6	G	1,5	6,0	2,3	70,0	22,5	1,45	0,15	4,2	2	Cylindrical	■
JME562020G6R015.0Z2-SIRA	03171178	6	G	2,0	6,0	3,0	80,0	30,0	1,94	0,15	3,07	2	Cylindrical	■
JME562030G6R015.0Z2-SIRA	03171180	6	G	3,0	6,0	4,5	90,0	45,0	2,85	0,15	1,7	2	Cylindrical	■
JME562010G7R010.0Z2-SIRA	03171181	7	G	1,0	6,0	1,5	60,0	20,0	0,95	0,1	4,93	2	Cylindrical	■
JME562012G7R010.0Z2-SIRA	03171182	7	G	1,2	6,0	1,8	80,0	24,0	1,15	0,1	4,2	2	Cylindrical	■
JME562015G7R015.0Z2-SIRA	03171183	7	G	1,5	6,0	2,3	80,0	30,0	1,45	0,15	3,38	2	Cylindrical	■
JME562020G7R015.0Z2-SIRA	03171184	7	G	2,0	6,0	3,0	80,0	40,0	1,94	0,15	2,42	2	Cylindrical	■
JME562030G7R015.0Z2-SIRA	03171186	7	G	3,0	6,0	4,5	100,0	60,0	2,85	0,15	1,31	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JME562 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	415 (370 — 460) *1350 (1300 — 1500)*
P2	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	405 (360 — 440) *1325 (1200 — 1400)*
P3	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	350 (310 — 380) *1150 (1100 — 1200)*
P4	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	305 (280 — 340) *1000 (920 — 1100)*
P5	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 320) *950 (860 — 1000)*
P6	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	330 (300 — 360) *1075 (990 — 1100)*
P7	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	310 (280 — 340) *1025 (920 — 1100)*
P8	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 320) *950 (860 — 1000)*
P11	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	300 (270 — 330) *980 (890 — 1000)*
P12	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (160 — 190) *570 (530 — 620)*
M1	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (190 — 260) *720 (630 — 850)*
M2	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	180 (150 — 210) *590 (500 — 680)*
M3	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	180 (150 — 210) *590 (500 — 680)*
M4	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	135 (110 — 150) *445 (370 — 490)*
M5	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	110 (92 — 130) *360 (310 — 420)*
N1	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	570 (500 — 640) *1875 (1700 — 2000)*
N2	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	570 (500 — 640) *1875 (1700 — 2000)*
N3	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	380 (340 — 420) *1250 (1200 — 1300)*
N11	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0050 *0,00020*	0.0075 *0,00030*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.046 *0,0018*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	510 (440 — 580) *1675 (1500 — 1900)*
S11	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860 — 1000)*
S12	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	225 (200 — 250) *740 (660 — 820)*
S13	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (160 — 200) *570 (530 — 650)*
H3	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90 — 140) *395 (300 — 450)*
H5	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
H7	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90 — 140) *395 (300 — 450)*
H8	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
H11	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 360) *1075 (960 — 1100)*
H12	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (270 — 330) *970 (890 — 1000)*
H21	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
H31	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	195 (170 — 210) *640 (560 — 680)*
GR1	A	0.500 *0,500*	0.50 *0,50*	0.0030 *0,00012*	0.0044 *0,00017*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	405 (350 — 460) *1325 (1200 — 1500)*

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JME562 Nutfräsen

SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	255 (230 — 280) *840 (760 — 910)*
P2	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	250 (230 — 270) *820 (760 — 880)*
P3	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	215 (200 — 230) *710 (660 — 750)*
P4	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 200) *620 (560 — 650)*
P5	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P6	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	200 (180 — 220) *660 (600 — 720)*
P7	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 210) *620 (560 — 680)*
P8	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P11	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	185 (170 — 200) *610 (560 — 650)*
P12	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.022 *0,00085*	0.026 *0,0010*	0.028 *0,0011*	110 (98 — 120) *360 (330 — 390)*
M1	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	135 (120 — 160) *445 (400 — 520)*
M2	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (91 — 130) *360 (300 — 420)*
M3	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (91 — 130) *360 (300 — 420)*
M4	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	80 (68 — 97) *260 (230 — 310)*
M5	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	70 (57 — 81) *230 (190 — 260)*
N1	E/M/A	0.24 *0,24*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	400 (350 — 440) *1300 (1200 — 1400)*
N2	E/M/A	0.24 *0,24*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	400 (350 — 440) *1300 (1200 — 1400)*
N3	E/M/A	0.24 *0,24*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	265 (240 — 290) *870 (790 — 950)*
N11	E/M/A	0.24 *0,24*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.048 *0,0019*	0.050 *0,0020*	350 (300 — 400) *1150 (990 — 1300)*
S11	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (160 — 200) *590 (530 — 650)*
S12	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	140 (120 — 150) *460 (400 — 490)*
S13	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	110 (93 — 120) *360 (310 — 390)*
H3	M/A	0.095 *0,095*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (61 — 100) *260 (210 — 320)*
H5	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150 — 180) *520 (500 — 590)*
H7	M/A	0.095 *0,095*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (61 — 100) *260 (210 — 320)*
H8	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150 — 180) *520 (500 — 590)*
H11	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	205 (180 — 230) *670 (600 — 750)*
H12	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 210) *620 (560 — 680)*
H21	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150 — 180) *520 (500 — 590)*
H31	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	120 (110 — 130) *395 (370 — 420)*
GR1	A	0.50 *0,50*	0.0020 *0,000080*	0.0030 *0,00012*	0.0040 *0,00016*	0.0050 *0,00020*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.018 *0,00070*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	350 (300 — 400) *1150 (990 — 1300)*

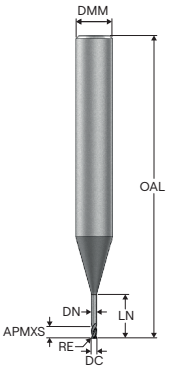
Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JME564

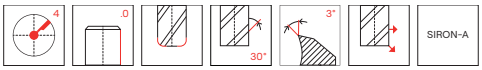
Mini – Universell – Eckfräser – 4 Schneiden – DMM 6 – Zylindrisch – Eckenradius





G

—Toleranzen:
—Rundlaufabweichung = <0-0,007 mm
—DMM= h5
—DC= 0,-0,013 mm
—RE= ±0,005 mm



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
JME564005G2R005.0Z4-SIRA	03227166	2	G	0,5	6,0	1,0	50,0	1,5	0,46	0,05	13,48	4	Cylindrical	■
JME564006G2R005.0Z4-SIRA	03227271	2	G	0,6	6,0	1,2	50,0	2,0	0,56	0,05	12,9	4	Cylindrical	■
JME564008G2R005.0Z4-SIRA	03171194	2	G	0,8	6,0	1,6	50,0	2,5	0,76	0,05	12,28	4	Cylindrical	■
JME564010G2R010.0Z4-SIRA	03171195	2	G	1,0	6,0	2,0	50,0	4,0	0,95	0,1	10,85	4	Cylindrical	■
JME564012G2R010.0Z4-SIRA	03171196	2	G	1,2	6,0	2,4	50,0	4,5	1,15	0,1	10,31	4	Cylindrical	■
JME564015G2R015.0Z4-SIRA	03171197	2	G	1,5	6,0	3,0	50,0	5,0	1,45	0,15	9,67	4	Cylindrical	■
JME564020G2R015.0Z4-SIRA	03171198	2	G	2,0	6,0	4,0	50,0	6,0	1,94	0,15	8,53	4	Cylindrical	■
JME564025G2R015.0Z4-SIRA	03171199	2	G	2,5	6,0	5,0	60,0	7,5	2,4	0,15	7,15	4	Cylindrical	■
JME564030G2R015.0Z4-SIRA	03171200	2	G	3,0	6,0	6,0	60,0	9,0	2,85	0,15	5,81	4	Cylindrical	■
JME564005G4R005.0Z4-SIRA	03171201	4	G	0,5	6,0	1,0	50,0	3,5	0,46	0,05	11,54	4	Cylindrical	■
JME564006G4R005.0Z4-SIRA	03171202	4	G	0,6	6,0	1,2	50,0	4,2	0,56	0,05	10,93	4	Cylindrical	■
JME564008G4R005.0Z4-SIRA	03171203	4	G	0,8	6,0	1,6	50,0	5,6	0,76	0,05	9,81	4	Cylindrical	■
JME564010G4R010.0Z4-SIRA	03171204	4	G	1,0	6,0	2,0	50,0	7,0	0,95	0,1	8,86	4	Cylindrical	■
JME564012G4R010.0Z4-SIRA	03171205	4	G	1,2	6,0	2,4	50,0	8,4	1,15	0,1	8,0	4	Cylindrical	■
JME564015G4R015.0Z4-SIRA	03171206	4	G	1,5	6,0	3,0	50,0	10,5	1,45	0,15	6,86	4	Cylindrical	■
JME564020G4R015.0Z4-SIRA	03171207	4	G	2,0	6,0	4,0	60,0	14,0	1,94	0,15	5,36	4	Cylindrical	■
JME564030G4R015.0Z4-SIRA	03171209	4	G	3,0	6,0	6,0	70,0	21,0	2,85	0,15	3,22	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JME564 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z									v_c
				0.5	0.6	0.8	1.0	1.2	1.5	2.0	2.5	3	
P1	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	395 (360 — 430) *1300 (1200 — 1400)*
P2	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	385 (350 — 420) *1275 (1200 — 1300)*
P3	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	330 (300 — 360) *1075 (990 — 1100)*
P4	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 320) *950 (860 — 1000)*
P5	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	280 (250 — 300) *920 (830 — 980)*
P6	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	310 (280 — 340) *1025 (920 — 1100)*
P7	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (270 — 320) *970 (890 — 1000)*
P8	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	280 (250 — 300) *920 (830 — 980)*
P11	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	285 (260 — 310) *940 (860 — 1000)*
P12	M/E/A	0.0500 *0,0500*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	170 (160 — 180) *560 (530 — 590)*
M1	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (200 — 280) *770 (660 — 910)*
M2	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	190 (160 — 220) *620 (530 — 720)*
M3	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	190 (160 — 220) *620 (530 — 720)*
M4	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	145 (120 — 160) *475 (400 — 520)*
M5	E/M/A	0.0250 *0,0250*	0.50 *0,50*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	120 (99 — 140) *395 (330 — 450)*
N1	E/M/A	0.100 *0,100*	0.90 *0,90*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	550 (490 — 610) *1800 (1700 — 2000)*
N2	E/M/A	0.100 *0,100*	0.90 *0,90*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	550 (490 — 610) *1800 (1700 — 2000)*
N3	E/M/A	0.100 *0,100*	0.90 *0,90*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	365 (330 — 410) *1200 (1100 — 1300)*
N11	E/M/A	0.100 *0,100*	0.90 *0,90*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	490 (430 — 560) *1600 (1500 — 1800)*
S11	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	285 (250 — 320) *940 (830 — 1000)*
S12	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (190 — 250) *720 (630 — 820)*
S13	E/M/A	0.0500 *0,0500*	0.60 *0,60*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	170 (150 — 190) *560 (500 — 620)*
H3	M/A	0.0500 *0,0500*	0.060 *0,060*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.038 *0,0015*	0.042 *0,0017*	125 (95 — 150) *410 (320 — 490)*
H5	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	240 (210 — 260) *790 (690 — 850)*
H7	M/A	0.0500 *0,0500*	0.060 *0,060*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.038 *0,0015*	0.042 *0,0017*	125 (95 — 150) *410 (320 — 490)*
H8	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.055 *0,0022*	240 (210 — 260) *790 (690 — 850)*
H11	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	305 (270 — 340) *1000 (890 — 1100)*
H12	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.055 *0,0022*	275 (250 — 310) *900 (830 — 1000)*
H21	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.055 *0,0022*	240 (210 — 260) *790 (690 — 850)*
H31	M/A	0.0500 *0,0500*	0.28 *0,28*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.048 *0,0019*	180 (160 — 200) *590 (530 — 650)*
GR1	A	0.500 *0,500*	0.65 *0,50*	0.0075 *0,00030*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00085*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	390 (340 — 440) *1300 (1200 — 1400)*

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JME564 Nutfräsen

SMG		a_p/DC	f_z									v_c
			0.5	0.6	0.8	1.0	1.2	1.5	2.0	2.5	3	
P1	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	250 (230 — 270) *820 (760 — 880)*
P2	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	245 (220 — 270) *800 (730 — 880)*
P3	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	210 (190 — 230) *690 (630 — 750)*
P4	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	185 (170 — 200) *610 (560 — 650)*
P5	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	175 (160 — 190) *570 (530 — 620)*
P6	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	200 (180 — 220) *660 (600 — 720)*
P7	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	185 (170 — 200) *610 (560 — 650)*
P8	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	175 (160 — 190) *570 (530 — 620)*
P11	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P12	M/E/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.024 *0,00095*	0.026 *0,0010*	0.030 *0,0012*	105 (96 — 110) *345 (320 — 360)*
M1	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	135 (110 — 150) *445 (370 — 490)*
M2	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (89 — 120) *360 (300 — 390)*
M3	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (89 — 120) *360 (300 — 390)*
M4	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	80 (67 — 95) *260 (220 — 310)*
M5	E/M/A	0.038 *0,038*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	65 (56 — 79) *215 (190 — 250)*
N1	E/M/A	0.15 *0,15*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	390 (350 — 440) *1275 (1200 — 1400)*
N2	E/M/A	0.15 *0,15*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	390 (350 — 440) *1275 (1200 — 1400)*
N3	E/M/A	0.15 *0,15*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	260 (230 — 290) *850 (760 — 950)*
N11	E/M/A	0.15 *0,15*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.048 *0,0019*	0.055 *0,0022*	345 (300 — 390) *1125 (990 — 1200)*
S11	E/M/A	0.11 *0,11*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (160 — 200) *590 (530 — 650)*
S12	E/M/A	0.11 *0,11*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	135 (120 — 150) *445 (400 — 490)*
S13	E/M/A	0.11 *0,11*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	105 (92 — 120) *345 (310 — 390)*
H3	M/A	0.0060 *0,0060*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (59 — 98) *260 (200 — 320)*
H5	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (140 — 170) *520 (460 — 550)*
H7	M/A	0.0060 *0,0060*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (59 — 98) *260 (200 — 320)*
H8	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.032 *0,0013*	160 (140 — 170) *520 (460 — 550)*
H11	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	200 (180 — 220) *660 (600 — 720)*
H12	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.032 *0,0013*	185 (170 — 200) *610 (560 — 650)*
H21	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.032 *0,0013*	160 (140 — 170) *520 (460 — 550)*
H31	M/A	0.020 *0,020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.025 *0,0010*	0.028 *0,0011*	120 (110 — 130) *395 (370 — 420)*
GR1	A	0.20 *0,20*	0.0050 *0,00020*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.024 *0,00095*	0.026 *0,0010*	325 (280 — 370) *1075 (920 — 1200)*

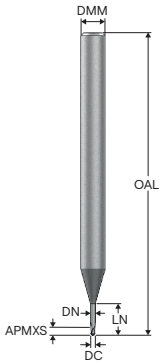
Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

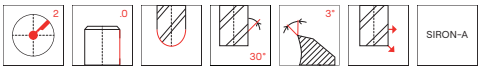
JMB542

Mini – Universell – Kugelkopf – 2 Schneiden – DMM 4 – Zylindrisch





G



– Toleranzen:
– Rundlaufabweichung =<0,007 mm
– DMM= h5
– DC= 0,-0,01 mm
– RE= ±0,005 mm

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
JMB542002G1B.0Z2-SIRA	03171221	1	G	0,2	4,0	0,2	45,0	0,4	0,18	0,1	14,57	2	Cylindrical	■
JMB542003G1B.0Z2-SIRA	03171222	1	G	0,3	4,0	0,3	45,0	0,6	0,28	0,15	14,24	2	Cylindrical	■
JMB542004G1B.0Z2-SIRA	03171223	1	G	0,4	4,0	0,4	45,0	0,8	0,37	0,2	13,81	2	Cylindrical	■
JMB542005G1B.0Z2-SIRA	03171224	1	G	0,5	4,0	0,5	45,0	1,0	0,46	0,25	13,47	2	Cylindrical	■
JMB542006G1B.0Z2-SIRA	03171225	1	G	0,6	4,0	0,6	45,0	1,2	0,56	0,3	13,14	2	Cylindrical	■
JMB542008G1B.0Z2-SIRA	03171226	1	G	0,8	4,0	0,8	45,0	1,6	0,76	0,4	12,46	2	Cylindrical	■
JMB542010G1B.0Z2-SIRA	03171228	1	G	1,0	4,0	1,0	50,0	2,0	0,95	0,5	11,77	2	Cylindrical	■
JMB542012G1B.0Z2-SIRA	03171229	1	G	1,2	4,0	1,2	50,0	2,4	1,15	0,6	11,07	2	Cylindrical	■
JMB542015G1B.0Z2-SIRA	03171230	1	G	1,5	4,0	1,5	50,0	3,0	1,45	0,75	9,88	2	Cylindrical	■
JMB542005G3B.0Z2-SIRA	03171231	3	G	0,5	4,0	0,5	45,0	2,5	0,46	0,25	11,25	2	Cylindrical	■
JMB542006G3B.0Z2-SIRA	03171233	3	G	0,6	4,0	0,6	45,0	3,0	0,56	0,3	10,61	2	Cylindrical	■
JMB542008G3B.0Z2-SIRA	03171234	3	G	0,8	4,0	0,8	45,0	4,0	0,76	0,4	9,44	2	Cylindrical	■
JMB542010G3B.0Z2-SIRA	03171235	3	G	1,0	4,0	1,0	50,0	5,0	0,95	0,5	8,38	2	Cylindrical	■
JMB542012G3B.0Z2-SIRA	03171236	3	G	1,2	4,0	1,2	50,0	6,0	1,15	0,6	7,44	2	Cylindrical	■
JMB542015G3B.0Z2-SIRA	03171237	3	G	1,5	4,0	1,5	50,0	7,5	1,45	0,75	6,13	2	Cylindrical	■
JMB542020G3B.0Z2-SIRA	03171238	3	G	2,0	4,0	2,0	50,0	10,0	1,94	1,0	4,4	2	Cylindrical	■
JMB542030G3B.0Z2-SIRA	03171240	3	G	3,0	4,0	3,0	60,0	15,0	2,85	1,5	1,81	2	Cylindrical	■
JMB542005G4B.0Z2-SIRA	03171241	4	G	0,5	4,0	0,5	45,0	4,0	0,46	0,25	9,65	2	Cylindrical	■
JMB542006G4B.0Z2-SIRA	03171242	4	G	0,6	4,0	0,6	45,0	5,0	0,56	0,3	8,74	2	Cylindrical	■
JMB542008G4B.0Z2-SIRA	03171243	4	G	0,8	4,0	0,8	45,0	7,0	0,76	0,4	7,23	2	Cylindrical	■
JMB542010G4B.0Z2-SIRA	03171244	4	G	1,0	4,0	1,0	50,0	8,5	0,95	0,5	6,27	2	Cylindrical	■
JMB542012G4B.0Z2-SIRA	03171245	4	G	1,2	4,0	1,2	50,0	10,0	1,15	0,6	5,44	2	Cylindrical	■
JMB542015G4B.0Z2-SIRA	03171246	4	G	1,5	4,0	1,5	50,0	12,0	1,45	0,75	4,44	2	Cylindrical	■
JMB542020G4B.0Z2-SIRA	03171247	4	G	2,0	4,0	2,0	60,0	16,0	1,94	1,0	3,02	2	Cylindrical	■
JMB542030G4B.0Z2-SIRA	03171249	4	G	3,0	4,0	3,0	70,0	24,0	2,85	1,5	1,16	2	Cylindrical	■
JMB542015G5B.0Z2-SIRA	03171250	5	G	1,5	4,0	1,5	60,0	15,0	1,45	0,75	3,75	2	Cylindrical	■
JMB542020G5B.0Z2-SIRA	03171251	5	G	2,0	4,0	2,0	60,0	20,0	1,94	1,0	2,5	2	Cylindrical	■
JMB542030G5B.0Z2-SIRA	03171253	5	G	3,0	4,0	3,0	70,0	30,0	2,85	1,5	0,93	2	Cylindrical	■
JMB542015G6B.0Z2-SIRA	03171254	6	G	1,5	4,0	1,5	70,0	22,5	1,45	0,75	2,7	2	Cylindrical	■
JMB542020G6B.0Z2-SIRA	03171255	6	G	2,0	4,0	2,0	70,0	30,0	1,94	1,0	1,74	2	Cylindrical	■
JMB542030G6B.0Z2-SIRA	03171257	6	G	3,0	4,0	3,0	90,0	45,0	2,85	1,5	0,63	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JMB542 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z											v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	365 (330 — 400) *1200 (1100 — 1300)*
P2	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	355 (320 — 390) *1175 (1100 — 1200)*
P3	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	305 (280 — 330) *1000 (920 — 1000)*
P4	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	270 (240 — 290) *890 (790 — 950)*
P5	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
P6	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 310) *950 (860 — 1000)*
P7	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	270 (250 — 300) *890 (830 — 980)*
P8	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
P11	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	265 (240 — 290) *870 (790 — 950)*
P12	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	155 (140 — 170) *510 (460 — 550)*
M1	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	215 (180 — 250) *710 (600 — 820)*
M2	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 200) *570 (500 — 650)*
M3	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 200) *570 (500 — 650)*
M4	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	130 (110 — 150) *425 (370 — 490)*
M5	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	110 (90 — 120) *360 (300 — 390)*
N1	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	485 (430 — 540) *1600 (1500 — 1700)*
N2	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	485 (430 — 540) *1600 (1500 — 1700)*
N3	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 360) *1075 (960 — 1100)*
N11	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0050 *0,00020*	0.0075 *0,00030*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.046 *0,0018*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	430 (370 — 480) *1400 (1300 — 1500)*
S11	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (250 — 330) *950 (830 — 1000)*
S12	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	225 (200 — 250) *740 (660 — 820)*
S13	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 190) *570 (500 — 620)*
H3	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90 — 140) *395 (300 — 450)*
H5	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H7	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90 — 140) *395 (300 — 450)*
H8	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H11	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	300 (270 — 330) *980 (890 — 1000)*
H12	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	275 (240 — 300) *900 (790 — 980)*
H21	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H31	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	180 (160 — 200) *590 (530 — 650)*
GR1	A	0.500 *0,500*	0.50 *0,50*	0.0030 *0,00012*	0.0044 *0,00017*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.028 *0,0011*	0.030 *0,0012*	0.038 *0,0015*	0.040 *0,0016*	405 (350 — 460) *1325 (1200 — 1500)*

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JMB542 Nutfräsen

SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	255 (230 — 280) *840 (760 — 910)*
P2	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	250 (230 — 270) *820 (760 — 880)*
P3	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	215 (200 — 230) *710 (660 — 750)*
P4	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 200) *620 (560 — 650)*
P5	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P6	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	200 (180 — 220) *660 (600 — 720)*
P7	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 210) *620 (560 — 680)*
P8	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (170 — 200) *590 (560 — 650)*
P11	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	185 (170 — 200) *610 (560 — 650)*
P12	M/E/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (98 — 120) *360 (330 — 390)*
M1	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	135 (120 — 160) *445 (400 — 520)*
M2	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (90 — 130) *360 (300 — 420)*
M3	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	110 (90 — 130) *360 (300 — 420)*
M4	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	80 (68 — 97) *260 (230 — 310)*
M5	E/M/A	0.32 *0,32*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	70 (57 — 81) *230 (190 — 260)*
N1	E/M/A	0.24 *0,24*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	400 (350 — 440) *1300 (1200 — 1400)*
N2	E/M/A	0.26 *0,26*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	400 (350 — 440) *1300 (1200 — 1400)*
N3	E/M/A	0.26 *0,26*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	265 (240 — 290) *870 (790 — 950)*
N11	E/M/A	0.24 *0,24*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	350 (300 — 390) *1150 (990 — 1200)*
S11	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	180 (160 — 200) *590 (530 — 650)*
S12	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	140 (120 — 150) *460 (400 — 490)*
S13	E/M/A	0.36 *0,36*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	105 (93 — 120) *345 (310 — 390)*
H3	M/A	0.10 *0,10*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (61 — 100) *260 (210 — 320)*
H5	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150 — 180) *520 (500 — 590)*
H7	M/A	0.10 *0,10*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	80 (61 — 100) *260 (210 — 320)*
H8	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150 — 180) *520 (500 — 590)*
H11	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	205 (180 — 230) *670 (600 — 750)*
H12	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	190 (170 — 210) *620 (560 — 680)*
H21	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	160 (150 — 180) *520 (500 — 590)*
H31	M/A	0.20 *0,20*	0.0026 *0,00010*	0.0040 *0,00016*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.024 *0,00095*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	120 (110 — 130) *395 (370 — 420)*
GR1	A	0.50 *0,50*	0.0020 *0,000080*	0.0030 *0,00012*	0.0040 *0,00016*	0.0050 *0,00020*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.018 *0,00070*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	350 (300 — 390) *1150 (990 — 1200)*

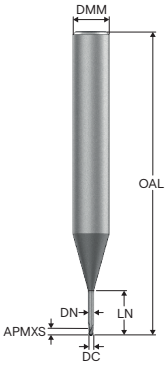
Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JMB562

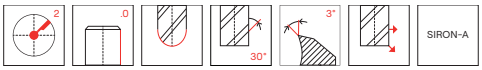
Mini – Universell – Kugelkopf – 2 Schneiden – DMM 6 – Zylindrisch





G

—Toleranzen:
—Rundlaufabweichung =<0,007 mm
—DMM= h5
—DC= 0,-0,01 mm
—RE= ±0,005 mm



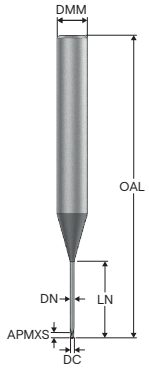
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
JMB562005G2B.0Z2-SIRA	03171261	2	G	0,5	6,0	0,5	50,0	1,5	0,46	0,25	13,69	2	Cylindrical	■
JMB562006G2B.0Z2-SIRA	03171262	2	G	0,6	6,0	0,6	50,0	2,0	0,56	0,3	13,13	2	Cylindrical	■
JMB562008G2B.0Z2-SIRA	03171263	2	G	0,8	6,0	0,8	50,0	2,5	0,76	0,4	12,6	2	Cylindrical	■
JMB562010G2B.0Z2-SIRA	03171264	2	G	1,0	6,0	1,0	50,0	4,0	0,95	0,5	11,15	2	Cylindrical	■
JMB562012G2B.0Z2-SIRA	03171265	2	G	1,2	6,0	1,2	50,0	4,5	1,15	0,6	10,67	2	Cylindrical	■
JMB562015G2B.0Z2-SIRA	03171266	2	G	1,5	6,0	1,5	50,0	5,0	1,45	0,75	10,07	2	Cylindrical	■
JMB562018G2B.0Z2-SIRA	03171267	2	G	1,8	6,0	1,8	50,0	5,4	1,75	0,9	9,61	2	Cylindrical	■
JMB562020G2B.0Z2-SIRA	03171268	2	G	2,0	6,0	2,0	50,0	6,0	1,94	1,0	9,05	2	Cylindrical	■
JMB562025G2B.0Z2-SIRA	03171269	2	G	2,5	6,0	2,5	60,0	7,5	2,4	1,25	7,71	2	Cylindrical	■
JMB562030G2B.0Z2-SIRA	03171270	2	G	3,0	6,0	3,0	60,0	9,0	2,85	1,5	6,35	2	Cylindrical	■
JMB562005G4B.0Z2-SIRA	03171271	4	G	0,5	6,0	0,5	50,0	3,5	0,46	0,25	11,7	2	Cylindrical	■
JMB562006G4B.0Z2-SIRA	03171272	4	G	0,6	6,0	0,6	50,0	4,2	0,56	0,3	11,1	2	Cylindrical	■
JMB562008G4B.0Z2-SIRA	03171273	4	G	0,8	6,0	0,8	50,0	5,6	0,76	0,4	10,02	2	Cylindrical	■
JMB562010G4B.0Z2-SIRA	03171274	4	G	1,0	6,0	1,0	50,0	7,0	0,95	0,5	9,06	2	Cylindrical	■
JMB562012G4B.0Z2-SIRA	03171275	4	G	1,2	6,0	1,2	50,0	8,4	1,15	0,6	8,22	2	Cylindrical	■
JMB562015G4B.0Z2-SIRA	03171276	4	G	1,5	6,0	1,5	50,0	10,5	1,45	0,75	7,07	2	Cylindrical	■
JMB562020G4B.0Z2-SIRA	03171277	4	G	2,0	6,0	2,0	60,0	14,0	1,94	1,0	5,57	2	Cylindrical	■
JMB562030G4B.0Z2-SIRA	03171279	4	G	3,0	6,0	3,0	70,0	21,0	2,85	1,5	3,38	2	Cylindrical	■
JMB562005G5B.0Z2-SIRA	03171280	5	G	0,5	6,0	0,5	50,0	5,0	0,46	0,25	10,54	2	Cylindrical	■
JMB562006G5B.0Z2-SIRA	03171281	5	G	0,6	6,0	0,6	50,0	6,0	0,56	0,3	9,85	2	Cylindrical	■
JMB562008G5B.0Z2-SIRA	03171282	5	G	0,8	6,0	0,8	50,0	8,0	0,76	0,4	8,64	2	Cylindrical	■
JMB562010G5B.0Z2-SIRA	03171283	5	G	1,0	6,0	1,0	50,0	10,0	0,95	0,5	7,63	2	Cylindrical	■
JMB562012G5B.0Z2-SIRA	03171284	5	G	1,2	6,0	1,2	50,0	12,0	1,15	0,6	6,77	2	Cylindrical	■
JMB562015G5B.0Z2-SIRA	03171285	5	G	1,5	6,0	1,5	60,0	15,0	1,45	0,75	5,68	2	Cylindrical	■
JMB562020G5B.0Z2-SIRA	03171287	5	G	2,0	6,0	2,0	60,0	20,0	1,94	1,0	4,32	2	Cylindrical	■
JMB562030G5B.0Z2-SIRA	03171289	5	G	3,0	6,0	3,0	70,0	30,0	2,85	1,5	2,5	2	Cylindrical	■

■ **Lagerstandard.**

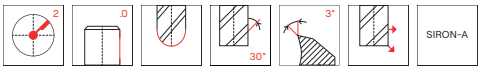
JMB562

Mini – Universell – Kugelkopf – 2 Schneiden – DMM 6 – Zylindrisch





G



—Toleranzen:
—Rundlaufabweichung =<0,007 mm
—DMM= h5
—DC= 0,-0,01 mm
—RE= ±0,005 mm

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
JMB562010G6B.0Z2-SIRA	03171290	6	G	1,0	6,0	1,0	60,0	15,0	0,95	0,5	6,04	2	Cylindrical	■
JMB562012G6B.0Z2-SIRA	03171291	6	G	1,2	6,0	1,2	60,0	18,0	1,15	0,6	5,24	2	Cylindrical	■
JMB562015G6B.0Z2-SIRA	03171292	6	G	1,5	6,0	1,5	70,0	22,5	1,45	0,75	4,28	2	Cylindrical	■
JMB562020G6B.0Z2-SIRA	03171293	6	G	2,0	6,0	2,0	80,0	30,0	1,94	1,0	3,14	2	Cylindrical	■
JMB562030G6B.0Z2-SIRA	03171295	6	G	3,0	6,0	3,0	90,0	45,0	2,85	1,5	1,74	2	Cylindrical	■
JMB562010G7B.0Z2-SIRA	03171296	7	G	1,0	6,0	1,0	60,0	20,0	0,95	0,5	4,99	2	Cylindrical	■
JMB562012G7B.0Z2-SIRA	03171297	7	G	1,2	6,0	1,2	80,0	24,0	1,15	0,6	4,27	2	Cylindrical	■
JMB562015G7B.0Z2-SIRA	03171298	7	G	1,5	6,0	1,5	80,0	30,0	1,45	0,75	3,43	2	Cylindrical	■
JMB562020G7B.0Z2-SIRA	03171299	7	G	2,0	6,0	2,0	80,0	40,0	1,94	1,0	2,47	2	Cylindrical	■
JMB562030G7B.0Z2-SIRA	03171301	7	G	3,0	6,0	3,0	100,0	60,0	2,85	1,5	1,34	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JMB562 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z											v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	365 (330 — 400) *1200 (1100 — 1300)*
P2	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	355 (320 — 390) *1175 (1100 — 1200)*
P3	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	305 (280 — 330) *1000 (920 — 1000)*
P4	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	270 (240 — 290) *890 (790 — 950)*
P5	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
P6	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (260 — 310) *950 (860 — 1000)*
P7	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	270 (250 — 300) *890 (830 — 980)*
P8	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	255 (230 — 280) *840 (760 — 910)*
P11	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	265 (240 — 290) *870 (790 — 950)*
P12	M/E/A	0.0500 *0,0500*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	155 (140 — 170) *510 (460 — 550)*
M1	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	215 (180 — 250) *710 (600 — 820)*
M2	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 200) *570 (500 — 650)*
M3	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 200) *570 (500 — 650)*
M4	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	130 (110 — 150) *425 (370 — 490)*
M5	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	110 (90 — 120) *360 (300 — 390)*
N1	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	485 (430 — 540) *1600 (1500 — 1700)*
N2	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	485 (430 — 540) *1600 (1500 — 1700)*
N3	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 360) *1075 (960 — 1100)*
N11	E/M/A	0.100 *0,100*	0.75 *0,75*	0.0050 *0,00020*	0.0075 *0,00030*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.046 *0,0018*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	430 (370 — 480) *1400 (1300 — 1500)*
S11	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	290 (250 — 330) *950 (830 — 1000)*
S12	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	225 (200 — 250) *740 (660 — 820)*
S13	E/M/A	0.0250 *0,0250*	0.60 *0,60*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	175 (150 — 190) *570 (500 — 620)*
H3	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90 — 140) *395 (300 — 450)*
H5	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H7	M/A	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	120 (90 — 140) *395 (300 — 450)*
H8	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H11	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	300 (270 — 330) *980 (890 — 1000)*
H12	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	275 (240 — 300) *900 (790 — 980)*
H21	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	235 (210 — 260) *770 (690 — 850)*
H31	M/A	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	180 (160 — 200) *590 (530 — 650)*
GR1	A	0.500 *0,500*	0.50 *0,50*	0.0030 *0,00012*	0.0044 *0,00017*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.028 *0,0011*	0.030 *0,0012*	0.038 *0,0015*	0.040 *0,0016*	405 (350 — 460) *1325 (1200 — 1500)*

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JMB562 Nutfräsen

SMG		a_p/DC	f_z												v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1.0	1.2	1.8	2.0	2.5	3.0	
P1	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	255 (230 — 280)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*840 (760 — 910)*
P2	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	250 (230 — 270)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*820 (760 — 880)*
P3	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	215 (200 — 230)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*710 (660 — 750)*
P4	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 650)*
P5	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (560 — 650)*
P6	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	200 (180 — 220)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*660 (600 — 720)*
P7	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 210)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 680)*
P8	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (560 — 650)*
P11	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	185 (170 — 200)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*610 (560 — 650)*
P12	M/E/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (98 — 120)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (330 — 390)*
M1	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	135 (120 — 160)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*445 (400 — 520)*
M2	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (90 — 130)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (300 — 420)*
M3	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	110 (90 — 130)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*360 (300 — 420)*
M4	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	80 (68 — 97)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*260 (230 — 310)*
M5	E/M/A	0.32	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	70 (57 — 81)
		0,32	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*230 (190 — 260)*
N1	E/M/A	0.24	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	400 (350 — 440)
		0,24	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*1300 (1200 — 1400)*
N2	E/M/A	0.26	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	400 (350 — 440)
		0,26	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*1300 (1200 — 1400)*
N3	E/M/A	0.26	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	265 (240 — 290)
		0,26	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*870 (790 — 950)*
N11	E/M/A	0.24	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.036	0.040	0.050	0.060	350 (300 — 390)
		0,24	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*1150 (990 — 1200)*
S11	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	180 (160 — 200)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*590 (530 — 650)*
S12	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	140 (120 — 150)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*460 (400 — 490)*
S13	E/M/A	0.36	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	105 (93 — 120)
		0,36	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*345 (310 — 390)*
H3	M/A	0.10	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.022	0.024	0.030	0.036	80 (61 — 100)
		0,10	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*260 (210 — 320)*
H5	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H7	M/A	0.10	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.022	0.024	0.030	0.036	80 (61 — 100)
		0,10	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*260 (210 — 320)*
H8	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H11	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	205 (180 — 230)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*670 (600 — 750)*
H12	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	190 (170 — 210)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*620 (560 — 680)*
H21	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	160 (150 — 180)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*520 (500 — 590)*
H31	M/A	0.20	0.0026	0.0040	0.0050	0.0065	0.0080	0.010	0.013	0.016	0.024	0.026	0.032	0.040	120 (110 — 130)
		0,20	*0,00010*	*0,00016*	*0,00020*	*0,00026*	*0,00032*	*0,00040*	*0,00050*	*0,00065*	*0,00095*	*0,0010*	*0,0013*	*0,0016*	*395 (370 — 420)*
GR1	A	0.50	0.0020	0.0030	0.0040	0.0050	0.0060	0.0080	0.010	0.012	0.018	0.020	0.025	0.030	350 (300 — 390)
		0,50	*0,000080*	*0,00012*	*0,00016*	*0,00020*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00070*	*0,00080*	*0,0010*	*0,0012*	*1150 (990 — 1200)*

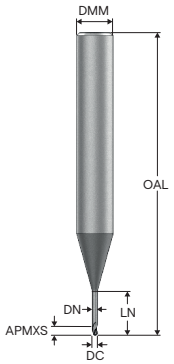
Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JMB563

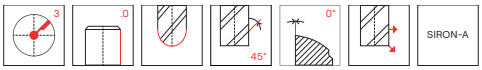
Mini – Universell – Kugelkopf – 3 Schneiden – DMM 6 – Zylindrisch





G

—Toleranzen:
—Rundlaufabweichung =<0,007 mm
—DMM= h5
—DC= 0,-0,02 mm
—RE= ±0,01 mm



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
JMB563010G2B.0Z3-SIRA	03171307	2	G	1,0	6,0	1,0	50,0	4,0	0,95	0,5	11,15	3	Cylindrical	■
JMB563012G2B.0Z3-SIRA	03171308	2	G	1,2	6,0	1,2	50,0	4,5	1,15	0,6	10,67	3	Cylindrical	■
JMB563015G2B.0Z3-SIRA	03171309	2	G	1,5	6,0	1,5	50,0	5,0	1,45	0,75	10,07	3	Cylindrical	■
JMB563020G2B.0Z3-SIRA	03171310	2	G	2,0	6,0	2,0	50,0	6,0	1,94	1,0	9,05	3	Cylindrical	■
JMB563025G2B.0Z3-SIRA	03171311	2	G	2,5	6,0	2,5	60,0	7,5	2,4	1,25	7,71	3	Cylindrical	■
JMB563030G2B.0Z3-SIRA	03171312	2	G	3,0	6,0	3,0	60,0	9,0	2,85	1,5	6,35	3	Cylindrical	■
JMB563010G4B.0Z3-SIRA	03171316	4	G	1,0	6,0	1,0	50,0	7,0	0,95	0,5	9,06	3	Cylindrical	■
JMB563012G4B.0Z3-SIRA	03171317	4	G	1,2	6,0	1,2	50,0	8,4	1,15	0,6	8,22	3	Cylindrical	■
JMB563015G4B.0Z3-SIRA	03171318	4	G	1,5	6,0	1,5	50,0	10,5	1,45	0,75	7,07	3	Cylindrical	■
JMB563020G4B.0Z3-SIRA	03171319	4	G	2,0	6,0	2,0	60,0	14,0	1,94	1,0	5,57	3	Cylindrical	■
JMB563030G4B.0Z3-SIRA	03171321	4	G	3,0	6,0	3,0	70,0	21,0	2,85	1,5	3,38	3	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JMB563 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z						v_c
				1	1.2	1.5	2.0	2.5	3.0	
P1	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	460 (410 — 500) *1500 (1400 — 1600)*
P2	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	445 (400 — 490) *1450 (1400 — 1600)*
P3	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	385 (350 — 420) *1275 (1200 — 1300)*
P4	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	340 (310 — 370) *1125 (1100 — 1200)*
P5	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 350) *1075 (960 — 1100)*
P6	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	365 (330 — 400) *1200 (1100 — 1300)*
P7	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	340 (310 — 380) *1125 (1100 — 1200)*
P8	M/E/A	0.0500 *0,0500*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	325 (290 — 350) *1075 (960 — 1100)*
P11	M/E/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	230 (190 — 270) *750 (630 — 880)*
P12	M/E/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	135 (120 — 160) *445 (400 — 520)*
M1	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	270 (230 — 320) *890 (760 — 1000)*
M2	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (180 — 250) *720 (600 — 820)*
M3	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (180 — 250) *720 (600 — 820)*
M4	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	165 (140 — 190) *540 (460 — 620)*
M5	E/M/A	0.0250 *0,0250*	0.38 *0,38*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	135 (120 — 160) *445 (400 — 520)*
N1	E/M/A	0.100 *0,100*	0.65 *0,65*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	590 (520 — 660) *1925 (1800 — 2100)*
N2	E/M/A	0.100 *0,100*	0.65 *0,65*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	590 (520 — 660) *1925 (1800 — 2100)*
N3	E/M/A	0.100 *0,100*	0.65 *0,65*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	395 (350 — 440) *1300 (1200 — 1400)*
N11	E/M/A	0.100 *0,100*	0.65 *0,65*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	520 (450 — 590) *1700 (1500 — 1900)*
S11	E/M/A	0.0250 *0,0250*	0.46 *0,46*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	345 (300 — 390) *1125 (990 — 1200)*
S12	E/M/A	0.0250 *0,0250*	0.46 *0,46*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	265 (230 — 300) *870 (760 — 980)*
S13	E/M/A	0.0250 *0,0250*	0.46 *0,46*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	205 (180 — 230) *670 (600 — 750)*
H3	M/A	0.0250 *0,0250*	0.095 *0,095*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	155 (120 — 190) *510 (400 — 620)*
H5	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860 — 1000)*
H7	M/A	0.0250 *0,0250*	0.095 *0,095*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	155 (120 — 190) *510 (400 — 620)*
H8	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860 — 1000)*
H11	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	375 (330 — 420) *1225 (1100 — 1300)*
H12	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	345 (310 — 380) *1125 (1100 — 1200)*
H21	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	295 (260 — 330) *970 (860 — 1000)*
H31	M/A	0.0500 *0,0500*	0.22 *0,22*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	225 (200 — 250) *740 (660 — 820)*
GR1	A	0.500 *0,500*	0.50 *0,50*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.040 *0,0016*	450 (390 — 510) *1475 (1300 — 1600)*

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte



STAHL UND GUSS

Das vollständige Programm an Hochleistungsvollhartmetallfräsern für hohe Produktivität in Stahl und Guss besteht aus Schaft- und Kugelkopffräsern.

- ST5541, JHP993, JHP951 und JH142 mit Fase oder Eckenradius
- ST5341, JHB970, JH112, JH150, JH160 Kugelkopffräser

Werkzeugauswahl Stahl und Guss

							
Werkzeugbezeichnung		ST5541	JHP993	JHP951	JH142	ST5341	JHB970
Seite(n)		276	293	299	303, 514	306	228, 311
Produktfamilie		Stabilizer	HPM	HPM	HSM/TORNADO	Stabilizer	HSM/TORNADO
Fräserausführung							
Aufnahmen	Zylindrisch	■	■	■	■	■	■
	Weldon	□	■	■		□	
Schneidenzahl		4	3,4,5	3,4,5	2-4-5-6	4	2
CSP							
	Metrisch	3-25	4-25	3-20	2-12	6-20	2-16
	Zoll	1/8-1				1/4-1	
Verfügbare Längen		1,2,3,4	2,3	2	2,3,6	2.3	1,2,3
Bearbeitung							
							
							
SMG							
P1		●	●	●	●	●	●
P2		●	●	●	●	●	●
P3		●	●	●	●	●	●
P4		●	●	●	●	●	●
P5		●	●	●	●	●	●
P6		●	●	●	●	●	●
P7		●	●	●	●	●	●
P8		●	●	●	●	●	●
P11-12		●	○	○	●	●	○
K1		●	●	●	●	●	
K2		●	●	●	●	●	
K3		●	●	●	●	●	
K4		●	●	●	●	●	
K5		●	●	●	●	●	
K6		●	●	●	●	●	
K7		●	●	●	●	●	

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl Stahl und Guss

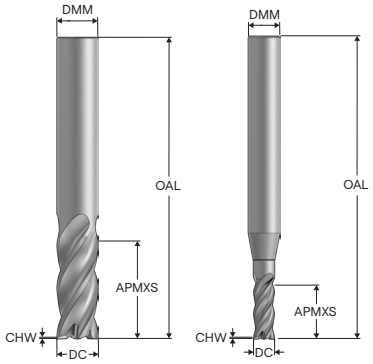
				
Werkzeugbezeichnung		JH112	JH150	JH160
Seite(n)		313, 517	520	522
Produktfamilie		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO
Fräserausführung		∪	∪	∪
Aufnahmen	Zylindrisch	■	■	■
	Weldon			
Schneidenzahl		2	4	4
CSP				
	Metrisch	2-12	6-12	3-12
	Zoll			
Verfügbare Längen		1,2,3,4,5,6	2	2
Bearbeitung				
				
SMG				
P1				●
P2				●
P3				●
P4				●
P5				●
P6				●
P7				●
P8				●
P11-12				○
K1		●	●	
K2		●	●	
K3		●	●	
K4		●	●	
K5		●	●	
K6		●	●	
K7		●	●	

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

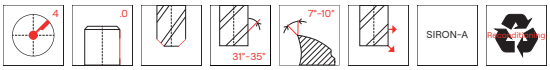
ST5541

Hochleistungsfräser – Stahl – Eckfräser – 4 Schneiden – Zylindrisch – Fase





—Toleranzen:
—DMM=h5
—DC=e7
—Nachschleifen möglich, wenn DC ≥ Ø6 ist



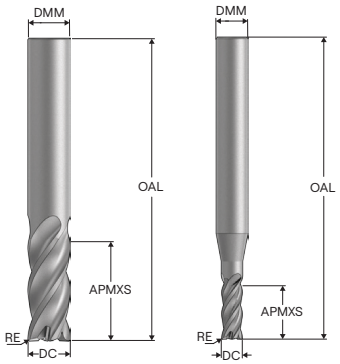
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
ST5541-030F2C.0Z4	SIRA	10302942	2	F	3,0	6,0	7,0	58,0	0,035	4	Cylindrical	■
ST5541-040F2C.0Z4	SIRA	10302943	2	F	4,0	6,0	10,0	58,0	0,045	4	Cylindrical	■
ST5541-050F2C.0Z4	SIRA	10302944	2	F	5,0	6,0	12,0	58,0	0,055	4	Cylindrical	■
ST5541-060D2C.0Z4	SIRA	10302945	2	D	6,0	6,0	14,0	58,0	0,075	4	Cylindrical	■
ST5541-080D2C.0Z4	SIRA	10302946	2	D	8,0	8,0	18,0	64,0	0,1	4	Cylindrical	■
ST5541-100D2C.0Z4	SIRA	10302947	2	D	10,0	10,0	22,0	73,0	0,125	4	Cylindrical	■
ST5541-120D2C.0Z4	SIRA	10302948	2	D	12,0	12,0	26,0	84,0	0,15	4	Cylindrical	■
ST5541-160D2C.0Z4	SIRA	10302949	2	D	16,0	16,0	34,0	95,0	0,2	4	Cylindrical	■
ST5541-200D2C.0Z4	SIRA	10302950	2	D	20,0	20,0	42,0	109,0	0,25	4	Cylindrical	■
ST5541-250D2C.0Z4	SIRA	10302951	2	D	25,0	25,0	52,0	125,0	0,3	4	Cylindrical	■
ST5541-030F3C.0Z4	SIRA	10302952	3	F	3,0	6,0	9,0	58,0	0,035	4	Cylindrical	■
ST5541-040F3C.0Z4	SIRA	10302953	3	F	4,0	6,0	12,0	58,0	0,045	4	Cylindrical	■
ST5541-050F3C.0Z4	SIRA	10302954	3	F	5,0	6,0	15,0	58,0	0,055	4	Cylindrical	■
ST5541-060D3C.0Z4	SIRA	10302955	3	D	6,0	6,0	18,0	64,0	0,075	4	Cylindrical	■
ST5541-080D3C.0Z4	SIRA	10302956	3	D	8,0	8,0	24,0	73,0	0,1	4	Cylindrical	■
ST5541-100D3C.0Z4	SIRA	10302957	3	D	10,0	10,0	30,0	85,0	0,125	4	Cylindrical	■
ST5541-120D3C.0Z4	SIRA	10302958	3	D	12,0	12,0	36,0	100,0	0,15	4	Cylindrical	■
ST5541-160D3C.0Z4	SIRA	10302959	3	D	16,0	16,0	48,0	115,0	0,2	4	Cylindrical	■
ST5541-200D3C.0Z4	SIRA	10302960	3	D	20,0	20,0	60,0	125,0	0,25	4	Cylindrical	■
ST5541-250D3C.0Z4	SIRA	10302961	3	D	25,0	25,0	75,0	155,0	0,3	4	Cylindrical	■

■ **Lagerstandard.**

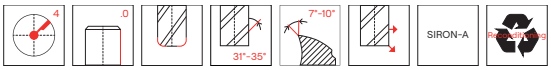
ST5541

Hochleistungsfräser – Stahl – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius





– Toleranzen:
– DMM=h5
– DC=e7
– RE= ±0,02 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist



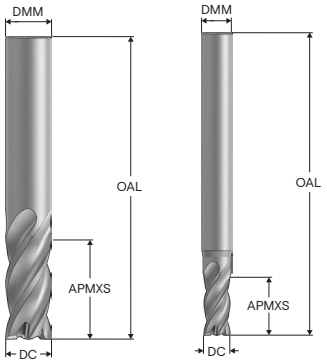
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
ST5541-030F2R020.0Z4	SIRA	10302962	2	F	3,0	6,0	7,0	58,0	0,2	4	Cylindrical	■
ST5541-040F2R020.0Z4	SIRA	10302963	2	F	4,0	6,0	10,0	58,0	0,2	4	Cylindrical	■
ST5541-050F2R020.0Z4	SIRA	10302964	2	F	5,0	6,0	12,0	58,0	0,2	4	Cylindrical	■
ST5541-060D2R050.0Z4	SIRA	10302965	2	D	6,0	6,0	14,0	58,0	0,5	4	Cylindrical	■
ST5541-080D2R050.0Z4	SIRA	10302966	2	D	8,0	8,0	18,0	64,0	0,5	4	Cylindrical	■
ST5541-100D2R050.0Z4	SIRA	10302967	2	D	10,0	10,0	22,0	73,0	0,5	4	Cylindrical	■
ST5541-120D2R050.0Z4	SIRA	10302968	2	D	12,0	12,0	26,0	84,0	0,5	4	Cylindrical	■
ST5541-120D2R100.0Z4	SIRA	10302969	2	D	12,0	12,0	26,0	84,0	1,0	4	Cylindrical	■
ST5541-160D2R050.0Z4	SIRA	10302970	2	D	16,0	16,0	34,0	95,0	0,5	4	Cylindrical	■
ST5541-160D2R100.0Z4	SIRA	10302972	2	D	16,0	16,0	34,0	95,0	1,0	4	Cylindrical	■
ST5541-160D2R300.0Z4	SIRA	10302971	2	D	16,0	16,0	34,0	95,0	3,0	4	Cylindrical	■
ST5541-200D2R050.0Z4	SIRA	10302973	2	D	20,0	20,0	42,0	109,0	0,5	4	Cylindrical	■
ST5541-200D2R100.0Z4	SIRA	10302975	2	D	20,0	20,0	42,0	109,0	1,0	4	Cylindrical	■
ST5541-200D2R300.0Z4	SIRA	10302974	2	D	20,0	20,0	42,0	109,0	3,0	4	Cylindrical	■
ST5541-250D2R050.0Z4	SIRA	10302976	2	D	25,0	25,0	52,0	125,0	0,5	4	Cylindrical	■
ST5541-250D2R100.0Z4	SIRA	10302978	2	D	25,0	25,0	52,0	125,0	1,0	4	Cylindrical	■
ST5541-250D2R300.0Z4	SIRA	10302977	2	D	25,0	25,0	52,0	125,0	3,0	4	Cylindrical	■
ST5541-030F3R020.0Z4	SIRA	10302979	3	F	3,0	6,0	9,0	58,0	0,2	4	Cylindrical	■
ST5541-040F3R020.0Z4	SIRA	10302980	3	F	4,0	6,0	12,0	58,0	0,2	4	Cylindrical	■
ST5541-050F3R020.0Z4	SIRA	10302981	3	F	5,0	6,0	15,0	58,0	0,2	4	Cylindrical	■
ST5541-060D3R050.0Z4	SIRA	10302982	3	D	6,0	6,0	18,0	64,0	0,5	4	Cylindrical	■
ST5541-080D3R050.0Z4	SIRA	10302983	3	D	8,0	8,0	24,0	73,0	0,5	4	Cylindrical	■
ST5541-100D3R050.0Z4	SIRA	10302984	3	D	10,0	10,0	30,0	85,0	0,5	4	Cylindrical	■
ST5541-120D3R050.0Z4	SIRA	10302985	3	D	12,0	12,0	36,0	100,0	0,5	4	Cylindrical	■
ST5541-120D3R100.0Z4	SIRA	10302986	3	D	12,0	12,0	36,0	100,0	1,0	4	Cylindrical	■
ST5541-160D3R050.0Z4	SIRA	10302987	3	D	16,0	16,0	48,0	115,0	0,5	4	Cylindrical	■
ST5541-160D3R100.0Z4	SIRA	10302989	3	D	16,0	16,0	48,0	115,0	1,0	4	Cylindrical	■
ST5541-160D3R300.0Z4	SIRA	10302988	3	D	16,0	16,0	48,0	115,0	3,0	4	Cylindrical	■
ST5541-200D3R050.0Z4	SIRA	10302990	3	D	20,0	20,0	60,0	125,0	0,5	4	Cylindrical	■
ST5541-200D3R100.0Z4	SIRA	10302992	3	D	20,0	20,0	60,0	125,0	1,0	4	Cylindrical	■
ST5541-200D3R300.0Z4	SIRA	10302991	3	D	20,0	20,0	60,0	125,0	3,0	4	Cylindrical	■
ST5541-250D3R050.0Z4	SIRA	10302993	3	D	25,0	25,0	75,0	155,0	0,5	4	Cylindrical	■
ST5541-250D3R100.0Z4	SIRA	10302995	3	D	25,0	25,0	75,0	155,0	1,0	4	Cylindrical	■
ST5541-250D3R300.0Z4	SIRA	10302994	3	D	25,0	25,0	75,0	155,0	3,0	4	Cylindrical	■

■ **Lagerstandard.**

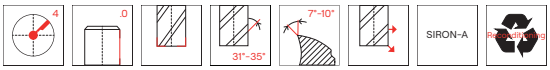
ST5541

Hochleistungsfräser – Stahl – Eckfräser – 4 Schneiden – Zylindrisch – Scharfe Schneide – Zoll





—Toleranzen:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—Nachschleifen möglich, wenn DC ≥ Ø.250 ist



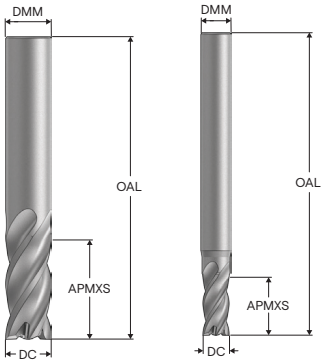
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll			
ST5541-.125D1S.0Z4	SIRA	10302742	1	D	0.125	0.125	0.125	1.500	4	Cylindrical	■
ST5541-.156F1S.0Z4	SIRA	10302743	1	F	0.156	0.188	0.156	2.000	4	Cylindrical	■
ST5541-.188D1S.0Z4	SIRA	10302744	1	D	0.188	0.188	0.188	2.000	4	Cylindrical	■
ST5541-.219F1S.0Z4	SIRA	10302745	1	F	0.219	0.250	0.219	2.000	4	Cylindrical	■
ST5541-.250D1S.0Z4	SIRA	10302746	1	D	0.250	0.250	0.250	2.000	4	Cylindrical	■
ST5541-.281F1S.0Z4	SIRA	10302747	1	F	0.281	0.313	0.281	2.000	4	Cylindrical	■
ST5541-.313D1S.0Z4	SIRA	10302748	1	D	0.313	0.313	0.313	2.000	4	Cylindrical	■
ST5541-.375D1S.0Z4	SIRA	10302749	1	D	0.375	0.375	0.375	2.000	4	Cylindrical	■
ST5541-.438D1S.0Z4	SIRA	10302750	1	D	0.438	0.438	0.438	2.750	4	Cylindrical	■
ST5541-.500D1S.0Z4	SIRA	10302751	1	D	0.500	0.500	0.500	2.500	4	Cylindrical	■
ST5541-.625D1S.0Z4	SIRA	10302752	1	D	0.625	0.625	0.625	3.000	4	Cylindrical	■
ST5541-.750D1S.0Z4	SIRA	10302753	1	D	0.750	0.750	0.750	3.000	4	Cylindrical	■
ST5541-.875D1S.0Z4	SIRA	10302754	1	D	0.875	0.875	0.875	4.000	4	Cylindrical	■
ST5541-1.00D1S.0Z4	SIRA	10302755	1	D	1.000	1.000	1.000	4.000	4	Cylindrical	■
ST5541-.125D2S.0Z4	SIRA	10302756	2	D	0.125	0.125	0.250	1.500	4	Cylindrical	■
ST5541-.156F2S.0Z4	SIRA	10302757	2	F	0.156	0.188	0.313	2.000	4	Cylindrical	■
ST5541-.188D2S.0Z4	SIRA	10302758	2	D	0.188	0.188	0.375	2.000	4	Cylindrical	■
ST5541-.219F2S.0Z4	SIRA	10302759	2	F	0.219	0.250	0.438	2.500	4	Cylindrical	■
ST5541-.250D2S.0Z4	SIRA	10302760	2	D	0.250	0.250	0.500	2.500	4	Cylindrical	■
ST5541-.281F2S.0Z4	SIRA	10302761	2	F	0.281	0.313	0.563	2.500	4	Cylindrical	■
ST5541-.313D2S.0Z4	SIRA	10302762	2	D	0.313	0.313	0.625	2.500	4	Cylindrical	■
ST5541-.375D2S.0Z4	SIRA	10302763	2	D	0.375	0.375	0.750	2.500	4	Cylindrical	■
ST5541-.438D2S.0Z4	SIRA	10302764	2	D	0.438	0.438	0.875	2.750	4	Cylindrical	■
ST5541-.500D2S.0Z4	SIRA	10302765	2	D	0.500	0.500	1.000	3.000	4	Cylindrical	■
ST5541-.625D2S.0Z4	SIRA	10302766	2	D	0.625	0.625	1.250	3.500	4	Cylindrical	■
ST5541-.750D2S.0Z4	SIRA	10302767	2	D	0.750	0.750	1.500	4.000	4	Cylindrical	■
ST5541-.875D2S.0Z4	SIRA	10302768	2	D	0.875	0.875	1.750	4.000	4	Cylindrical	■
ST5541-1.00D2S.0Z4	SIRA	10302769	2	D	1.000	1.000	2.000	5.000	4	Cylindrical	■

■ **Lagerstandard.**

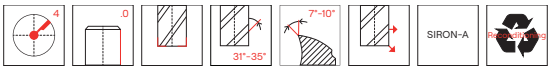
ST5541

Hochleistungsfräser – Stahl – Eckfräser – 4 Schneiden – Zylindrisch – Scharfe Schneide – Zoll





—Toleranzen:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—Nachschleifen möglich, wenn DC ≥ Ø.250 ist



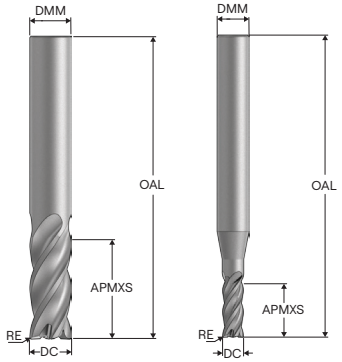
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll			
ST5541-.125D3S.0Z4	SIRA	10302770	3	D	0.125	0.125	0.375	1.500	4	Cylindrical	■
ST5541-.156F3S.0Z4	SIRA	10302771	3	F	0.156	0.188	0.469	2.000	4	Cylindrical	■
ST5541-.188D3S.0Z4	SIRA	10302772	3	D	0.188	0.188	0.563	2.000	4	Cylindrical	■
ST5541-.219F3S.0Z4	SIRA	10302773	3	F	0.219	0.250	0.656	2.500	4	Cylindrical	■
ST5541-.250D3S.0Z4	SIRA	10302774	3	D	0.250	0.250	0.750	2.500	4	Cylindrical	■
ST5541-.281F3S.0Z4	SIRA	10302775	3	F	0.281	0.313	0.844	2.500	4	Cylindrical	■
ST5541-.313D3S.0Z4	SIRA	10302776	3	D	0.313	0.313	0.938	2.500	4	Cylindrical	■
ST5541-.375D3S.0Z4	SIRA	10302777	3	D	0.375	0.375	1.125	3.000	4	Cylindrical	■
ST5541-.438D3S.0Z4	SIRA	10302778	3	D	0.438	0.438	1.313	4.000	4	Cylindrical	■
ST5541-.500D3S.0Z4	SIRA	10302779	3	D	0.500	0.500	1.250	3.000	4	Cylindrical	■
ST5541-.625D3S.0Z4	SIRA	10302780	3	D	0.625	0.625	1.875	4.000	4	Cylindrical	■
ST5541-.750D3S.0Z4	SIRA	10302781	3	D	0.750	0.750	2.250	5.000	4	Cylindrical	■
ST5541-.875D3S.0Z4	SIRA	10302782	3	D	0.875	0.875	2.625	5.000	4	Cylindrical	■
ST5541-1.00D3S.0Z4	SIRA	10302783	3	D	1.000	1.000	3.000	6.000	4	Cylindrical	■
ST5541-.500D4S.0Z4	SIRA	10302784	4	D	0.500	0.500	1.500	4.000	4	Cylindrical	■

■ **Lagerstandard.**

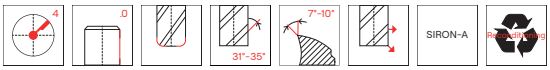
ST5541

Hochleistungsfräser – Stahl – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius – Zoll





—Toleranzen:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Nachschleifen möglich, wenn DC ≥ Ø.250 ist



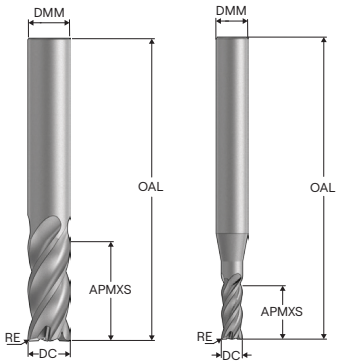
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll			
ST5541-.125D1R010.0Z4	SIRA	10302785	1	D	0.125	0.125	0.125	1.500	0.010	4	Cylindrical	■
ST5541-.156F1R010.0Z4	SIRA	10302786	1	F	0.156	0.188	0.156	2.000	0.010	4	Cylindrical	■
ST5541-.188D1R010.0Z4	SIRA	10302787	1	D	0.188	0.188	0.188	2.000	0.010	4	Cylindrical	■
ST5541-.219F1R020.0Z4	SIRA	10302788	1	F	0.219	0.250	0.219	2.000	0.020	4	Cylindrical	■
ST5541-.250D1R020.0Z4	SIRA	10302789	1	D	0.250	0.250	0.250	2.000	0.020	4	Cylindrical	■
ST5541-.281F1R020.0Z4	SIRA	10302790	1	F	0.281	0.313	0.281	2.000	0.020	4	Cylindrical	■
ST5541-.313D1R020.0Z4	SIRA	10302791	1	D	0.313	0.313	0.313	2.000	0.020	4	Cylindrical	■
ST5541-.375D1R020.0Z4	SIRA	10302792	1	D	0.375	0.375	0.375	2.000	0.020	4	Cylindrical	■
ST5541-.438D1R020.0Z4	SIRA	10302793	1	D	0.438	0.438	0.438	2.750	0.020	4	Cylindrical	■
ST5541-.500D1R030.0Z4	SIRA	10302794	1	D	0.500	0.500	0.500	2.500	0.030	4	Cylindrical	■
ST5541-.625D1R030.0Z4	SIRA	10302795	1	D	0.625	0.625	0.625	3.000	0.030	4	Cylindrical	■
ST5541-.750D1R030.0Z4	SIRA	10302796	1	D	0.750	0.750	0.750	3.000	0.030	4	Cylindrical	■
ST5541-.875D1R030.0Z4	SIRA	10302797	1	D	0.875	0.875	0.875	4.000	0.030	4	Cylindrical	■
ST5541-1.00D1R030.0Z4	SIRA	10302798	1	D	1.000	1.000	1.000	4.000	0.030	4	Cylindrical	■
ST5541-.125D2R010.0Z4	SIRA	10302799	2	D	0.125	0.125	0.250	1.500	0.010	4	Cylindrical	■
ST5541-.156F2R010.0Z4	SIRA	10302800	2	F	0.156	0.188	0.313	2.000	0.010	4	Cylindrical	■
ST5541-.188D2R010.0Z4	SIRA	10302801	2	D	0.188	0.188	0.375	2.000	0.010	4	Cylindrical	■
ST5541-.219F2R020.0Z4	SIRA	10302802	2	F	0.219	0.250	0.438	2.500	0.020	4	Cylindrical	■
ST5541-.250D2R020.0Z4	SIRA	10302803	2	D	0.250	0.250	0.500	2.500	0.020	4	Cylindrical	■
ST5541-.281F2R020.0Z4	SIRA	10302805	2	F	0.281	0.313	0.563	2.500	0.020	4	Cylindrical	■
ST5541-.313D2R020.0Z4	SIRA	10302806	2	D	0.313	0.313	0.625	2.500	0.020	4	Cylindrical	■
ST5541-.375D2R020.0Z4	SIRA	10302808	2	D	0.375	0.375	0.750	2.500	0.020	4	Cylindrical	■
ST5541-.438D2R020.0Z4	SIRA	10302810	2	D	0.438	0.438	0.875	2.750	0.020	4	Cylindrical	■
ST5541-.500D2R030.0Z4	SIRA	10302812	2	D	0.500	0.500	1.000	3.000	0.030	4	Cylindrical	■
ST5541-.500D2R060.0Z4	SIRA	10302813	2	D	0.500	0.500	1.000	3.000	0.060	4	Cylindrical	■
ST5541-.500D2R120.0Z4	SIRA	10302814	2	D	0.500	0.500	1.000	3.000	0.120	4	Cylindrical	■
ST5541-.625D2R030.0Z4	SIRA	10302816	2	D	0.625	0.625	1.250	3.500	0.030	4	Cylindrical	■
ST5541-.625D2R060.0Z4	SIRA	10302817	2	D	0.625	0.625	1.250	3.500	0.060	4	Cylindrical	■
ST5541-.625D2R090.0Z4	SIRA	10302818	2	D	0.625	0.625	1.250	3.500	0.090	4	Cylindrical	■
ST5541-.625D2R120.0Z4	SIRA	10302819	2	D	0.625	0.625	1.250	3.500	0.120	4	Cylindrical	■
ST5541-.750D2R030.0Z4	SIRA	10302821	2	D	0.750	0.750	1.500	4.000	0.030	4	Cylindrical	■
ST5541-.750D2R060.0Z4	SIRA	10302822	2	D	0.750	0.750	1.500	4.000	0.060	4	Cylindrical	■
ST5541-.750D2R090.0Z4	SIRA	10302823	2	D	0.750	0.750	1.500	4.000	0.090	4	Cylindrical	■
ST5541-.750D2R120.0Z4	SIRA	10302824	2	D	0.750	0.750	1.500	4.000	0.120	4	Cylindrical	■
ST5541-.750D2R250.0Z4	SIRA	10302825	2	D	0.750	0.750	1.500	4.000	0.250	4	Cylindrical	■
ST5541-.875D2R030.0Z4	SIRA	10302827	2	D	0.875	0.875	1.750	4.000	0.030	4	Cylindrical	■
ST5541-1.00D2R030.0Z4	SIRA	10302828	2	D	1.000	1.000	2.000	5.000	0.030	4	Cylindrical	■

■ **Lagerstandard.**

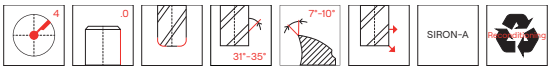
ST5541

Hochleistungsfräser – Stahl – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius – Zoll





—Toleranzen:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Nachschleifen möglich, wenn DC ≥ Ø.250 ist



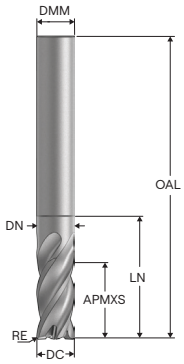
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll			
ST5541-.125D3R010.0Z4	SIRA	10302830	3	D	0.125	0.125	0.375	1.500	0.010	4	Cylindrical	■
ST5541-.156F3R010.0Z4	SIRA	10302831	3	F	0.156	0.188	0.469	2.000	0.010	4	Cylindrical	■
ST5541-.188D3R010.0Z4	SIRA	10302832	3	D	0.188	0.188	0.563	2.000	0.010	4	Cylindrical	■
ST5541-.219F3R020.0Z4	SIRA	10302833	3	F	0.219	0.250	0.656	2.500	0.020	4	Cylindrical	■
ST5541-.250D3R020.0Z4	SIRA	10302834	3	D	0.250	0.250	0.750	2.500	0.020	4	Cylindrical	■
ST5541-.281F3R020.0Z4	SIRA	10302835	3	F	0.281	0.313	0.844	2.500	0.020	4	Cylindrical	■
ST5541-.313D3R020.0Z4	SIRA	10302836	3	D	0.313	0.313	0.938	2.500	0.020	4	Cylindrical	■
ST5541-.375D3R020.0Z4	SIRA	10302837	3	D	0.375	0.375	1.125	3.000	0.020	4	Cylindrical	■
ST5541-.438D3R020.0Z4	SIRA	10302838	3	D	0.438	0.438	1.313	4.000	0.020	4	Cylindrical	■
ST5541-.500D3R030.0Z4	SIRA	10302839	3	D	0.500	0.500	1.250	3.000	0.030	4	Cylindrical	■
ST5541-.500D3R060.0Z4	SIRA	10302840	3	D	0.500	0.500	1.250	3.000	0.060	4	Cylindrical	■
ST5541-.500D3R120.0Z4	SIRA	10302841	3	D	0.500	0.500	1.250	3.000	0.120	4	Cylindrical	■
ST5541-.625D3R030.0Z4	SIRA	10302842	3	D	0.625	0.625	1.875	4.000	0.030	4	Cylindrical	■
ST5541-.625D3R060.0Z4	SIRA	10302843	3	D	0.625	0.625	1.875	4.000	0.060	4	Cylindrical	■
ST5541-.625D3R090.0Z4	SIRA	10302844	3	D	0.625	0.625	1.875	4.000	0.090	4	Cylindrical	■
ST5541-.625D3R120.0Z4	SIRA	10302845	3	D	0.625	0.625	1.875	4.000	0.120	4	Cylindrical	■
ST5541-.750D3R030.0Z4	SIRA	10302846	3	D	0.750	0.750	2.250	5.000	0.030	4	Cylindrical	■
ST5541-.750D3R060.0Z4	SIRA	10302847	3	D	0.750	0.750	2.250	5.000	0.060	4	Cylindrical	■
ST5541-.750D3R090.0Z4	SIRA	10302848	3	D	0.750	0.750	2.250	5.000	0.090	4	Cylindrical	■
ST5541-.750D3R120.0Z4	SIRA	10302849	3	D	0.750	0.750	2.250	5.000	0.120	4	Cylindrical	■
ST5541-.750D3R250.0Z4	SIRA	10302850	3	D	0.750	0.750	2.250	5.000	0.250	4	Cylindrical	■
ST5541-.875D3R030.0Z4	SIRA	10302851	3	D	0.875	0.875	2.625	5.000	0.030	4	Cylindrical	■
ST5541-1.00D3R030.0Z4	SIRA	10302852	3	D	1.000	1.000	3.000	6.000	0.030	4	Cylindrical	■
ST5541-.500D4R030.0Z4	SIRA	10302853	4	D	0.500	0.500	1.500	4.000	0.030	4	Cylindrical	■

■ **Lagerstandard.**

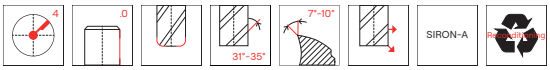
ST5541

Hochleistungsfräser – Stahl – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius – Zoll





– Toleranzen:
– DMM= -.0001"/-.0004"
– DC= + .000" / - .002"
– RE= ±.0008"
– Nachschleifen möglich



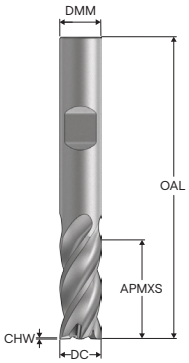
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zoll			
ST5541-.250E2R020.0Z4	SIRA	10302804	2	E	0.250	0.250	0.500	2.500	0.750	0.240	0.020	4	Cylindrical	■
ST5541-.313E2R020.0Z4	SIRA	10302807	2	E	0.313	0.313	0.625	3.000	0.938	0.300	0.020	4	Cylindrical	■
ST5541-.375E2R020.0Z4	SIRA	10302809	2	E	0.375	0.375	0.750	3.000	1.125	0.360	0.020	4	Cylindrical	■
ST5541-.438E2R020.0Z4	SIRA	10302811	2	E	0.438	0.438	0.875	4.000	1.313	0.420	0.020	4	Cylindrical	■
ST5541-.500E2R030.0Z4	SIRA	10302815	2	E	0.500	0.500	1.000	3.000	1.500	0.480	0.030	4	Cylindrical	■
ST5541-.625E2R030.0Z4	SIRA	10302820	2	E	0.625	0.625	1.250	3.500	1.875	0.600	0.030	4	Cylindrical	■
ST5541-.750E2R030.0Z4	SIRA	10302826	2	E	0.750	0.750	1.500	4.000	2.250	0.720	0.030	4	Cylindrical	■
ST5541-1.00E2R030.0Z4	SIRA	10302829	2	E	1.000	1.000	2.000	5.000	3.000	0.960	0.030	4	Cylindrical	■

■ **Lagerstandard.**

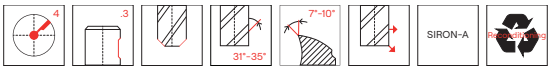
ST5541

Hochleistungsfräser – Stahl – Eckfräser – 4 Schneiden – Weldon – Fase





- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich



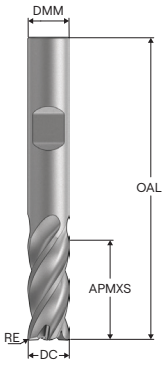
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	CHW	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm			
ST5541-060D2C.3Z4	SIRA	10302996	2	D	6,0	6,0	14,0	58,0	0,075	4	Weldon	☐
ST5541-080D2C.3Z4	SIRA	10302997	2	D	8,0	8,0	18,0	64,0	0,1	4	Weldon	☐
ST5541-100D2C.3Z4	SIRA	10302998	2	D	10,0	10,0	22,0	73,0	0,125	4	Weldon	☐
ST5541-120D2C.3Z4	SIRA	10302999	2	D	12,0	12,0	26,0	84,0	0,15	4	Weldon	☐
ST5541-160D2C.3Z4	SIRA	10303000	2	D	16,0	16,0	34,0	95,0	0,2	4	Weldon	☐
ST5541-200D2C.3Z4	SIRA	10303001	2	D	20,0	20,0	42,0	109,0	0,25	4	Weldon	☐
ST5541-250D2C.3Z4	SIRA	10303002	2	D	25,0	25,0	52,0	125,0	0,3	4	Weldon	☐
ST5541-060D3C.3Z4	SIRA	10303003	3	D	6,0	6,0	18,0	64,0	0,075	4	Weldon	☐
ST5541-080D3C.3Z4	SIRA	10303004	3	D	8,0	8,0	24,0	73,0	0,1	4	Weldon	☐
ST5541-100D3C.3Z4	SIRA	10303005	3	D	10,0	10,0	30,0	85,0	0,125	4	Weldon	☐
ST5541-120D3C.3Z4	SIRA	10303006	3	D	12,0	12,0	36,0	100,0	0,15	4	Weldon	☐
ST5541-160D3C.3Z4	SIRA	10303007	3	D	16,0	16,0	48,0	115,0	0,2	4	Weldon	☐
ST5541-200D3C.3Z4	SIRA	10303008	3	D	20,0	20,0	60,0	125,0	0,25	4	Weldon	☐
ST5541-250D3C.3Z4	SIRA	10303009	3	D	25,0	25,0	75,0	155,0	0,3	4	Weldon	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

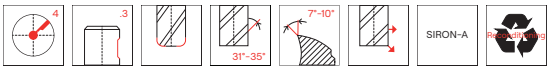
ST5541

Hochleistungsfräser – Stahl – Eckfräser – 4 Schneiden – Weldon – Eckenradius





– Toleranzen:
– DMM=h5
– DC=e7
– RE= ±0,02 mm
– Nachschleifen möglich



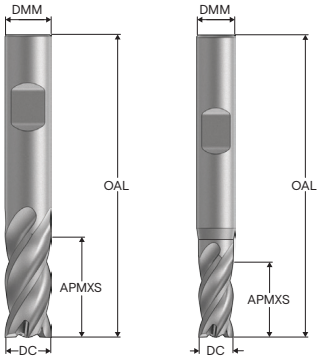
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	RE	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm			
ST5541-060D2R050.3Z4	SIRA	10303010	2	D	6,0	6,0	14,0	58,0	0,5	4	Weldon	☐
ST5541-080D2R050.3Z4	SIRA	10303011	2	D	8,0	8,0	18,0	64,0	0,5	4	Weldon	☐
ST5541-100D2R050.3Z4	SIRA	10303012	2	D	10,0	10,0	22,0	73,0	0,5	4	Weldon	☐
ST5541-120D2R050.3Z4	SIRA	10303013	2	D	12,0	12,0	26,0	84,0	0,5	4	Weldon	☐
ST5541-120D2R100.3Z4	SIRA	10303014	2	D	12,0	12,0	26,0	84,0	1,0	4	Weldon	☐
ST5541-160D2R050.3Z4	SIRA	10303015	2	D	16,0	16,0	34,0	95,0	0,5	4	Weldon	☐
ST5541-160D2R100.3Z4	SIRA	10303017	2	D	16,0	16,0	34,0	95,0	1,0	4	Weldon	☐
ST5541-160D2R300.3Z4	SIRA	10303016	2	D	16,0	16,0	34,0	95,0	3,0	4	Weldon	☐
ST5541-200D2R050.3Z4	SIRA	10303018	2	D	20,0	20,0	42,0	109,0	0,5	4	Weldon	☐
ST5541-200D2R100.3Z4	SIRA	10303020	2	D	20,0	20,0	42,0	109,0	1,0	4	Weldon	☐
ST5541-200D2R300.3Z4	SIRA	10303019	2	D	20,0	20,0	42,0	109,0	3,0	4	Weldon	☐
ST5541-250D2R050.3Z4	SIRA	10303021	2	D	25,0	25,0	52,0	125,0	0,5	4	Weldon	☐
ST5541-250D2R100.3Z4	SIRA	10303023	2	D	25,0	25,0	52,0	125,0	1,0	4	Weldon	☐
ST5541-250D2R300.3Z4	SIRA	10303022	2	D	25,0	25,0	52,0	125,0	3,0	4	Weldon	☐
ST5541-060D3R050.3Z4	SIRA	10303024	3	D	6,0	6,0	18,0	64,0	0,5	4	Weldon	☐
ST5541-080D3R050.3Z4	SIRA	10303025	3	D	8,0	8,0	24,0	73,0	0,5	4	Weldon	☐
ST5541-100D3R050.3Z4	SIRA	10303026	3	D	10,0	10,0	30,0	85,0	0,5	4	Weldon	☐
ST5541-120D3R050.3Z4	SIRA	10303027	3	D	12,0	12,0	36,0	100,0	0,5	4	Weldon	☐
ST5541-120D3R100.3Z4	SIRA	10303028	3	D	12,0	12,0	36,0	100,0	1,0	4	Weldon	☐
ST5541-160D3R050.3Z4	SIRA	10303029	3	D	16,0	16,0	48,0	115,0	0,5	4	Weldon	☐
ST5541-160D3R100.3Z4	SIRA	10303031	3	D	16,0	16,0	48,0	115,0	1,0	4	Weldon	☐
ST5541-160D3R300.3Z4	SIRA	10303030	3	D	16,0	16,0	48,0	115,0	3,0	4	Weldon	☐
ST5541-200D3R050.3Z4	SIRA	10303032	3	D	20,0	20,0	60,0	125,0	0,5	4	Weldon	☐
ST5541-200D3R100.3Z4	SIRA	10303034	3	D	20,0	20,0	60,0	125,0	1,0	4	Weldon	☐
ST5541-200D3R300.3Z4	SIRA	10303033	3	D	20,0	20,0	60,0	125,0	3,0	4	Weldon	☐
ST5541-250D3R050.3Z4	SIRA	10303035	3	D	25,0	25,0	75,0	155,0	0,5	4	Weldon	☐
ST5541-250D3R100.3Z4	SIRA	10303037	3	D	25,0	25,0	75,0	155,0	1,0	4	Weldon	☐
ST5541-250D3R300.3Z4	SIRA	10303036	3	D	25,0	25,0	75,0	155,0	3,0	4	Weldon	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

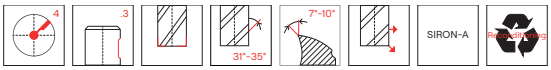
ST5541

Hochleistungsfräser – Stahl – Eckfräser – 4 Schneiden – Weldon – Scharfe Schneide – Zoll





—Toleranzen:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—Nachschleifen möglich



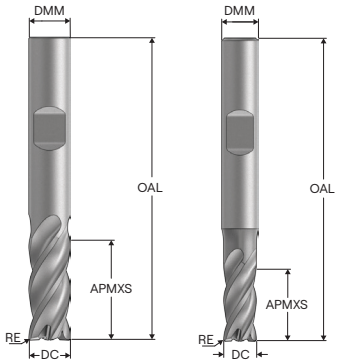
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll			
ST5541-.250D1S.3Z4	SIRA	10302854	1	D	0.250	0.250	0.250	2.000	4	Weldon	□
ST5541-.281F1S.3Z4	SIRA	10302855	1	F	0.281	0.313	0.281	2.000	4	Weldon	□
ST5541-.313D1S.3Z4	SIRA	10302856	1	D	0.313	0.313	0.313	2.000	4	Weldon	□
ST5541-.375D1S.3Z4	SIRA	10302857	1	D	0.375	0.375	0.375	2.000	4	Weldon	■
ST5541-.438D1S.3Z4	SIRA	10302858	1	D	0.438	0.438	0.438	2.750	4	Weldon	■
ST5541-.500D1S.3Z4	SIRA	10302859	1	D	0.500	0.500	0.500	2.500	4	Weldon	■
ST5541-.625D1S.3Z4	SIRA	10302860	1	D	0.625	0.625	0.625	3.000	4	Weldon	■
ST5541-.750D1S.3Z4	SIRA	10302861	1	D	0.750	0.750	0.750	3.000	4	Weldon	■
ST5541-.875D1S.3Z4	SIRA	10302862	1	D	0.875	0.875	0.875	4.000	4	Weldon	□
ST5541-1.00D1S.3Z4	SIRA	10302863	1	D	1.000	1.000	1.000	4.000	4	Weldon	■
ST5541-.250D2S.3Z4	SIRA	10302864	2	D	0.250	0.250	0.500	2.500	4	Weldon	□
ST5541-.281F2S.3Z4	SIRA	10302865	2	F	0.281	0.313	0.563	2.500	4	Weldon	□
ST5541-.313D2S.3Z4	SIRA	10302866	2	D	0.313	0.313	0.625	2.500	4	Weldon	□
ST5541-.375D2S.3Z4	SIRA	10302867	2	D	0.375	0.375	0.750	2.500	4	Weldon	■
ST5541-.438D2S.3Z4	SIRA	10302868	2	D	0.438	0.438	0.875	2.750	4	Weldon	■
ST5541-.500D2S.3Z4	SIRA	10302869	2	D	0.500	0.500	1.000	3.000	4	Weldon	■
ST5541-.625D2S.3Z4	SIRA	10302870	2	D	0.625	0.625	1.250	3.500	4	Weldon	■
ST5541-.750D2S.3Z4	SIRA	10302871	2	D	0.750	0.750	1.500	4.000	4	Weldon	■
ST5541-.875D2S.3Z4	SIRA	10302872	2	D	0.875	0.875	1.750	4.000	4	Weldon	□
ST5541-1.00D2S.3Z4	SIRA	10302873	2	D	1.000	1.000	2.000	5.000	4	Weldon	■
ST5541-.250D3S.3Z4	SIRA	10302874	3	D	0.250	0.250	0.750	2.500	4	Weldon	□
ST5541-.281F3S.3Z4	SIRA	10302875	3	F	0.281	0.313	0.844	2.500	4	Weldon	□
ST5541-.313D3S.3Z4	SIRA	10302876	3	D	0.313	0.313	0.938	2.500	4	Weldon	□
ST5541-.375D3S.3Z4	SIRA	10302877	3	D	0.375	0.375	1.125	3.000	4	Weldon	■
ST5541-.438D3S.3Z4	SIRA	10302878	3	D	0.438	0.438	1.313	4.000	4	Weldon	■
ST5541-.500D3S.3Z4	SIRA	10302879	3	D	0.500	0.500	1.250	3.000	4	Weldon	■
ST5541-.625D3S.3Z4	SIRA	10302880	3	D	0.625	0.625	1.875	4.000	4	Weldon	■
ST5541-.750D3S.3Z4	SIRA	10302881	3	D	0.750	0.750	2.250	5.000	4	Weldon	■
ST5541-.875D3S.3Z4	SIRA	10302882	3	D	0.875	0.875	2.625	5.000	4	Weldon	□
ST5541-1.00D3S.3Z4	SIRA	10302883	3	D	1.000	1.000	3.000	6.000	4	Weldon	■
ST5541-.500D4S.3Z4	SIRA	10302884	4	D	0.500	0.500	1.500	4.000	4	Weldon	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

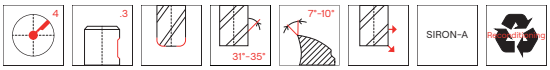
ST5541

Hochleistungsfräser – Stahl – Eckfräser – 4 Schneiden – Weldon – Eckenradius – Zoll





– Toleranzen:
– DMM= -.0001"/-.0004"
– DC= + .000" / - .002"
– RE= ±.0008"
– Nachschleifen möglich



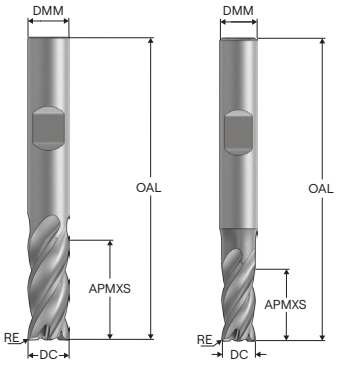
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	RE	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll	Zoll			
ST5541-.250D1R020.3Z4	SIRA	10302885	1	D	0.250	0.250	0.250	2.000	0.020	4	Weldon	□
ST5541-.281F1R020.3Z4	SIRA	10302886	1	F	0.281	0.313	0.281	2.000	0.020	4	Weldon	□
ST5541-.313D1R020.3Z4	SIRA	10302887	1	D	0.313	0.313	0.313	2.000	0.020	4	Weldon	□
ST5541-.375D1R020.3Z4	SIRA	10302888	1	D	0.375	0.375	0.375	2.000	0.020	4	Weldon	■
ST5541-.438D1R020.3Z4	SIRA	10302889	1	D	0.438	0.438	0.438	2.750	0.020	4	Weldon	□
ST5541-.500D1R030.3Z4	SIRA	10302890	1	D	0.500	0.500	0.500	2.500	0.030	4	Weldon	■
ST5541-.625D1R030.3Z4	SIRA	10302891	1	D	0.625	0.625	0.625	3.000	0.030	4	Weldon	■
ST5541-.750D1R030.3Z4	SIRA	10302892	1	D	0.750	0.750	0.750	3.000	0.030	4	Weldon	■
ST5541-.875D1R030.3Z4	SIRA	10302893	1	D	0.875	0.875	0.875	4.000	0.030	4	Weldon	□
ST5541-1.00D1R030.3Z4	SIRA	10302894	1	D	1.000	1.000	1.000	4.000	0.030	4	Weldon	■
ST5541-.250D2R020.3Z4	SIRA	10302895	2	D	0.250	0.250	0.500	2.500	0.020	4	Weldon	□
ST5541-.281F2R020.3Z4	SIRA	10302897	2	F	0.281	0.313	0.563	2.500	0.020	4	Weldon	□
ST5541-.313D2R020.3Z4	SIRA	10302898	2	D	0.313	0.313	0.625	2.500	0.020	4	Weldon	□
ST5541-.375D2R020.3Z4	SIRA	10302900	2	D	0.375	0.375	0.750	2.500	0.020	4	Weldon	■
ST5541-.438D2R020.3Z4	SIRA	10302902	2	D	0.438	0.438	0.875	2.750	0.020	4	Weldon	□
ST5541-.500D2R030.3Z4	SIRA	10302904	2	D	0.500	0.500	1.000	3.000	0.030	4	Weldon	■
ST5541-.500D2R060.3Z4	SIRA	10302905	2	D	0.500	0.500	1.000	3.000	0.060	4	Weldon	□
ST5541-.500D2R120.3Z4	SIRA	10302907	2	D	0.500	0.500	1.000	3.000	0.120	4	Weldon	□
ST5541-.625D2R030.3Z4	SIRA	10302908	2	D	0.625	0.625	1.250	3.500	0.030	4	Weldon	■
ST5541-.625D2R060.3Z4	SIRA	10302909	2	D	0.625	0.625	1.250	3.500	0.060	4	Weldon	□
ST5541-.625D2R090.3Z4	SIRA	10302910	2	D	0.625	0.625	1.250	3.500	0.090	4	Weldon	□
ST5541-.625D2R120.3Z4	SIRA	10302911	2	D	0.625	0.625	1.250	3.500	0.120	4	Weldon	□
ST5541-.750D2R030.3Z4	SIRA	10302913	2	D	0.750	0.750	1.500	4.000	0.030	4	Weldon	■
ST5541-.750D2R060.3Z4	SIRA	10302914	2	D	0.750	0.750	1.500	4.000	0.060	4	Weldon	□
ST5541-.750D2R090.3Z4	SIRA	10302915	2	D	0.750	0.750	1.500	4.000	0.090	4	Weldon	□
ST5541-.750D2R120.3Z4	SIRA	10302916	2	D	0.750	0.750	1.500	4.000	0.120	4	Weldon	□
ST5541-.750D2R250.3Z4	SIRA	10302917	2	D	0.750	0.750	1.500	4.000	0.250	4	Weldon	□
ST5541-.875D2R030.3Z4	SIRA	10302919	2	D	0.875	0.875	1.750	4.000	0.030	4	Weldon	□
ST5541-1.00D2R030.3Z4	SIRA	10302920	2	D	1.000	1.000	2.000	5.000	0.030	4	Weldon	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

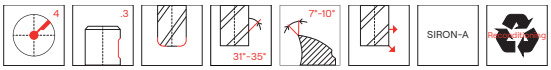
ST5541

Hochleistungsfräser – Stahl – Eckfräser – 4 Schneiden – Weldon – Eckenradius – Zoll





—Toleranzen:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Nachschleifen möglich



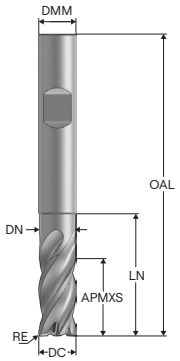
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	RE	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll	Zoll			
ST5541-.250D3R020.3Z4	SIRA	10302922	3	D	0.250	0.250	0.750	2.500	0.020	4	Weldon	□
ST5541-.281F3R020.3Z4	SIRA	10302923	3	F	0.281	0.313	0.844	2.500	0.020	4	Weldon	□
ST5541-.313D3R020.3Z4	SIRA	10302924	3	D	0.313	0.313	0.938	2.500	0.020	4	Weldon	□
ST5541-.375D3R020.3Z4	SIRA	10302925	3	D	0.375	0.375	1.125	3.000	0.020	4	Weldon	■
ST5541-.438D3R020.3Z4	SIRA	10302926	3	D	0.438	0.438	1.313	4.000	0.020	4	Weldon	□
ST5541-.500D3R030.3Z4	SIRA	10302927	3	D	0.500	0.500	1.250	3.000	0.030	4	Weldon	■
ST5541-.500D3R060.3Z4	SIRA	10302928	3	D	0.500	0.500	1.250	3.000	0.060	4	Weldon	□
ST5541-.500D3R120.3Z4	SIRA	10302929	3	D	0.500	0.500	1.250	3.000	0.120	4	Weldon	□
ST5541-.625D3R030.3Z4	SIRA	10302930	3	D	0.625	0.625	1.875	4.000	0.030	4	Weldon	■
ST5541-.625D3R060.3Z4	SIRA	10302931	3	D	0.625	0.625	1.875	4.000	0.060	4	Weldon	□
ST5541-.625D3R090.3Z4	SIRA	10302932	3	D	0.625	0.625	1.875	4.000	0.090	4	Weldon	□
ST5541-.625D3R120.3Z4	SIRA	10302933	3	D	0.625	0.625	1.875	4.000	0.120	4	Weldon	□
ST5541-.750D3R030.3Z4	SIRA	10302934	3	D	0.750	0.750	2.250	5.000	0.030	4	Weldon	■
ST5541-.750D3R060.3Z4	SIRA	10302935	3	D	0.750	0.750	2.250	5.000	0.060	4	Weldon	□
ST5541-.750D3R090.3Z4	SIRA	10302936	3	D	0.750	0.750	2.250	5.000	0.090	4	Weldon	□
ST5541-.750D3R120.3Z4	SIRA	10302937	3	D	0.750	0.750	2.250	5.000	0.120	4	Weldon	□
ST5541-.750D3R250.3Z4	SIRA	10302938	3	D	0.750	0.750	2.250	5.000	0.250	4	Weldon	□
ST5541-.875D3R030.3Z4	SIRA	10302939	3	D	0.875	0.875	2.625	5.000	0.030	4	Weldon	□
ST5541-1.00D3R030.3Z4	SIRA	10302940	3	D	1.000	1.000	3.000	6.000	0.030	4	Weldon	■
ST5541-.500D4R030.3Z4	SIRA	10302941	4	D	0.500	0.500	1.500	4.000	0.030	4	Weldon	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

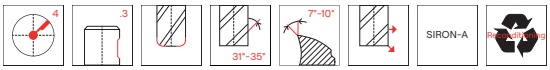
ST5541

Hochleistungsfräser – Stahl – Eckfräser – 4 Schneiden – Weldon – Eckenradius – Zoll





—Toleranzen:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0008"
—Nachschleifen möglich



Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zoll			
ST5541-.250E2R020.3Z4	SIRA	10302896	2	E	0.250	0.250	0.500	2.500	0.750	0.240	0.020	4	Weldon	☐
ST5541-.313E2R020.3Z4	SIRA	10302899	2	E	0.313	0.313	0.625	3.000	0.938	0.300	0.020	4	Weldon	☐
ST5541-.375E2R020.3Z4	SIRA	10302901	2	E	0.375	0.375	0.750	3.000	1.125	0.360	0.020	4	Weldon	☐
ST5541-.438E2R020.3Z4	SIRA	10302903	2	E	0.438	0.438	0.875	4.000	1.313	0.420	0.020	4	Weldon	☐
ST5541-.500E2R030.3Z4	SIRA	10302906	2	E	0.500	0.500	1.000	3.000	1.500	0.480	0.030	4	Weldon	☐
ST5541-.625E2R030.3Z4	SIRA	10302912	2	E	0.625	0.625	1.250	3.500	1.875	0.600	0.030	4	Weldon	☐
ST5541-.750E2R030.3Z4	SIRA	10302918	2	E	0.750	0.750	1.500	4.000	2.250	0.720	0.030	4	Weldon	☐
ST5541-1.00E2R030.3Z4	SIRA	10302921	2	E	1.000	1.000	2.000	5.000	3.000	0.960	0.030	4	Weldon	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – ST5541 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z										v_c
				3	4	5	6	8	10	12	16	20	25	
P1	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,16 *0.0065*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,3 *0.012*	220 (170 — 230) *720 (560 — 750)*
P2	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	0,24 *0.0095*	0,26 *0.010*	0,3 *0.012*	215 (160 — 220) *710 (530 — 720)*
P3	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,06 *0.0024*	0,075 *0.0030*	0,09 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	190 (140 — 200) *620 (460 — 650)*
P4	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,06 *0.0024*	0,075 *0.0030*	0,09 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	165 (130 — 170) *540 (430 — 550)*
P5	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*	160 (120 — 170) *520 (400 — 550)*
P6	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,2 *0.0080*	0,24 *0.0095*	0,28 *0.011*	180 (140 — 190) *590 (460 — 620)*
P7	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,2 *0.0080*	0,24 *0.0095*	0,28 *0.011*	170 (130 — 180) *560 (430 — 590)*
P8	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,06 *0.0024*	0,075 *0.0030*	0,09 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	160 (120 — 160) *520 (400 — 520)*
P11	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,042 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,2 *0.0080*	0,24 *0.0095*	0,28 *0.011*	165 (130 — 170) *540 (430 — 550)*
P12	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,03 *0.0012*	0,038 *0.0015*	0,048 *0.0019*	0,06 *0.0024*	0,08 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,19 *0.0075*	110 (80 — 110) *360 (270 — 360)*
K1	E	0,25 *0.25*	1,5 *1.5*	0,048 *0.0019*	0,065 *0.0026*	0,08 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	0,24 *0.0095*	0,26 *0.010*	0,3 *0.012*	215 (170 — 230) *710 (560 — 750)*
K2	E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*	195 (150 — 200) *640 (500 — 650)*
K3	E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*	165 (130 — 170) *540 (430 — 550)*
K4	E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*	160 (120 — 160) *520 (400 — 520)*
K5	E	0,25 *0.25*	1,5 *1.5*	0,038 *0.0015*	0,05 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,1 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,19 *0.0075*	0,22 *0.0085*	0,25 *0.010*	95 (71 — 100) *310 (240 — 320)*
K6	E	0,25 *0.25*	1,5 *1.5*	0,044 *0.0017*	0,055 *0.0022*	0,07 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	0,24 *0.0095*	0,28 *0.011*	140 (110 — 140) *460 (370 — 450)*
K7	E	0,25 *0.25*	1,5 *1.5*	0,038 *0.0015*	0,05 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,1 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,19 *0.0075*	0,22 *0.0085*	0,25 *0.010*	120 (91 — 130) *395 (300 — 420)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – ST5541 Nutfräsen

SMG		a_p/DC	f_z										v_c
			3	4	5	6	8	10	12	16	20	25	
P1	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,16 *0.0065*	195 (150 — 200) *640 (500 — 650)*
P2	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,16 *0.0065*	190 (140 — 200) *620 (460 — 650)*
P3	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,16 *0.0065*	165 (130 — 170) *540 (430 — 550)*
P4	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	145 (110 — 150) *475 (370 — 490)*
P5	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	135 (110 — 140) *445 (370 — 450)*
P6	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	155 (120 — 160) *510 (400 — 520)*
P7	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	145 (110 — 150) *475 (370 — 490)*
P8	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,16 *0.0065*	135 (110 — 140) *445 (370 — 450)*
P11	M/A/D/E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 150) *460 (370 — 490)*
P12	M/A/D/E	1,5 *1.5*	0,016 *0.00065*	0,022 *0.00085*	0,026 *0.0010*	0,032 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	85 (64 — 92) *280 (210 — 300)*
K1	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,16 *0.0065*	190 (150 — 200) *620 (500 — 650)*
K2	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	165 (130 — 170) *540 (430 — 550)*
K3	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 140) *460 (370 — 450)*
K4	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	135 (99 — 140) *445 (330 — 450)*
K5	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	80 (59 — 85) *260 (200 — 270)*
K6	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	120 (87 — 120) *395 (290 — 390)*
K7	E	1,5 *1.5*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	100 (76 — 100) *330 (250 — 320)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – ST5541 Eckfräsen – Zoll

SMG		a_e/DC	a_p/DC	f_z													v_c
				1/8	5/32	3/16	7/32	1/4	9/32	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	
P1	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,05 *0.0020*	0,06 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	0,1 *0.0040*	0,11 *0.0044*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	0,22 *0.0085*	0,25 *0.010*	0,28 *0.011*	0,3 *0.012*	220 (170 — 230) *720 (560 — 750)*
P2	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,05 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,09 *0.0036*	0,1 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	0,2 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,3 *0.012*	215 (160 — 220) *710 (530 — 720)*
P3	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,048 *0.0019*	0,06 *0.0024*	0,07 *0.0028*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,18 *0.0070*	0,22 *0.0085*	0,25 *0.010*	0,26 *0.010*	0,28 *0.011*	190 (140 — 200) *620 (460 — 650)*
P4	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,06 *0.0024*	0,07 *0.0028*	0,08 *0.0032*	0,095 *0.0038*	0,1 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	165 (130 — 170) *540 (430 — 550)*
P5	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,2 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	160 (120 — 170) *520 (400 — 550)*
P6	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,2 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	180 (140 — 190) *590 (460 — 620)*
P7	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,2 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	170 (130 — 180) *560 (430 — 590)*
P8	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,048 *0.0019*	0,06 *0.0024*	0,07 *0.0028*	0,085 *0.0034*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,18 *0.0070*	0,22 *0.0085*	0,25 *0.010*	0,26 *0.010*	0,28 *0.011*	160 (120 — 160) *520 (400 — 520)*
P11	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,2 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	165 (130 — 170) *540 (430 — 550)*
P12	M/A/D/E	0,25 *0.25*	1,5 *1.5*	0,03 *0.0012*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	0,06 *0.0024*	0,07 *0.0028*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,19 *0.0075*	110 (80 — 110) *360 (270 — 360)*
K1	E	0,25 *0.25*	1,5 *1.5*	0,05 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,09 *0.0036*	0,1 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	0,2 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	0,3 *0.012*	215 (170 — 230) *710 (560 — 750)*
K2	E	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,2 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	195 (150 — 200) *640 (500 — 650)*
K3	E	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,2 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	165 (130 — 170) *540 (430 — 550)*
K4	E	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,2 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	160 (120 — 160) *520 (400 — 520)*
K5	E	0,25 *0.25*	1,5 *1.5*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,07 *0.0028*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,19 *0.0075*	0,22 *0.0085*	0,24 *0.0095*	0,25 *0.010*	95 (71 — 100) *310 (240 — 320)*
K6	E	0,25 *0.25*	1,5 *1.5*	0,046 *0.0018*	0,055 *0.0022*	0,07 *0.0028*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,2 *0.0080*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	140 (110 — 140) *460 (370 — 450)*
K7	E	0,25 *0.25*	1,5 *1.5*	0,04 *0.0016*	0,05 *0.0020*	0,06 *0.0024*	0,07 *0.0028*	0,08 *0.0032*	0,09 *0.0036*	0,1 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,19 *0.0075*	0,22 *0.0085*	0,24 *0.0095*	0,25 *0.010*	120 (91 — 130) *395 (300 — 420)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – ST5541 Nutfräsen – Zoll

SMG		a_p/DC	f_z														v_c
			1/8	5/32	3/16	7/32	1/4	9/32	5/16	3/8	7/16	1/2	5/8	3/4	7/8	1	
P1	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,16	195 (150 — 200)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*640 (500 — 650)*
P2	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,17	190 (140 — 200)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*620 (460 — 650)*
P3	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,16	165 (130 — 170)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*540 (430 — 550)*
P4	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	145 (110 — 150)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*475 (370 — 490)*
P5	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	135 (110 — 140)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*445 (370 — 450)*
P6	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	155 (120 — 160)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*510 (400 — 520)*
P7	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	145 (110 — 150)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*475 (370 — 490)*
P8	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,16	135 (110 — 140)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*445 (370 — 450)*
P11	M/A/D/E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	140 (110 — 150)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*460 (370 — 490)*
P12	M/A/D/E	1,5	0,017	0,022	0,025	0,030	0,034	0,038	0,042	0,050	0,060	0,065	0,080	0,085	0,095	0,10	85 (64 — 92)
		1.5	*0.00065*	*0.00085*	*0.0010*	*0.0012*	*0.0013*	*0.0015*	*0.0017*	*0.0020*	*0.0024*	*0.0026*	*0.0032*	*0.0034*	*0.0038*	*0.0040*	*280 (210 — 300)*
K1	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,17	190 (150 — 200)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0065*	*620 (500 — 650)*
K2	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	165 (130 — 170)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*540 (430 — 550)*
K3	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	140 (110 — 140)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*460 (370 — 450)*
K4	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	135 (99 — 140)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*445 (330 — 450)*
K5	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,13	0,14	80 (59 — 85)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0050*	*0.0055*	*260 (200 — 270)*
K6	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,14	0,15	120 (87 — 120)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0055*	*0.0060*	*395 (290 — 390)*
K7	E	1,5	0,020	0,026	0,030	0,036	0,042	0,046	0,050	0,060	0,070	0,085	0,10	0,12	0,13	0,14	100 (76 — 100)
		1.5	*0.00080*	*0.0010*	*0.0012*	*0.0014*	*0.0017*	*0.0018*	*0.0020*	*0.0024*	*0.0028*	*0.0034*	*0.0040*	*0.0048*	*0.0050*	*0.0055*	*330 (250 — 320)*

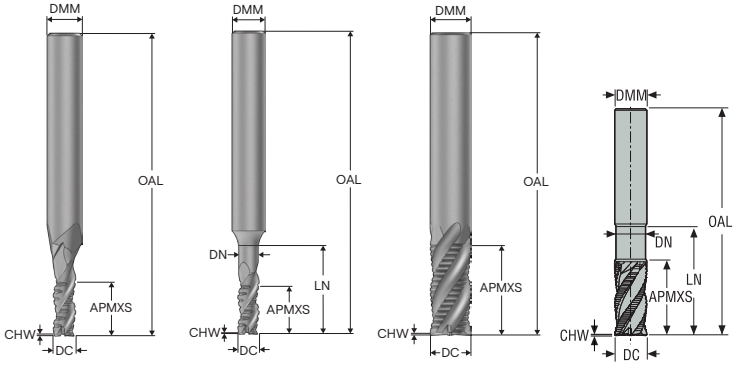
Schnittdaten, siehe Seite 699 - 707

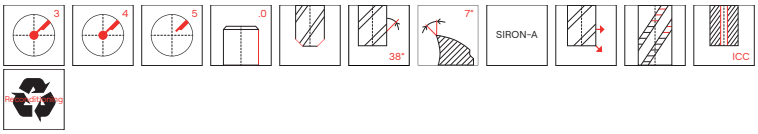
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JHP993

Hochleistungsfräser – Stahl – Eckfräser – 3-5 Schneiden – Zylindrisch – Fase







—Toleranzen:
—DMM=h5
—DC=-0,02/-0,1 mm
—CHW= ±0,05 mm
—Nachschleifen möglich, wenn DC ≥ Ø6 ist

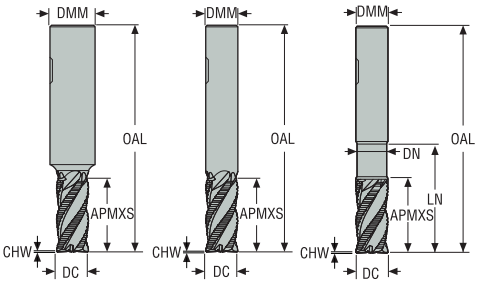
Bezeichnung	Produkt-nummer	Längen-index		Spanteiler	CSP	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
						mm	mm	mm	mm	mm	mm	mm			
JHP993040F2C.0Z3-SIRA	02826806	2	F	■	–	4,0	6,0	10,0	50,0	–	–	0,15	3	Cylindrical	■
JHP993050F2C.0Z4-SIRA	02826808	2	F	■	–	5,0	6,0	12,0	55,0	–	–	0,15	4	Cylindrical	■
JHP993060D2C.0Z4-SIRA	02826809	2	D	■	–	6,0	6,0	14,0	55,0	–	–	0,2	4	Cylindrical	■
JHP993075F2C.0Z4-SIRA	02826811	2	F	■	–	7,5	8,0	17,0	60,0	–	–	0,2	4	Cylindrical	■
JHP993080D2C.0Z4A-SIRA	02826814	2	D	■	■	8,0	8,0	18,0	60,0	–	–	0,2	4	Cylindrical	■
JHP993080D2C.0Z4-SIRA	02826812	2	D	■	–	8,0	8,0	18,0	60,0	–	–	0,2	4	Cylindrical	■
JHP993095F2C.0Z4-SIRA	02826816	2	F	■	–	9,5	10,0	20,0	70,0	–	–	0,2	4	Cylindrical	■
JHP993100D2C.0Z4A-SIRA	02826818	2	D	■	■	10,0	10,0	22,0	70,0	–	–	0,2	4	Cylindrical	■
JHP993100D2C.0Z4-SIRA	02826817	2	D	■	–	10,0	10,0	22,0	70,0	–	–	0,2	4	Cylindrical	■
JHP993115F2C.0Z4-SIRA	02826820	2	F	■	–	11,5	12,0	25,0	80,0	–	–	0,2	4	Cylindrical	■
JHP993120D2C.0Z4A-SIRA	02826822	2	D	■	■	12,0	12,0	26,0	80,0	–	–	0,2	4	Cylindrical	■
JHP993120D2C.0Z4-SIRA	02826821	2	D	■	–	12,0	12,0	26,0	80,0	–	–	0,2	4	Cylindrical	■
JHP993140D2C.0Z4-SIRA	02826824	2	D	■	–	14,0	14,0	30,0	80,0	–	–	0,3	4	Cylindrical	■
JHP993160D2C.0Z4A-SIRA	02856501	2	D	■	■	16,0	16,0	34,0	90,0	–	–	0,3	4	Cylindrical	■
JHP993160D2C.0Z4-SIRA	02856499	2	D	■	–	16,0	16,0	34,0	90,0	–	–	0,3	4	Cylindrical	■
JHP993160D2C.0Z5-SIRA	02826825	2	D	■	–	16,0	16,0	34,0	90,0	–	–	0,3	5	Cylindrical	■
JHP993200D2C.0Z4A-SIRA	02856506	2	D	■	■	20,0	20,0	42,0	100,0	–	–	0,5	4	Cylindrical	■
JHP993200D2C.0Z4-SIRA	02856505	2	D	■	–	20,0	20,0	42,0	100,0	–	–	0,5	4	Cylindrical	■
JHP993200D2C.0Z5-SIRA	02826828	2	D	■	–	20,0	20,0	42,0	100,0	–	–	0,5	5	Cylindrical	■
JHP993250D2C.0Z4A-SIRA	02856510	2	D	■	■	25,0	25,0	52,0	125,0	–	–	0,5	4	Cylindrical	■
JHP993040G3C.0Z3-SIRA	02826807	3	G	■	–	4,0	6,0	10,0	55,0	15,0	3,7	0,15	3	Cylindrical	■
JHP993060E3C.0Z4-SIRA	02826810	3	E	■	–	6,0	6,0	14,0	65,0	24,0	5,6	0,2	4	Cylindrical	■
JHP993080E3C.0Z4-SIRA	02826815	3	E	■	–	8,0	8,0	18,0	70,0	32,0	7,4	0,2	4	Cylindrical	■
JHP993100E3C.0Z4-SIRA	02826819	3	E	■	–	10,0	10,0	22,0	85,0	40,0	9,4	0,2	4	Cylindrical	■
JHP993120E3C.0Z4-SIRA	02826823	3	E	■	–	12,0	12,0	26,0	100,0	50,0	11,4	0,2	4	Cylindrical	■
JHP993160E3C.0Z4-SIRA	02856502	3	E	■	–	16,0	16,0	34,0	110,0	60,0	15,4	0,3	4	Cylindrical	■
JHP993200E3C.0Z4-SIRA	02856507	3	E	■	–	20,0	20,0	42,0	125,0	70,0	19,2	0,5	4	Cylindrical	■

■ **Lagerstandard.**

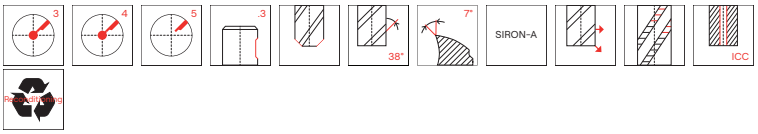
JHP993

Hochleistungsfräser – Stahl – Eckfräser – 3-5 Schneiden – Weldon – Fase





– Toleranzen:
– DMM=h5
– DC=-0,02/-0,1 mm
– CHW= ±0,05 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist



Bezeichnung	Produkt-nummer	Längen-index		Spanteiler	CSP	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
						mm	mm	mm	mm	mm	mm	mm			
JHP993040F2C.3Z3-SIRA	02828150	2	F	■	–	4,0	6,0	10,0	50,0	–	–	0,15	3	Weldon	■
JHP993050F2C.3Z4-SIRA	02828152	2	F	■	–	5,0	6,0	12,0	55,0	–	–	0,15	4	Weldon	■
JHP993060D2C.3Z4-SIRA	02828153	2	D	■	–	6,0	6,0	14,0	55,0	–	–	0,2	4	Weldon	■
JHP993075F2C.3Z4-SIRA	02828155	2	F	■	–	7,5	8,0	17,0	60,0	–	–	0,2	4	Weldon	■
JHP993080D2C.3Z4A-SIRA	02828246	2	D	■	■	8,0	8,0	18,0	60,0	–	–	0,2	4	Weldon	□
JHP993080D2C.3Z4-SIRA	02828156	2	D	■	–	8,0	8,0	18,0	60,0	–	–	0,2	4	Weldon	■
JHP993095F2C.3Z4-SIRA	02828158	2	F	■	–	9,5	10,0	20,0	70,0	–	–	0,2	4	Weldon	■
JHP993100D2C.3Z4A-SIRA	02828247	2	D	■	■	10,0	10,0	22,0	70,0	–	–	0,2	4	Weldon	□
JHP993100D2C.3Z4-SIRA	02828159	2	D	■	–	10,0	10,0	22,0	70,0	–	–	0,2	4	Weldon	■
JHP993120D2C.3Z4A-SIRA	02828248	2	D	■	■	12,0	12,0	26,0	80,0	–	–	0,2	4	Weldon	□
JHP993120D2C.3Z4-SIRA	02828162	2	D	■	–	12,0	12,0	26,0	80,0	–	–	0,2	4	Weldon	■
JHP993140D2C.3Z4-SIRA	02828164	2	D	■	–	14,0	14,0	30,0	80,0	–	–	0,3	4	Weldon	■
JHP993160D2C.3Z4A-SIRA	02856512	2	D	■	■	16,0	16,0	34,0	90,0	–	–	0,3	4	Weldon	■
JHP993160D2C.3Z4-SIRA	02856500	2	D	■	–	16,0	16,0	34,0	90,0	–	–	0,3	4	Weldon	■
JHP993160D2C.3Z5-SIRA	02828165	2	D	■	–	16,0	16,0	34,0	90,0	–	–	0,3	5	Weldon	■
JHP993200D2C.3Z4A-SIRA	02856513	2	D	■	■	20,0	20,0	42,0	100,0	–	–	0,5	4	Weldon	■
JHP993200D2C.3Z4-SIRA	02856504	2	D	■	–	20,0	20,0	42,0	100,0	–	–	0,5	4	Weldon	■
JHP993200D2C.3Z5-SIRA	02828167	2	D	■	–	20,0	20,0	42,0	100,0	–	–	0,5	5	Weldon	■
JHP993250D2C.3Z4A-SIRA	02856514	2	D	■	■	25,0	25,0	52,0	125,0	–	–	0,5	4	Weldon	■
JHP993250D2C.3Z4-SIRA	02856509	2	D	■	–	25,0	25,0	52,0	125,0	–	–	0,5	4	Weldon	■
JHP993060E3C.3Z4-SIRA	02828154	3	E	■	–	6,0	6,0	14,0	65,0	24,0	5,6	0,2	4	Weldon	■
JHP993080E3C.3Z4-SIRA	02828157	3	E	■	–	8,0	8,0	18,0	70,0	32,0	7,4	0,2	4	Weldon	■
JHP993100E3C.3Z4-SIRA	02828160	3	E	■	–	10,0	10,0	22,0	85,0	40,0	9,4	0,2	4	Weldon	■
JHP993120E3C.3Z4-SIRA	02828163	3	E	■	–	12,0	12,0	26,0	100,0	50,0	11,4	0,2	4	Weldon	■
JHP993160E3C.3Z4-SIRA	02856503	3	E	■	–	16,0	16,0	34,0	110,0	60,0	15,4	0,3	4	Weldon	■
JHP993200E3C.3Z4-SIRA	02856508	3	E	■	–	20,0	20,0	42,0	125,0	70,0	19,2	0,5	4	Weldon	■
JHP993200E3C.3Z5-SIRA	02828168	3	E	■	–	20,0	20,0	42,0	125,0	70,0	19,2	0,5	5	Weldon	■
JHP993250E3C.3Z4-SIRA	02856511	3	E	■	–	25,0	25,0	52,0	150,0	90,0	24,0	0,5	4	Weldon	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JHP993 Eckfräsen PCEDC=3 und PCEDC=4

SMG		a_e/DC	a_p/DC	f_z										v_c
				4	5	6	8	10	12	14	16	20	25	
P1	E/M/A	0.400 *0,400*	1.7 *1,7*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	230 (200 — 260) *750 (660 — 850)*
P2	E/M/A	0.400 *0,400*	1.7 *1,7*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	225 (200 — 250) *740 (660 — 820)*
P3	E/M/A	0.400 *0,400*	1.7 *1,7*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	195 (170 — 220) *640 (560 — 720)*
P4	E/M/A	0.400 *0,400*	1.7 *1,7*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.18 *0,0070*	0.20 *0,0080*	175 (150 — 190) *570 (500 — 620)*
P5	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	165 (150 — 190) *540 (500 — 620)*
P6	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	185 (160 — 210) *610 (530 — 680)*
P7	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	175 (160 — 200) *570 (530 — 650)*
P8	E/M/A	0.400 *0,400*	1.7 *1,7*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	160 (140 — 180) *520 (460 — 590)*
P11	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	170 (150 — 190) *560 (500 — 620)*
P12	E/M/A	0.400 *0,400*	1.7 *1,7*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	110 (95 — 120) *360 (320 — 390)*
K1	E/M/A	0.400 *0,400*	1.7 *1,7*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	225 (200 — 250) *740 (660 — 820)*
K2	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	200 (180 — 220) *660 (600 — 720)*
K3	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	170 (150 — 190) *560 (500 — 620)*
K4	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	160 (140 — 180) *520 (460 — 590)*
K5	E/M/A	0.400 *0,400*	1.7 *1,7*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	100 (86 — 110) *330 (290 — 360)*
K6	E/M/A	0.400 *0,400*	1.7 *1,7*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	0.17 *0,0065*	0.20 *0,0080*	145 (130 — 160) *475 (430 — 520)*
K7	E/M/A	0.400 *0,400*	1.7 *1,7*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	125 (110 — 140) *410 (370 — 450)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JHP993 Eckfräsen PCEDC=5

SMG		a_e/DC	a_p/DC	f_z		v_c
				16	20	
P1	E/M/A	0.376 *0,376*	1.0 *1,0*	0.17 *0,0065*	0.22 *0,0085*	205 (180 — 230) *670 (600 — 750)*
P2	E/M/A	0.376 *0,376*	1.0 *1,0*	0.18 *0,0070*	0.22 *0,0085*	195 (170 — 220) *640 (560 — 720)*
P3	E/M/A	0.376 *0,376*	1.0 *1,0*	0.17 *0,0065*	0.20 *0,0080*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	155 (140 — 170) *510 (460 — 550)*
P5	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	145 (130 — 160) *475 (430 — 520)*
P6	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	165 (150 — 180) *540 (500 — 590)*
P7	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	155 (140 — 170) *510 (460 — 550)*
P8	E/M/A	0.376 *0,376*	1.0 *1,0*	0.17 *0,0065*	0.20 *0,0080*	145 (130 — 160) *475 (430 — 520)*
P11	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	150 (130 — 170) *490 (430 — 550)*
P12	E/M/A	0.376 *0,376*	1.0 *1,0*	0.11 *0,0044*	0.13 *0,0050*	100 (85 — 110) *330 (280 — 360)*
K1	E/M/A	0.376 *0,376*	1.0 *1,0*	0.18 *0,0070*	0.22 *0,0085*	195 (170 — 220) *640 (560 — 720)*
K2	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	175 (160 — 200) *570 (530 — 650)*
K3	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	150 (130 — 170) *490 (430 — 550)*
K4	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	145 (130 — 160) *475 (430 — 520)*
K5	E/M/A	0.376 *0,376*	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	85 (75 — 99) *280 (250 — 320)*
K6	E/M/A	0.376 *0,376*	1.0 *1,0*	0.16 *0,0065*	0.20 *0,0080*	125 (110 — 140) *410 (370 — 450)*
K7	E/M/A	0.376 *0,376*	1.0 *1,0*	0.15 *0,0060*	0.18 *0,0070*	110 (96 — 120) *360 (320 — 390)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JHP993 Nutfräsen PCEDC=3 und PCEDC=4

SMG		a_p/DC	f_z										v_c
			4	5	6	8	10	12	14	16	20	25	
P1	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	195 (170 — 220) *640 (560 — 720)*
P3	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	165 (150 — 190) *540 (500 — 620)*
P4	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	145 (130 — 160) *475 (430 — 520)*
P5	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	140 (130 — 160) *460 (430 — 520)*
P6	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	155 (140 — 170) *510 (460 — 550)*
P7	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	150 (130 — 160) *490 (430 — 520)*
P8	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	140 (130 — 160) *460 (430 — 520)*
P11	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	145 (130 — 160) *475 (430 — 520)*
P12	E/M/A	1.5 *1,5*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	90 (76 — 100) *295 (250 — 320)*
K1	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	195 (170 — 220) *640 (560 — 720)*
K2	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	170 (150 — 190) *560 (500 — 620)*
K3	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	145 (130 — 160) *475 (430 — 520)*
K4	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	135 (120 — 150) *445 (400 — 490)*
K5	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	80 (70 — 93) *260 (230 — 300)*
K6	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	120 (110 — 130) *395 (370 — 420)*
K7	E/M/A	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	105 (90 — 110) *345 (300 — 360)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JHP993 Nutfräsen PCEDC=5

SMG		a_p/DC	f_z		v_c
			16	20	
P1	E/M/A	0.44 *0,44*	0.17 *0,0065*	0.20 *0,0080*	160 (140 — 180) *520 (460 — 590)*
P2	E/M/A	0.44 *0,44*	0.17 *0,0065*	0.22 *0,0085*	155 (140 — 170) *510 (460 — 550)*
P3	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.20 *0,0080*	135 (120 — 150) *445 (400 — 490)*
P4	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.20 *0,0080*	120 (110 — 130) *395 (370 — 420)*
P5	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	115 (99 — 130) *375 (330 — 420)*
P6	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	130 (120 — 140) *425 (400 — 450)*
P7	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	120 (110 — 130) *395 (370 — 420)*
P8	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.20 *0,0080*	115 (99 — 130) *375 (330 — 420)*
P11	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	120 (110 — 130) *395 (370 — 420)*
P12	E/M/A	0.44 *0,44*	0.11 *0,0044*	0.13 *0,0050*	80 (68 — 89) *260 (230 — 290)*
K1	E/M/A	0.44 *0,44*	0.17 *0,0065*	0.22 *0,0085*	160 (140 — 180) *520 (460 — 590)*
K2	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	140 (120 — 150) *460 (400 — 490)*
K3	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	120 (110 — 130) *395 (370 — 420)*
K4	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	115 (97 — 120) *375 (320 — 390)*
K5	E/M/A	0.44 *0,44*	0.14 *0,0055*	0.17 *0,0065*	70 (60 — 79) *230 (200 — 250)*
K6	E/M/A	0.44 *0,44*	0.16 *0,0065*	0.19 *0,0075*	100 (86 — 110) *330 (290 — 360)*
K7	E/M/A	0.44 *0,44*	0.14 *0,0055*	0.17 *0,0065*	90 (77 — 100) *295 (260 — 320)*

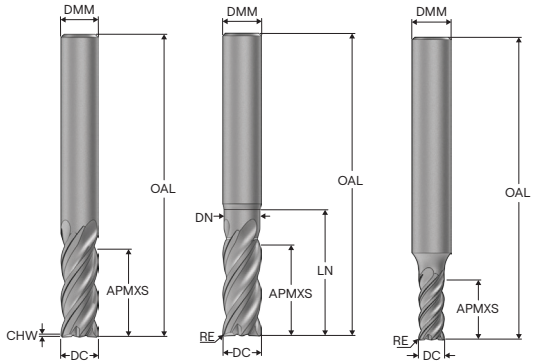
Schnittdaten, siehe Seite 699 - 707

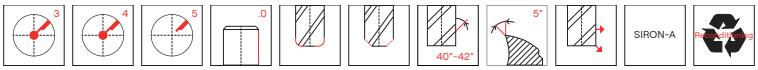
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JHP951

Hochleistungsfräser – Eckfräser – Stahl – 3-5 Schneiden – Zylindrisch – Eckenradius oder Fase







– Toleranzen:
– DMM=h5
– DC=e7
– RE= ±0,02 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

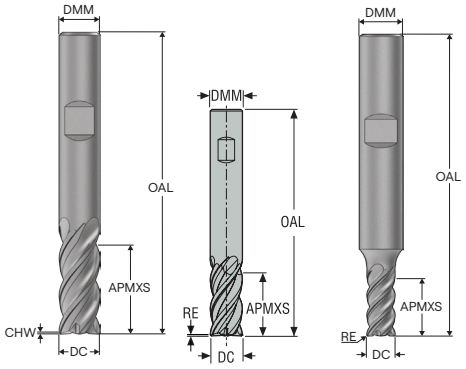
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm	mm			
JHP951030F2C.0Z3-SIRA	02828192	2	F	3,0	6,0	8,0	50,0	–	–	0,1	–	3	Cylindrical	■
JHP951030F2R020.0Z3-SIRA	02828191	2	F	3,0	6,0	8,0	50,0	–	–	–	0,2	3	Cylindrical	■
JHP951030F2R050.0Z3-SIRA	02828190	2	F	3,0	6,0	8,0	50,0	–	–	–	0,5	3	Cylindrical	■
JHP951040F2C.0Z4-SIRA	02828197	2	F	4,0	6,0	10,0	55,0	–	–	0,15	–	4	Cylindrical	■
JHP951040F2R020.0Z4-SIRA	02828194	2	F	4,0	6,0	10,0	55,0	–	–	–	0,2	4	Cylindrical	■
JHP951040F2R050.0Z4-SIRA	02828195	2	F	4,0	6,0	10,0	55,0	–	–	–	0,5	4	Cylindrical	■
JHP951050F2C.0Z4-SIRA	02828201	2	F	5,0	6,0	12,0	55,0	–	–	0,2	–	4	Cylindrical	■
JHP951050F2R020.0Z4-SIRA	02828199	2	F	5,0	6,0	12,0	55,0	–	–	–	0,2	4	Cylindrical	■
JHP951050F2R050.0Z4-SIRA	02828198	2	F	5,0	6,0	12,0	55,0	–	–	–	0,5	4	Cylindrical	■
JHP951060D2C.0Z4-SIRA	02828205	2	D	6,0	6,0	14,0	55,0	–	–	0,2	–	4	Cylindrical	■
JHP951060D2R020.0Z4-SIRA	02828203	2	D	6,0	6,0	14,0	55,0	–	–	–	0,2	4	Cylindrical	■
JHP951060D2R050.0Z4-SIRA	02828202	2	D	6,0	6,0	14,0	55,0	–	–	–	0,5	4	Cylindrical	■
JHP951080D2C.0Z4-SIRA	02828212	2	D	8,0	8,0	18,0	60,0	–	–	0,3	–	4	Cylindrical	■
JHP951080D2R020.0Z4-SIRA	02828209	2	D	8,0	8,0	18,0	60,0	–	–	–	0,2	4	Cylindrical	■
JHP951080D2R050.0Z4-SIRA	02828207	2	D	8,0	8,0	18,0	60,0	–	–	–	0,5	4	Cylindrical	■
JHP951080D2R100.0Z4-SIRA	02828208	2	D	8,0	8,0	18,0	60,0	–	–	–	1,0	4	Cylindrical	■
JHP951100E2C.0Z4-SIRA	02828218	2	E	10,0	10,0	22,0	70,0	28,0	9,4	0,3	–	4	Cylindrical	■
JHP951100E2R050.0Z4-SIRA	02828216	2	E	10,0	10,0	22,0	70,0	28,0	9,4	–	0,5	4	Cylindrical	■
JHP951100E2R100.0Z4-SIRA	02828214	2	E	10,0	10,0	22,0	70,0	28,0	9,4	–	1,0	4	Cylindrical	■
JHP951120E2C.0Z4-SIRA	02828226	2	E	12,0	12,0	26,0	80,0	33,0	11,4	0,4	–	4	Cylindrical	■
JHP951120E2R050.0Z4-SIRA	02828224	2	E	12,0	12,0	26,0	80,0	33,0	11,4	–	0,5	4	Cylindrical	■
JHP951120E2R100.0Z4-SIRA	02828222	2	E	12,0	12,0	26,0	80,0	33,0	11,4	–	1,0	4	Cylindrical	■
JHP951160E2C.0Z4-SIRA	02927873	2	E	16,0	16,0	34,0	90,0	40,0	15,0	0,5	–	4	Cylindrical	■
JHP951160E2C.0Z5-SIRA	02828232	2	E	16,0	16,0	34,0	90,0	40,0	15,4	0,5	–	5	Cylindrical	■
JHP951160E2R050.0Z4-SIRA	02927875	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	0,5	4	Cylindrical	■
JHP951160E2R050.0Z5-SIRA	02828230	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	0,5	5	Cylindrical	■
JHP951160E2R100.0Z4-SIRA	02927876	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	1,0	4	Cylindrical	■
JHP951160E2R100.0Z5-SIRA	02828231	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	1,0	5	Cylindrical	■

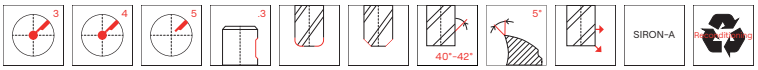
■ **Lagerstandard.**

JHP951

Hochleistungsfräser – Eckfräser – Stahl – 3-5 Schneiden – Weldon – Eckenradius oder Fase







- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	CHW	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm	mm			
JHP951030F2C.3Z3-SIRA	02828193	2	F	3,0	6,0	8,0	50,0	–	–	0,1	–	3	Weldon	■
JHP951030F2R020.3Z3-SIRA	02828260	2	F	3,0	6,0	8,0	50,0	–	–	–	0,2	3	Weldon	■
JHP951030F2R050.3Z3-SIRA	02828259	2	F	3,0	6,0	8,0	50,0	–	–	–	0,5	3	Weldon	□
JHP951040F2C.3Z4-SIRA	02828196	2	F	4,0	6,0	10,0	55,0	–	–	0,15	–	4	Weldon	■
JHP951040F2R020.3Z4-SIRA	02828261	2	F	4,0	6,0	10,0	55,0	–	–	–	0,2	4	Weldon	□
JHP951040F2R050.3Z4-SIRA	02828262	2	F	4,0	6,0	10,0	55,0	–	–	–	0,5	4	Weldon	□
JHP951050F2C.3Z4-SIRA	02828200	2	F	5,0	6,0	12,0	55,0	–	–	0,2	–	4	Weldon	■
JHP951050F2R020.3Z4-SIRA	02828264	2	F	5,0	6,0	12,0	55,0	–	–	–	0,2	4	Weldon	□
JHP951050F2R050.3Z4-SIRA	02828263	2	F	5,0	6,0	12,0	55,0	–	–	–	0,5	4	Weldon	□
JHP951060D2C.3Z4-SIRA	02828206	2	D	6,0	6,0	14,0	55,0	–	–	0,2	–	4	Weldon	■
JHP951060D2R020.3Z4-SIRA	02828266	2	D	6,0	6,0	14,0	55,0	–	–	–	0,2	4	Weldon	□
JHP951060D2R050.3Z4-SIRA	02828265	2	D	6,0	6,0	14,0	55,0	–	–	–	0,5	4	Weldon	□
JHP951080D2C.3Z4-SIRA	02828210	2	D	8,0	8,0	18,0	60,0	–	–	0,3	–	4	Weldon	■
JHP951080D2R020.3Z4-SIRA	02828269	2	D	8,0	8,0	18,0	60,0	–	–	–	0,2	4	Weldon	□
JHP951080D2R050.3Z4-SIRA	02828267	2	D	8,0	8,0	18,0	60,0	–	–	–	0,5	4	Weldon	■
JHP951080D2R100.3Z4-SIRA	02828268	2	D	8,0	8,0	18,0	60,0	–	–	–	1,0	4	Weldon	□
JHP951100E2C.3Z4-SIRA	02828220	2	E	10,0	10,0	22,0	70,0	28,0	9,4	0,3	–	4	Weldon	■
JHP951100E2R050.3Z4-SIRA	02828271	2	E	10,0	10,0	22,0	70,0	28,0	9,4	–	0,5	4	Weldon	■
JHP951100E2R100.3Z4-SIRA	02828270	2	E	10,0	10,0	22,0	70,0	28,0	9,4	–	1,0	4	Weldon	□
JHP951120E2C.3Z4-SIRA	02828228	2	E	12,0	12,0	26,0	80,0	33,0	11,4	0,4	–	4	Weldon	■
JHP951120E2R050.3Z4-SIRA	02828273	2	E	12,0	12,0	26,0	80,0	33,0	11,4	–	0,5	4	Weldon	■
JHP951120E2R100.3Z4-SIRA	02828272	2	E	12,0	12,0	26,0	80,0	33,0	11,4	–	1,0	4	Weldon	■
JHP951160E2C.3Z4-SIRA	02927874	2	E	16,0	16,0	34,0	90,0	40,0	15,0	0,5	–	4	Weldon	■
JHP951160E2C.3Z5-SIRA	02828233	2	E	16,0	16,0	34,0	90,0	40,0	15,4	0,5	–	5	Weldon	■
JHP951160E2R050.3Z4-SIRA	02927879	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	0,5	4	Weldon	■
JHP951160E2R050.3Z5-SIRA	02828275	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	0,5	5	Weldon	□
JHP951160E2R100.3Z4-SIRA	02927880	2	E	16,0	16,0	34,0	90,0	40,0	15,0	–	1,0	4	Weldon	□
JHP951160E2R100.3Z5-SIRA	02828276	2	E	16,0	16,0	34,0	90,0	40,0	15,4	–	1,0	5	Weldon	□
JHP951200E2R050.3Z4-SIRA	02927877	2	E	20,0	20,0	42,0	100,0	48,0	19,0	–	0,5	4	Weldon	■
JHP951200E2R050.3Z5-SIRA	02828235	2	E	20,0	20,0	42,0	100,0	48,0	19,4	–	0,5	5	Weldon	■
JHP951200E2R100.3Z4-SIRA	02927878	2	E	20,0	20,0	42,0	100,0	48,0	19,0	–	1,0	4	Weldon	■
JHP951200E2R100.3Z5-SIRA	02828234	2	E	20,0	20,0	42,0	100,0	48,0	19,4	–	1,0	5	Weldon	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JHP951 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z									v_c
				3	4	5	6	8	10	12	16	20	
P1	E/M/A	0.400 *0,400*	1.7 *1,7*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	230 (200 — 260) *750 (660 — 850)*
P2	E/M/A	0.400 *0,400*	1.7 *1,7*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.17 *0,0065*	0.19 *0,0075*	220 (200 — 250) *720 (660 — 820)*
P3	E/M/A	0.400 *0,400*	1.7 *1,7*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	190 (170 — 210) *620 (560 — 680)*
P4	E/M/A	0.400 *0,400*	1.7 *1,7*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	170 (150 — 190) *560 (500 — 620)*
P5	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	165 (150 — 180) *540 (500 — 590)*
P6	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	185 (160 — 210) *610 (530 — 680)*
P7	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	175 (150 — 190) *570 (500 — 620)*
P8	E/M/A	0.400 *0,400*	1.7 *1,7*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	160 (140 — 180) *520 (460 — 590)*
P11	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (150 — 190) *560 (500 — 620)*
P12	E/M/A	0.400 *0,400*	1.7 *1,7*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	110 (94 — 120) *360 (310 — 390)*
K1	E/M/A	0.400 *0,400*	1.7 *1,7*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.17 *0,0065*	0.19 *0,0075*	225 (200 — 250) *740 (660 — 820)*
K2	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	200 (180 — 220) *660 (600 — 720)*
K3	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (150 — 190) *560 (500 — 620)*
K4	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	160 (140 — 180) *520 (460 — 590)*
K5	E/M/A	0.400 *0,400*	1.7 *1,7*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	100 (85 — 110) *330 (280 — 360)*
K6	E/M/A	0.400 *0,400*	1.7 *1,7*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	140 (130 — 160) *460 (430 — 520)*
K7	E/M/A	0.400 *0,400*	1.7 *1,7*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	125 (110 — 140) *410 (370 — 450)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JHP951 Nutfräsen

SMG		a_p/DC	f_z									v_c
			3	4	5	6	8	10	12	16	20	
P1	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	195 (170 — 220) *640 (560 — 720)*
P2	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	190 (170 — 210) *620 (560 — 680)*
P3	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	165 (150 — 180) *540 (500 — 590)*
P4	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	145 (130 — 160) *475 (430 — 520)*
P5	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	140 (120 — 150) *460 (400 — 490)*
P6	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	155 (140 — 170) *510 (460 — 550)*
P7	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	145 (130 — 160) *475 (430 — 520)*
P8	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	140 (120 — 150) *460 (400 — 490)*
P11	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	145 (130 — 160) *475 (430 — 520)*
P12	E/M/A	1.5 *1,5*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	85 (75 — 99) *280 (250 — 320)*
K1	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	195 (170 — 220) *640 (560 — 720)*
K2	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	170 (150 — 190) *560 (500 — 620)*
K3	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	140 (130 — 160) *460 (430 — 520)*
K4	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	135 (120 — 150) *445 (400 — 490)*
K5	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.15 *0,0060*	80 (70 — 92) *260 (230 — 300)*
K6	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	120 (110 — 130) *395 (370 — 420)*
K7	E/M/A	1.5 *1,5*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.15 *0,0060*	105 (89 — 110) *345 (300 — 360)*

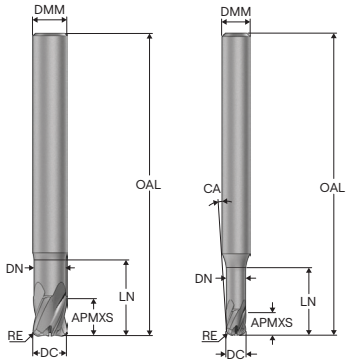
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

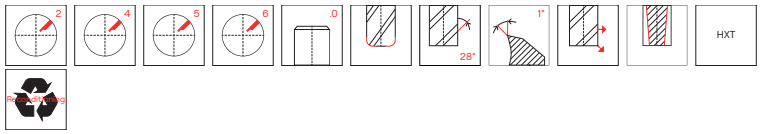
JH142

Hochgeschwindigkeitsfräsen – Hochpräzise – Torisch – Gehärteter Stahl – 2-6 Schneiden – Zylindrisch – Eckenra-





—Toleranzen:
—Rundlaufabweichung = <0,005 mm
—DMM = h5
—DC= 0-0,01 mm
—RE= ±0,005 mm
—Nachschleifen möglich, wenn DC ≥ Ø6 ist



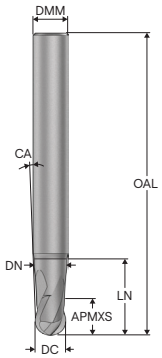
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
JH142020G2R030.0Z2-HXT	02968223	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	2	Cylindrical	■
JH142020G2R030.0Z4-HXT	02968224	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	4	Cylindrical	■
JH142020G2R050.0Z2-HXT	02968225	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	2	Cylindrical	■
JH142020G2R050.0Z4-HXT	02968226	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	4	Cylindrical	■
JH142030G2R050.0Z2-HXT	02968227	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	2	Cylindrical	■
JH142030G2R050.0Z4-HXT	02968228	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	4	Cylindrical	■
JH142030G2R100.0Z2-HXT	02968229	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	2	Cylindrical	■
JH142030G2R100.0Z4-HXT	02968230	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	4	Cylindrical	■
JH142040G2R030.0Z2-HXT	02968231	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	2	Cylindrical	■
JH142040G2R030.0Z4-HXT	02970110	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	4	Cylindrical	■
JH142040G2R050.0Z4-HXT	02968232	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,5	5,44	4	Cylindrical	■
JH142040G2R100.0Z4-HXT	02968233	2	G	4,0	6,0	4,0	50,0	8,0	3,7	1,0	5,69	4	Cylindrical	■
JH142060E2R050.0Z4-HXT	02968235	2	E	6,0	6,0	6,0	50,0	12,0	5,6	0,5	–	4	Cylindrical	■
JH142060E2R100.0Z4-HXT	02968237	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	4	Cylindrical	■
JH142060E2R100.0Z5-HXT	02968238	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	5	Cylindrical	■
JH142060E2R150.0Z5-HXT	02968240	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,5	–	5	Cylindrical	■
JH142060E2R200.0Z5-HXT	02968241	2	E	6,0	6,0	6,0	50,0	12,0	5,6	2,0	–	5	Cylindrical	■
JH142080E2R050.0Z5-HXT	02968242	2	E	8,0	8,0	8,0	60,0	16,0	7,4	0,5	–	5	Cylindrical	■
JH142080E2R100.0Z5-HXT	02968243	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,0	–	5	Cylindrical	■
JH142080E2R150.0Z5-HXT	02968244	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,5	–	5	Cylindrical	■
JH142080E2R200.0Z5-HXT	02968245	2	E	8,0	8,0	8,0	60,0	16,0	7,4	2,0	–	5	Cylindrical	■
JH142080E2R300.0Z5-HXT	02968246	2	E	8,0	8,0	8,0	60,0	16,0	7,4	3,0	–	5	Cylindrical	■
JH142100E2R050.0Z5-HXT	02968247	2	E	10,0	10,0	10,0	70,0	20,0	9,4	0,5	–	5	Cylindrical	■
JH142100E2R100.0Z5-HXT	02968248	2	E	10,0	10,0	10,0	70,0	20,0	9,4	1,0	–	5	Cylindrical	■
JH142100E2R200.0Z5-HXT	02968249	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,0	–	5	Cylindrical	■
JH142100E2R250.0Z5-HXT	02968250	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,5	–	5	Cylindrical	■
JH142120E2R100.0Z6-HXT	02968251	2	E	12,0	12,0	12,0	75,0	24,0	11,4	1,0	–	6	Cylindrical	■
JH142120E2R200.0Z6-HXT	02968252	2	E	12,0	12,0	12,0	75,0	24,0	11,4	2,0	–	6	Cylindrical	■
JH142120E2R300.0Z6-HXT	02968253	2	E	12,0	12,0	12,0	75,0	24,0	11,4	3,0	–	6	Cylindrical	■

■ **Lagerstandard.**

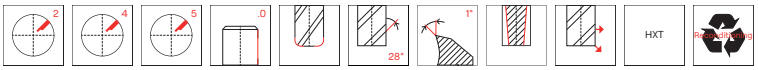
JH142

Hochgeschwindigkeitsfräsen – Hochpräzise – Torisch – Gehärteter Stahl – 2-5 Schneiden – Zylindrisch – Eckenra-





J



- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm					
JH142020J3R030.0Z2-HXT	02968255	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	0,9	2	Cylindrical	■
JH142020J3R030.0Z4-HXT	02968256	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	0,9	4	Cylindrical	■
JH142020J3R050.0Z2-HXT	02968257	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	0,9	2	Cylindrical	■
JH142020J3R050.0Z4-HXT	02968258	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	0,9	4	Cylindrical	■
JH142030J3R050.0Z2-HXT	02968259	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	0,9	2	Cylindrical	■
JH142030J3R050.0Z4-HXT	02968260	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	0,9	4	Cylindrical	■
JH142030J3R100.0Z2-HXT	02968261	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	0,9	2	Cylindrical	■
JH142030J3R100.0Z4-HXT	02968262	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	0,9	4	Cylindrical	■
JH142040J3R030.0Z2-HXT	02968263	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	0,9	2	Cylindrical	■
JH142040J3R030.0Z4-HXT	02970111	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	0,9	4	Cylindrical	■
JH142040J3R050.0Z2-HXT	02968265	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	0,9	2	Cylindrical	■
JH142040J3R050.0Z4-HXT	02968264	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	0,9	4	Cylindrical	■
JH142040J3R100.0Z2-HXT	02968266	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	0,9	2	Cylindrical	■
JH142040J3R100.0Z4-HXT	02968267	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	0,9	4	Cylindrical	■
JH142060J3R050.0Z4-HXT	02968268	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	0,9	4	Cylindrical	■
JH142060J3R050.0Z5-HXT	02968269	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	0,9	5	Cylindrical	■
JH142060J3R100.0Z4-HXT	02968270	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	0,9	4	Cylindrical	■
JH142060J3R100.0Z5-HXT	02968271	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	0,9	5	Cylindrical	■
JH142060J3R150.0Z5-HXT	02968272	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,5	1,8	0,9	5	Cylindrical	■
JH142060J3R200.0Z5-HXT	02968273	3	J	6,0	8,0	6,0	75,0	30,0	5,6	2,0	1,83	0,9	5	Cylindrical	■
JH142080J3R050.0Z5-HXT	02968274	3	J	8,0	10,0	8,0	85,0	40,0	7,4	0,5	1,34	0,9	5	Cylindrical	■
JH142080J3R100.0Z5-HXT	02968275	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,0	1,36	0,9	5	Cylindrical	■
JH142080J3R150.0Z5-HXT	02968276	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,5	1,37	0,9	5	Cylindrical	■
JH142080J3R200.0Z5-HXT	02968277	3	J	8,0	10,0	8,0	85,0	40,0	7,4	2,0	1,39	0,9	5	Cylindrical	■
JH142100J3R050.0Z5-HXT	02968278	3	J	10,0	12,0	10,0	100,0	50,0	9,4	0,5	1,1	0,9	5	Cylindrical	■
JH142100J3R100.0Z5-HXT	02968279	3	J	10,0	12,0	10,0	100,0	50,0	9,4	1,0	1,11	0,9	5	Cylindrical	■
JH142100J3R200.0Z5-HXT	02968280	3	J	10,0	12,0	10,0	100,0	50,0	9,4	2,0	1,13	0,9	5	Cylindrical	■
JH142020J6R030.0Z4-HXT	02968282	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,3	4,33	0,9	4	Cylindrical	■
JH142020J6R050.0Z4-HXT	02968283	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,5	4,36	0,9	4	Cylindrical	■
JH142030J6R050.0Z4-HXT	02968284	6	J	3,0	6,0	3,0	75,0	30,0	2,8	0,5	2,52	0,9	4	Cylindrical	■
JH142030J6R100.0Z4-HXT	02968285	6	J	3,0	6,0	3,0	75,0	30,0	2,8	1,0	2,56	0,9	4	Cylindrical	■
JH142040J6R030.0Z4-HXT	02968286	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,3	1,36	0,9	4	Cylindrical	■
JH142040J6R050.0Z4-HXT	02968287	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,5	1,37	0,9	4	Cylindrical	■
JH142040J6R100.0Z4-HXT	02968288	6	J	4,0	6,0	4,0	80,0	40,0	3,7	1,0	1,38	0,9	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH142 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	6	8	10	12	16	
P1	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	485 (460 — 530) *1600 (1600 — 1700)*
P2	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	470 (450 — 520) *1550 (1500 — 1700)*
P3	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	405 (390 — 450) *1325 (1300 — 1400)*
P4	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	360 (340 — 390) *1175 (1200 — 1200)*
P5	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
P6	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	385 (370 — 420) *1275 (1300 — 1300)*
P7	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	365 (350 — 400) *1200 (1200 — 1300)*
P8	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	340 (330 — 380) *1125 (1100 — 1200)*
P11	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	355 (340 — 390) *1175 (1200 — 1200)*
K1	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
K2	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	300 (290 — 330) *980 (960 — 1000)*
K3	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	255 (240 — 280) *840 (790 — 910)*
K4	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	245 (230 — 260) *800 (760 — 850)*
K5	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
K6	A/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	500 (480 — 550) *1650 (1600 — 1800)*
K7	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	440 (420 — 490) *1450 (1400 — 1600)*
H3	M/A	0.0200 *0,0200*	0.020 *0,020*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	95 (72 — 110) *310 (240 — 360)*
H5	M/A	0.0400 *0,0400*	0.040 *0,040*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	305 (290 — 330) *1000 (960 — 1000)*
H7	M/A	0.0200 *0,0200*	0.020 *0,020*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	95 (72 — 110) *310 (240 — 360)*
H8	M/A	0.0400 *0,0400*	0.040 *0,040*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	310 (290 — 330) *1025 (960 — 1000)*
H11	M/A	0.0400 *0,0400*	0.040 *0,040*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	390 (360 — 420) *1275 (1200 — 1300)*
H12	M/A	0.0500 *0,0500*	0.050 *0,050*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	345 (320 — 370) *1125 (1100 — 1200)*
H21	M/A	0.0400 *0,0400*	0.040 *0,040*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	310 (290 — 330) *1025 (960 — 1000)*
H31	M/A	0.0300 *0,0300*	0.030 *0,030*	0.013 *0,00050*	0.019 *0,00075*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	140 (120 — 160) *460 (400 — 520)*

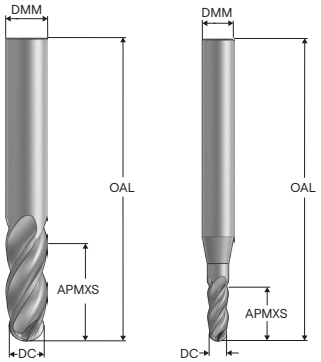
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

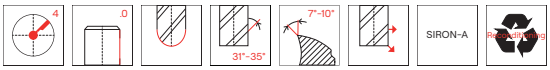
ST5341

Hochleistungsfräser – Stahl – Kugelkopf – 4 Schneiden – Zylindrisch





– Toleranzen:
– DMM=h5
– DC=e7
– RE= ±0,01 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist



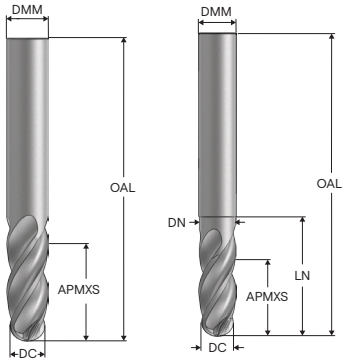
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	RE	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm			
ST5341-030F2B.0Z4	SIRA	10302669	2	F	3,0	6,0	7,0	58,0	1,5	4	Cylindrical	■
ST5341-040F2B.0Z4	SIRA	10302670	2	F	4,0	6,0	10,0	58,0	2,0	4	Cylindrical	■
ST5341-050F2B.0Z4	SIRA	10302671	2	F	5,0	6,0	12,0	58,0	2,5	4	Cylindrical	■
ST5341-060D2B.0Z4	SIRA	10302672	2	D	6,0	6,0	14,0	58,0	3,0	4	Cylindrical	■
ST5341-080D2B.0Z4	SIRA	10302673	2	D	8,0	8,0	18,0	64,0	4,0	4	Cylindrical	■
ST5341-100D2B.0Z4	SIRA	10302674	2	D	10,0	10,0	22,0	73,0	5,0	4	Cylindrical	■
ST5341-120D2B.0Z4	SIRA	10302675	2	D	12,0	12,0	26,0	84,0	6,0	4	Cylindrical	■
ST5341-160D2B.0Z4	SIRA	10302676	2	D	16,0	16,0	34,0	95,0	8,0	4	Cylindrical	■
ST5341-200D2B.0Z4	SIRA	10302677	2	D	20,0	20,0	42,0	109,0	10,0	4	Cylindrical	■
ST5341-030F3B.0Z4	SIRA	10302678	3	F	3,0	6,0	9,0	58,0	1,5	4	Cylindrical	■
ST5341-040F3B.0Z4	SIRA	10302679	3	F	4,0	6,0	12,0	58,0	2,0	4	Cylindrical	■
ST5341-050F3B.0Z4	SIRA	10302680	3	F	5,0	6,0	15,0	58,0	2,5	4	Cylindrical	■
ST5341-060D3B.0Z4	SIRA	10302681	3	D	6,0	6,0	18,0	64,0	3,0	4	Cylindrical	■
ST5341-080D3B.0Z4	SIRA	10302682	3	D	8,0	8,0	24,0	73,0	4,0	4	Cylindrical	■
ST5341-100D3B.0Z4	SIRA	10302683	3	D	10,0	10,0	30,0	85,0	5,0	4	Cylindrical	■
ST5341-120D3B.0Z4	SIRA	10302684	3	D	12,0	12,0	36,0	100,0	6,0	4	Cylindrical	■
ST5341-160D3B.0Z4	SIRA	10302685	3	D	16,0	16,0	48,0	115,0	8,0	4	Cylindrical	■
ST5341-200D3B.0Z4	SIRA	10302686	3	D	20,0	20,0	60,0	125,0	10,0	4	Cylindrical	■

■ **Lagerstandard.**

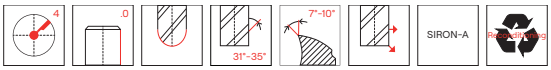
ST5341

Hochleistungsfräser – Stahl – Kugelkopf – 4 Schneiden – Zylindrisch – Zoll





—Toleranzen:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0004"
—Nachschleifen möglich, wenn DC ≥ Ø.250 ist



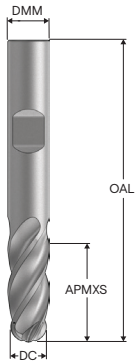
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Aufnahmen	Lagerstandard
					Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zoll			
ST5341-.125D2B.0Z4	SIRA	10302637	2	D	0.125	0.125	0.250	1.500	–	–	0.063	4	Cylindrical	■
ST5341-.188D2B.0Z4	SIRA	10302638	2	D	0.188	0.188	0.375	2.000	–	–	0.094	4	Cylindrical	■
ST5341-.250D2B.0Z4	SIRA	10302639	2	D	0.250	0.250	0.500	2.500	–	–	0.125	4	Cylindrical	■
ST5341-.250E2B.0Z4	SIRA	10302640	2	E	0.250	0.250	0.500	2.500	0.750	0.240	0.125	4	Cylindrical	■
ST5341-.313D2B.0Z4	SIRA	10302641	2	D	0.313	0.313	0.625	2.500	–	–	0.156	4	Cylindrical	■
ST5341-.313E2B.0Z4	SIRA	10302642	2	E	0.313	0.313	0.625	3.000	0.938	0.300	0.156	4	Cylindrical	■
ST5341-.375D2B.0Z4	SIRA	10302643	2	D	0.375	0.375	0.750	2.500	–	–	0.188	4	Cylindrical	■
ST5341-.375E2B.0Z4	SIRA	10302644	2	E	0.375	0.375	0.750	3.000	1.125	0.360	0.188	4	Cylindrical	■
ST5341-.438D2B.0Z4	SIRA	10302645	2	D	0.438	0.438	0.875	2.750	–	–	0.219	4	Cylindrical	■
ST5341-.500D2B.0Z4	SIRA	10302646	2	D	0.500	0.500	1.000	3.000	–	–	0.250	4	Cylindrical	■
ST5341-.500E2B.0Z4	SIRA	10302647	2	E	0.500	0.500	1.000	3.000	1.500	0.480	0.250	4	Cylindrical	■
ST5341-.625D2B.0Z4	SIRA	10302648	2	D	0.625	0.625	1.250	3.500	–	–	0.313	4	Cylindrical	■
ST5341-.625E2B.0Z4	SIRA	10302649	2	E	0.625	0.625	1.250	3.500	1.875	0.600	0.313	4	Cylindrical	■
ST5341-.750D2B.0Z4	SIRA	10302650	2	D	0.750	0.750	1.500	4.000	–	–	0.375	4	Cylindrical	■
ST5341-.750E2B.0Z4	SIRA	10302651	2	E	0.750	0.750	1.500	4.000	2.250	0.720	0.375	4	Cylindrical	■
ST5341-1.00D2B.0Z4	SIRA	10302652	2	D	1.000	1.000	2.000	5.000	–	–	0.500	4	Cylindrical	■
ST5341-1.00E2B.0Z4	SIRA	10302653	2	E	1.000	1.000	2.000	5.000	3.000	0.960	0.500	4	Cylindrical	■

■ **Lagerstandard.**

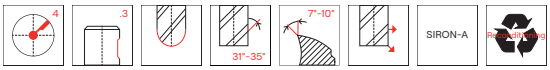
ST5341

Hochleistungsfräser – Stahl – Kugelkopf – 4 Schneiden – Weldon





- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,01 mm
- Nachschleifen möglich

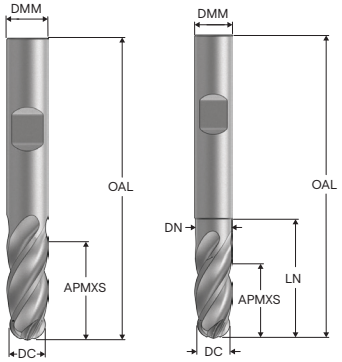


Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	RE	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm			
ST5341-060D2B.3Z4	SIRA	10302687	2	D	6,0	6,0	14,0	58,0	3,0	4	Weldon	☐
ST5341-080D2B.3Z4	SIRA	10302688	2	D	8,0	8,0	18,0	64,0	4,0	4	Weldon	☐
ST5341-100D2B.3Z4	SIRA	10302689	2	D	10,0	10,0	22,0	73,0	5,0	4	Weldon	☐
ST5341-120D2B.3Z4	SIRA	10302690	2	D	12,0	12,0	26,0	84,0	6,0	4	Weldon	☐
ST5341-160D2B.3Z4	SIRA	10302691	2	D	16,0	16,0	34,0	95,0	8,0	4	Weldon	☐
ST5341-200D2B.3Z4	SIRA	10302692	2	D	20,0	20,0	42,0	109,0	10,0	4	Weldon	☐
ST5341-060D3B.3Z4	SIRA	10302693	3	D	6,0	6,0	18,0	64,0	3,0	4	Weldon	☐
ST5341-080D3B.3Z4	SIRA	10302694	3	D	8,0	8,0	24,0	73,0	4,0	4	Weldon	☐
ST5341-100D3B.3Z4	SIRA	10302695	3	D	10,0	10,0	30,0	85,0	5,0	4	Weldon	☐
ST5341-120D3B.3Z4	SIRA	10302696	3	D	12,0	12,0	36,0	100,0	6,0	4	Weldon	☐
ST5341-160D3B.3Z4	SIRA	10302697	3	D	16,0	16,0	48,0	115,0	8,0	4	Weldon	☐
ST5341-200D3B.3Z4	SIRA	10302698	3	D	20,0	20,0	60,0	125,0	10,0	4	Weldon	☐

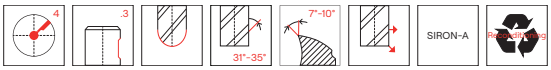
☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

ST5341
Hochleistungsfräser – Stahl – Kugelkopf – 4 Schneiden – Weldon – Zoll





—Toleranzen:
—DMM= -.0001"/-.0004"
—DC= + .000" / - .002"
—RE= ±.0004"
—Nachschleifen möglich
☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.



Schnittdaten – ST5341 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z										v_c
				1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1	
P1	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	260 (210 — 310) *850 (690 — 1000)*
P2	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	250 (200 — 310) *820 (660 — 1000)*
P3	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	215 (180 — 260) *710 (600 — 850)*
P4	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	190 (160 — 230) *620 (530 — 750)*
P5	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	180 (150 — 220) *590 (500 — 720)*
P6	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	205 (170 — 250) *670 (560 — 820)*
P7	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	190 (160 — 230) *620 (530 — 750)*
P8	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	180 (150 — 220) *590 (500 — 720)*
P11	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	185 (150 — 230) *610 (500 — 750)*
P12	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	110 (88 — 130) *360 (290 — 420)*
K1	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	255 (210 — 310) *840 (690 — 1000)*
K2	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	220 (180 — 270) *720 (600 — 880)*
K3	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	185 (150 — 230) *610 (500 — 750)*
K4	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	175 (150 — 210) *570 (500 — 680)*
K5	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	105 (85 — 130) *345 (280 — 420)*
K6	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	155 (130 — 190) *510 (430 — 620)*
K7	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	135 (110 — 160) *445 (370 — 520)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – ST5341 Kopierfräsen/Schruppen – Zoll

SMG		a_e/DC	a_p/DC	f_z										v_c
				1/8	3/16	1/4	5/16	3/8	7/16	1/2	5/8	3/4	1	
P1	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	260 (210 — 310) *850 (690 — 1000)*
P2	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	250 (200 — 310) *820 (660 — 1000)*
P3	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	215 (180 — 260) *710 (600 — 850)*
P4	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	190 (160 — 230) *620 (530 — 750)*
P5	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	180 (150 — 220) *590 (500 — 720)*
P6	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	205 (170 — 250) *670 (560 — 820)*
P7	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	190 (160 — 230) *620 (530 — 750)*
P8	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	180 (150 — 220) *590 (500 — 720)*
P11	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	185 (150 — 230) *610 (500 — 750)*
P12	M/A/D/E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	110 (88 — 130) *360 (290 — 420)*
K1	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	255 (210 — 310) *840 (690 — 1000)*
K2	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	220 (180 — 270) *720 (600 — 880)*
K3	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	185 (150 — 230) *610 (500 — 750)*
K4	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	175 (150 — 210) *570 (500 — 680)*
K5	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	105 (85 — 130) *345 (280 — 420)*
K6	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	155 (130 — 190) *510 (430 — 620)*
K7	E	0,060 *0.060*	2,0 *2.0*	0,028 *0.0011*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	135 (110 — 160) *445 (370 — 520)*

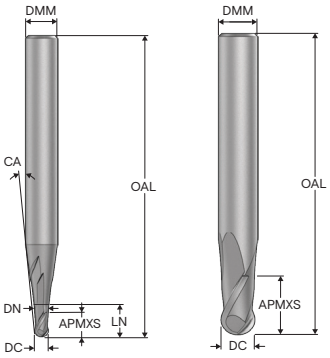
Schnittdaten, siehe Seite 699 - 707

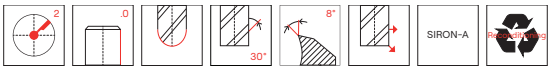
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JHB970

Hochgeschwindigkeitsfräsen – Universell – Kugelkopf – 2 Schneiden – Zylindrisch







– Toleranzen:
– DMM= h5
– DC= -0,02/-0,04 mm
– RE= ±0,01 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Beschichtung	Produktnummer	Längenindex		DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm	mm	mm				
JHB970020G1B.0Z2	SIRA	10072058	1	G	2,0	3,0	3,0	50,0	10,0	1,9	1,0	2,5	2	Cylindrical	■
JHB970030D1B.0Z2	SIRA	10072059	1	D	3,0	3,0	4,5	50,0	–	–	1,5	–	2	Cylindrical	■
JHB970040D1B.0Z2	SIRA	10072060	1	D	4,0	4,0	6,0	60,0	–	–	2,0	–	2	Cylindrical	■
JHB970050D1B.0Z2	SIRA	10072061	1	D	5,0	5,0	7,5	60,0	–	–	2,5	–	2	Cylindrical	■
JHB970060D1B.0Z2	SIRA	10072062	1	D	6,0	6,0	9,0	75,0	–	–	3,0	–	2	Cylindrical	■
JHB970020G2B.0Z2	SIRA	10072063	2	G	2,0	6,0	3,0	60,0	4,0	1,9	1,0	8,0	2	Cylindrical	■
JHB970025G2B.0Z2	SIRA	10072064	2	G	2,5	6,0	4,0	60,0	5,0	2,4	1,25	7,5	2	Cylindrical	■
JHB970030G2B.0Z2	SIRA	10072065	2	G	3,0	6,0	4,5	60,0	6,0	2,8	1,5	5,5	2	Cylindrical	■
JHB970035G2B.0Z2	SIRA	10072066	2	G	3,5	6,0	5,0	60,0	7,0	3,2	1,75	4,5	2	Cylindrical	■
JHB970040G2B.0Z2	SIRA	10072067	2	G	4,0	6,0	6,0	60,0	8,0	3,7	2,0	3,0	2	Cylindrical	■
JHB970050G2B.0Z2	SIRA	10072068	2	G	5,0	6,0	7,5	60,0	10,0	4,6	2,5	2,0	2	Cylindrical	■
JHB970060G2B.0Z2	SIRA	10072069	2	G	6,0	8,0	9,0	75,0	12,0	5,6	3,0	2,5	2	Cylindrical	■
JHB970080D2B.0Z2	SIRA	10072070	2	D	8,0	8,0	12,0	75,0	–	–	4,0	–	2	Cylindrical	■
JHB970100D2B.0Z2	SIRA	10072071	2	D	10,0	10,0	15,0	80,0	–	–	5,0	–	2	Cylindrical	■
JHB970120D2B.0Z2	SIRA	10072072	2	D	12,0	12,0	18,0	90,0	–	–	6,0	–	2	Cylindrical	■
JHB970160D2B.0Z2	SIRA	10072073	2	D	16,0	16,0	24,0	100,0	–	–	8,0	–	2	Cylindrical	■
JHB970020G3B.0Z2	SIRA	10072074	3	G	2,0	6,0	3,0	80,0	4,0	1,9	1,0	8,0	2	Cylindrical	■
JHB970030G3B.0Z2	SIRA	10072075	3	G	3,0	6,0	4,5	80,0	6,0	2,8	1,5	5,5	2	Cylindrical	■
JHB970040G3B.0Z2	SIRA	10072076	3	G	4,0	6,0	6,0	80,0	8,0	3,7	2,0	3,0	2	Cylindrical	■
JHB970060G3B.0Z2	SIRA	10072077	3	G	6,0	8,0	9,0	100,0	12,0	5,6	3,0	2,5	2	Cylindrical	■
JHB970080D3B.0Z2	SIRA	10072078	3	D	8,0	8,0	12,0	108,0	–	–	4,0	–	2	Cylindrical	■
JHB970100D3B.0Z2	SIRA	10072079	3	D	10,0	10,0	15,0	125,0	–	–	5,0	–	2	Cylindrical	■
JHB970120D3B.0Z2	SIRA	10072080	3	D	12,0	12,0	18,0	125,0	–	–	6,0	–	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JHB970 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	2.5	3	3.5	4	5	6	8	10	12	16	
P1	M	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.014 *0,00055*	0.016 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.028 *0,0011*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	210 (190 — 230) *690 (630 — 750)*
P2	M	0.200 *0,200*	1.0 *1,0*	0.011 *0,00044*	0.014 *0,00055*	0.017 *0,00065*	0.019 *0,00075*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	205 (180 — 230) *670 (600 — 750)*
P3	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	180 (160 — 200) *590 (530 — 650)*
P4	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	155 (140 — 170) *510 (460 — 550)*
P5	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	150 (140 — 170) *490 (460 — 550)*
P6	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	170 (150 — 190) *560 (500 — 620)*
P7	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	160 (140 — 180) *520 (460 — 590)*
P8	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.018 *0,00070*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	150 (140 — 170) *490 (460 — 550)*
P11	M	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.017 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	75 (67 — 86) *245 (220 — 280)*
P12	M	0.200 *0,200*	1.0 *1,0*	0.0070 *0,00028*	0.0085 *0,00034*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	48 (42 — 53) *155 (140 — 170)*
M1	E	0.200 *0,200*	1.0 *1,0*	0.0090 *0,00036*	0.011 *0,00044*	0.013 *0,00050*	0.015 *0,00060*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	90 (80 — 100) *295 (270 — 320)*
M2	E	0.200 *0,200*	1.0 *1,0*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	75 (65 — 85) *245 (220 — 270)*
M3	E	0.150 *0,150*	1.0 *1,0*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	65 (55 — 75) *215 (190 — 240)*
M4	E	0.150 *0,150*	1.0 *1,0*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	49 (42 — 56) *160 (140 — 180)*
M5	E	0.150 *0,150*	1.0 *1,0*	0.0050 *0,00020*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	41 (35 — 47) *135 (120 — 150)*
S1	E	0.100 *0,100*	0.80 *0,80*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	50 (40 — 59) *165 (140 — 190)*
S2	E	0.100 *0,100*	0.80 *0,80*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	40 (33 — 48) *130 (110 — 150)*
S3	E	0.100 *0,100*	0.60 *0,60*	0.0040 *0,00016*	0.0050 *0,00020*	0.0060 *0,00024*	0.0070 *0,00028*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.028 *0,0011*	30 (20 — 39) *100 (66 — 120)*
S11	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	90 (79 — 100) *295 (260 — 320)*
S12	E	0.200 *0,200*	1.0 *1,0*	0.010 *0,00040*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	70 (61 — 80) *230 (210 — 260)*
S13	E	0.200 *0,200*	1.0 *1,0*	0.0085 *0,00034*	0.011 *0,00044*	0.013 *0,00050*	0.015 *0,00060*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	55 (48 — 63) *180 (160 — 200)*

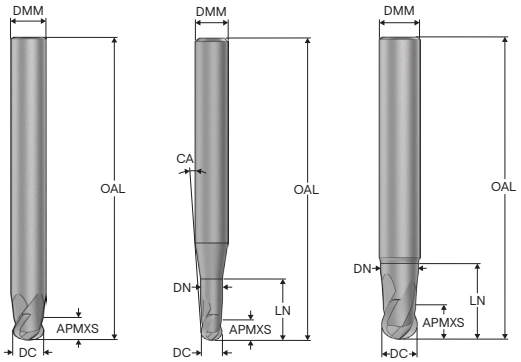
Schnittdaten, siehe Seite 699 - 707

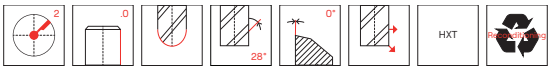
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH112

Hochgeschwindigkeitsfräsen – Hochpräzise – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch







—Toleranzen:
—Rundlaufabweichung = <0,005 mm
—DMM = h5
—DC= 0-0,01 mm
—RE= ±0,005 mm
—Nachschleifen möglich, wenn DC ≥ Ø6 ist

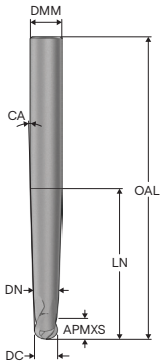
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
JH112020G1B.0Z2-HXT	02970112	1	G	2,0	4,0	2,0	40,0	4,0	1,9	1,0	6,45	2	Cylindrical	■
JH112030G1B.0Z2-HXT	02970113	1	G	3,0	4,0	3,0	40,0	6,0	2,8	1,5	3,3	2	Cylindrical	■
JH112040D1B.0Z2-HXT	02970114	1	D	4,0	4,0	4,0	40,0	–	–	2,0	–	2	Cylindrical	■
JH112050G1B.0Z2-HXT	02970115	1	G	5,0	6,0	5,0	50,0	10,0	4,6	2,5	2,0	2	Cylindrical	■
JH112060D1B.0Z2-HXT	02970116	1	D	6,0	6,0	6,0	50,0	–	–	3,0	–	2	Cylindrical	■
JH112080D1B.0Z2-HXT	02970117	1	D	8,0	8,0	8,0	65,0	–	–	4,0	–	2	Cylindrical	■
JH112100D1B.0Z2-HXT	02970118	1	D	10,0	10,0	10,0	65,0	–	–	5,0	–	2	Cylindrical	■
JH112020G2B.0Z2-HXT	02970119	2	G	2,0	3,0	2,0	50,0	10,0	1,9	1,0	2,5	2	Cylindrical	■
JH112030D2B.0Z2-HXT	02970120	2	D	3,0	3,0	3,0	50,0	–	–	1,5	–	2	Cylindrical	■
JH112040D2B.0Z2-HXT	02970121	2	D	4,0	4,0	4,0	60,0	–	–	2,0	–	2	Cylindrical	■
JH112050D2B.0Z2-HXT	02970122	2	D	5,0	5,0	5,0	60,0	–	–	2,5	–	2	Cylindrical	■
JH112060D2B.0Z2-HXT	02970123	2	D	6,0	6,0	6,0	75,0	–	–	3,0	–	2	Cylindrical	■
JH112020G3B.0Z2-HXT	02970124	3	G	2,0	6,0	2,0	60,0	4,0	1,9	1,0	8,12	2	Cylindrical	■
JH112025G3B.0Z2-HXT	02970125	3	G	2,5	6,0	2,5	60,0	5,0	2,4	1,25	7,39	2	Cylindrical	■
JH112030G3B.0Z2-HXT	02970126	3	G	3,0	6,0	3,0	60,0	6,0	2,8	1,5	5,5	2	Cylindrical	■
JH112035G3B.0Z2-HXT	02968289	3	G	3,5	6,0	3,5	65,0	7,0	3,2	1,75	3,81	2	Cylindrical	■
JH112040G3B.0Z2-HXT	02970127	3	G	4,0	6,0	4,0	65,0	8,0	3,7	2,0	3,34	2	Cylindrical	■
JH112050G3B.0Z2-HXT	02970128	3	G	5,0	6,0	5,0	65,0	10,0	4,6	2,5	2,0	2	Cylindrical	■
JH112060G3B.0Z2-HXT	02970129	3	G	6,0	8,0	6,0	75,0	12,0	5,6	3,0	2,78	2	Cylindrical	■
JH112080E3B.0Z2-HXT	02968290	3	E	8,0	8,0	8,0	75,0	16,0	7,4	4,0	–	2	Cylindrical	■
JH112100E3B.0Z2-HXT	02968291	3	E	10,0	10,0	10,0	80,0	20,0	9,4	5,0	–	2	Cylindrical	■
JH112120E3B.0Z2-HXT	02968292	3	E	12,0	12,0	12,0	90,0	24,0	11,4	6,0	–	2	Cylindrical	■
JH112020G4B.0Z2-HXT	02970130	4	G	2,0	6,0	2,0	80,0	20,0	1,9	1,0	3,82	2	Cylindrical	■
JH112030G4B.0Z2-HXT	02970131	4	G	3,0	6,0	3,0	80,0	20,0	2,8	1,5	2,91	2	Cylindrical	■
JH112040G4B.0Z2-HXT	02970132	4	G	4,0	6,0	4,0	80,0	20,0	3,7	2,0	1,97	2	Cylindrical	■
JH112050G4B.0Z2-HXT	02970133	4	G	5,0	6,0	5,0	100,0	50,0	4,6	2,5	0,53	2	Cylindrical	■
JH112060D4B.0Z2-HXT	02968293	4	D	6,0	6,0	6,0	100,0	–	–	3,0	–	2	Cylindrical	■
JH112080D4B.0Z2-HXT	02968294	4	D	8,0	8,0	8,0	110,0	–	–	4,0	–	2	Cylindrical	■
JH112100D4B.0Z2-HXT	02968295	4	D	10,0	10,0	10,0	125,0	–	–	5,0	–	2	Cylindrical	■
JH112120D4B.0Z2-HXT	02968296	4	D	12,0	12,0	12,0	125,0	–	–	6,0	–	2	Cylindrical	■

■ **Lagerstandard.**

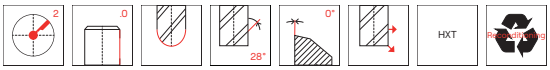
JH112

Hochgeschwindigkeitsfräsen – Hochpräzise – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch





J



—Toleranzen:
—Rundlaufabweichung = <0,005 mm
—DMM = h5
—DC= 0-0,01 mm
—RE= ±0,005 mm
—Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm					
JH112020J5B.0Z2-HXT	02970134	5	J	2,0	6,0	2,0	80,0	35,0	1,9	1,0	3,3	3,55	2	Cylindrical	■
JH112030J5B.0Z2-HXT	02970135	5	J	3,0	6,0	3,0	80,0	40,0	2,8	1,5	2,2	2,5	2	Cylindrical	■
JH112040J5B.0Z2-HXT	02970136	5	J	4,0	6,0	4,0	80,0	52,0	3,7	2,0	1,2	1,4	2	Cylindrical	■
JH112050J5B.0Z2-HXT	02970137	5	J	5,0	8,0	5,0	100,0	56,0	4,6	2,5	1,6	1,95	2	Cylindrical	■
JH112060J5B.0Z2-HXT	02970138	5	J	6,0	8,0	6,0	100,0	56,0	5,6	3,0	1,1	1,4	2	Cylindrical	■
JH112080J5B.0Z2-HXT	02970139	5	J	8,0	10,0	8,0	125,0	62,0	7,4	4,0	1,0	1,43	2	Cylindrical	■
JH112100J5B.0Z2-HXT	02970140	5	J	10,0	12,0	10,0	125,0	61,0	9,4	5,0	1,0	1,5	2	Cylindrical	■
JH112060J6B.0Z2-HXT	02970141	6	J	6,0	10,0	6,0	125,0	62,0	5,6	3,0	2,0	2,3	2	Cylindrical	■
JH112080J6B.0Z2-HXT	02970142	6	J	8,0	12,0	8,0	150,0	67,0	7,4	4,0	1,8	2,3	2	Cylindrical	■
JH112100J6B.0Z2-HXT	02970143	6	J	10,0	12,0	10,0	150,0	79,0	9,4	5,0	0,8	1,1	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH112 Kopierfräsen/ Feinbearbeitung

SMG		a_p/DC	f_z										v_c
			2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	520 (500 — 730) *1700 (1700 — 2300)*
K2	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	445 (430 — 630) *1450 (1500 — 2000)*
K3	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	380 (360 — 530) *1250 (1200 — 1700)*
K4	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	360 (350 — 510) *1175 (1200 — 1600)*
K5	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	415 (370 — 610) *1350 (1300 — 2000)*
K6	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	610 (550 — 900) *2000 (1900 — 2900)*
K7	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	680 (560 — 790) *2225 (1900 — 2500)*
H3	M	0.16 *0,16*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (150 — 230) *510 (500 — 750)*
H5	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H7	M	0.16 *0,16*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (150 — 230) *510 (500 — 750)*
H8	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H11	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	360 (300 — 420) *1175 (990 — 1300)*
H12	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	330 (280 — 380) *1075 (920 — 1200)*
H21	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H31	M	0.30 *0,30*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	300 (290 — 430) *980 (960 — 1400)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JH112 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.250 *0,250*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (310 — 450) *1025 (1100 — 1400)*
K2	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	280 (270 — 390) *920 (890 — 1200)*
K3	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	235 (230 — 330) *770 (760 — 1000)*
K4	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	225 (220 — 320) *740 (730 — 1000)*
K5	E	0.160 *0,160*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	280 (250 — 410) *920 (830 — 1300)*
K6	E	0.160 *0,160*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	415 (370 — 610) *1350 (1300 — 2000)*
K7	E	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	420 (350 — 490) *1375 (1200 — 1600)*
H3	M	0.120 *0,120*	0.040 *0,040*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	110 (100 — 160) *360 (330 — 520)*
H5	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H7	M	0.120 *0,120*	0.040 *0,040*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	110 (100 — 160) *360 (330 — 520)*
H8	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H11	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	225 (190 — 260) *740 (630 — 850)*
H12	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	205 (170 — 240) *670 (560 — 780)*
H21	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H31	M	0.200 *0,200*	0.10 *0,10*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	200 (200 — 280) *660 (660 — 910)*

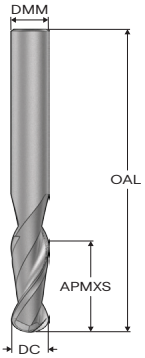
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

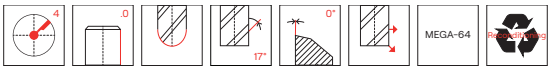
JH150

Hochgeschwindigkeitsfräsen – Gehärteter Stahl – Kugelkopf – 4 Schneiden – Zylindrisch





D



—Toleranzen:
—DMM= h5
—DC= -0,02/-0,04 mm
—RE= ±0,01 mm
—Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
150060-MEGA-64	00019198	2	D	6,0	6,0	6,0	80,0	3,0	4	Cylindrical	■
150080-MEGA-64	00019208	2	D	8,0	8,0	8,0	85,0	4,0	4	Cylindrical	■
150100-MEGA-64	00019219	2	D	10,0	10,0	10,0	100,0	5,0	4	Cylindrical	■
150120-MEGA-64	00019254	2	D	12,0	12,0	12,0	100,0	6,0	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH150 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
K1	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	290 (310 — 370) *950 (1100 — 1200)*
K2	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	250 (270 — 320) *820 (890 — 1000)*
K3	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	210 (230 — 270) *690 (760 — 880)*
K5	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	255 (270 — 330) *840 (890 — 1000)*
K6	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	375 (390 — 500) *1225 (1300 — 1600)*
K7	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	325 (340 — 430) *1075 (1200 — 1400)*
H3	M	0.0500 *0,0500*	0.020 *0,020*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	85 (88 — 120) *280 (290 — 390)*
H5	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H7	M	0.0500 *0,0500*	0.020 *0,020*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	85 (88 — 120) *280 (290 — 390)*
H8	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H11	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	230 (210 — 250) *750 (690 — 820)*
H12	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	210 (190 — 230) *690 (630 — 750)*
H21	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H31	M	0.150 *0,150*	0.060 *0,060*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	125 (130 — 180) *410 (430 — 590)*

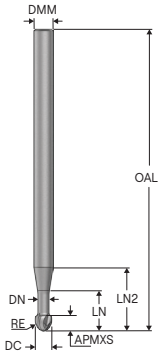
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH160

Hochgeschwindigkeitsfräsen – Gehärteter Stahl – Kugelkopf – 4 Schneiden – Zylindrisch





E

—Toleranzen:
—DMM= h5
—DC= 0,02/-0,06 mm
—SA=250°



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
160030-MEGA-64	00040365	2	E	3,0	3,0	2,3	60,0	4,5	1,8	1,5	4	Cylindrical	■
160040-MEGA-64	00040366	2	E	4,0	4,0	3,1	60,0	5,6	2,4	2,0	4	Cylindrical	■
160050-MEGA-64	00040367	2	E	5,0	5,0	3,9	70,0	6,4	3,0	2,5	4	Cylindrical	■
160060-MEGA-64	00040368	2	E	6,0	6,0	4,7	80,0	9,7	3,6	3,0	4	Cylindrical	■
160080-MEGA-64	00040369	2	E	8,0	8,0	6,2	85,0	11,2	4,8	4,0	4	Cylindrical	■
160100-MEGA-64	00040370	2	E	10,0	10,0	7,8	100,0	15,6	6,0	5,0	4	Cylindrical	■
160120-MEGA-64	00040371	2	E	12,0	12,0	9,4	125,0	17,2	7,2	6,0	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH160 Kopierfräsen/ Feinbearbeitung

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
P1	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	550 (450 — 700) *1800 (1500 — 2200)*
P2	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	530 (440 — 680) *1750 (1500 — 2200)*
P3	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	460 (380 — 590) *1500 (1300 — 1900)*
P4	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	405 (340 — 520) *1325 (1200 — 1700)*
P5	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	385 (320 — 490) *1275 (1100 — 1600)*
P6	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	430 (360 — 560) *1400 (1200 — 1800)*
P7	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	410 (340 — 520) *1350 (1200 — 1700)*
P8	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	385 (320 — 490) *1275 (1100 — 1600)*
P11	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	395 (330 — 510) *1300 (1100 — 1600)*
P12	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	235 (200 — 300) *770 (660 — 980)*
H3	M/E/A	0.0100 *0,0100*	0.0075 *0,0075*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	85 (91 — 110) *280 (300 — 360)*
H5	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H7	M/E/A	0.0100 *0,0100*	0.0075 *0,0075*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	85 (91 — 110) *280 (300 — 360)*
H8	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H11	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	430 (400 — 460) *1400 (1400 — 1500)*
H12	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	355 (340 — 380) *1175 (1200 — 1200)*
H21	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H31	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	165 (180 — 210) *540 (600 — 680)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte



ROSTFREI UND ISO-S-WERKSTOFFE

Das vollständige Programm an Hochleistungsvollhartmetallfräsern für hohe Produktivität in Rostfrei und ISO-S-Werkstoffen besteht aus Schaftfräsern, Kugelkopffräsern und Kreissegmentfräsern.

- JS754, JS755, JS720, JHP751, JHP760, JHP770, JHP780, JHP794, JCG790, JH770, JH740, JH710, JH790, JH730, JHP994, SHF712, SME714, SME716 und JCO710 mit Fase oder Eckenradius
- JS730, JH780, JHB720, JH721, JH722, SMB713, SMB714 und SMB716 Kugelkopffräser.
- JH724, JH726, JH734, JH736, JH744, JH746 Tonnenfräser.

Werkzeugauswahl Rostfrei und S-Werkstoffe

								
Werkzeugbezeichnung		JS754	JS755	JS720	JS730	JHP751	JHP760	JHP770
Seite(n)		326	343	354	374	378	381	385
Produktfamilie		SOLID²	SOLID²	SOLID²	SOLID²	HPM	HPM	HPM
Fräserausführung								
Auf-nahmen	Zylindrisch	■	■	■	■	■	■	■
	Weldon	■	■	■	□	■	■	■
	Safe-Lock	□	□	□	□			□
Schneidenzahl		4	5	6-9	6	2-4	2,3,4	4-5
CSP		■					■	■
	Metrisch	3-25	6-25	6-25	6-25	2-20	4-25	6-25
	Zoll							
Verfügbare Längen		2,3	2,3	2,3	2,3	1,2	2,3	2
Bearbeitung								
								
								
								
SMG								
M1		●	●	●	●		●	
M2		●	●	●	●		●	
M3		●	●	●	●		●	
M4		●	●	●	●		●	
M5		●	●	●	●		●	
S1		●	●	●	●	●		
S2		●	●	●	●	●		
S3		●	●	●	●	●		
S11		●	●	●	●	●		●
S12		●	●	●	●	●		●
S13		●	●	●	●	●		●

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage. □ Safe-Lock verfügbar, die Lieferzeit beträgt 6 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl Rostfrei und S-Werkstoffe

										
Werkzeugbezeichnung		JHP780	JHP794	JCG790	JH724	JH726	JH734	JH736	JH744	JH746
Seite(n)		392	381	399	431	431	405	407	409	411
Produktfamilie		HPM	HPM	Ceramic	HSM/ TORNADO	HSM/ TORNADO	HSM/ TORNADO	HSM/ TORNADO	HSM/ TORNADO	HSM/ TORNADO
Fräserausführung										
Aufnahmen	Zylindrisch	■		■	■	■	■	■	■	■
	Weldon	■	■							
	Safe-Lock	□								
Schneidenzahl		4	4	5-6	6	6	4	6	4	6
CSP		■	■						■	■
	Metrisch	6-25	6-25	6-25	10	10	6-16	10-16	4-16	10-16
	Zoll									
Verfügbare Längen		2	2	2	2	2	2	2	2,4	2
Bearbeitung										
										
										
SMG										
M1			●		●	●	●	●	●	●
M2			●		●	●	●	●	●	●
M3			●		●	●	●	●	●	●
M4			●		●	●				
M5			●		●	●				
S1		●		●	●	●				
S2		●		●	●	●				
S3		●		●	●	●				
S11					●	●	●	●	●	●
S12					●	●	●	●	●	●
S13					●	●	●	●	●	●

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage. □ Safe-Lock verfügbar, die Lieferzeit beträgt 6 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl Rostfrei und S-Werkstoffe

								
Werkzeugbezeichnung		JH770	JH740	JH710	JH790	JH730	JHP994	JH780
Seite(n)		413	415	417	419	421	423	425
Produktfamilie		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HPM	HSM/TORNADO
Fräserausführung								
Auf-nahmen	Zylindrisch	■	■	■	■	■	■	■
	Weldon							
	Safe-Lock							
Schneidenzahl		3,4,5,6	4-5	5	6	5,6,7	4	4
CSP								
	Metrisch	3-10	6-10	6-8	9,5	6-10	6-10	1,83-4,89
	Zoll							
Verfügbare Längen		2	2	2	2,3	2	3	2
Bearbeitung								
								
								
SMG								
M1								
M2								
M3								
M4								
M5								
S1								
S2		●	●	●	●	●	●	●
S3								
S11		●	●	●	●	●	●	
S12		●	●	●	●	●	●	●
S13								

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage. □ Safe-Lock verfügbar, die Lieferzeit beträgt 6 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl Rostfrei und S-Werkstoffe

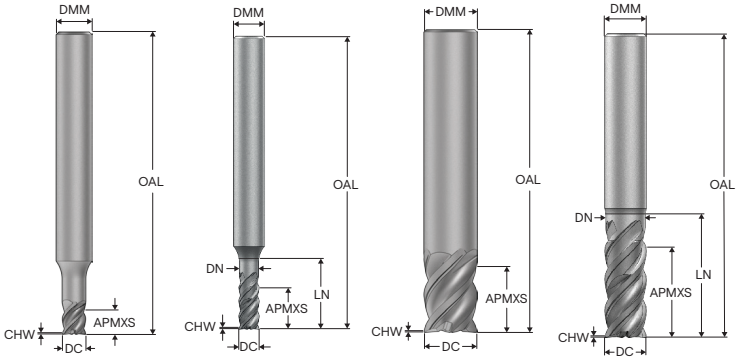
							
Werkzeugbezeichnung		JHB720	JH721	JH722	SHF712	SME714/716	SMB713/714/416
Seite(n)		427	429	431	504	504	261
Produktfamilie		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HFM	MINI	MINI
Fräserausführung							
Auf-nahmen	Zylindrisch	■	■	■	■	■	■
	Weldon						
	Safe-Lock						
Schneidenzahl		3	6	6	3-4-5	3-4-5	4
CSP							
	Metrisch	2-16	6-8	10	1-10	1-10	0,5-3,0
	Zoll						
Verfügbare Längen		2	2	2	1,2,3,4	1,2,3,4	2,4
Bearbeitung							
							
							
SMG							
M1		●					
M2		●					
M3		●					
M4		●					
M5		●					
S1		○					
S2		○	●	●	●	●	●
S3		○					
S11		●	●	●			
S12		●	●	●	●	●	●
S13		●					

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

JS754

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 4 Schneiden – Zylindrisch – Fase







– Toleranzen:
– DMM = h5
– DC= e7
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

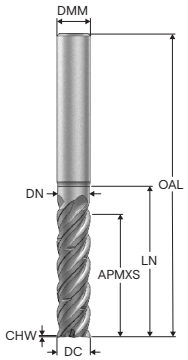
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	CHW	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
JS754030F1C.0Z4-HXT	10165556	1	F	3,0	6,0	4,0	50,0	–	–	0,035	–	4	Cylindrical	■
JS754040F1C.0Z4-HXT	10164855	1	F	4,0	6,0	6,0	50,0	–	–	0,045	–	4	Cylindrical	■
JS754050F1C.0Z4-HXT	10165557	1	F	5,0	6,0	7,0	50,0	–	–	0,055	–	4	Cylindrical	■
JS754060D1C.0Z4-HXT	10164856	1	D	6,0	6,0	8,0	50,0	–	–	0,075	–	4	Cylindrical	■
JS754080D1C.0Z4-HXT	10164857	1	D	8,0	8,0	11,0	58,0	–	–	0,1	–	4	Cylindrical	■
JS754100D1C.0Z4-HXT	10164858	1	D	10,0	10,0	13,0	58,0	–	–	0,125	–	4	Cylindrical	■
JS754120D1C.0Z4-HXT	10164859	1	D	12,0	12,0	15,0	67,0	–	–	0,15	–	4	Cylindrical	■
JS754160D1C.0Z4-HXT	10164860	1	D	16,0	16,0	19,0	73,0	–	–	0,2	–	4	Cylindrical	■
JS754030G2C.0Z4-HXT	03186807	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,035	7,0	4	Cylindrical	■
JS754040G2C.0Z4-HXT	03186808	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,045	4,0	4	Cylindrical	■
JS754050G2C.0Z4-HXT	03186809	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,055	2,0	4	Cylindrical	■
JS754060E2C.0Z4-HXT	03186810	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	–	4	Cylindrical	■
JS754080E2C.0Z4-HXT	03186811	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	–	4	Cylindrical	■
JS754100E2C.0Z4-HXT	03186812	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	–	4	Cylindrical	■
JS754120E2C.0Z4-HXT	03186813	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	–	4	Cylindrical	■
JS754160E2C.0Z4-HXT	03186814	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	–	4	Cylindrical	■
JS754200E2C.0Z4-HXT	03186815	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	–	4	Cylindrical	■
JS754060E3C.0Z4-HXT	03186823	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	–	4	Cylindrical	■
JS754080E3C.0Z4-HXT	03186824	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	–	4	Cylindrical	■
JS754100E3C.0Z4-HXT	03186825	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	–	4	Cylindrical	■
JS754120E3C.0Z4-HXT	03186826	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	–	4	Cylindrical	■
JS754160E3C.0Z4-HXT	03186827	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	–	4	Cylindrical	■
JS754200E3C.0Z4-HXT	03186828	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	–	4	Cylindrical	■
JS754250E3C.0Z4-HXT	03186829	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	–	4	Cylindrical	■

■ **Lagerstandard.**

JS754

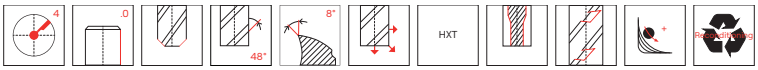
Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 4 Schneiden – Zylindrisch – Fase





E

—Toleranzen:
—DMM = h5
—DC= e7
—Nachschleifen möglich



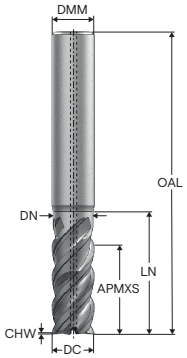
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JS754100E2C.0Z4C-HXT	03186817	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	Cylindrical	■
JS754120E2C.0Z4C-HXT	03186818	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	Cylindrical	■
JS754060E3C.0Z4C-HXT	03200550	3	E	■	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	Cylindrical	■
JS754080E3C.0Z4C-HXT	03200551	3	E	■	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	Cylindrical	■
JS754100E3C.0Z4C-HXT	03186830	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	Cylindrical	■
JS754120E3C.0Z4C-HXT	03186831	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	Cylindrical	■
JS754160E3C.0Z4C-HXT	03186832	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	Cylindrical	■
JS754200E3C.0Z4C-HXT	03186833	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	Cylindrical	■

■ **Lagerstandard.**

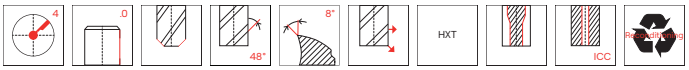
JS754

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 4 Schneiden – Zylindrisch – Fase





E



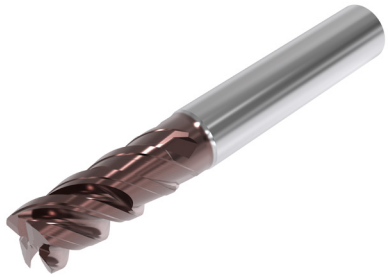
—Toleranzen:
—DMM = h5
—DC= e7
—Nachschleifen möglich

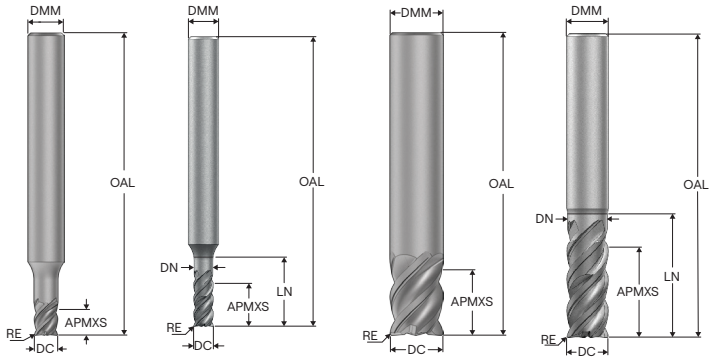
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JS754060E2C.0Z4A-HXT	03186834	2	E	■	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	Cylindrical	■
JS754080E2C.0Z4A-HXT	03186835	2	E	■	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	Cylindrical	■
JS754100E2C.0Z4A-HXT	03186836	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	Cylindrical	■
JS754120E2C.0Z4A-HXT	03186837	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	Cylindrical	■
JS754160E2C.0Z4A-HXT	03186838	2	E	■	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	Cylindrical	■
JS754200E2C.0Z4A-HXT	03186839	2	E	■	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	Cylindrical	■

■ **Lagerstandard.**

JS754

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 4 Schneiden – Zylindrisch – Eckenradius







—Toleranzen:
—DMM = h5
—DC= e7
—RE= ±0,02 mm
—Nachschleifen möglich, wenn DC ≥ Ø6 ist

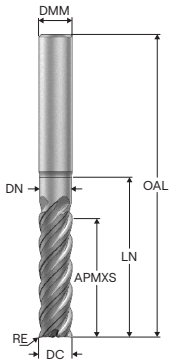
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
JS754030F1R020.0Z4-HXT	10165558	1	F	3,0	6,0	4,0	50,0	–	–	0,2	–	4	Cylindrical	■
JS754040F1R020.0Z4-HXT	10164867	1	F	4,0	6,0	6,0	50,0	–	–	0,2	–	4	Cylindrical	■
JS754050F1R020.0Z4-HXT	10165559	1	F	5,0	6,0	7,0	50,0	–	–	0,2	–	4	Cylindrical	■
JS754060D1R020.0Z4-HXT	10164868	1	D	6,0	6,0	8,0	50,0	–	–	0,2	–	4	Cylindrical	■
JS754060D1R050.0Z4-HXT	10164869	1	D	6,0	6,0	8,0	50,0	–	–	0,5	–	4	Cylindrical	■
JS754080D1R050.0Z4-HXT	10164871	1	D	8,0	8,0	11,0	58,0	–	–	0,5	–	4	Cylindrical	■
JS754100D1R050.0Z4-HXT	10164873	1	D	10,0	10,0	13,0	58,0	–	–	0,5	–	4	Cylindrical	■
JS754100D1R100.0Z4-HXT	10164874	1	D	10,0	10,0	13,0	58,0	–	–	1,0	–	4	Cylindrical	■
JS754120D1R050.0Z4-HXT	10164875	1	D	12,0	12,0	15,0	67,0	–	–	0,5	–	4	Cylindrical	■
JS754120D1R100.0Z4-HXT	10164876	1	D	12,0	12,0	15,0	67,0	–	–	1,0	–	4	Cylindrical	■
JS754160D1R050.0Z4-HXT	10164877	1	D	16,0	16,0	19,0	73,0	–	–	0,5	–	4	Cylindrical	■
JS754160D1R100.0Z4-HXT	10164878	1	D	16,0	16,0	19,0	73,0	–	–	1,0	–	4	Cylindrical	■
JS754030G2R020.0Z4-HXT	03186840	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,2	7,0	4	Cylindrical	■
JS754040G2R020.0Z4-HXT	03186841	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,2	4,0	4	Cylindrical	■
JS754050G2R020.0Z4-HXT	03186842	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,2	2,0	4	Cylindrical	■
JS754060E2R020.0Z4-HXT	03186843	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	–	4	Cylindrical	■
JS754060E2R050.0Z4-HXT	03186844	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	–	4	Cylindrical	■
JS754060E2R100.0Z4-HXT	03186845	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	–	4	Cylindrical	■
JS754080E2R050.0Z4-HXT	03186846	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	–	4	Cylindrical	■
JS754080E2R100.0Z4-HXT	03186847	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	–	4	Cylindrical	■
JS754100E2R050.0Z4-HXT	03186848	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	–	4	Cylindrical	■
JS754100E2R100.0Z4-HXT	03186849	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	–	4	Cylindrical	■
JS754100E2R150.0Z4-HXT	03200552	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,5	–	4	Cylindrical	■
JS754100E2R200.0Z4-HXT	03186850	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	–	4	Cylindrical	■
JS754100E2R300.0Z4-HXT	03186851	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	–	4	Cylindrical	■
JS754120E2R050.0Z4-HXT	03186852	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	–	4	Cylindrical	■
JS754120E2R100.0Z4-HXT	03186853	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	–	4	Cylindrical	■
JS754120E2R150.0Z4-HXT	03200553	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,5	–	4	Cylindrical	■
JS754120E2R200.0Z4-HXT	03186854	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	–	4	Cylindrical	■
JS754120E2R300.0Z4-HXT	03186855	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	–	4	Cylindrical	■
JS754160E2R050.0Z4-HXT	03186856	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	–	4	Cylindrical	■
JS754160E2R100.0Z4-HXT	03186857	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	–	4	Cylindrical	■
JS754160E2R200.0Z4-HXT	03186858	2	E	16,0	16,0	32,0	92,0	42,0	15,2	2,0	–	4	Cylindrical	■

■ **Lagerstandard.**

JS754

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 4 Schneiden – Zylindrisch – Eckenradius





E



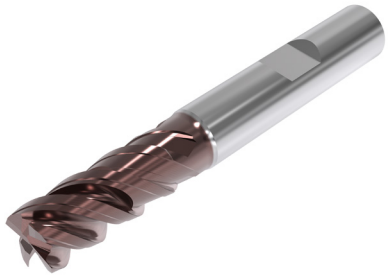
– Toleranzen:
– DMM = h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich

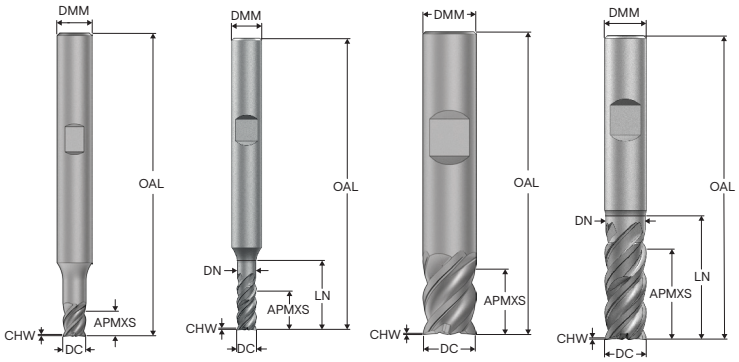
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS754160E2R300.0Z4-HXT	03186859	2	E	16,0	16,0	32,0	92,0	42,0	15,2	3,0	4	Cylindrical	■
JS754160E2R400.0Z4-HXT	03186860	2	E	16,0	16,0	32,0	92,0	42,0	15,2	4,0	4	Cylindrical	■
JS754160E2R600.0Z4-HXT	03186861	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	4	Cylindrical	■
JS754200E2R050.0Z4-HXT	03186862	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	4	Cylindrical	■
JS754200E2R100.0Z4-HXT	03186863	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	4	Cylindrical	■
JS754200E2R200.0Z4-HXT	03186864	2	E	20,0	20,0	40,0	104,0	51,0	19,0	2,0	4	Cylindrical	■
JS754200E2R300.0Z4-HXT	03186865	2	E	20,0	20,0	40,0	104,0	51,0	19,0	3,0	4	Cylindrical	■
JS754200E2R600.0Z4-HXT	03186867	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	4	Cylindrical	■
JS754060E3R020.0Z4-HXT	03186873	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	4	Cylindrical	■
JS754060E3R050.0Z4-HXT	03186874	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	4	Cylindrical	■
JS754060E3R100.0Z4-HXT	03186875	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	4	Cylindrical	■
JS754080E3R050.0Z4-HXT	03186876	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	4	Cylindrical	■
JS754080E3R100.0Z4-HXT	03186877	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	4	Cylindrical	■
JS754100E3R050.0Z4-HXT	03186878	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	4	Cylindrical	■
JS754100E3R100.0Z4-HXT	03186879	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	4	Cylindrical	■
JS754100E3R200.0Z4-HXT	03186880	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	4	Cylindrical	■
JS754100E3R300.0Z4-HXT	03186881	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	4	Cylindrical	■
JS754120E3R050.0Z4-HXT	03186882	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	4	Cylindrical	■
JS754120E3R100.0Z4-HXT	03186883	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	4	Cylindrical	■
JS754120E3R200.0Z4-HXT	03186884	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	4	Cylindrical	■
JS754120E3R300.0Z4-HXT	03186885	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	4	Cylindrical	■
JS754160E3R050.0Z4-HXT	03186886	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	4	Cylindrical	■
JS754160E3R100.0Z4-HXT	03186887	3	E	16,0	16,0	55,0	115,0	65,0	15,2	1,0	4	Cylindrical	■
JS754160E3R200.0Z4-HXT	03186888	3	E	16,0	16,0	55,0	115,0	65,0	15,2	2,0	4	Cylindrical	■
JS754160E3R300.0Z4-HXT	03186889	3	E	16,0	16,0	55,0	115,0	65,0	15,2	3,0	4	Cylindrical	■
JS754160E3R400.0Z4-HXT	03186890	3	E	16,0	16,0	55,0	115,0	65,0	15,2	4,0	4	Cylindrical	■
JS754160E3R600.0Z4-HXT	03186891	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	4	Cylindrical	■
JS754200E3R050.0Z4-HXT	03186892	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	4	Cylindrical	■
JS754200E3R100.0Z4-HXT	03186893	3	E	20,0	20,0	61,0	125,0	72,0	19,0	1,0	4	Cylindrical	■
JS754200E3R200.0Z4-HXT	03186894	3	E	20,0	20,0	61,0	125,0	72,0	19,0	2,0	4	Cylindrical	■
JS754200E3R300.0Z4-HXT	03186895	3	E	20,0	20,0	61,0	125,0	72,0	19,0	3,0	4	Cylindrical	■
JS754200E3R400.0Z4-HXT	03186896	3	E	20,0	20,0	61,0	125,0	72,0	19,0	4,0	4	Cylindrical	■
JS754200E3R600.0Z4-HXT	03186897	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	4	Cylindrical	■

■ **Lagerstandard.**

JS754

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 4 Schneiden – Weldon – Fase







—Toleranzen:
—DMM = h5
—DC= e7
—Nachschleifen möglich, wenn DC ≥ Ø6 ist

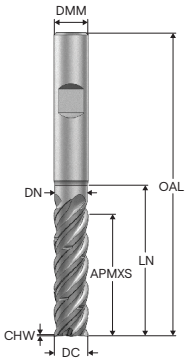
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	CHW	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
JS754030F1C.3Z4-HXT	10165658	1	F	3,0	6,0	4,0	50,0	–	–	0,035	–	4	Weldon	□
JS754040F1C.3Z4-HXT	10164861	1	F	4,0	6,0	6,0	50,0	–	–	0,045	–	4	Weldon	□
JS754050F1C.3Z4-HXT	10165660	1	F	5,0	6,0	7,0	50,0	–	–	0,055	–	4	Weldon	□
JS754060D1C.3Z4-HXT	10164862	1	D	6,0	6,0	8,0	50,0	–	–	0,075	–	4	Weldon	□
JS754080D1C.3Z4-HXT	10164863	1	D	8,0	8,0	11,0	58,0	–	–	0,1	–	4	Weldon	□
JS754100D1C.3Z4-HXT	10164864	1	D	10,0	10,0	13,0	58,0	–	–	0,125	–	4	Weldon	□
JS754120D1C.3Z4-HXT	10164865	1	D	12,0	12,0	15,0	67,0	–	–	0,15	–	4	Weldon	□
JS754160D1C.3Z4-HXT	10164866	1	D	16,0	16,0	19,0	73,0	–	–	0,2	–	4	Weldon	□
JS754030G2C.3Z4-HXT	03186975	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,035	7,0	4	Weldon	□
JS754040G2C.3Z4-HXT	03186976	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,045	4,0	4	Weldon	□
JS754050G2C.3Z4-HXT	03186977	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,055	2,0	4	Weldon	□
JS754060E2C.3Z4-HXT	03186978	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	–	4	Weldon	■
JS754080E2C.3Z4-HXT	03186979	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	–	4	Weldon	■
JS754100E2C.3Z4-HXT	03186980	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	–	4	Weldon	■
JS754120E2C.3Z4-HXT	03186981	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	–	4	Weldon	■
JS754160E2C.3Z4-HXT	03186982	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	–	4	Weldon	■
JS754200E2C.3Z4-HXT	03186983	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	–	4	Weldon	■
JS754060E3C.3Z4-HXT	03186990	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	–	4	Weldon	■
JS754080E3C.3Z4-HXT	03186991	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	–	4	Weldon	■
JS754100E3C.3Z4-HXT	03186992	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	–	4	Weldon	■
JS754120E3C.3Z4-HXT	03186993	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	–	4	Weldon	■
JS754160E3C.3Z4-HXT	03186994	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	–	4	Weldon	■
JS754200E3C.3Z4-HXT	03186995	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	–	4	Weldon	■
JS754250E3C.3Z4-HXT	03186996	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	–	4	Weldon	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

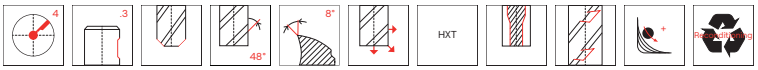
JS754

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 4 Schneiden – Weldon – Fase





E



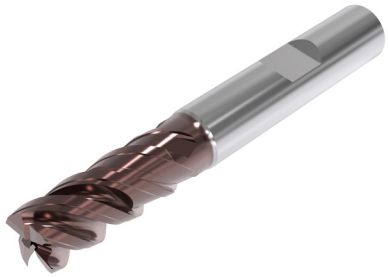
—Toleranzen:
—DMM = h5
—DC= e7
—Nachschleifen möglich

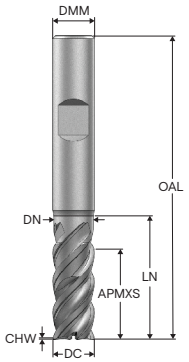
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JS754100E2C.3Z4C-HXT	03186985	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	Weldon	■
JS754120E2C.3Z4C-HXT	03186986	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	Weldon	■
JS754060E3C.3Z4C-HXT	03200562	3	E	■	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	Weldon	■
JS754080E3C.3Z4C-HXT	03200563	3	E	■	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	Weldon	■
JS754100E3C.3Z4C-HXT	03186997	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	Weldon	■
JS754120E3C.3Z4C-HXT	03186998	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	Weldon	■
JS754160E3C.3Z4C-HXT	03186999	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	Weldon	■
JS754200E3C.3Z4C-HXT	03187000	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	Weldon	■

■ **Lagerstandard.**

JS754

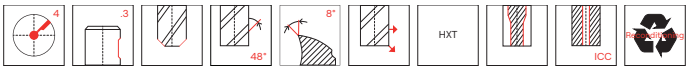
Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 4 Schneiden – Weldon – Fase





E

—Toleranzen:
—DMM = h5
—DC= e7
—Nachschleifen möglich

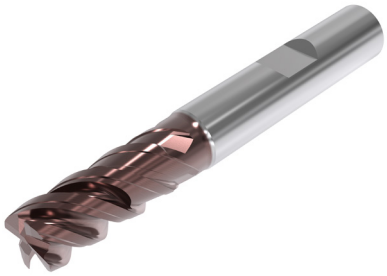


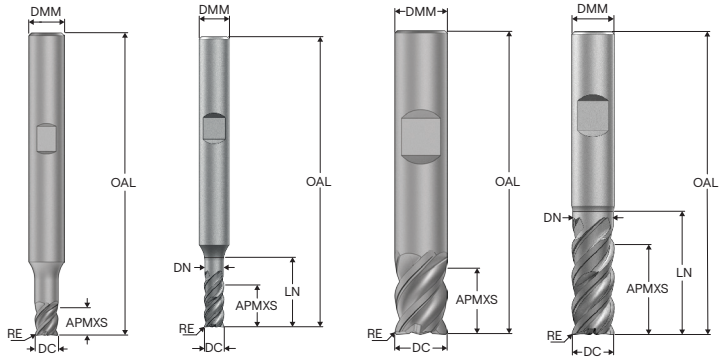
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JS754060E2C.3Z4A-HXT	03187001	2	E	■	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	Weldon	■
JS754080E2C.3Z4A-HXT	03187002	2	E	■	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	Weldon	■
JS754100E2C.3Z4A-HXT	03187003	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	Weldon	■
JS754120E2C.3Z4A-HXT	03187004	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	Weldon	■
JS754160E2C.3Z4A-HXT	03187005	2	E	■	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	Weldon	■
JS754200E2C.3Z4A-HXT	03187006	2	E	■	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	Weldon	■

■ **Lagerstandard.**

JS754

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 4 Schneiden – Weldon – Eckenradius







– Toleranzen:
– DMM = h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

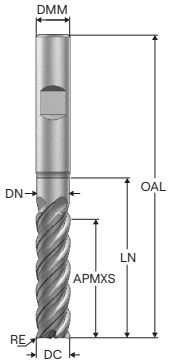
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
JS754030F1R020.3Z4-HXT	10165560	1	F	3,0	6,0	4,0	50,0	–	–	0,2	–	4	Weldon	□
JS754040F1R020.3Z4-HXT	10164879	1	F	4,0	6,0	6,0	50,0	–	–	0,2	–	4	Weldon	□
JS754050F1R020.3Z4-HXT	10165561	1	F	5,0	6,0	7,0	50,0	–	–	0,2	–	4	Weldon	□
JS754060D1R020.3Z4-HXT	10164880	1	D	6,0	6,0	8,0	50,0	–	–	0,2	–	4	Weldon	□
JS754060D1R050.3Z4-HXT	10164881	1	D	6,0	6,0	8,0	50,0	–	–	0,5	–	4	Weldon	□
JS754080D1R050.3Z4-HXT	10164883	1	D	8,0	8,0	11,0	58,0	–	–	0,5	–	4	Weldon	□
JS754100D1R050.3Z4-HXT	10164885	1	D	10,0	10,0	13,0	58,0	–	–	0,5	–	4	Weldon	□
JS754100D1R100.3Z4-HXT	10164886	1	D	10,0	10,0	13,0	58,0	–	–	1,0	–	4	Weldon	□
JS754120D1R050.3Z4-HXT	10164887	1	D	12,0	12,0	15,0	67,0	–	–	0,5	–	4	Weldon	□
JS754120D1R100.3Z4-HXT	10164888	1	D	12,0	12,0	15,0	67,0	–	–	1,0	–	4	Weldon	□
JS754160D1R050.3Z4-HXT	10164889	1	D	16,0	16,0	19,0	73,0	–	–	0,5	–	4	Weldon	□
JS754160D1R100.3Z4-HXT	10164890	1	D	16,0	16,0	19,0	73,0	–	–	1,0	–	4	Weldon	□
JS754030G2R020.3Z4-HXT	03187007	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,2	7,0	4	Weldon	□
JS754040G2R020.3Z4-HXT	03187008	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,2	4,0	4	Weldon	□
JS754050G2R020.3Z4-HXT	03187009	2	G	5,0	6,0	10,0	57,0	16,0	4,75	0,2	2,0	4	Weldon	□
JS754060E2R020.3Z4-HXT	03187010	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	–	4	Weldon	■
JS754060E2R050.3Z4-HXT	03187011	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	–	4	Weldon	■
JS754060E2R100.3Z4-HXT	03187012	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	–	4	Weldon	■
JS754080E2R050.3Z4-HXT	03187013	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	–	4	Weldon	■
JS754080E2R100.3Z4-HXT	03187014	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	–	4	Weldon	■
JS754100E2R050.3Z4-HXT	03187015	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	–	4	Weldon	■
JS754100E2R100.3Z4-HXT	03187016	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	–	4	Weldon	■
JS754100E2R150.3Z4-HXT	03200564	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,5	–	4	Weldon	■
JS754100E2R200.3Z4-HXT	03187017	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	–	4	Weldon	■
JS754100E2R300.3Z4-HXT	03187018	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	–	4	Weldon	■
JS754120E2R050.3Z4-HXT	03187019	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	–	4	Weldon	■
JS754120E2R100.3Z4-HXT	03187020	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	–	4	Weldon	■
JS754120E2R150.3Z4-HXT	03200565	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,5	–	4	Weldon	■
JS754120E2R200.3Z4-HXT	03187021	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	–	4	Weldon	■
JS754120E2R300.3Z4-HXT	03187022	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	–	4	Weldon	■
JS754160E2R050.3Z4-HXT	03187023	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	–	4	Weldon	■
JS754160E2R100.3Z4-HXT	03187024	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	–	4	Weldon	■
JS754160E2R200.3Z4-HXT	03187025	2	E	16,0	16,0	32,0	92,0	42,0	15,2	2,0	–	4	Weldon	■
JS754160E2R300.3Z4-HXT	03187026	2	E	16,0	16,0	32,0	92,0	42,0	15,2	3,0	–	4	Weldon	■
JS754160E2R400.3Z4-HXT	03187027	2	E	16,0	16,0	32,0	92,0	42,0	15,2	4,0	–	4	Weldon	■
JS754160E2R600.3Z4-HXT	03187028	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	–	4	Weldon	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS754

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 4 Schneiden – Weldon – Eckenradius





E



—Toleranzen:
—DMM = h5
—DC= e7
—RE= ±0,02 mm
—Nachschleifen möglich

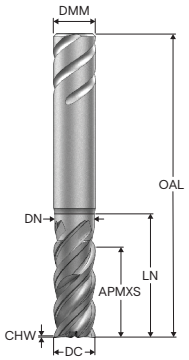
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS754200E2R050.3Z4-HXT	03187029	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	4	Weldon	■
JS754200E2R100.3Z4-HXT	03187030	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	4	Weldon	■
JS754200E2R200.3Z4-HXT	03187031	2	E	20,0	20,0	40,0	104,0	51,0	19,0	2,0	4	Weldon	■
JS754200E2R300.3Z4-HXT	03187032	2	E	20,0	20,0	40,0	104,0	51,0	19,0	3,0	4	Weldon	■
JS754200E2R600.3Z4-HXT	03187034	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	4	Weldon	■
JS754060E3R020.3Z4-HXT	03187040	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	4	Weldon	□
JS754060E3R050.3Z4-HXT	03187041	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	4	Weldon	□
JS754060E3R100.3Z4-HXT	03187042	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	4	Weldon	□
JS754080E3R050.3Z4-HXT	03187043	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	4	Weldon	□
JS754080E3R100.3Z4-HXT	03187044	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	4	Weldon	□
JS754100E3R050.3Z4-HXT	03187045	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	4	Weldon	□
JS754100E3R100.3Z4-HXT	03187046	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	4	Weldon	□
JS754100E3R200.3Z4-HXT	03187047	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	4	Weldon	□
JS754100E3R300.3Z4-HXT	03187049	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	4	Weldon	□
JS754120E3R050.3Z4-HXT	03187050	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	4	Weldon	□
JS754120E3R100.3Z4-HXT	03187051	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	4	Weldon	□
JS754120E3R200.3Z4-HXT	03187052	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	4	Weldon	□
JS754120E3R300.3Z4-HXT	03187053	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	4	Weldon	□
JS754160E3R050.3Z4-HXT	03187054	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	4	Weldon	■
JS754160E3R100.3Z4-HXT	03187055	3	E	16,0	16,0	55,0	115,0	65,0	15,2	1,0	4	Weldon	□
JS754160E3R200.3Z4-HXT	03187056	3	E	16,0	16,0	55,0	115,0	65,0	15,2	2,0	4	Weldon	□
JS754160E3R300.3Z4-HXT	03187057	3	E	16,0	16,0	55,0	115,0	65,0	15,2	3,0	4	Weldon	□
JS754160E3R400.3Z4-HXT	03187058	3	E	16,0	16,0	55,0	115,0	65,0	15,2	4,0	4	Weldon	□
JS754160E3R600.3Z4-HXT	03187059	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	4	Weldon	□
JS754200E3R050.3Z4-HXT	03187060	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	4	Weldon	□
JS754200E3R100.3Z4-HXT	03187061	3	E	20,0	20,0	61,0	125,0	72,0	19,0	1,0	4	Weldon	□
JS754200E3R200.3Z4-HXT	03187062	3	E	20,0	20,0	61,0	125,0	72,0	19,0	2,0	4	Weldon	□
JS754200E3R300.3Z4-HXT	03187063	3	E	20,0	20,0	61,0	125,0	72,0	19,0	3,0	4	Weldon	□
JS754200E3R400.3Z4-HXT	03187064	3	E	20,0	20,0	61,0	125,0	72,0	19,0	4,0	4	Weldon	□
JS754200E3R600.3Z4-HXT	03187065	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	4	Weldon	□

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS754

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 4 Schneiden – Safe-Lock – Fase





E



- Toleranzen:
- DMM = h5
- DC= e7
- Nachschleifen möglich

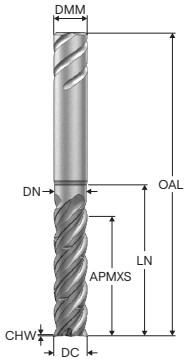
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS754060E2C.9Z4-HXT	03187144	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	Safe-lock	☐
JS754080E2C.9Z4-HXT	03187145	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	Safe-lock	☐
JS754100E2C.9Z4-HXT	03187146	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	Safe-lock	☐
JS754120E2C.9Z4-HXT	03187147	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	Safe-lock	☐
JS754160E2C.9Z4-HXT	03187148	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	Safe-lock	☐
JS754200E2C.9Z4-HXT	03187149	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	Safe-lock	☐
JS754250E2C.9Z4-HXT	03187150	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	4	Safe-lock	☐
JS754060E3C.9Z4-HXT	03187153	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	Safe-lock	☐
JS754080E3C.9Z4-HXT	03187154	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	Safe-lock	☐
JS754100E3C.9Z4-HXT	03187155	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	Safe-lock	☐
JS754120E3C.9Z4-HXT	03187156	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	Safe-lock	☐
JS754160E3C.9Z4-HXT	03187157	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	Safe-lock	☐
JS754200E3C.9Z4-HXT	03187158	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	Safe-lock	☐
JS754250E3C.9Z4-HXT	03187159	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	4	Safe-lock	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

JS754

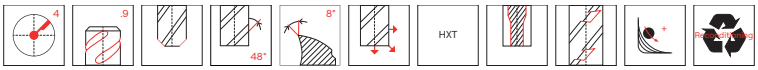
Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 4 Schneiden – Safe-Lock – Fase





E

—Toleranzen:
—DMM = h5
—DC= e7
—Nachschleifen möglich



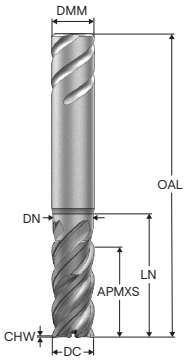
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JS754100E2C.9Z4C-HXT	03187151	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	Safe-lock	□
JS754120E2C.9Z4C-HXT	03187152	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	Safe-lock	□
JS754060E3C.9Z4C-HXT	03200571	3	E	■	6,0	6,0	21,0	65,0	26,0	5,7	0,075	4	Safe-lock	□
JS754080E3C.9Z4C-HXT	03200572	3	E	■	8,0	8,0	32,0	75,0	37,0	7,6	0,1	4	Safe-lock	□
JS754100E3C.9Z4C-HXT	03187160	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	4	Safe-lock	□
JS754120E3C.9Z4C-HXT	03187161	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	4	Safe-lock	□
JS754160E3C.9Z4C-HXT	03187162	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	4	Safe-lock	□
JS754200E3C.9Z4C-HXT	03187163	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	4	Safe-lock	□

□ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

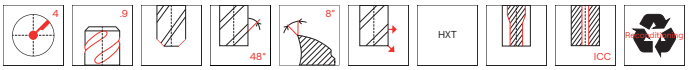
JS754

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 4 Schneiden – Safe-Lock – Fase





E



—Toleranzen:
—DMM = h5
—DC= e7
—Nachschleifen möglich

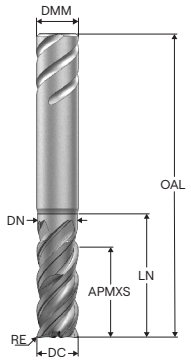
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JS754060E2C.9Z4A-HXT	03187164	2	E	■	6,0	6,0	12,0	57,0	18,0	5,7	0,075	4	Safe-lock	☐
JS754080E2C.9Z4A-HXT	03187165	2	E	■	8,0	8,0	16,0	63,0	25,0	7,6	0,1	4	Safe-lock	☐
JS754100E2C.9Z4A-HXT	03187166	2	E	■	10,0	10,0	20,0	72,0	29,0	9,5	0,125	4	Safe-lock	☐
JS754120E2C.9Z4A-HXT	03187167	2	E	■	12,0	12,0	24,0	83,0	35,0	11,4	0,15	4	Safe-lock	☐
JS754160E2C.9Z4A-HXT	03187168	2	E	■	16,0	16,0	32,0	92,0	42,0	15,2	0,2	4	Safe-lock	☐
JS754200E2C.9Z4A-HXT	03187169	2	E	■	20,0	20,0	40,0	104,0	51,0	19,0	0,25	4	Safe-lock	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.
ICC = mit interner Kühlschmiermittelzufuhr

JS754

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 4 Schneiden – Safe-Lock – Eckenradius





E



—Toleranzen:
—DMM = h5
—DC= e7
—RE= ±0,02 mm
—Nachschleifen möglich

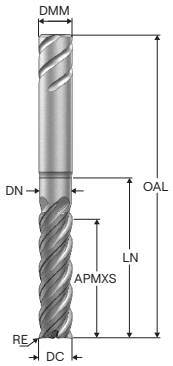
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS754060E2R020.9Z4-HXT	03187170	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	4	Safe-lock	□
JS754060E2R050.9Z4-HXT	03187171	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	4	Safe-lock	□
JS754060E2R100.9Z4-HXT	03187172	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	4	Safe-lock	□
JS754080E2R050.9Z4-HXT	03187173	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	4	Safe-lock	□
JS754080E2R100.9Z4-HXT	03187174	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	4	Safe-lock	□
JS754100E2R050.9Z4-HXT	03187175	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	4	Safe-lock	□
JS754100E2R100.9Z4-HXT	03187176	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	4	Safe-lock	□
JS754100E2R150.9Z4-HXT	03200573	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,5	4	Safe-lock	□
JS754100E2R200.9Z4-HXT	03187177	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	4	Safe-lock	□
JS754100E2R300.9Z4-HXT	03187178	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	4	Safe-lock	□
JS754120E2R050.9Z4-HXT	03187179	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	4	Safe-lock	□
JS754120E2R100.9Z4-HXT	03187180	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	4	Safe-lock	□
JS754120E2R150.9Z4-HXT	03200832	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,5	4	Safe-lock	□
JS754120E2R200.9Z4-HXT	03187181	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	4	Safe-lock	□
JS754120E2R300.9Z4-HXT	03187182	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	4	Safe-lock	□
JS754160E2R050.9Z4-HXT	03187183	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	4	Safe-lock	□
JS754160E2R100.9Z4-HXT	03187184	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	4	Safe-lock	□
JS754160E2R200.9Z4-HXT	03187185	2	E	16,0	16,0	32,0	92,0	42,0	15,2	2,0	4	Safe-lock	□
JS754160E2R300.9Z4-HXT	03187186	2	E	16,0	16,0	32,0	92,0	42,0	15,2	3,0	4	Safe-lock	□
JS754160E2R400.9Z4-HXT	03187187	2	E	16,0	16,0	32,0	92,0	42,0	15,2	4,0	4	Safe-lock	■
JS754160E2R600.9Z4-HXT	03187188	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	4	Safe-lock	□
JS754200E2R050.9Z4-HXT	03187189	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	4	Safe-lock	□
JS754200E2R100.9Z4-HXT	03187190	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	4	Safe-lock	□
JS754200E2R200.9Z4-HXT	03187191	2	E	20,0	20,0	40,0	104,0	51,0	19,0	2,0	4	Safe-lock	□
JS754200E2R300.9Z4-HXT	03187192	2	E	20,0	20,0	40,0	104,0	51,0	19,0	3,0	4	Safe-lock	□
JS754200E2R400.9Z4-HXT	03187193	2	E	20,0	20,0	40,0	104,0	51,0	19,0	4,0	4	Safe-lock	□
JS754200E2R600.9Z4-HXT	03187194	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	4	Safe-lock	□

□ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

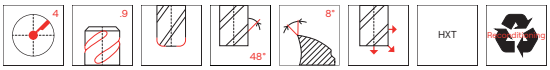
JS754

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 4 Schneiden – Safe-Lock – Eckenradius





E



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS754060E3R020.9Z4-HXT	03187197	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	4	Safe-lock	☐
JS754060E3R050.9Z4-HXT	03187198	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	4	Safe-lock	☐
JS754060E3R100.9Z4-HXT	03187199	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	4	Safe-lock	☐
JS754080E3R050.9Z4-HXT	03187200	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	4	Safe-lock	☐
JS754080E3R100.9Z4-HXT	03187201	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	4	Safe-lock	☐
JS754100E3R050.9Z4-HXT	03187202	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	4	Safe-lock	☐
JS754100E3R100.9Z4-HXT	03187203	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	4	Safe-lock	☐
JS754100E3R200.9Z4-HXT	03187204	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	4	Safe-lock	☐
JS754100E3R300.9Z4-HXT	03187205	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	4	Safe-lock	☐
JS754120E3R050.9Z4-HXT	03187206	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	4	Safe-lock	☐
JS754120E3R100.9Z4-HXT	03187207	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	4	Safe-lock	☐
JS754120E3R200.9Z4-HXT	03187208	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	4	Safe-lock	☐
JS754120E3R300.9Z4-HXT	03187209	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	4	Safe-lock	☐
JS754160E3R050.9Z4-HXT	03187210	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	4	Safe-lock	☐
JS754160E3R100.9Z4-HXT	03187211	3	E	16,0	16,0	55,0	115,0	65,0	15,2	1,0	4	Safe-lock	☐
JS754160E3R200.9Z4-HXT	03187212	3	E	16,0	16,0	55,0	115,0	65,0	15,2	2,0	4	Safe-lock	☐
JS754160E3R300.9Z4-HXT	03187213	3	E	16,0	16,0	55,0	115,0	65,0	15,2	3,0	4	Safe-lock	☐
JS754160E3R400.9Z4-HXT	03187214	3	E	16,0	16,0	55,0	115,0	65,0	15,2	4,0	4	Safe-lock	☐
JS754160E3R600.9Z4-HXT	03187215	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	4	Safe-lock	☐
JS754200E3R050.9Z4-HXT	03187216	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	4	Safe-lock	☐
JS754200E3R100.9Z4-HXT	03187217	3	E	20,0	20,0	61,0	125,0	72,0	19,0	1,0	4	Safe-lock	☐
JS754200E3R200.9Z4-HXT	03187218	3	E	20,0	20,0	61,0	125,0	72,0	19,0	2,0	4	Safe-lock	☐
JS754200E3R300.9Z4-HXT	03187219	3	E	20,0	20,0	61,0	125,0	72,0	19,0	3,0	4	Safe-lock	☐
JS754200E3R400.9Z4-HXT	03187220	3	E	20,0	20,0	61,0	125,0	72,0	19,0	4,0	4	Safe-lock	☐
JS754200E3R600.9Z4-HXT	03187221	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	4	Safe-lock	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

Schnittdaten – JS754 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z										v_c
				3	4	5	6	8	10	12	16	20	25	
P11	M/A/D/E	0.400 *0,400*	0.80 *0,80*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	165 (130 — 180) *540 (430 — 590)*
P12	M/A/D/E	0.400 *0,400*	0.80 *0,80*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	105 (83 — 120) *345 (280 — 390)*
M1	E	0.400 *0,400*	1.0 *1,0*	0.020 *0,00080*	0.026 *0,0010*	0.034 *0,0013*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	0.13 *0,0050*	110 (96 — 130) *360 (320 — 420)*
M2	E	0.400 *0,400*	1.0 *1,0*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	90 (79 — 110) *295 (260 — 360)*
M3	E	0.400 *0,400*	0.90 *0,90*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	60 (44 — 76) *195 (150 — 240)*
M4	E	0.400 *0,400*	0.90 *0,90*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	46 (34 — 59) *150 (120 — 190)*
M5	E	0.400 *0,400*	0.90 *0,90*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	39 (29 — 49) *130 (96 — 160)*
S1	E	0.150 *0,150*	0.50 *0,50*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	50 (26 — 68) *165 (86 — 220)*
S2	E	0.150 *0,150*	0.50 *0,50*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	41 (21 — 55) *135 (69 — 180)*
S3	E	0.150 *0,150*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	36 (19 — 48) *120 (63 — 150)*
S11	E	0.400 *0,400*	0.70 *0,70*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	110 (73 — 140) *360 (240 — 450)*
S12	E	0.400 *0,400*	0.70 *0,70*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	85 (56 — 110) *280 (190 — 360)*
S13	E	0.400 *0,400*	0.70 *0,70*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	65 (44 — 87) *215 (150 — 280)*

Schnittdaten – JS754 Nutfräsen

SMG		a_p/DC	f_z										v_c
			3	4	5	6	8	10	12	16	20	25	
P11	M/A/D/E	0.80 *0,80*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	150 (120 — 170) *490 (400 — 550)*
P12	M/A/D/E	0.80 *0,80*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	90 (69 — 100) *295 (230 — 320)*
M1	E	0.80 *0,80*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	95 (85 — 120) *310 (280 — 390)*
M2	E	0.80 *0,80*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	80 (69 — 97) *260 (230 — 310)*
M3	E	0.60 *0,60*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	55 (39 — 67) *180 (130 — 210)*
M4	E	0.60 *0,60*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	40 (29 — 50) *130 (96 — 160)*
M5	E	0.60 *0,60*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	33 (25 — 42) *110 (83 — 130)*
S1	E	0.30 *0,30*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	41 (21 — 54) *135 (69 — 170)*
S2	E	0.30 *0,30*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	33 (17 — 43) *110 (56 — 140)*
S3	E	0.30 *0,30*	0.0095 *0,00038*	0.012 *0,00048*	0.015 *0,00060*	0.019 *0,00075*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	28 (15 — 37) *90 (50 — 120)*
S11	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	95 (63 — 120) *310 (210 — 390)*
S12	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	70 (48 — 95) *230 (160 — 310)*
S13	E	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	55 (38 — 74) *180 (130 — 240)*

Bei einem Radius mit mehr als 15% DC, fz um 20% reduzieren

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS754-2C Dynamisches Fräsen a_e/DC=0,05-0,1

SMG		a_e/DC	a_p/DC	f_z		v_c
				10	12	
P11	M/A/D/E	0.100 *0,100*	2.0 *2,0*	0.15 *0,0060*	0.17 *0,0065*	265 (220 — 290) *870 (730 — 950)*
P12	M/A/D/E	0.100 *0,100*	2.0 *2,0*	0.10 *0,0040*	0.12 *0,0048*	170 (150 — 190) *560 (500 — 620)*
M1	E	0.100 *0,100*	2.0 *2,0*	0.11 *0,0044*	0.13 *0,0050*	205 (180 — 230) *670 (600 — 750)*
M2	E	0.100 *0,100*	2.0 *2,0*	0.10 *0,0040*	0.12 *0,0048*	170 (150 — 190) *560 (500 — 620)*
M3	E	0.100 *0,100*	2.0 *2,0*	0.10 *0,0040*	0.12 *0,0048*	130 (120 — 150) *425 (400 — 490)*
M4	E	0.100 *0,100*	2.0 *2,0*	0.085 *0,0034*	0.10 *0,0040*	100 (86 — 110) *330 (290 — 360)*
M5	E	0.100 *0,100*	2.0 *2,0*	0.085 *0,0034*	0.10 *0,0040*	85 (72 — 96) *280 (240 — 310)*
S1	E	0.0500 *0,0500*	2.0 *2,0*	0.085 *0,0034*	0.10 *0,0040*	70 (43 — 99) *230 (150 — 320)*
S2	E	0.0500 *0,0500*	2.0 *2,0*	0.085 *0,0034*	0.10 *0,0040*	60 (35 — 80) *195 (120 — 260)*
S3	E	0.0500 *0,0500*	2.0 *2,0*	0.080 *0,0032*	0.095 *0,0038*	50 (31 — 70) *165 (110 — 220)*
S11	E	0.0800 *0,0800*	2.0 *2,0*	0.070 *0,0028*	0.085 *0,0034*	165 (140 — 190) *540 (460 — 620)*
S12	E	0.0800 *0,0800*	2.0 *2,0*	0.070 *0,0028*	0.085 *0,0034*	125 (110 — 150) *410 (370 — 490)*
S13	E	0.0800 *0,0800*	2.0 *2,0*	0.060 *0,0024*	0.070 *0,0028*	100 (84 — 110) *330 (280 — 360)*

Schnittdaten – JS754-3C Dynamisches Fräsen a_e/DC=0,05-0,1

SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
P11	M/A/D/E	0.100 *0,100*	4.0 *4,0*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.22 *0,0085*	0.25 *0,010*	265 (220 — 290) *870 (730 — 950)*
P12	M/A/D/E	0.100 *0,100*	4.0 *4,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (140 — 180) *560 (460 — 590)*
M1	E	0.100 *0,100*	4.0 *4,0*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	205 (170 — 230) *670 (560 — 750)*
M2	E	0.100 *0,100*	4.0 *4,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (140 — 190) *560 (460 — 620)*
M3	E	0.100 *0,100*	4.0 *4,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 150) *425 (370 — 490)*
M4	E	0.100 *0,100*	4.0 *4,0*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	100 (86 — 110) *330 (290 — 360)*
M5	E	0.100 *0,100*	4.0 *4,0*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	85 (72 — 96) *280 (240 — 310)*
S1	E	0.0500 *0,0500*	4.0 *4,0*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	70 (43 — 99) *230 (150 — 320)*
S2	E	0.0500 *0,0500*	4.0 *4,0*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	55 (35 — 80) *180 (120 — 260)*
S3	E	0.0500 *0,0500*	4.0 *4,0*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	50 (30 — 70) *165 (99 — 220)*
S11	E	0.0800 *0,0800*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	165 (140 — 190) *540 (460 — 620)*
S12	E	0.0800 *0,0800*	4.0 *4,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 150) *410 (370 — 490)*
S13	E	0.0800 *0,0800*	4.0 *4,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	100 (84 — 110) *330 (280 — 360)*

Bei einem Radius mit mehr als 15% DC, fz um 20% reduzieren

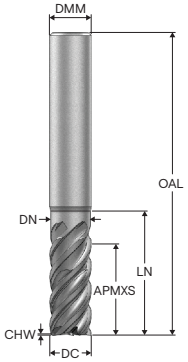
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JS755

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 5 Schneiden – Zylindrisch – Fase





E

—Toleranzen:
—DMM = h5
—DC= e7
—Nachschleifen möglich



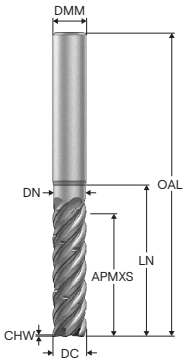
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS755060E2C.0Z5-HXT	03186907	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	5	Cylindrical	■
JS755080E2C.0Z5-HXT	03186908	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	5	Cylindrical	■
JS755100E2C.0Z5-HXT	03186909	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	5	Cylindrical	■
JS755120E2C.0Z5-HXT	03186910	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	5	Cylindrical	■
JS755160E2C.0Z5-HXT	03186911	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	5	Cylindrical	■
JS755200E2C.0Z5-HXT	03186912	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	5	Cylindrical	■
JS755250E2C.0Z5-HXT	03186913	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	5	Cylindrical	■
JS755060E3C.0Z5-HXT	03186914	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	5	Cylindrical	■
JS755080E3C.0Z5-HXT	03186915	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	5	Cylindrical	■
JS755100E3C.0Z5-HXT	03186916	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	Cylindrical	■
JS755120E3C.0Z5-HXT	03186917	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	Cylindrical	■
JS755160E3C.0Z5-HXT	03186918	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	Cylindrical	■
JS755200E3C.0Z5-HXT	03186919	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	Cylindrical	■
JS755250E3C.0Z5-HXT	03186920	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	5	Cylindrical	■

■ **Lagerstandard.**

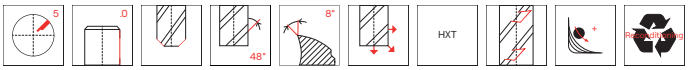
JS755

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 5 Schneiden – Zylindrisch – Fase





E



—Toleranzen:
—DMM = h5
—DC= e7
—Nachschleifen möglich

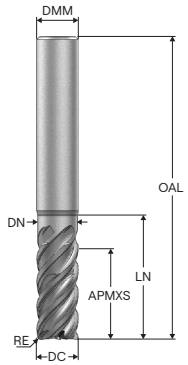
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JS755100E3C.0Z5C-HXT	03186921	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	Cylindrical	■
JS755120E3C.0Z5C-HXT	03186922	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	Cylindrical	■
JS755160E3C.0Z5C-HXT	03186923	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	Cylindrical	■
JS755200E3C.0Z5C-HXT	03186924	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	Cylindrical	■

■ **Lagerstandard.**

JS755

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 5 Schneiden – Zylindrisch – Eckenradius





E



—Toleranzen:
—DMM = h5
—DC= e7
—RE= ±0,02 mm
—Nachschleifen möglich

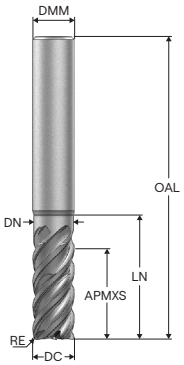
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS755060E2R020.0Z5-HXT	03186925	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	5	Cylindrical	■
JS755060E2R050.0Z5-HXT	03186926	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	5	Cylindrical	■
JS755060E2R100.0Z5-HXT	03186927	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	5	Cylindrical	■
JS755080E2R050.0Z5-HXT	03186928	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	5	Cylindrical	■
JS755080E2R100.0Z5-HXT	03186929	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	5	Cylindrical	■
JS755100E2R050.0Z5-HXT	03186930	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	5	Cylindrical	■
JS755100E2R100.0Z5-HXT	03186931	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	5	Cylindrical	■
JS755100E2R200.0Z5-HXT	03186932	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	5	Cylindrical	■
JS755100E2R300.0Z5-HXT	03186933	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	5	Cylindrical	■
JS755120E2R050.0Z5-HXT	03186934	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	5	Cylindrical	■
JS755120E2R100.0Z5-HXT	03186935	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	5	Cylindrical	■
JS755120E2R200.0Z5-HXT	03186936	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	5	Cylindrical	■
JS755120E2R300.0Z5-HXT	03186937	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	5	Cylindrical	■
JS755160E2R050.0Z5-HXT	03186938	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	5	Cylindrical	■
JS755160E2R100.0Z5-HXT	03186939	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	5	Cylindrical	■
JS755200E2R050.0Z5-HXT	03186941	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	5	Cylindrical	■
JS755200E2R100.0Z5-HXT	03186942	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	5	Cylindrical	■

■ **Lagerstandard.**

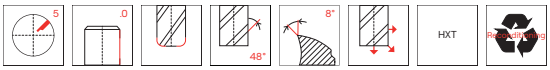
JS755

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 5 Schneiden – Zylindrisch – Eckenradius





E



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

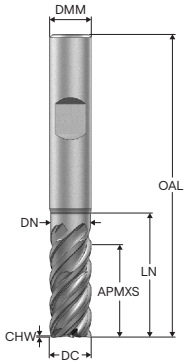
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS755060E3R020.0Z5-HXT	03186946	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	5	Cylindrical	■
JS755060E3R050.0Z5-HXT	03186947	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	5	Cylindrical	■
JS755060E3R100.0Z5-HXT	03186948	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	5	Cylindrical	■
JS755080E3R050.0Z5-HXT	03186949	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	5	Cylindrical	■
JS755080E3R100.0Z5-HXT	03186950	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	5	Cylindrical	■
JS755100E3R050.0Z5-HXT	03186951	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	5	Cylindrical	■
JS755100E3R100.0Z5-HXT	03186952	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	5	Cylindrical	■
JS755100E3R200.0Z5-HXT	03186953	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	5	Cylindrical	■
JS755100E3R300.0Z5-HXT	03186954	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	5	Cylindrical	■
JS755120E3R050.0Z5-HXT	03186955	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	5	Cylindrical	■
JS755120E3R100.0Z5-HXT	03186956	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	5	Cylindrical	■
JS755120E3R200.0Z5-HXT	03186957	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	5	Cylindrical	■
JS755120E3R300.0Z5-HXT	03186958	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	5	Cylindrical	■
JS755160E3R050.0Z5-HXT	03186959	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	5	Cylindrical	■
JS755160E3R600.0Z5-HXT	03186960	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	5	Cylindrical	■
JS755200E3R050.0Z5-HXT	03186961	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	5	Cylindrical	■
JS755200E3R600.0Z5-HXT	03186962	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	5	Cylindrical	■

■ **Lagerstandard.**

JS755

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 5 Schneiden – Weldon – Fase





E

—Toleranzen:
—DMM = h5
—DC= e7
—Nachschleifen möglich



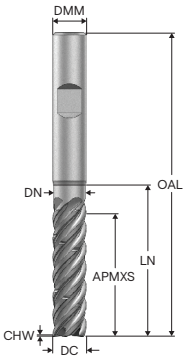
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS755060E2C.3Z5-HXT	03187083	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	5	Weldon	■
JS755080E2C.3Z5-HXT	03187084	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	5	Weldon	■
JS755100E2C.3Z5-HXT	03187085	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	5	Weldon	■
JS755120E2C.3Z5-HXT	03187086	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	5	Weldon	■
JS755160E2C.3Z5-HXT	03187087	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	5	Weldon	■
JS755200E2C.3Z5-HXT	03187088	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	5	Weldon	■
JS755250E2C.3Z5-HXT	03187089	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	5	Weldon	■
JS755060E3C.3Z5-HXT	03187090	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	5	Weldon	■
JS755080E3C.3Z5-HXT	03187091	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	5	Weldon	■
JS755100E3C.3Z5-HXT	03187092	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	Weldon	■
JS755120E3C.3Z5-HXT	03187093	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	Weldon	■
JS755160E3C.3Z5-HXT	03187094	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	Weldon	■
JS755200E3C.3Z5-HXT	03187095	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	Weldon	■
JS755250E3C.3Z5-HXT	03187096	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	5	Weldon	■

■ **Lagerstandard.**

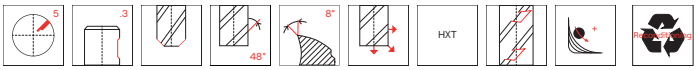
JS755

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 5 Schneiden – Weldon – Fase





E



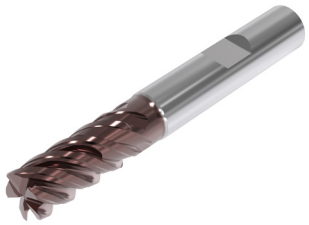
- Toleranzen:
- DMM = h5
- DC= e7
- Nachschleifen möglich

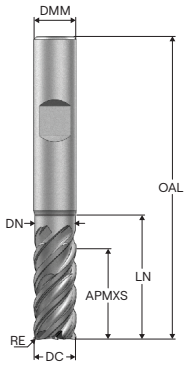
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JS755100E3C.3Z5C-HXT	03187097	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	Weldon	■
JS755120E3C.3Z5C-HXT	03187098	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	Weldon	■
JS755160E3C.3Z5C-HXT	03187099	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	Weldon	■
JS755200E3C.3Z5C-HXT	03187100	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	Weldon	■

■ **Lagerstandard.**

JS755

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 5 Schneiden – Weldon – Eckenradius





E



—Toleranzen:
—DMM = h5
—DC= e7
—RE= ±0,02 mm
—Nachschleifen möglich

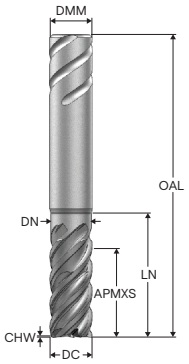
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS755060E2R020.3Z5-HXT	03187101	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	5	Weldon	■
JS755060E2R050.3Z5-HXT	03187102	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	5	Weldon	■
JS755060E2R100.3Z5-HXT	03187103	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	5	Weldon	■
JS755080E2R050.3Z5-HXT	03187104	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	5	Weldon	■
JS755080E2R100.3Z5-HXT	03187105	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	5	Weldon	■
JS755100E2R050.3Z5-HXT	03187106	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	5	Weldon	■
JS755100E2R100.3Z5-HXT	03187107	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	5	Weldon	■
JS755100E2R200.3Z5-HXT	03187108	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	5	Weldon	■
JS755100E2R300.3Z5-HXT	03187109	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	5	Weldon	■
JS755120E2R050.3Z5-HXT	03187110	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	5	Weldon	■
JS755120E2R100.3Z5-HXT	03187111	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	5	Weldon	■
JS755120E2R200.3Z5-HXT	03187112	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	5	Weldon	■
JS755120E2R300.3Z5-HXT	03187113	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	5	Weldon	■
JS755160E2R050.3Z5-HXT	03187114	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	5	Weldon	■
JS755160E2R100.3Z5-HXT	03187115	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	5	Weldon	■
JS755160E2R600.3Z5-HXT	03187116	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	5	Weldon	■
JS755200E2R050.3Z5-HXT	03187117	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	5	Weldon	■
JS755200E2R100.3Z5-HXT	03187118	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	5	Weldon	■
JS755200E2R600.3Z5-HXT	03187119	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	5	Weldon	■
JS755060E3R020.3Z5-HXT	03187122	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	5	Weldon	□
JS755060E3R050.3Z5-HXT	03187123	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	5	Weldon	□
JS755060E3R100.3Z5-HXT	03187124	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	5	Weldon	□
JS755080E3R050.3Z5-HXT	03187125	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	5	Weldon	□
JS755080E3R100.3Z5-HXT	03187126	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	5	Weldon	□
JS755100E3R050.3Z5-HXT	03187127	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	5	Weldon	□
JS755100E3R100.3Z5-HXT	03187128	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	5	Weldon	□
JS755100E3R200.3Z5-HXT	03187129	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	5	Weldon	□
JS755100E3R300.3Z5-HXT	03187130	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	5	Weldon	□
JS755120E3R050.3Z5-HXT	03187131	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	5	Weldon	□
JS755120E3R100.3Z5-HXT	03187132	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	5	Weldon	□
JS755120E3R200.3Z5-HXT	03187133	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	5	Weldon	□
JS755120E3R300.3Z5-HXT	03187134	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	5	Weldon	□
JS755160E3R050.3Z5-HXT	03187135	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	5	Weldon	□
JS755160E3R600.3Z5-HXT	03187136	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	5	Weldon	□
JS755200E3R050.3Z5-HXT	03187137	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	5	Weldon	□
JS755200E3R600.3Z5-HXT	03187138	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	5	Weldon	□

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS755

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 5 Schneiden – Safe-Lock – Fase





E



—Toleranzen:
—DMM = h5
—DC= e7
—Nachschleifen möglich

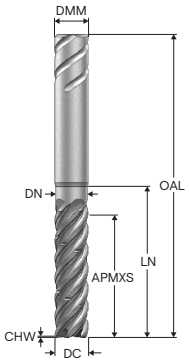
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS755060E2C.9Z5-HXT	03187235	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,075	5	Safe-lock	☐
JS755080E2C.9Z5-HXT	03187236	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	5	Safe-lock	☐
JS755100E2C.9Z5-HXT	03187237	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,125	5	Safe-lock	☐
JS755120E2C.9Z5-HXT	03187238	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,15	5	Safe-lock	☐
JS755160E2C.9Z5-HXT	03187239	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,2	5	Safe-lock	☐
JS755200E2C.9Z5-HXT	03187240	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,25	5	Safe-lock	☐
JS755250E2C.9Z5-HXT	03187241	2	E	25,0	25,0	50,0	121,0	65,0	23,8	0,3	5	Safe-lock	☐
JS755060E3C.9Z5-HXT	03187242	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,075	5	Safe-lock	☐
JS755080E3C.9Z5-HXT	03187243	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,1	5	Safe-lock	☐
JS755100E3C.9Z5-HXT	03187244	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	Safe-lock	☐
JS755120E3C.9Z5-HXT	03187245	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	Safe-lock	☐
JS755160E3C.9Z5-HXT	03187246	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	Safe-lock	☐
JS755200E3C.9Z5-HXT	03187247	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	Safe-lock	☐
JS755250E3C.9Z5-HXT	03187248	3	E	25,0	25,0	85,0	153,0	94,0	23,8	0,3	5	Safe-lock	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

JS755

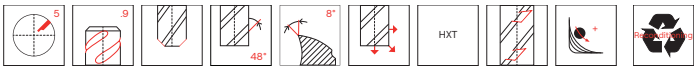
Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 5 Schneiden – Safe-Lock – Fase





E

—Toleranzen:
—DMM = h5
—DC= e7
—Nachschleifen möglich



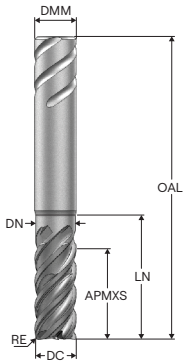
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JS755100E3C.9Z5C-HXT	03187249	3	E	■	10,0	10,0	40,0	89,0	47,0	9,5	0,125	5	Safe-lock	□
JS755120E3C.9Z5C-HXT	03187250	3	E	■	12,0	12,0	45,0	100,0	53,0	11,4	0,15	5	Safe-lock	□
JS755160E3C.9Z5C-HXT	03187252	3	E	■	16,0	16,0	55,0	115,0	65,0	15,2	0,2	5	Safe-lock	□
JS755200E3C.9Z5C-HXT	03187253	3	E	■	20,0	20,0	61,0	125,0	72,0	19,0	0,25	5	Safe-lock	□

□ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

JS755

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 5 Schneiden – Safe-Lock – Eckenradius





E



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JS755060E2R020.9Z5-HXT	03187254	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,2	5	Safe-lock	☐
JS755060E2R050.9Z5-HXT	03187255	2	E	6,0	6,0	12,0	57,0	18,0	5,7	0,5	5	Safe-lock	☐
JS755060E2R100.9Z5-HXT	03187256	2	E	6,0	6,0	12,0	57,0	18,0	5,7	1,0	5	Safe-lock	☐
JS755080E2R050.9Z5-HXT	03187257	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	5	Safe-lock	☐
JS755080E2R100.9Z5-HXT	03187258	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	5	Safe-lock	☐
JS755100E2R050.9Z5-HXT	03187259	2	E	10,0	10,0	20,0	72,0	29,0	9,5	0,5	5	Safe-lock	☐
JS755100E2R100.9Z5-HXT	03187260	2	E	10,0	10,0	20,0	72,0	29,0	9,5	1,0	5	Safe-lock	☐
JS755100E2R200.9Z5-HXT	03187261	2	E	10,0	10,0	20,0	72,0	29,0	9,5	2,0	5	Safe-lock	☐
JS755100E2R300.9Z5-HXT	03187262	2	E	10,0	10,0	20,0	72,0	29,0	9,5	3,0	5	Safe-lock	☐
JS755120E2R050.9Z5-HXT	03187263	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,5	5	Safe-lock	☐
JS755120E2R100.9Z5-HXT	03187264	2	E	12,0	12,0	24,0	83,0	35,0	11,4	1,0	5	Safe-lock	☐
JS755120E2R200.9Z5-HXT	03187265	2	E	12,0	12,0	24,0	83,0	35,0	11,4	2,0	5	Safe-lock	☐
JS755120E2R300.9Z5-HXT	03187266	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,0	5	Safe-lock	☐
JS755160E2R050.9Z5-HXT	03187267	2	E	16,0	16,0	32,0	92,0	42,0	15,2	0,5	5	Safe-lock	☐
JS755160E2R100.9Z5-HXT	03187269	2	E	16,0	16,0	32,0	92,0	42,0	15,2	1,0	5	Safe-lock	☐
JS755160E2R600.9Z5-HXT	03187270	2	E	16,0	16,0	32,0	92,0	42,0	15,2	6,0	5	Safe-lock	☐
JS755200E2R050.9Z5-HXT	03187271	2	E	20,0	20,0	40,0	104,0	51,0	19,0	0,5	5	Safe-lock	☐
JS755200E2R100.9Z5-HXT	03187272	2	E	20,0	20,0	40,0	104,0	51,0	19,0	1,0	5	Safe-lock	☐
JS755200E2R600.9Z5-HXT	03187273	2	E	20,0	20,0	40,0	104,0	51,0	19,0	6,0	5	Safe-lock	☐
JS755060E3R020.9Z5-HXT	03187276	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,2	5	Safe-lock	☐
JS755060E3R050.9Z5-HXT	03187277	3	E	6,0	6,0	21,0	65,0	26,0	5,7	0,5	5	Safe-lock	☐
JS755060E3R100.9Z5-HXT	03187279	3	E	6,0	6,0	21,0	65,0	26,0	5,7	1,0	5	Safe-lock	☐
JS755080E3R050.9Z5-HXT	03187280	3	E	8,0	8,0	32,0	75,0	37,0	7,6	0,5	5	Safe-lock	☐
JS755080E3R100.9Z5-HXT	03187281	3	E	8,0	8,0	32,0	75,0	37,0	7,6	1,0	5	Safe-lock	☐
JS755100E3R050.9Z5-HXT	03187282	3	E	10,0	10,0	40,0	89,0	47,0	9,5	0,5	5	Safe-lock	☐
JS755100E3R100.9Z5-HXT	03187283	3	E	10,0	10,0	40,0	89,0	47,0	9,5	1,0	5	Safe-lock	☐
JS755100E3R200.9Z5-HXT	03187284	3	E	10,0	10,0	40,0	89,0	47,0	9,5	2,0	5	Safe-lock	☐
JS755100E3R300.9Z5-HXT	03187285	3	E	10,0	10,0	40,0	89,0	47,0	9,5	3,0	5	Safe-lock	☐
JS755120E3R050.9Z5-HXT	03187286	3	E	12,0	12,0	45,0	100,0	53,0	11,4	0,5	5	Safe-lock	☐
JS755120E3R100.9Z5-HXT	03187287	3	E	12,0	12,0	45,0	100,0	53,0	11,4	1,0	5	Safe-lock	☐
JS755120E3R200.9Z5-HXT	03187288	3	E	12,0	12,0	45,0	100,0	53,0	11,4	2,0	5	Safe-lock	☐
JS755120E3R300.9Z5-HXT	03187289	3	E	12,0	12,0	45,0	100,0	53,0	11,4	3,0	5	Safe-lock	☐
JS755160E3R050.9Z5-HXT	03187290	3	E	16,0	16,0	55,0	115,0	65,0	15,2	0,5	5	Safe-lock	☐
JS755160E3R600.9Z5-HXT	03187291	3	E	16,0	16,0	55,0	115,0	65,0	15,2	6,0	5	Safe-lock	☐
JS755200E3R050.9Z5-HXT	03187292	3	E	20,0	20,0	61,0	125,0	72,0	19,0	0,5	5	Safe-lock	☐
JS755200E3R600.9Z5-HXT	03187293	3	E	20,0	20,0	61,0	125,0	72,0	19,0	6,0	5	Safe-lock	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

Schnittdaten – JS755 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
P11	M/A/D/E	0.400 *0,400*	1.1 *1,1*	0.044 *0,0017*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	135 (97 — 150) *445 (320 — 490)*
P12	M/A/D/E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	85 (63 — 99) *280 (210 — 320)*
M1	E	0.400 *0,400*	1.1 *1,1*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	170 (150 — 190) *560 (500 — 620)*
M2	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	140 (120 — 150) *460 (400 — 490)*
M3	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	110 (92 — 120) *360 (310 — 390)*
M4	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	85 (71 — 95) *280 (240 — 310)*
M5	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	70 (59 — 79) *230 (200 — 250)*
S1	E	0.0300 *0,0300*	2.0 *2,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	70 (48 — 110) *230 (160 — 360)*
S2	E	0.0300 *0,0300*	2.0 *2,0*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	60 (39 — 89) *195 (130 — 290)*
S3	E	0.0300 *0,0300*	2.0 *2,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	50 (34 — 78) *165 (120 — 250)*
S11	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	140 (120 — 160) *460 (400 — 520)*
S12	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	110 (91 — 120) *360 (300 — 390)*
S13	E	0.400 *0,400*	1.1 *1,1*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	85 (73 — 100) *280 (240 — 320)*

Schnittdaten – JS755_3C Dynamisches Fräsen a_e/DC=0,05-0,1

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P11	M/A/D/E	0.100 *0,100*	4.0 *4,0*	0.15 *0,0060*	0.17 *0,0065*	0.22 *0,0085*	0.25 *0,010*	265 (220 — 290) *870 (730 — 950)*
P12	M/A/D/E	0.100 *0,100*	4.0 *4,0*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (140 — 180) *560 (460 — 590)*
M1	E	0.100 *0,100*	4.0 *4,0*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	205 (170 — 220) *670 (560 — 720)*
M2	E	0.100 *0,100*	4.0 *4,0*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	170 (140 — 180) *560 (460 — 590)*
M3	E	0.100 *0,100*	4.0 *4,0*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	130 (110 — 140) *425 (370 — 450)*
M4	E	0.100 *0,100*	4.0 *4,0*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	100 (85 — 110) *330 (280 — 360)*
M5	E	0.100 *0,100*	4.0 *4,0*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	85 (71 — 96) *280 (240 — 310)*
S1	E	0.0500 *0,0500*	4.0 *4,0*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	70 (43 — 99) *230 (150 — 320)*
S2	E	0.0500 *0,0500*	4.0 *4,0*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	55 (35 — 80) *180 (120 — 260)*
S3	E	0.0500 *0,0500*	4.0 *4,0*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	50 (31 — 70) *165 (110 — 220)*
S11	E	0.0800 *0,0800*	4.0 *4,0*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	160 (140 — 190) *520 (460 — 620)*
S12	E	0.0800 *0,0800*	4.0 *4,0*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	125 (110 — 140) *410 (370 — 450)*
S13	E	0.0800 *0,0800*	4.0 *4,0*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	100 (83 — 110) *330 (280 — 360)*

Bei einem Radius mit mehr als 15% DC, fz um 20% reduzieren

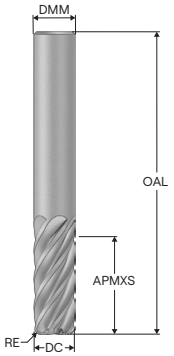
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

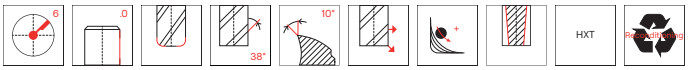
JS720

Hochleistungsfräser – Titan – Eckfräser – 6 Schneiden – Zylindrisch – Eckenradius





D



– Toleranzen:
– DMM = h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich

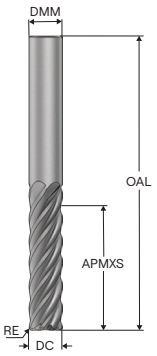
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JS720060D2R050.0Z6-HXT	03060293	2	D	6,0	6,0	17,0	57,0	0,5	6	Cylindrical	■
JS720060D2R100.0Z6-HXT	03060294	2	D	6,0	6,0	17,0	57,0	1,0	6	Cylindrical	■
JS720080D2R050.0Z6-HXT	03060295	2	D	8,0	8,0	23,0	63,0	0,5	6	Cylindrical	■
JS720080D2R100.0Z6-HXT	03061294	2	D	8,0	8,0	23,0	63,0	1,0	6	Cylindrical	■
JS720100D2R050.0Z6-HXT	03060296	2	D	10,0	10,0	26,0	72,0	0,5	6	Cylindrical	■
JS720100D2R100.0Z6-HXT	03060298	2	D	10,0	10,0	26,0	72,0	1,0	6	Cylindrical	■
JS720100D2R200.0Z6-HXT	03060299	2	D	10,0	10,0	26,0	72,0	2,0	6	Cylindrical	■
JS720100D2R300.0Z6-HXT	03060300	2	D	10,0	10,0	26,0	72,0	3,0	6	Cylindrical	■
JS720120D2R050.0Z6-HXT	03060301	2	D	12,0	12,0	30,0	83,0	0,5	6	Cylindrical	■
JS720120D2R100.0Z6-HXT	03060304	2	D	12,0	12,0	30,0	83,0	1,0	6	Cylindrical	■
JS720120D2R200.0Z6-HXT	03060305	2	D	12,0	12,0	30,0	83,0	2,0	6	Cylindrical	■
JS720120D2R300.0Z6-HXT	03060306	2	D	12,0	12,0	30,0	83,0	3,0	6	Cylindrical	■
JS720160D2R050.0Z6-HXT	03060307	2	D	16,0	16,0	44,0	99,0	0,5	6	Cylindrical	■
JS720160D2R100.0Z6-HXT	03060309	2	D	16,0	16,0	44,0	99,0	1,0	6	Cylindrical	■
JS720160D2R200.0Z6-HXT	03060310	2	D	16,0	16,0	44,0	99,0	2,0	6	Cylindrical	■
JS720160D2R300.0Z6-HXT	03060311	2	D	16,0	16,0	44,0	99,0	3,0	6	Cylindrical	■
JS720160D2R400.0Z6-HXT	03060312	2	D	16,0	16,0	44,0	99,0	4,0	6	Cylindrical	■
JS720160D2R600.0Z6-HXT	03060313	2	D	16,0	16,0	44,0	99,0	6,0	6	Cylindrical	■
JS720200D2R050.0Z6-HXT	10228426	2	D	20,0	20,0	45,0	105,0	0,5	6	Cylindrical	■
JS720200D2R100.0Z6-HXT	10228427	2	D	20,0	20,0	45,0	105,0	1,0	6	Cylindrical	■
JS720200D2R200.0Z6-HXT	10228428	2	D	20,0	20,0	45,0	105,0	2,0	6	Cylindrical	■
JS720200D2R300.0Z6-HXT	10228429	2	D	20,0	20,0	45,0	105,0	3,0	6	Cylindrical	■
JS720250D2R100.0Z6-HXT	10228431	2	D	25,0	25,0	50,0	125,0	1,0	6	Cylindrical	■
JS720250D2R300.0Z6-HXT	03169498	2	D	25,0	25,0	50,0	125,0	3,0	6	Cylindrical	■

■ **Lagerstandard.**

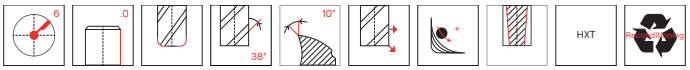
JS720

Hochleistungsfräser – Titan – Eckfräser – 6 Schneiden – Zylindrisch – Eckenradius





D



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

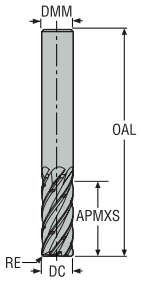
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JS720080D3R050.0Z6-HXT	10228433	3	D	8,0	8,0	32,0	80,0	0,5	6	Cylindrical	■
JS720080D3R100.0Z6-HXT	10228434	3	D	8,0	8,0	32,0	80,0	1,0	6	Cylindrical	■
JS720100D3R050.0Z6-HXT	10228435	3	D	10,0	10,0	40,0	89,0	0,5	6	Cylindrical	■
JS720100D3R100.0Z6-HXT	10228436	3	D	10,0	10,0	40,0	89,0	1,0	6	Cylindrical	■
JS720100D3R200.0Z6-HXT	10228437	3	D	10,0	10,0	40,0	89,0	2,0	6	Cylindrical	■
JS720120D3R050.0Z6-HXT	10228438	3	D	12,0	12,0	45,0	100,0	0,5	6	Cylindrical	■
JS720120D3R100.0Z6-HXT	10228439	3	D	12,0	12,0	45,0	100,0	1,0	6	Cylindrical	■
JS720120D3R200.0Z6-HXT	10228440	3	D	12,0	12,0	45,0	100,0	2,0	6	Cylindrical	■
JS720160D3R050.0Z6-HXT	10228441	3	D	16,0	16,0	65,0	130,0	0,5	6	Cylindrical	■
JS720160D3R100.0Z6-HXT	10228442	3	D	16,0	16,0	65,0	130,0	1,0	6	Cylindrical	■
JS720160D3R200.0Z6-HXT	10228443	3	D	16,0	16,0	65,0	130,0	2,0	6	Cylindrical	■
JS720160D3R300.0Z6-HXT	03169497	3	D	16,0	16,0	65,0	130,0	3,0	6	Cylindrical	■
JS720200D3R050.0Z6-HXT	03060314	3	D	20,0	20,0	62,0	121,0	0,5	6	Cylindrical	■
JS720200D3R100.0Z6-HXT	03060316	3	D	20,0	20,0	62,0	121,0	1,0	6	Cylindrical	■
JS720200D3R200.0Z6-HXT	03060317	3	D	20,0	20,0	62,0	121,0	2,0	6	Cylindrical	■
JS720200D3R300.0Z6-HXT	03060318	3	D	20,0	20,0	62,0	121,0	3,0	6	Cylindrical	■
JS720200D3R400.0Z6-HXT	03060319	3	D	20,0	20,0	62,0	121,0	4,0	6	Cylindrical	■
JS720200D3R500.0Z6-HXT	03060320	3	D	20,0	20,0	62,0	121,0	5,0	6	Cylindrical	■
JS720200D3R600.0Z6-HXT	03060321	3	D	20,0	20,0	62,0	121,0	6,0	6	Cylindrical	■
JS720250D3R050.0Z6-HXT	03060322	3	D	25,0	25,0	78,0	146,0	0,5	6	Cylindrical	■
JS720250D3R100.0Z6-HXT	03060323	3	D	25,0	25,0	78,0	146,0	1,0	6	Cylindrical	■
JS720250D3R200.0Z6-HXT	03060324	3	D	25,0	25,0	78,0	146,0	2,0	6	Cylindrical	■
JS720250D3R300.0Z6-HXT	03060325	3	D	25,0	25,0	78,0	146,0	3,0	6	Cylindrical	■
JS720250D3R400.0Z6-HXT	03060326	3	D	25,0	25,0	78,0	146,0	4,0	6	Cylindrical	■
JS720250D3R600.0Z6-HXT	03060327	3	D	25,0	25,0	78,0	146,0	6,0	6	Cylindrical	■

■ **Lagerstandard.**

JS720

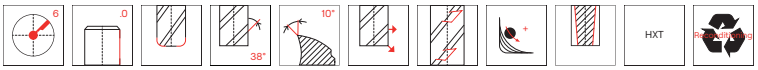
Hochleistungsfräser – Titan – Eckfräser – 6 Schneiden – Zylindrisch – Eckenradius





D

– Toleranzen:
– DMM = h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich



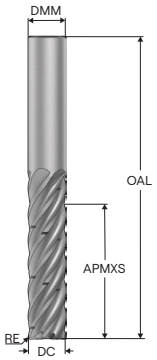
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JS720080D2R050.0Z6C-HXT	10228513	2	D	■	8,0	8,0	23,0	63,0	0,5	6	Cylindrical	■
JS720080D2R100.0Z6C-HXT	10228514	2	D	■	8,0	8,0	23,0	63,0	1,0	6	Cylindrical	■
JS720100D2R050.0Z6C-HXT	03060297	2	D	■	10,0	10,0	26,0	72,0	0,5	6	Cylindrical	■
JS720100D2R100.0Z6C-HXT	10228515	2	D	■	10,0	10,0	26,0	72,0	1,0	6	Cylindrical	■
JS720120D2R050.0Z6C-HXT	03060302	2	D	■	12,0	12,0	30,0	83,0	0,5	6	Cylindrical	■
JS720120D2R100.0Z6C-HXT	03298280	2	D	■	12,0	12,0	30,0	83,0	1,0	6	Cylindrical	■
JS720120D2R200.0Z6C-HXT	03298281	2	D	■	12,0	12,0	30,0	83,0	2,0	6	Cylindrical	■
JS720120D2R250.0Z6C-HXT	03298282	2	D	■	12,0	12,0	30,0	83,0	2,5	6	Cylindrical	■
JS720120D2R300.0Z6C-HXT	03298283	2	D	■	12,0	12,0	30,0	83,0	3,0	6	Cylindrical	■
JS720120D2R310.0Z6C-HXT	03298284	2	D	■	12,0	12,0	30,0	83,0	3,1	6	Cylindrical	■
JS720160D2R050.0Z6C-HXT	03060308	2	D	■	16,0	16,0	44,0	99,0	0,5	6	Cylindrical	■
JS720160D2R100.0Z6C-HXT	03298285	2	D	■	16,0	16,0	44,0	99,0	1,0	6	Cylindrical	■
JS720160D2R200.0Z6C-HXT	03298286	2	D	■	16,0	16,0	44,0	99,0	2,0	6	Cylindrical	■
JS720160D2R250.0Z6C-HXT	03298287	2	D	■	16,0	16,0	44,0	99,0	2,5	6	Cylindrical	■
JS720160D2R300.0Z6C-HXT	03298288	2	D	■	16,0	16,0	44,0	99,0	3,0	6	Cylindrical	■
JS720160D2R400.0Z6C-HXT	03298290	2	D	■	16,0	16,0	44,0	99,0	4,0	6	Cylindrical	■
JS720160D2R600.0Z6C-HXT	03298291	2	D	■	16,0	16,0	44,0	99,0	6,0	6	Cylindrical	■

■ **Lagerstandard.**

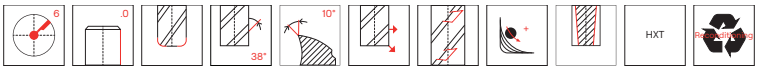
JS720

Hochleistungsfräser – Titan – Eckfräser – 6 Schneiden – Zylindrisch – Eckenradius





D



– Toleranzen:
– DMM = h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich

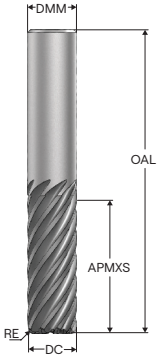
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JS720160D3R050.0Z6C-HXT	10228516	3	D	■	16,0	16,0	65,0	130,0	0,5	6	Cylindrical	■
JS720160D3R100.0Z6C-HXT	10228517	3	D	■	16,0	16,0	65,0	130,0	1,0	6	Cylindrical	■
JS720160D3R200.0Z6C-HXT	10228518	3	D	■	16,0	16,0	65,0	130,0	2,0	6	Cylindrical	■
JS720160D3R300.0Z6C-HXT	10228519	3	D	■	16,0	16,0	65,0	130,0	3,0	6	Cylindrical	■
JS720200D3R050.0Z6C-HXT	03060315	3	D	■	20,0	20,0	62,0	121,0	0,5	6	Cylindrical	■
JS720200D3R100.0Z6C-HXT	03298292	3	D	■	20,0	20,0	62,0	121,0	1,0	6	Cylindrical	■
JS720200D3R300.0Z6C-HXT	03298295	3	D	■	20,0	20,0	62,0	121,0	3,0	6	Cylindrical	■
JS720200D3R400.0Z6C-HXT	03298297	3	D	■	20,0	20,0	62,0	121,0	4,0	6	Cylindrical	■
JS720200D3R500.0Z6C-HXT	03298298	3	D	■	20,0	20,0	62,0	121,0	5,0	6	Cylindrical	■
JS720200D3R600.0Z6C-HXT	03298299	3	D	■	20,0	20,0	62,0	121,0	6,0	6	Cylindrical	■
JS720250D3R050.0Z6C-HXT	03066270	3	D	■	25,0	25,0	78,0	146,0	0,5	6	Cylindrical	■
JS720250D3R400.0Z6C-HXT	03298303	3	D	■	25,0	25,0	78,0	146,0	4,0	6	Cylindrical	■
JS720250D3R600.0Z6C-HXT	03298304	3	D	■	25,0	25,0	78,0	146,0	6,0	6	Cylindrical	■

■ **Lagerstandard.**

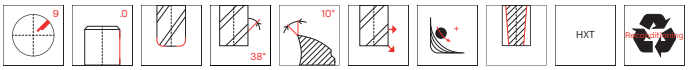
JS720

Hochleistungsfräser – Titan – Eckfräser – 9 Schneiden – Zylindrisch – Eckenradius





D



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

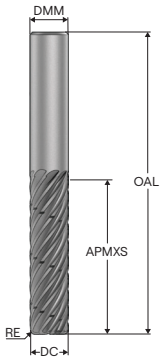
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JS720100D2R050.0Z9-HXT	10067510	2	D	10,0	10,0	26,0	72,0	0,5	9	Cylindrical	■
JS720100D2R100.0Z9-HXT	10067511	2	D	10,0	10,0	26,0	72,0	1,0	9	Cylindrical	■
JS720100D2R200.0Z9-HXT	10067512	2	D	10,0	10,0	26,0	72,0	2,0	9	Cylindrical	■
JS720120D2R050.0Z9-HXT	10067513	2	D	12,0	12,0	30,0	83,0	0,5	9	Cylindrical	■
JS720120D2R100.0Z9-HXT	10067514	2	D	12,0	12,0	30,0	83,0	1,0	9	Cylindrical	■
JS720120D2R200.0Z9-HXT	10067515	2	D	12,0	12,0	30,0	83,0	2,0	9	Cylindrical	■
JS720160D2R100.0Z9-HXT	10008152	2	D	16,0	16,0	44,0	99,0	1,0	9	Cylindrical	■
JS720160D2R200.0Z9-HXT	10008153	2	D	16,0	16,0	44,0	99,0	2,0	9	Cylindrical	■
JS720160D2R300.0Z9-HXT	10008154	2	D	16,0	16,0	44,0	99,0	3,0	9	Cylindrical	■
JS720200D2R100.0Z9-HXT	10228393	2	D	20,0	20,0	45,0	105,0	1,0	9	Cylindrical	■
JS720200D2R200.0Z9-HXT	10228394	2	D	20,0	20,0	45,0	105,0	2,0	9	Cylindrical	■
JS720200D2R300.0Z9-HXT	10228395	2	D	20,0	20,0	45,0	105,0	3,0	9	Cylindrical	■
JS720250D2R100.0Z9-HXT	10008155	2	D	25,0	25,0	50,0	125,0	1,0	9	Cylindrical	■
JS720250D2R200.0Z9-HXT	10008156	2	D	25,0	25,0	50,0	125,0	2,0	9	Cylindrical	■
JS720250D2R300.0Z9-HXT	10008157	2	D	25,0	25,0	50,0	125,0	3,0	9	Cylindrical	■
JS720100D3R050.0Z9-HXT	10067516	3	D	10,0	10,0	40,0	89,0	0,5	9	Cylindrical	■
JS720100D3R100.0Z9-HXT	10067517	3	D	10,0	10,0	40,0	89,0	1,0	9	Cylindrical	■
JS720100D3R200.0Z9-HXT	10067518	3	D	10,0	10,0	40,0	89,0	2,0	9	Cylindrical	■
JS720120D3R050.0Z9-HXT	10067519	3	D	12,0	12,0	45,0	100,0	0,5	9	Cylindrical	■
JS720120D3R100.0Z9-HXT	10067520	3	D	12,0	12,0	45,0	100,0	1,0	9	Cylindrical	■
JS720120D3R200.0Z9-HXT	10067521	3	D	12,0	12,0	45,0	100,0	2,0	9	Cylindrical	■
JS720160D3R100.0Z9-HXT	10008158	3	D	16,0	16,0	65,0	130,0	1,0	9	Cylindrical	■
JS720160D3R200.0Z9-HXT	10008159	3	D	16,0	16,0	65,0	130,0	2,0	9	Cylindrical	■
JS720160D3R300.0Z9-HXT	10008160	3	D	16,0	16,0	65,0	130,0	3,0	9	Cylindrical	■
JS720200D3R100.0Z9-HXT	10008161	3	D	20,0	20,0	62,0	121,0	1,0	9	Cylindrical	■
JS720200D3R200.0Z9-HXT	10008162	3	D	20,0	20,0	62,0	121,0	2,0	9	Cylindrical	■
JS720200D3R300.0Z9-HXT	10008163	3	D	20,0	20,0	62,0	121,0	3,0	9	Cylindrical	■
JS720250D3R100.0Z9-HXT	10008164	3	D	25,0	25,0	78,0	146,0	1,0	9	Cylindrical	■
JS720250D3R300.0Z9-HXT	10008166	3	D	25,0	25,0	78,0	146,0	3,0	9	Cylindrical	■

■ **Lagerstandard.**

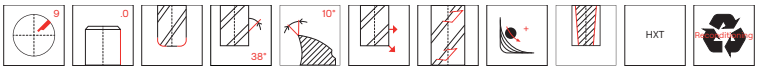
JS720

Hochleistungsfräser – Titan – Eckfräser – 9 Schneiden – Zylindrisch – Eckenradius





D



– Toleranzen:
– DMM = h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich

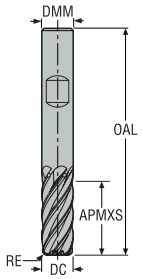
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JS720100D3R050.0Z9C-HXT	10067522	3	D	■	10,0	10,0	40,0	89,0	0,5	9	Cylindrical	■
JS720100D3R100.0Z9C-HXT	10067523	3	D	■	10,0	10,0	40,0	89,0	1,0	9	Cylindrical	■
JS720100D3R200.0Z9C-HXT	10067524	3	D	■	10,0	10,0	40,0	89,0	2,0	9	Cylindrical	■
JS720120D3R050.0Z9C-HXT	10067525	3	D	■	12,0	12,0	45,0	100,0	0,5	9	Cylindrical	■
JS720120D3R100.0Z9C-HXT	10067526	3	D	■	12,0	12,0	45,0	100,0	1,0	9	Cylindrical	■
JS720120D3R200.0Z9C-HXT	10067527	3	D	■	12,0	12,0	45,0	100,0	2,0	9	Cylindrical	■
JS720160D3R100.0Z9C-HXT	10067528	3	D	■	16,0	16,0	65,0	130,0	1,0	9	Cylindrical	■
JS720160D3R200.0Z9C-HXT	10067529	3	D	■	16,0	16,0	65,0	130,0	2,0	9	Cylindrical	■
JS720160D3R300.0Z9C-HXT	10067530	3	D	■	16,0	16,0	65,0	130,0	3,0	9	Cylindrical	■
JS720200D3R100.0Z9C-HXT	10067531	3	D	■	20,0	20,0	62,0	121,0	1,0	9	Cylindrical	■
JS720200D3R200.0Z9C-HXT	10067532	3	D	■	20,0	20,0	62,0	121,0	2,0	9	Cylindrical	■
JS720200D3R300.0Z9C-HXT	10067533	3	D	■	20,0	20,0	62,0	121,0	3,0	9	Cylindrical	■

■ **Lagerstandard.**

JS720

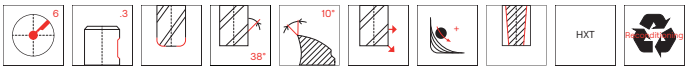
Hochleistungsfräser – Titan – Eckfräser – 6 Schneiden – Weldon – Eckenradius





D

- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich



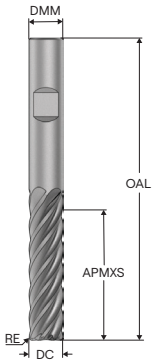
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JS720060D2R050.3Z6-HXT	03060339	2	D	6,0	6,0	17,0	57,0	0,5	6	Weldon	☐
JS720060D2R100.3Z6-HXT	03060340	2	D	6,0	6,0	17,0	57,0	1,0	6	Weldon	☐
JS720080D2R050.3Z6-HXT	03060341	2	D	8,0	8,0	23,0	63,0	0,5	6	Weldon	☐
JS720080D2R100.3Z6-HXT	03061295	2	D	8,0	8,0	23,0	63,0	1,0	6	Weldon	☐
JS720100D2R050.3Z6-HXT	03060342	2	D	10,0	10,0	26,0	72,0	0,5	6	Weldon	☐
JS720100D2R100.3Z6-HXT	03060344	2	D	10,0	10,0	26,0	72,0	1,0	6	Weldon	☐
JS720100D2R200.3Z6-HXT	03060345	2	D	10,0	10,0	26,0	72,0	2,0	6	Weldon	☐
JS720100D2R300.3Z6-HXT	03060346	2	D	10,0	10,0	26,0	72,0	3,0	6	Weldon	☐
JS720120D2R050.3Z6-HXT	03060347	2	D	12,0	12,0	30,0	83,0	0,5	6	Weldon	☐
JS720120D2R100.3Z6-HXT	03060349	2	D	12,0	12,0	30,0	83,0	1,0	6	Weldon	☐
JS720120D2R200.3Z6-HXT	03060350	2	D	12,0	12,0	30,0	83,0	2,0	6	Weldon	☐
JS720120D2R300.3Z6-HXT	03060351	2	D	12,0	12,0	30,0	83,0	3,0	6	Weldon	☐
JS720160D2R050.3Z6-HXT	03060352	2	D	16,0	16,0	44,0	99,0	0,5	6	Weldon	☐
JS720160D2R100.3Z6-HXT	03060354	2	D	16,0	16,0	44,0	99,0	1,0	6	Weldon	☐
JS720160D2R200.3Z6-HXT	03060355	2	D	16,0	16,0	44,0	99,0	2,0	6	Weldon	■
JS720160D2R300.3Z6-HXT	03060356	2	D	16,0	16,0	44,0	99,0	3,0	6	Weldon	■
JS720160D2R400.3Z6-HXT	03060357	2	D	16,0	16,0	44,0	99,0	4,0	6	Weldon	☐
JS720160D2R600.3Z6-HXT	03060358	2	D	16,0	16,0	44,0	99,0	6,0	6	Weldon	☐
JS720200D2R050.3Z6-HXT	10228444	2	D	20,0	20,0	45,0	105,0	0,5	6	Weldon	☐
JS720200D2R100.3Z6-HXT	10228445	2	D	20,0	20,0	45,0	105,0	1,0	6	Weldon	☐
JS720200D2R200.3Z6-HXT	10228446	2	D	20,0	20,0	45,0	105,0	2,0	6	Weldon	☐
JS720200D2R300.3Z6-HXT	10228447	2	D	20,0	20,0	45,0	105,0	3,0	6	Weldon	☐
JS720250D2R050.3Z6-HXT	10228448	2	D	25,0	25,0	50,0	125,0	0,5	6	Weldon	☐
JS720250D2R100.3Z6-HXT	10228449	2	D	25,0	25,0	50,0	125,0	1,0	6	Weldon	☐
JS720250D2R200.3Z6-HXT	10228450	2	D	25,0	25,0	50,0	125,0	2,0	6	Weldon	☐
JS720250D2R300.3Z6-HXT	10228451	2	D	25,0	25,0	50,0	125,0	3,0	6	Weldon	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

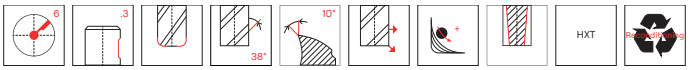
JS720

Hochleistungsfräser – Titan – Eckfräser – 6 Schneiden – Weldon – Eckenradius





D



—Toleranzen:
—DMM = h5
—DC= e7
—RE= ±0,02 mm
—Nachschleifen möglich

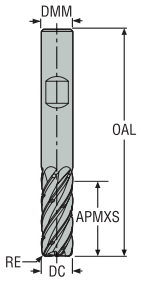
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JS720080D3R050.3Z6-HXT	10228452	3	D	8,0	8,0	32,0	80,0	0,5	6	Weldon	□
JS720080D3R100.3Z6-HXT	10228453	3	D	8,0	8,0	32,0	80,0	1,0	6	Weldon	□
JS720100D3R050.3Z6-HXT	10228454	3	D	10,0	10,0	40,0	89,0	0,5	6	Weldon	□
JS720100D3R100.3Z6-HXT	10228455	3	D	10,0	10,0	40,0	89,0	1,0	6	Weldon	□
JS720100D3R200.3Z6-HXT	10228456	3	D	10,0	10,0	40,0	89,0	2,0	6	Weldon	□
JS720120D3R050.3Z6-HXT	10228457	3	D	12,0	12,0	45,0	100,0	0,5	6	Weldon	□
JS720120D3R100.3Z6-HXT	10228458	3	D	12,0	12,0	45,0	100,0	1,0	6	Weldon	□
JS720120D3R200.3Z6-HXT	10228459	3	D	12,0	12,0	45,0	100,0	2,0	6	Weldon	□
JS720160D3R050.3Z6-HXT	10228460	3	D	16,0	16,0	65,0	130,0	0,5	6	Weldon	□
JS720160D3R100.3Z6-HXT	10228461	3	D	16,0	16,0	65,0	130,0	1,0	6	Weldon	□
JS720160D3R200.3Z6-HXT	10228462	3	D	16,0	16,0	65,0	130,0	2,0	6	Weldon	□
JS720160D3R300.3Z6-HXT	10228463	3	D	16,0	16,0	65,0	130,0	3,0	6	Weldon	□
JS720200D3R050.3Z6-HXT	03060359	3	D	20,0	20,0	62,0	121,0	0,5	6	Weldon	□
JS720200D3R100.3Z6-HXT	03060361	3	D	20,0	20,0	62,0	121,0	1,0	6	Weldon	□
JS720200D3R200.3Z6-HXT	03060362	3	D	20,0	20,0	62,0	121,0	2,0	6	Weldon	□
JS720200D3R300.3Z6-HXT	03060363	3	D	20,0	20,0	62,0	121,0	3,0	6	Weldon	■
JS720200D3R400.3Z6-HXT	03060364	3	D	20,0	20,0	62,0	121,0	4,0	6	Weldon	■
JS720200D3R500.3Z6-HXT	03060365	3	D	20,0	20,0	62,0	121,0	5,0	6	Weldon	□
JS720200D3R600.3Z6-HXT	03060366	3	D	20,0	20,0	62,0	121,0	6,0	6	Weldon	□
JS720250D3R050.3Z6-HXT	03060367	3	D	25,0	25,0	78,0	146,0	0,5	6	Weldon	□
JS720250D3R100.3Z6-HXT	03060368	3	D	25,0	25,0	78,0	146,0	1,0	6	Weldon	□
JS720250D3R200.3Z6-HXT	03060369	3	D	25,0	25,0	78,0	146,0	2,0	6	Weldon	□
JS720250D3R300.3Z6-HXT	03060370	3	D	25,0	25,0	78,0	146,0	3,0	6	Weldon	□
JS720250D3R400.3Z6-HXT	03060371	3	D	25,0	25,0	78,0	146,0	4,0	6	Weldon	■
JS720250D3R600.3Z6-HXT	03060372	3	D	25,0	25,0	78,0	146,0	6,0	6	Weldon	□

□ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS720

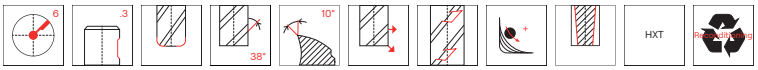
Hochleistungsfräser – Titan – Eckfräser – 6 Schneiden – Weldon – Eckenradius





D

– Toleranzen:
– DMM = h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich



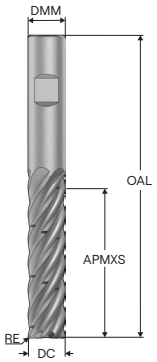
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JS720080D2R050.3Z6C-HXT	10228520	2	D	■	8,0	8,0	23,0	63,0	0,5	6	Weldon	□
JS720080D2R100.3Z6C-HXT	10228521	2	D	■	8,0	8,0	23,0	63,0	1,0	6	Weldon	□
JS720100D2R050.3Z6C-HXT	03060343	2	D	■	10,0	10,0	26,0	72,0	0,5	6	Weldon	□
JS720100D2R100.3Z6C-HXT	10228522	2	D	■	10,0	10,0	26,0	72,0	1,0	6	Weldon	□
JS720120D2R050.3Z6C-HXT	03060348	2	D	■	12,0	12,0	30,0	83,0	0,5	6	Weldon	□
JS720120D2R100.3Z6C-HXT	03298308	2	D	■	12,0	12,0	30,0	83,0	1,0	6	Weldon	□
JS720120D2R200.3Z6C-HXT	03298309	2	D	■	12,0	12,0	30,0	83,0	2,0	6	Weldon	□
JS720120D2R250.3Z6C-HXT	03298310	2	D	■	12,0	12,0	30,0	83,0	2,5	6	Weldon	□
JS720120D2R300.3Z6C-HXT	03298311	2	D	■	12,0	12,0	30,0	83,0	3,0	6	Weldon	□
JS720120D2R310.3Z6C-HXT	03298312	2	D	■	12,0	12,0	30,0	83,0	3,1	6	Weldon	□
JS720160D2R050.3Z6C-HXT	03060353	2	D	■	16,0	16,0	44,0	99,0	0,5	6	Weldon	■
JS720160D2R100.3Z6C-HXT	03298313	2	D	■	16,0	16,0	44,0	99,0	1,0	6	Weldon	■
JS720160D2R200.3Z6C-HXT	03298314	2	D	■	16,0	16,0	44,0	99,0	2,0	6	Weldon	■
JS720160D2R250.3Z6C-HXT	03298315	2	D	■	16,0	16,0	44,0	99,0	2,5	6	Weldon	■
JS720160D2R300.3Z6C-HXT	03298316	2	D	■	16,0	16,0	44,0	99,0	3,0	6	Weldon	■
JS720160D2R400.3Z6C-HXT	03298318	2	D	■	16,0	16,0	44,0	99,0	4,0	6	Weldon	■
JS720160D2R600.3Z6C-HXT	03298319	2	D	■	16,0	16,0	44,0	99,0	6,0	6	Weldon	■

□ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

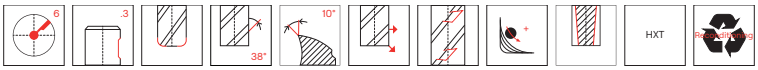
JS720

Hochleistungsfräser – Titan – Eckfräser – 6 Schneiden – Weldon – Eckenradius





D



– Toleranzen:
– DMM = h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich

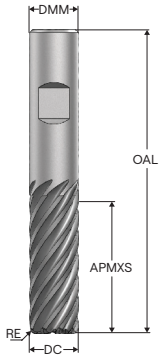
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JS720160D3R050.3Z6C-HXT	10228523	3	D	■	16,0	16,0	65,0	130,0	0,5	6	Weldon	□
JS720160D3R100.3Z6C-HXT	10228524	3	D	■	16,0	16,0	65,0	130,0	1,0	6	Weldon	□
JS720160D3R200.3Z6C-HXT	10228525	3	D	■	16,0	16,0	65,0	130,0	2,0	6	Weldon	□
JS720160D3R300.3Z6C-HXT	10228526	3	D	■	16,0	16,0	65,0	130,0	3,0	6	Weldon	□
JS720200D3R050.3Z6C-HXT	03060360	3	D	■	20,0	20,0	62,0	121,0	0,5	6	Weldon	■
JS720200D3R100.3Z6C-HXT	03298320	3	D	■	20,0	20,0	62,0	121,0	1,0	6	Weldon	■
JS720200D3R200.3Z6C-HXT	03298321	3	D	■	20,0	20,0	62,0	121,0	2,0	6	Weldon	■
JS720200D3R250.3Z6C-HXT	03298322	3	D	■	20,0	20,0	62,0	121,0	2,5	6	Weldon	■
JS720200D3R300.3Z6C-HXT	03298323	3	D	■	20,0	20,0	62,0	121,0	3,0	6	Weldon	■
JS720200D3R400.3Z6C-HXT	03298325	3	D	■	20,0	20,0	62,0	121,0	4,0	6	Weldon	■
JS720200D3R500.3Z6C-HXT	03298326	3	D	■	20,0	20,0	62,0	121,0	5,0	6	Weldon	■
JS720200D3R600.3Z6C-HXT	03298327	3	D	■	20,0	20,0	62,0	121,0	6,0	6	Weldon	■
JS720250D3R050.3Z6C-HXT	03066460	3	D	■	25,0	25,0	78,0	146,0	0,5	6	Weldon	■
JS720250D3R100.3Z6C-HXT	03298328	3	D	■	25,0	25,0	78,0	146,0	1,0	6	Weldon	■
JS720250D3R300.3Z6C-HXT	03298330	3	D	■	25,0	25,0	78,0	146,0	3,0	6	Weldon	■
JS720250D3R400.3Z6C-HXT	03298331	3	D	■	25,0	25,0	78,0	146,0	4,0	6	Weldon	■
JS720250D3R600.3Z6C-HXT	03298332	3	D	■	25,0	25,0	78,0	146,0	6,0	6	Weldon	■

□ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

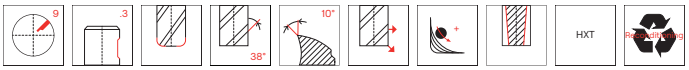
JS720

Hochleistungsfräser – Titan – Eckfräser – 9 Schneiden – Weldon – Eckenradius





D



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

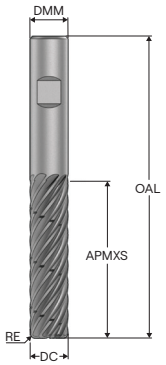
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JS720100D2R050.3Z9-HXT	10067881	2	D	10,0	10,0	26,0	72,0	0,5	9	Weldon	☐
JS720100D2R100.3Z9-HXT	10067882	2	D	10,0	10,0	26,0	72,0	1,0	9	Weldon	☐
JS720100D2R200.3Z9-HXT	10067883	2	D	10,0	10,0	26,0	72,0	2,0	9	Weldon	☐
JS720120D2R050.3Z9-HXT	10067884	2	D	12,0	12,0	30,0	83,0	0,5	9	Weldon	☐
JS720120D2R100.3Z9-HXT	10067885	2	D	12,0	12,0	30,0	83,0	1,0	9	Weldon	☐
JS720120D2R200.3Z9-HXT	10067886	2	D	12,0	12,0	30,0	83,0	2,0	9	Weldon	☐
JS720160D2R100.3Z9-HXT	10008279	2	D	16,0	16,0	44,0	99,0	1,0	9	Weldon	☐
JS720160D2R200.3Z9-HXT	10008280	2	D	16,0	16,0	44,0	99,0	2,0	9	Weldon	☐
JS720160D2R300.3Z9-HXT	10008281	2	D	16,0	16,0	44,0	99,0	3,0	9	Weldon	☐
JS720200D2R100.3Z9-HXT	10228396	2	D	20,0	20,0	45,0	105,0	1,0	9	Weldon	☐
JS720200D2R200.3Z9-HXT	10228397	2	D	20,0	20,0	45,0	105,0	2,0	9	Weldon	☐
JS720200D2R300.3Z9-HXT	10228398	2	D	20,0	20,0	45,0	105,0	3,0	9	Weldon	☐
JS720250D2R100.3Z9-HXT	10008282	2	D	25,0	25,0	50,0	125,0	1,0	9	Weldon	☐
JS720250D2R200.3Z9-HXT	10008283	2	D	25,0	25,0	50,0	125,0	2,0	9	Weldon	☐
JS720250D2R300.3Z9-HXT	10008284	2	D	25,0	25,0	50,0	125,0	3,0	9	Weldon	☐
JS720100D3R050.3Z9-HXT	10067887	3	D	10,0	10,0	40,0	89,0	0,5	9	Weldon	☐
JS720100D3R100.3Z9-HXT	10067888	3	D	10,0	10,0	40,0	89,0	1,0	9	Weldon	☐
JS720100D3R200.3Z9-HXT	10067889	3	D	10,0	10,0	40,0	89,0	2,0	9	Weldon	☐
JS720120D3R050.3Z9-HXT	10067890	3	D	12,0	12,0	45,0	100,0	0,5	9	Weldon	☐
JS720120D3R100.3Z9-HXT	10067891	3	D	12,0	12,0	45,0	100,0	1,0	9	Weldon	☐
JS720120D3R200.3Z9-HXT	10067892	3	D	12,0	12,0	45,0	100,0	2,0	9	Weldon	☐
JS720160D3R100.3Z9-HXT	10008285	3	D	16,0	16,0	65,0	130,0	1,0	9	Weldon	☐
JS720160D3R200.3Z9-HXT	10008286	3	D	16,0	16,0	65,0	130,0	2,0	9	Weldon	☐
JS720160D3R300.3Z9-HXT	10008287	3	D	16,0	16,0	65,0	130,0	3,0	9	Weldon	☐
JS720200D3R100.3Z9-HXT	10008288	3	D	20,0	20,0	62,0	121,0	1,0	9	Weldon	☐
JS720200D3R200.3Z9-HXT	10008289	3	D	20,0	20,0	62,0	121,0	2,0	9	Weldon	☐
JS720200D3R300.3Z9-HXT	10008290	3	D	20,0	20,0	62,0	121,0	3,0	9	Weldon	☐
JS720250D3R100.3Z9-HXT	10008292	3	D	25,0	25,0	78,0	146,0	1,0	9	Weldon	☐
JS720250D3R200.3Z9-HXT	10008293	3	D	25,0	25,0	78,0	146,0	2,0	9	Weldon	☐
JS720250D3R300.3Z9-HXT	10008294	3	D	25,0	25,0	78,0	146,0	3,0	9	Weldon	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS720

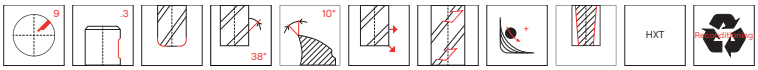
Hochleistungsfräser – Titan – Eckfräser – 9 Schneiden – Weldon – Eckenradius





D

– Toleranzen:
– DMM = h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich



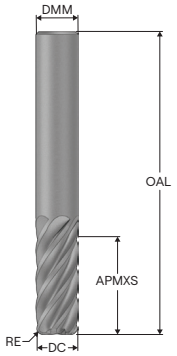
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JS720100D3R050.3Z9C-HXT	10067893	3	D	■	10,0	10,0	40,0	89,0	0,5	9	Weldon	□
JS720100D3R100.3Z9C-HXT	10067894	3	D	■	10,0	10,0	40,0	89,0	1,0	9	Weldon	□
JS720100D3R200.3Z9C-HXT	10067895	3	D	■	10,0	10,0	40,0	89,0	2,0	9	Weldon	□
JS720120D3R050.3Z9C-HXT	10067897	3	D	■	12,0	12,0	45,0	100,0	0,5	9	Weldon	□
JS720120D3R100.3Z9C-HXT	10067898	3	D	■	12,0	12,0	45,0	100,0	1,0	9	Weldon	□
JS720120D3R200.3Z9C-HXT	10067899	3	D	■	12,0	12,0	45,0	100,0	2,0	9	Weldon	□
JS720160D3R100.3Z9C-HXT	10067900	3	D	■	16,0	16,0	65,0	130,0	1,0	9	Weldon	□
JS720160D3R200.3Z9C-HXT	10067901	3	D	■	16,0	16,0	65,0	130,0	2,0	9	Weldon	□
JS720160D3R300.3Z9C-HXT	10067902	3	D	■	16,0	16,0	65,0	130,0	3,0	9	Weldon	□
JS720200D3R100.3Z9C-HXT	10067903	3	D	■	20,0	20,0	62,0	121,0	1,0	9	Weldon	□
JS720200D3R200.3Z9C-HXT	10067904	3	D	■	20,0	20,0	62,0	121,0	2,0	9	Weldon	□
JS720200D3R300.3Z9C-HXT	10067905	3	D	■	20,0	20,0	62,0	121,0	3,0	9	Weldon	□
JS720250D3R100.3Z9C-HXT	10067906	3	D	■	25,0	25,0	78,0	146,0	1,0	9	Weldon	□
JS720250D3R200.3Z9C-HXT	10067907	3	D	■	25,0	25,0	78,0	146,0	2,0	9	Weldon	□
JS720250D3R300.3Z9C-HXT	10067908	3	D	■	25,0	25,0	78,0	146,0	3,0	9	Weldon	□

□ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

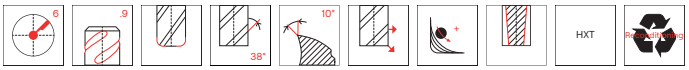
JS720

Hochleistungsfräser – Titan – Eckfräser – 6 Schneiden – Safe-Lock – Eckenradius





D



– Toleranzen:
– DMM = h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich

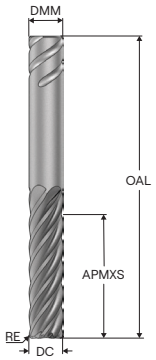
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JS720060D2R050.9Z6-HXT	03060374	2	D	6,0	6,0	17,0	57,0	0,5	6	Safe-lock	☐
JS720060D2R100.9Z6-HXT	03060375	2	D	6,0	6,0	17,0	57,0	1,0	6	Safe-lock	☐
JS720080D2R050.9Z6-HXT	03060376	2	D	8,0	8,0	23,0	63,0	0,5	6	Safe-lock	☐
JS720080D2R100.9Z6-HXT	03061296	2	D	8,0	8,0	23,0	63,0	1,0	6	Safe-lock	☐
JS720100D2R050.9Z6-HXT	03060377	2	D	10,0	10,0	26,0	72,0	0,5	6	Safe-lock	☐
JS720100D2R100.9Z6-HXT	03060379	2	D	10,0	10,0	26,0	72,0	1,0	6	Safe-lock	☐
JS720100D2R200.9Z6-HXT	03060380	2	D	10,0	10,0	26,0	72,0	2,0	6	Safe-lock	☐
JS720100D2R300.9Z6-HXT	03060381	2	D	10,0	10,0	26,0	72,0	3,0	6	Safe-lock	☐
JS720120D2R050.9Z6-HXT	03060382	2	D	12,0	12,0	30,0	83,0	0,5	6	Safe-lock	☐
JS720120D2R100.9Z6-HXT	03060384	2	D	12,0	12,0	30,0	83,0	1,0	6	Safe-lock	☐
JS720120D2R200.9Z6-HXT	03060385	2	D	12,0	12,0	30,0	83,0	2,0	6	Safe-lock	☐
JS720120D2R300.9Z6-HXT	03060386	2	D	12,0	12,0	30,0	83,0	3,0	6	Safe-lock	☐
JS720160D2R050.9Z6-HXT	03060387	2	D	16,0	16,0	44,0	99,0	0,5	6	Safe-lock	☐
JS720160D2R100.9Z6-HXT	03060389	2	D	16,0	16,0	44,0	99,0	1,0	6	Safe-lock	☐
JS720160D2R200.9Z6-HXT	03060390	2	D	16,0	16,0	44,0	99,0	2,0	6	Safe-lock	☐
JS720160D2R300.9Z6-HXT	03060391	2	D	16,0	16,0	44,0	99,0	3,0	6	Safe-lock	☐
JS720160D2R400.9Z6-HXT	03060392	2	D	16,0	16,0	44,0	99,0	4,0	6	Safe-lock	☐
JS720160D2R600.9Z6-HXT	03060393	2	D	16,0	16,0	44,0	99,0	6,0	6	Safe-lock	☐
JS720200D2R050.9Z6-HXT	10228464	2	D	20,0	20,0	45,0	105,0	0,5	6	Safe-lock	☐
JS720200D2R100.9Z6-HXT	10228465	2	D	20,0	20,0	45,0	105,0	1,0	6	Safe-lock	☐
JS720200D2R200.9Z6-HXT	10228467	2	D	20,0	20,0	45,0	105,0	2,0	6	Safe-lock	☐
JS720200D2R300.9Z6-HXT	10228468	2	D	20,0	20,0	45,0	105,0	3,0	6	Safe-lock	☐
JS720250D2R050.9Z6-HXT	10228469	2	D	25,0	25,0	50,0	125,0	0,5	6	Safe-lock	☐
JS720250D2R100.9Z6-HXT	10228470	2	D	25,0	25,0	50,0	125,0	1,0	6	Safe-lock	☐
JS720250D2R200.9Z6-HXT	10228471	2	D	25,0	25,0	50,0	125,0	2,0	6	Safe-lock	☐
JS720250D2R300.9Z6-HXT	10228472	2	D	25,0	25,0	50,0	125,0	3,0	6	Safe-lock	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

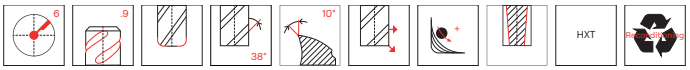
JS720

Hochleistungsfräser – Titan – Eckfräser – 6 Schneiden – Safe-Lock – Eckenradius





D



—Toleranzen:
—DMM = h5
—DC= e7
—RE= ±0,02 mm
—Nachschleifen möglich

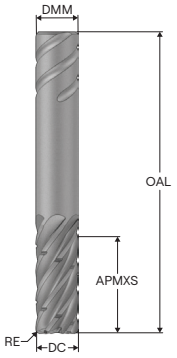
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JS720080D3R050.9Z6-HXT	10228473	3	D	8,0	8,0	32,0	80,0	0,5	6	Safe-lock	☐
JS720080D3R100.9Z6-HXT	10228474	3	D	8,0	8,0	32,0	80,0	1,0	6	Safe-lock	☐
JS720100D3R050.9Z6-HXT	10228475	3	D	10,0	10,0	40,0	89,0	0,5	6	Safe-lock	☐
JS720100D3R100.9Z6-HXT	10228476	3	D	10,0	10,0	40,0	89,0	1,0	6	Safe-lock	☐
JS720100D3R200.9Z6-HXT	10228477	3	D	10,0	10,0	40,0	89,0	2,0	6	Safe-lock	☐
JS720120D3R050.9Z6-HXT	10228478	3	D	12,0	12,0	45,0	100,0	0,5	6	Safe-lock	☐
JS720120D3R100.9Z6-HXT	10228479	3	D	12,0	12,0	45,0	100,0	1,0	6	Safe-lock	☐
JS720120D3R200.9Z6-HXT	10228480	3	D	12,0	12,0	45,0	100,0	2,0	6	Safe-lock	☐
JS720160D3R050.9Z6-HXT	10228481	3	D	16,0	16,0	65,0	130,0	0,5	6	Safe-lock	☐
JS720160D3R100.9Z6-HXT	10228482	3	D	16,0	16,0	65,0	130,0	1,0	6	Safe-lock	☐
JS720160D3R200.9Z6-HXT	10228483	3	D	16,0	16,0	65,0	130,0	2,0	6	Safe-lock	☐
JS720160D3R300.9Z6-HXT	10228484	3	D	16,0	16,0	65,0	130,0	3,0	6	Safe-lock	☐
JS720200D3R050.9Z6-HXT	03060394	3	D	20,0	20,0	62,0	121,0	0,5	6	Safe-lock	☐
JS720200D3R100.9Z6-HXT	03060396	3	D	20,0	20,0	62,0	121,0	1,0	6	Safe-lock	☐
JS720200D3R200.9Z6-HXT	03060397	3	D	20,0	20,0	62,0	121,0	2,0	6	Safe-lock	☐
JS720200D3R300.9Z6-HXT	03060398	3	D	20,0	20,0	62,0	121,0	3,0	6	Safe-lock	☐
JS720200D3R400.9Z6-HXT	03060399	3	D	20,0	20,0	62,0	121,0	4,0	6	Safe-lock	☐
JS720200D3R500.9Z6-HXT	03060400	3	D	20,0	20,0	62,0	121,0	5,0	6	Safe-lock	☐
JS720200D3R600.9Z6-HXT	03060401	3	D	20,0	20,0	62,0	121,0	6,0	6	Safe-lock	☐
JS720250D3R050.9Z6-HXT	03060402	3	D	25,0	25,0	78,0	146,0	0,5	6	Safe-lock	☐
JS720250D3R100.9Z6-HXT	03060403	3	D	25,0	25,0	78,0	146,0	1,0	6	Safe-lock	☐
JS720250D3R200.9Z6-HXT	03060404	3	D	25,0	25,0	78,0	146,0	2,0	6	Safe-lock	☐
JS720250D3R300.9Z6-HXT	03060405	3	D	25,0	25,0	78,0	146,0	3,0	6	Safe-lock	☐
JS720250D3R400.9Z6-HXT	03060406	3	D	25,0	25,0	78,0	146,0	4,0	6	Safe-lock	☐
JS720250D3R600.9Z6-HXT	03060407	3	D	25,0	25,0	78,0	146,0	6,0	6	Safe-lock	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

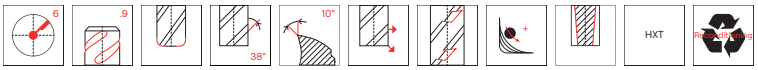
JS720

Hochleistungsfräser – Titan – Eckfräser – 6 Schneiden – Safe-Lock – Eckenradius





D



– Toleranzen:
– DMM = h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich

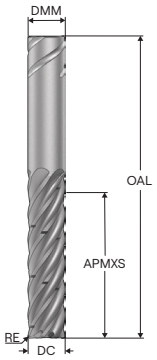
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JS720080D2R050.9Z6C-HXT	10228527	2	D	■	8,0	8,0	23,0	63,0	0,5	6	Safe-lock	□
JS720080D2R100.9Z6C-HXT	10228528	2	D	■	8,0	8,0	23,0	63,0	1,0	6	Safe-lock	□
JS720100D2R050.9Z6C-HXT	03060378	2	D	■	10,0	10,0	26,0	72,0	0,5	6	Safe-lock	□
JS720100D2R100.9Z6C-HXT	10228529	2	D	■	10,0	10,0	26,0	72,0	1,0	6	Safe-lock	□
JS720120D2R050.9Z6C-HXT	03060383	2	D	■	12,0	12,0	30,0	83,0	0,5	6	Safe-lock	□
JS720120D2R100.9Z6C-HXT	03298334	2	D	■	12,0	12,0	30,0	83,0	1,0	6	Safe-lock	□
JS720120D2R200.9Z6C-HXT	03298335	2	D	■	12,0	12,0	30,0	83,0	2,0	6	Safe-lock	□
JS720120D2R250.9Z6C-HXT	03298336	2	D	■	12,0	12,0	30,0	83,0	2,5	6	Safe-lock	□
JS720120D2R300.9Z6C-HXT	03298337	2	D	■	12,0	12,0	30,0	83,0	3,0	6	Safe-lock	□
JS720120D2R310.9Z6C-HXT	03298338	2	D	■	12,0	12,0	30,0	83,0	3,1	6	Safe-lock	□
JS720160D2R050.9Z6C-HXT	03060388	2	D	■	16,0	16,0	44,0	99,0	0,5	6	Safe-lock	■
JS720160D2R100.9Z6C-HXT	03298339	2	D	■	16,0	16,0	44,0	99,0	1,0	6	Safe-lock	□
JS720160D2R200.9Z6C-HXT	03298340	2	D	■	16,0	16,0	44,0	99,0	2,0	6	Safe-lock	□
JS720160D2R250.9Z6C-HXT	03298341	2	D	■	16,0	16,0	44,0	99,0	2,5	6	Safe-lock	□
JS720160D2R300.9Z6C-HXT	03298342	2	D	■	16,0	16,0	44,0	99,0	3,0	6	Safe-lock	□
JS720160D2R310.9Z6C-HXT	03298343	2	D	■	16,0	16,0	44,0	99,0	3,1	6	Safe-lock	□
JS720160D2R400.9Z6C-HXT	03298344	2	D	■	16,0	16,0	44,0	99,0	4,0	6	Safe-lock	□
JS720160D2R600.9Z6C-HXT	03298345	2	D	■	16,0	16,0	44,0	99,0	6,0	6	Safe-lock	□

□ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage. ■ **Lagerstandard.**

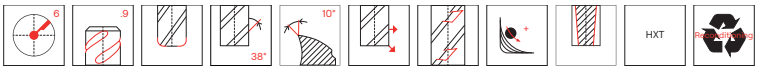
JS720

Hochleistungsfräser – Titan – Eckfräser – 6 Schneiden – Safe-Lock – Eckenradius





D



– Toleranzen:
– DMM = h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich

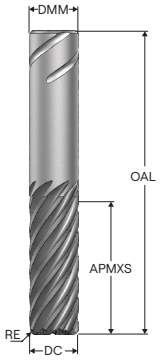
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JS720160D3R050.9Z6C-HXT	10228530	3	D	■	16,0	16,0	65,0	130,0	0,5	6	Safe-lock	□
JS720160D3R100.9Z6C-HXT	10228531	3	D	■	16,0	16,0	65,0	130,0	1,0	6	Safe-lock	□
JS720160D3R200.9Z6C-HXT	10228532	3	D	■	16,0	16,0	65,0	130,0	2,0	6	Safe-lock	□
JS720160D3R300.9Z6C-HXT	10228533	3	D	■	16,0	16,0	65,0	130,0	3,0	6	Safe-lock	□
JS720200D3R050.9Z6C-HXT	03060395	3	D	■	20,0	20,0	62,0	121,0	0,5	6	Safe-lock	□
JS720200D3R100.9Z6C-HXT	03298346	3	D	■	20,0	20,0	62,0	121,0	1,0	6	Safe-lock	□
JS720200D3R200.9Z6C-HXT	03298347	3	D	■	20,0	20,0	62,0	121,0	2,0	6	Safe-lock	□
JS720200D3R250.9Z6C-HXT	03298348	3	D	■	20,0	20,0	62,0	121,0	2,5	6	Safe-lock	□
JS720200D3R300.9Z6C-HXT	03298349	3	D	■	20,0	20,0	62,0	121,0	3,0	6	Safe-lock	□
JS720200D3R310.9Z6C-HXT	03298350	3	D	■	20,0	20,0	62,0	121,0	3,1	6	Safe-lock	□
JS720200D3R400.9Z6C-HXT	03298351	3	D	■	20,0	20,0	62,0	121,0	4,0	6	Safe-lock	□
JS720200D3R500.9Z6C-HXT	03298352	3	D	■	20,0	20,0	62,0	121,0	5,0	6	Safe-lock	□
JS720200D3R600.9Z6C-HXT	03298353	3	D	■	20,0	20,0	62,0	121,0	6,0	6	Safe-lock	□
JS720250D3R050.9Z6C-HXT	03066461	3	D	■	25,0	25,0	78,0	146,0	0,5	6	Safe-lock	□
JS720250D3R100.9Z6C-HXT	03298354	3	D	■	25,0	25,0	78,0	146,0	1,0	6	Safe-lock	□
JS720250D3R200.9Z6C-HXT	03298355	3	D	■	25,0	25,0	78,0	146,0	2,0	6	Safe-lock	□
JS720250D3R300.9Z6C-HXT	03298356	3	D	■	25,0	25,0	78,0	146,0	3,0	6	Safe-lock	□
JS720250D3R400.9Z6C-HXT	03298357	3	D	■	25,0	25,0	78,0	146,0	4,0	6	Safe-lock	□
JS720250D3R600.9Z6C-HXT	03298358	3	D	■	25,0	25,0	78,0	146,0	6,0	6	Safe-lock	□

□ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

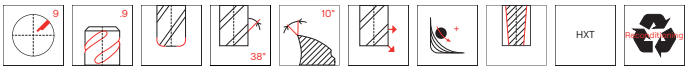
JS720

Hochleistungsfräser – Titan – Eckfräser – 9 Schneiden – Safe-Lock – Eckenradius





D



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

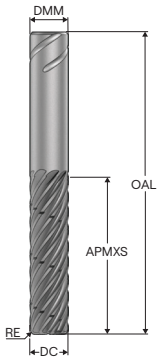
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JS720100D2R050.9Z9-HXT	10067909	2	D	10,0	10,0	26,0	72,0	0,5	9	Safe-lock	☐
JS720100D2R100.9Z9-HXT	10067910	2	D	10,0	10,0	26,0	72,0	1,0	9	Safe-lock	☐
JS720100D2R200.9Z9-HXT	10067911	2	D	10,0	10,0	26,0	72,0	2,0	9	Safe-lock	☐
JS720120D2R050.9Z9-HXT	10067912	2	D	12,0	12,0	30,0	83,0	0,5	9	Safe-lock	☐
JS720120D2R100.9Z9-HXT	10067913	2	D	12,0	12,0	30,0	83,0	1,0	9	Safe-lock	☐
JS720120D2R200.9Z9-HXT	10067914	2	D	12,0	12,0	30,0	83,0	2,0	9	Safe-lock	☐
JS720160D2R100.9Z9-HXT	10008295	2	D	16,0	16,0	44,0	99,0	1,0	9	Safe-lock	☐
JS720160D2R200.9Z9-HXT	10008296	2	D	16,0	16,0	44,0	99,0	2,0	9	Safe-lock	☐
JS720160D2R300.9Z9-HXT	10008297	2	D	16,0	16,0	44,0	99,0	3,0	9	Safe-lock	☐
JS720200D2R100.9Z9-HXT	10228399	2	D	20,0	20,0	45,0	105,0	1,0	9	Safe-lock	☐
JS720200D2R200.9Z9-HXT	10228400	2	D	20,0	20,0	45,0	105,0	2,0	9	Safe-lock	☐
JS720200D2R300.9Z9-HXT	10228401	2	D	20,0	20,0	45,0	105,0	3,0	9	Safe-lock	☐
JS720250D2R100.9Z9-HXT	10008298	2	D	25,0	25,0	50,0	125,0	1,0	9	Safe-lock	☐
JS720250D2R200.9Z9-HXT	10008299	2	D	25,0	25,0	50,0	125,0	2,0	9	Safe-lock	☐
JS720250D2R300.9Z9-HXT	10008300	2	D	25,0	25,0	50,0	125,0	3,0	9	Safe-lock	☐
JS720100D3R050.9Z9-HXT	10067915	3	D	10,0	10,0	40,0	89,0	0,5	9	Safe-lock	☐
JS720100D3R100.9Z9-HXT	10067916	3	D	10,0	10,0	40,0	89,0	1,0	9	Safe-lock	☐
JS720100D3R200.9Z9-HXT	10067917	3	D	10,0	10,0	40,0	89,0	2,0	9	Safe-lock	☐
JS720120D3R050.9Z9-HXT	10067918	3	D	12,0	12,0	45,0	100,0	0,5	9	Safe-lock	☐
JS720120D3R100.9Z9-HXT	10067919	3	D	12,0	12,0	45,0	100,0	1,0	9	Safe-lock	☐
JS720120D3R200.9Z9-HXT	10067921	3	D	12,0	12,0	45,0	100,0	2,0	9	Safe-lock	☐
JS720160D3R100.9Z9-HXT	10008301	3	D	16,0	16,0	65,0	130,0	1,0	9	Safe-lock	☐
JS720160D3R200.9Z9-HXT	10008302	3	D	16,0	16,0	65,0	130,0	2,0	9	Safe-lock	☐
JS720160D3R300.9Z9-HXT	10008303	3	D	16,0	16,0	65,0	130,0	3,0	9	Safe-lock	☐
JS720200D3R100.9Z9-HXT	10008304	3	D	20,0	20,0	62,0	121,0	1,0	9	Safe-lock	☐
JS720200D3R200.9Z9-HXT	10008305	3	D	20,0	20,0	62,0	121,0	2,0	9	Safe-lock	☐
JS720200D3R300.9Z9-HXT	10008306	3	D	20,0	20,0	62,0	121,0	3,0	9	Safe-lock	☐
JS720250D3R100.9Z9-HXT	10008307	3	D	25,0	25,0	78,0	146,0	1,0	9	Safe-lock	☐
JS720250D3R200.9Z9-HXT	10008308	3	D	25,0	25,0	78,0	146,0	2,0	9	Safe-lock	☐
JS720250D3R300.9Z9-HXT	10008309	3	D	25,0	25,0	78,0	146,0	3,0	9	Safe-lock	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

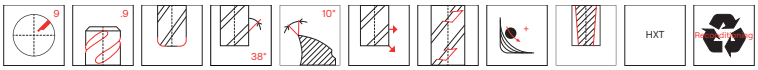
JS720

Hochleistungsfräser – Titan – Eckfräser – 9 Schneiden – Safe-Lock – Eckenradius





—Toleranzen:
—DMM = h5
—DC= e7
—RE= ±0,02 mm
—Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JS720100D3R050.9Z9C-HXT	10067922	3	D	■	10,0	10,0	40,0	89,0	0,5	9	Safe-lock	□
JS720100D3R100.9Z9C-HXT	10067923	3	D	■	10,0	10,0	40,0	89,0	1,0	9	Safe-lock	□
JS720100D3R200.9Z9C-HXT	10067924	3	D	■	10,0	10,0	40,0	89,0	2,0	9	Safe-lock	□
JS720120D3R050.9Z9C-HXT	10067925	3	D	■	12,0	12,0	45,0	100,0	0,5	9	Safe-lock	□
JS720120D3R100.9Z9C-HXT	10067926	3	D	■	12,0	12,0	45,0	100,0	1,0	9	Safe-lock	□
JS720120D3R200.9Z9C-HXT	10067927	3	D	■	12,0	12,0	45,0	100,0	2,0	9	Safe-lock	□
JS720160D3R100.9Z9C-HXT	10067928	3	D	■	16,0	16,0	65,0	130,0	1,0	9	Safe-lock	□
JS720160D3R200.9Z9C-HXT	10067929	3	D	■	16,0	16,0	65,0	130,0	2,0	9	Safe-lock	□
JS720160D3R300.9Z9C-HXT	10067930	3	D	■	16,0	16,0	65,0	130,0	3,0	9	Safe-lock	□
JS720200D3R100.9Z9C-HXT	10067931	3	D	■	20,0	20,0	62,0	121,0	1,0	9	Safe-lock	□
JS720200D3R200.9Z9C-HXT	10067932	3	D	■	20,0	20,0	62,0	121,0	2,0	9	Safe-lock	□
JS720200D3R300.9Z9C-HXT	10067933	3	D	■	20,0	20,0	62,0	121,0	3,0	9	Safe-lock	□
JS720250D3R100.9Z9C-HXT	10067934	3	D	■	25,0	25,0	78,0	146,0	1,0	9	Safe-lock	□
JS720250D3R200.9Z9C-HXT	10067935	3	D	■	25,0	25,0	78,0	146,0	2,0	9	Safe-lock	□
JS720250D3R300.9Z9C-HXT	10067936	3	D	■	25,0	25,0	78,0	146,0	3,0	9	Safe-lock	□

□ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

Schnittdaten – JS720 Eckfräsen PCEDC =6

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
M1	E	0.400 *0,400*	1.1 *1,1*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	110 (85 — 140) *360 (280 — 450)*
M2	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	90 (70 — 110) *295 (230 — 360)*
M3	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	70 (55 — 99) *230 (190 — 320)*
M4	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (60 — 99) *260 (200 — 320)*
M5	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	65 (50 — 83) *215 (170 — 270)*
S1	E	0.0500 *0,0500*	2.6 *2,6*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	43 (29 — 71) *140 (96 — 230)*
S2	E	0.0500 *0,0500*	2.6 *2,6*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.14 *0,0055*	34 (23 — 57) *110 (76 — 180)*
S3	E	0.0500 *0,0500*	2.6 *2,6*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	30 (20 — 49) *100 (66 — 160)*
S11	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	105 (78 — 120) *345 (260 — 390)*
S12	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (60 — 99) *260 (200 — 320)*
S13	E	0.400 *0,400*	1.1 *1,1*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	80 (60 — 99) *260 (200 — 320)*

Schnittdaten – JS720 Eckfräsen dynamisches Fräsen a_e/DC=0,07 PCEDC =6

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	1.9 *1,9*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	140 (110 — 180) *460 (370 — 590)*
M2	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	115 (91 — 150) *375 (300 — 490)*
M3	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	90 (72 — 120) *295 (240 — 390)*
M4	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (78 — 120) *345 (260 — 390)*
M5	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	85 (65 — 100) *280 (220 — 320)*
S1	E	2.6 *2,6*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	41 (28 — 68) *135 (92 — 220)*
S2	E	2.6 *2,6*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	33 (22 — 54) *110 (73 — 170)*
S3	E	2.6 *2,6*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	29 (20 — 47) *95 (66 — 150)*
S11	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	135 (110 — 160) *445 (370 — 520)*
S12	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (78 — 120) *345 (260 — 390)*
S13	E	1.9 *1,9*	0.060 *0,0024*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (78 — 120) *345 (260 — 390)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JS720 Eckfräsen dynamisches Fräsen a_e/DC=0,07 PCEDC =9

SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
M1	E	2.0 *2,0*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	0.20 *0,0080*	125 (98 — 160) *410 (330 — 520)*
M2	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	105 (82 — 130) *345 (270 — 420)*
M3	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	80 (64 — 110) *260 (210 — 360)*
M4	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	95 (70 — 110) *310 (230 — 360)*
M5	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	75 (59 — 96) *245 (200 — 310)*
S1	E	2.8 *2,8*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	37 (25 — 61) *120 (83 — 200)*
S2	E	2.8 *2,8*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	30 (20 — 49) *100 (66 — 160)*
S3	E	2.8 *2,8*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.11 *0,0044*	26 (18 — 43) *85 (60 — 140)*
S11	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	120 (91 — 150) *395 (300 — 490)*
S12	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	95 (70 — 110) *310 (230 — 360)*
S13	E	2.0 *2,0*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	95 (70 — 110) *310 (230 — 360)*

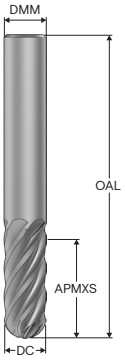
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

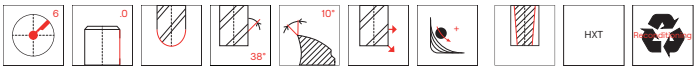
JS730

Hochleistungsfräser – Titan – Kugelkopf – 6 Schneiden – Zylindrisch





D



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Zwei Schneiden zur Mitte
- Nachschleifen möglich

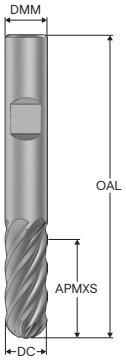
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JS730060D2B.0Z6-HXT	03067605	2	D	6,0	6,0	17,0	57,0	3,0	6	Cylindrical	■
JS730080D2B.0Z6-HXT	03067606	2	D	8,0	8,0	23,0	63,0	4,0	6	Cylindrical	■
JS730100D2B.0Z6-HXT	03067607	2	D	10,0	10,0	26,0	72,0	5,0	6	Cylindrical	■
JS730120D2B.0Z6-HXT	03067608	2	D	12,0	12,0	30,0	83,0	6,0	6	Cylindrical	■
JS730160D2B.0Z6-HXT	03067609	2	D	16,0	16,0	44,0	99,0	8,0	6	Cylindrical	■
JS730200D3B.0Z6-HXT	03067610	3	D	20,0	20,0	62,0	121,0	10,0	6	Cylindrical	■
JS730250D3B.0Z6-HXT	03067611	3	D	25,0	25,0	78,0	146,0	12,5	6	Cylindrical	■

■ **Lagerstandard.**

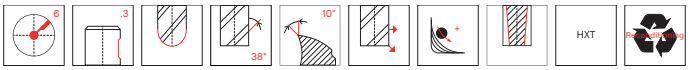
JS730

Hochleistungsfräser – Titan – Kugelkopf – 6 Schneiden – Weldon





D



– Toleranzen:
– DMM = h5
– DC= e7
– RE= ±0,02 mm
– Zwei Schneiden zur Mitte
– Nachschleifen möglich

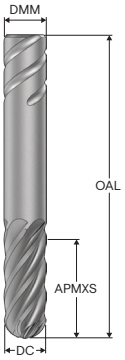
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JS730060D2B.3Z6-HXT	03067778	2	D	6,0	6,0	17,0	57,0	3,0	6	Weldon	☐
JS730080D2B.3Z6-HXT	03067779	2	D	8,0	8,0	23,0	63,0	4,0	6	Weldon	■
JS730100D2B.3Z6-HXT	03067780	2	D	10,0	10,0	26,0	72,0	5,0	6	Weldon	☐
JS730120D2B.3Z6-HXT	03067781	2	D	12,0	12,0	30,0	83,0	6,0	6	Weldon	☐
JS730160D2B.3Z6-HXT	03067782	2	D	16,0	16,0	44,0	99,0	8,0	6	Weldon	☐
JS730200D3B.3Z6-HXT	03067783	3	D	20,0	20,0	62,0	121,0	10,0	6	Weldon	☐
JS730250D3B.3Z6-HXT	03067784	3	D	25,0	25,0	78,0	146,0	12,5	6	Weldon	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

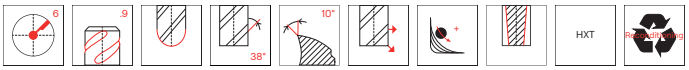
JS730

Hochleistungsfräser – Titan – Kugelkopf 6 Schneiden – Safe-Lock





D



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Zwei Schneiden zur Mitte
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JS730060D2B.9Z6-HXT	03067785	2	D	6,0	6,0	17,0	57,0	3,0	6	Safe-lock	☐
JS730080D2B.9Z6-HXT	03067786	2	D	8,0	8,0	23,0	63,0	4,0	6	Safe-lock	☐
JS730100D2B.9Z6-HXT	03067787	2	D	10,0	10,0	26,0	72,0	5,0	6	Safe-lock	☐
JS730120D2B.9Z6-HXT	03067788	2	D	12,0	12,0	30,0	83,0	6,0	6	Safe-lock	☐
JS730160D2B.9Z6-HXT	03067789	2	D	16,0	16,0	44,0	99,0	8,0	6	Safe-lock	☐
JS730200D3B.9Z6-HXT	03067790	3	D	20,0	20,0	62,0	121,0	10,0	6	Safe-lock	☐
JS730250D3B.9Z6-HXT	03067791	3	D	25,0	25,0	78,0	146,0	12,5	6	Safe-lock	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

Schnittdaten – JS730 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
M1	E	0.100 *0,100*	1.8 *1,8*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	140 (89 — 150) *460 (300 — 490)*
M2	E	0.150 *0,150*	2.2 *2,2*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	110 (70 — 120) *360 (230 — 390)*
M3	E	0.100 *0,100*	1.8 *1,8*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	85 (55 — 99) *280 (190 — 320)*
M4	E	0.100 *0,100*	1.8 *1,8*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	90 (57 — 100) *295 (190 — 320)*
M5	E	0.100 *0,100*	1.8 *1,8*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	75 (47 — 85) *245 (160 — 270)*
S1	E	0.150 *0,150*	2.2 *2,2*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	43 (29 — 70) *140 (96 — 220)*
S2	E	0.150 *0,150*	2.2 *2,2*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	34 (23 — 57) *110 (76 — 180)*
S3	E	0.150 *0,150*	2.2 *2,2*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	30 (20 — 49) *100 (66 — 160)*
S11	E	0.300 *0,300*	1.2 *1,2*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	130 (79 — 130) *425 (260 — 420)*
S12	E	0.300 *0,300*	1.2 *1,2*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	0.095 *0,0038*	100 (61 — 100) *330 (210 — 320)*
S13	E	0.300 *0,300*	1.2 *1,2*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.085 *0,0034*	100 (62 — 100) *330 (210 — 320)*

Schnittdaten – JS730 Eckfräsen dynamisches Fräsen a_e/DC=0,07

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	1.9 *1,9*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	145 (93 — 150) *475 (310 — 490)*
M2	E	2.2 *2,2*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	125 (78 — 130) *410 (260 — 420)*
M3	E	1.9 *1,9*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.18 *0,0070*	90 (58 — 100) *295 (200 — 320)*
M4	E	1.9 *1,9*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	95 (59 — 100) *310 (200 — 320)*
M5	E	1.9 *1,9*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	80 (50 — 89) *260 (170 — 290)*
S1	E	2.2 *2,2*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	47 (32 — 79) *155 (110 — 250)*
S2	E	2.2 *2,2*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	38 (26 — 63) *125 (86 — 200)*
S3	E	2.2 *2,2*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.13 *0,0050*	33 (23 — 55) *110 (76 — 180)*
S11	E	1.9 *1,9*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	150 (94 — 150) *490 (310 — 490)*
S12	E	1.9 *1,9*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	115 (72 — 110) *375 (240 — 360)*
S13	E	1.9 *1,9*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	120 (74 — 120) *395 (250 — 390)*

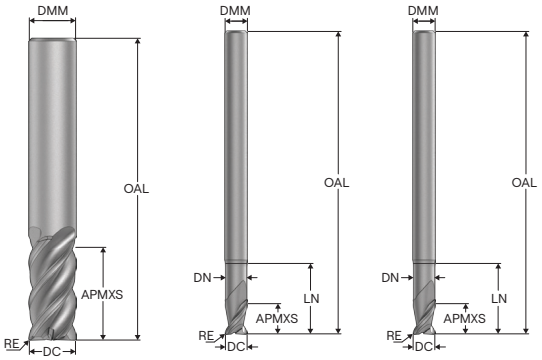
Schnittdaten, siehe Seite 699 - 707

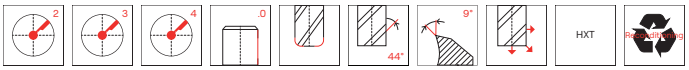
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JHP751

Hochleistungsfräser – Titan – Eckfräser – 2-4 Schneiden – Zylindrisch – Eckenradius







– Toleranzen:
– DMM=h5
– DC=-0,02/-0,04 mm
– RE= ±0,02 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

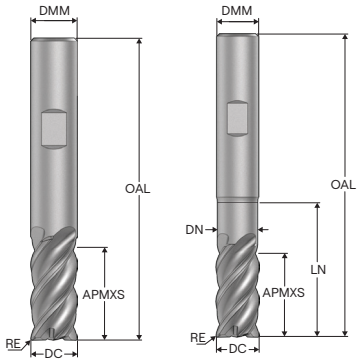
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm	mm	mm			
JHP751080D1R040.0Z4	HXT	10105487	1	D	8,0	8,0	16,0	58,0	–	–	0,4	4	Cylindrical	■
JHP751100D1R040.0Z4	HXT	10105548	1	D	10,0	10,0	20,0	66,0	–	–	0,4	4	Cylindrical	■
JHP751100D1R150.0Z4	HXT	10105549	1	D	10,0	10,0	20,0	66,0	–	–	1,5	4	Cylindrical	■
JHP751120D1R040.0Z4	HXT	10105550	1	D	12,0	12,0	24,0	75,0	–	–	0,4	4	Cylindrical	■
JHP751120D1R150.0Z4	HXT	10105552	1	D	12,0	12,0	24,0	75,0	–	–	1,5	4	Cylindrical	■
JHP751160D1R040.0Z4	HXT	10105581	1	D	16,0	16,0	32,0	92,0	–	–	0,4	4	Cylindrical	■
JHP751160D1R150.0Z4	HXT	10105582	1	D	16,0	16,0	32,0	92,0	–	–	1,5	4	Cylindrical	■
JHP751200D1R080.0Z4	HXT	10105583	1	D	20,0	20,0	40,0	104,0	–	–	0,8	4	Cylindrical	■
JHP751020G2R020.0Z2	HXT	10105584	2	G	2,0	3,0	3,0	38,0	6,0	1,9	0,2	2	Cylindrical	■
JHP751030G2R020.0Z2	HXT	10105585	2	E	3,0	3,0	4,5	38,0	9,0	2,8	0,2	2	Cylindrical	■
JHP751040G2R020.0Z2	HXT	10105586	2	G	4,0	6,0	6,0	50,0	9,0	3,7	0,2	2	Cylindrical	■
JHP751050G2R030.0Z2	HXT	10105587	2	G	5,0	6,0	7,5	50,0	9,0	4,6	0,3	2	Cylindrical	■
JHP751060E2R030.0Z3	HXT	10105588	2	E	6,0	6,0	9,0	57,0	19,0	5,6	0,3	3	Cylindrical	■
JHP751080E2R040.0Z4	HXT	10105589	2	E	8,0	8,0	16,0	63,0	24,0	7,4	0,4	4	Cylindrical	■
JHP751100E2R040.0Z4	HXT	10105590	2	E	10,0	10,0	20,0	72,0	30,0	9,4	0,4	4	Cylindrical	■
JHP751100E2R080.0Z4	HXT	10105591	2	E	10,0	10,0	20,0	72,0	30,0	9,4	0,8	4	Cylindrical	■
JHP751100E2R200.0Z4	HXT	10105593	2	E	10,0	10,0	20,0	72,0	30,0	9,4	2,0	4	Cylindrical	■
JHP751120E2R040.0Z4	HXT	10105594	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,4	4	Cylindrical	■
JHP751120E2R080.0Z4	HXT	10105595	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,8	4	Cylindrical	■
JHP751120E2R310.0Z4	HXT	10105596	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,1	4	Cylindrical	■
JHP751140E2R080.0Z4	HXT	10105597	2	E	14,0	14,0	28,0	92,0	45,0	13,4	0,8	4	Cylindrical	■
JHP751160E2R040.0Z4	HXT	10105598	2	E	16,0	16,0	32,0	104,0	52,0	15,4	0,4	4	Cylindrical	■
JHP751160E2R080.0Z4	HXT	10105599	2	E	16,0	16,0	32,0	104,0	52,0	15,4	0,8	4	Cylindrical	■
JHP751160E2R200.0Z4	HXT	10105600	2	E	16,0	16,0	32,0	104,0	52,0	15,4	2,0	4	Cylindrical	■
JHP751200E2R080.0Z4	HXT	10105601	2	E	20,0	20,0	40,0	129,0	75,0	19,4	0,8	4	Cylindrical	■

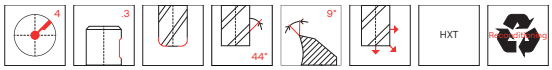
■ **Lagerstandard.**

JHP751

Hochleistungsfräser – Titan – Eckfräser – 2-4 Schneiden – Weldon – Eckenradius







– Toleranzen:
– DMM=h5
– DC=-0,02/-0,04 mm
– RE= ±0,02 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm	mm	mm			
JHP751080D1R040.3Z4	HXT	10105739	1	D	8,0	8,0	16,0	58,0	–	–	0,4	4	Weldon	■
JHP751100D1R040.3Z4	HXT	10105740	1	D	10,0	10,0	20,0	66,0	–	–	0,4	4	Weldon	■
JHP751100D1R150.3Z4	HXT	10105742	1	D	10,0	10,0	20,0	66,0	–	–	1,5	4	Weldon	■
JHP751120D1R040.3Z4	HXT	10105743	1	D	12,0	12,0	24,0	75,0	–	–	0,4	4	Weldon	■
JHP751120D1R150.3Z4	HXT	10105744	1	D	12,0	12,0	24,0	75,0	–	–	1,5	4	Weldon	■
JHP751160D1R040.3Z4	HXT	10105745	1	D	16,0	16,0	32,0	92,0	–	–	0,4	4	Weldon	■
JHP751160D1R150.3Z4	HXT	10105746	1	D	16,0	16,0	32,0	92,0	–	–	1,5	4	Weldon	■
JHP751200D1R080.3Z4	HXT	10105747	1	D	20,0	20,0	40,0	104,0	–	–	0,8	4	Weldon	■
JHP751080E2R040.3Z4	HXT	10105748	2	E	8,0	8,0	16,0	63,0	24,0	7,4	0,4	4	Weldon	■
JHP751100E2R040.3Z4	HXT	10105749	2	E	10,0	10,0	20,0	72,0	30,0	9,4	0,4	4	Weldon	■
JHP751100E2R080.3Z4	HXT	10105750	2	E	10,0	10,0	20,0	72,0	30,0	9,4	0,8	4	Weldon	■
JHP751100E2R200.3Z4	HXT	10105751	2	E	10,0	10,0	20,0	72,0	30,0	9,4	2,0	4	Weldon	■
JHP751120E2R040.3Z4	HXT	10105752	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,4	4	Weldon	■
JHP751120E2R080.3Z4	HXT	10105753	2	E	12,0	12,0	24,0	83,0	35,0	11,4	0,8	4	Weldon	■
JHP751120E2R310.3Z4	HXT	10105754	2	E	12,0	12,0	24,0	83,0	35,0	11,4	3,1	4	Weldon	■
JHP751140E2R080.3Z4	HXT	10105755	2	E	14,0	14,0	28,0	92,0	45,0	13,4	0,8	4	Weldon	■
JHP751160E2R040.3Z4	HXT	10105756	2	E	16,0	16,0	32,0	104,0	52,0	15,4	0,4	4	Weldon	■
JHP751160E2R080.3Z4	HXT	10105757	2	E	16,0	16,0	32,0	104,0	52,0	15,4	0,8	4	Weldon	■
JHP751160E2R200.3Z4	HXT	10105758	2	E	16,0	16,0	32,0	104,0	52,0	15,4	2,0	4	Weldon	■
JHP751200E2R080.3Z4	HXT	10105759	2	E	20,0	20,0	40,0	129,0	75,0	19,4	0,8	4	Weldon	■

■ **Lagerstandard.**

Schnittdaten – JHP751 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	14	16	20	
S1	E/M/A	0.0600 *0,0600*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	48 (33 — 64) *155 (110 — 200)*
S2	E/M/A	0.0600 *0,0600*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	39 (26 — 51) *130 (86 — 160)*
S3	E/M/A	0.0400 *0,0400*	1.2 *1,2*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	33 (26 — 50) *110 (86 — 160)*
S11	E/M/A	0.0800 *0,0800*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	145 (130 — 180) *475 (430 — 590)*
S12	E/M/A	0.0800 *0,0800*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	110 (95 — 140) *360 (320 — 450)*
S13	E/M/A	0.0800 *0,0800*	1.2 *1,2*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.10 *0,0040*	0.12 *0,0048*	90 (76 — 110) *295 (250 — 360)*

Schnittdaten – JHP751 Nutfräsen

SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	14	16	20	
S1	E/M/A	0.44 *0,44*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	30 (20 — 39) *100 (66 — 120)*
S2	E/M/A	0.44 *0,44*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	24 (17 — 32) *80 (56 — 100)*
S3	E/M/A	0.34 *0,34*	0.0046 *0,00018*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.032 *0,0013*	0.034 *0,0013*	0.040 *0,0016*	20 (15 — 29) *65 (50 — 95)*
S11	E/M/A	0.70 *0,70*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	90 (78 — 110) *295 (260 — 360)*
S12	E/M/A	0.70 *0,70*	0.0085 *0,00034*	0.013 *0,00050*	0.017 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	70 (60 — 89) *230 (200 — 290)*
S13	E/M/A	0.70 *0,70*	0.0075 *0,00030*	0.011 *0,00044*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	55 (48 — 71) *180 (160 — 230)*

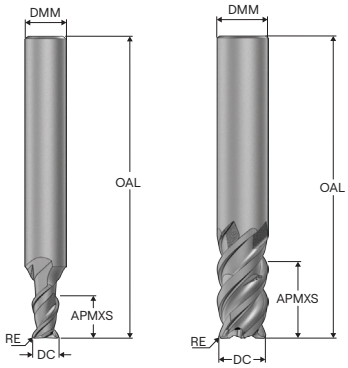
Schnittdaten, siehe Seite 699 - 707

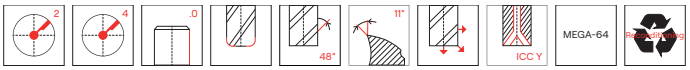
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JHP760

Hochleistungsfräser – ISO-M – Eckfräser – 2-4 Schneiden – Zylindrisch – Eckenradius







– Toleranzen:
– DMM=h5
– DC=-0,02/-0,04 mm
– RE= ±0,03 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

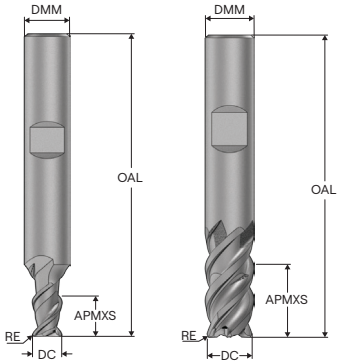
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm				
760040R020Z2.0A-MEGA-64	02734051	2	F	■	4,0	6,0	8,0	50,0	0,2	4,0	2	Cylindrical	■
760040R040Z2.0A-MEGA-64	02623413	2	F	■	4,0	6,0	8,0	50,0	0,4	4,0	2	Cylindrical	■
760050R020Z2.0A-MEGA-64	02734052	2	F	■	5,0	6,0	10,0	50,0	0,2	2,0	2	Cylindrical	■
760050R040Z2.0A-MEGA-64	02623435	2	F	■	5,0	6,0	10,0	50,0	0,4	2,0	2	Cylindrical	■
760060R020Z4.0A-MEGA-64	02734053	2	D	■	6,0	6,0	12,0	50,0	0,2	–	4	Cylindrical	■
760060R040Z4.0A-MEGA-64	02623433	2	D	■	6,0	6,0	12,0	50,0	0,4	–	4	Cylindrical	■
760080R040Z4.0A-MEGA-64	02623436	2	D	■	8,0	8,0	16,0	55,0	0,4	–	4	Cylindrical	■
760080R100Z4.0A-MEGA-64	02623437	2	D	■	8,0	8,0	16,0	55,0	1,0	–	4	Cylindrical	■
760100R040Z4.0A-MEGA-64	02623460	2	D	■	10,0	10,0	20,0	65,0	0,4	–	4	Cylindrical	■
760100R100Z4.0A-MEGA-64	02623463	2	D	■	10,0	10,0	20,0	65,0	1,0	–	4	Cylindrical	■
760100R150Z4.0A-MEGA-64	02623466	2	D	■	10,0	10,0	20,0	65,0	1,5	–	4	Cylindrical	■
760120R040Z4.0A-MEGA-64	02623819	2	D	■	12,0	12,0	24,0	75,0	0,4	–	4	Cylindrical	■
760120R100Z4.0A-MEGA-64	02623825	2	D	■	12,0	12,0	24,0	75,0	1,0	–	4	Cylindrical	■
760120R150Z4.0A-MEGA-64	02623828	2	D	■	12,0	12,0	24,0	75,0	1,5	–	4	Cylindrical	■
760120R310Z4.0A-MEGA-64	02623833	2	D	■	12,0	12,0	24,0	75,0	3,1	–	4	Cylindrical	■
760200R040Z4.0A-MEGA-64	02734055	2	D	■	20,0	20,0	45,0	100,0	0,4	–	4	Cylindrical	■
760200R080Z4.0A-MEGA-64	02623852	2	D	■	20,0	20,0	45,0	100,0	0,8	–	4	Cylindrical	■
760L080R040Z4.0A-MEGA-64	02623438	3	D	■	8,0	8,0	28,0	65,0	0,4	–	4	Cylindrical	■
760L100R040Z4.0A-MEGA-64	02623461	3	D	■	10,0	10,0	36,0	75,0	0,4	–	4	Cylindrical	■
760L100R100Z4.0A-MEGA-64	02623464	3	D	■	10,0	10,0	36,0	75,0	1,0	–	4	Cylindrical	■
760L100R150Z4.0A-MEGA-64	02623467	3	D	■	10,0	10,0	36,0	75,0	1,5	–	4	Cylindrical	■
760L100R200Z4.0A-MEGA-64	02623472	3	D	■	10,0	10,0	36,0	75,0	2,0	–	4	Cylindrical	■
760L100R310Z4.0A-MEGA-64	02623807	3	D	■	10,0	10,0	36,0	75,0	3,1	–	4	Cylindrical	■
760L120R040Z4.0A-MEGA-64	02623821	3	D	■	12,0	12,0	42,0	90,0	0,4	–	4	Cylindrical	■
760L120R100Z4.0A-MEGA-64	02623826	3	D	■	12,0	12,0	42,0	90,0	1,0	–	4	Cylindrical	■
760L120R150Z4.0A-MEGA-64	02623829	3	D	■	12,0	12,0	42,0	90,0	1,5	–	4	Cylindrical	■
760L120R400Z4.0A-MEGA-64	02623838	3	D	■	12,0	12,0	42,0	90,0	4,0	–	4	Cylindrical	■
760L160R040Z4.0A-MEGA-64	02623840	3	D	■	16,0	16,0	50,0	100,0	0,4	–	4	Cylindrical	■
760L160R100Z4.0A-MEGA-64	02623842	3	D	■	16,0	16,0	50,0	100,0	1,0	–	4	Cylindrical	■
760L160R150Z4.0A-MEGA-64	02623844	3	D	■	16,0	16,0	50,0	100,0	1,5	–	4	Cylindrical	■

■ **Lagerstandard.**

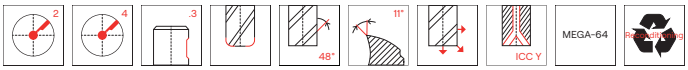
JHP760

Hochleistungsfräser – ISO-M – Eckfräser – 2-4 Schneiden – Weldon – Eckenradius





F D



—Toleranzen:
—DMM=h5
—DC=-0,02/-0,04 mm
—RE= ±0,03 mm
—Nachschleifen möglich, wenn DC ≥ Ø6 ist

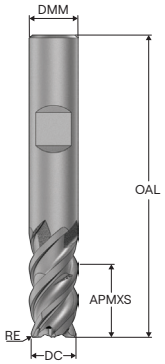
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm				
760040R020Z2.0A-MEGA-64W	02734065	2	F	■	4,0	6,0	8,0	50,0	0,2	4,0	2	Weldon	□
760040R040Z2.0A-MEGA-64W	02669339	2	F	■	4,0	6,0	8,0	50,0	0,4	4,0	2	Weldon	□
760050R020Z2.0A-MEGA-64W	02734068	2	F	■	5,0	6,0	10,0	50,0	0,2	2,0	2	Weldon	□
760050R040Z2.0A-MEGA-64W	02669340	2	F	■	5,0	6,0	10,0	50,0	0,4	2,0	2	Weldon	□
760060R020Z4.0A-MEGA-64W	02734069	2	D	■	6,0	6,0	12,0	50,0	0,2	–	4	Weldon	□
760060R040Z4.0A-MEGA-64W	02669341	2	D	■	6,0	6,0	12,0	50,0	0,4	–	4	Weldon	□
760080R040Z4.0A-MEGA-64W	02669343	2	D	■	8,0	8,0	16,0	55,0	0,4	–	4	Weldon	■
760080R100Z4.0A-MEGA-64W	02669344	2	D	■	8,0	8,0	16,0	55,0	1,0	–	4	Weldon	□
760100R040Z4A-MEGA-64	02623442	2	D	■	10,0	10,0	20,0	65,0	0,4	–	4	Weldon	■
760100R100Z4A-MEGA-64	02623462	2	D	■	10,0	10,0	20,0	65,0	1,0	–	4	Weldon	■
760100R150Z4A-MEGA-64	02623465	2	D	■	10,0	10,0	20,0	65,0	1,5	–	4	Weldon	■
760120R040Z4A-MEGA-64	02623817	2	D	■	12,0	12,0	24,0	75,0	0,4	–	4	Weldon	■
760120R100Z4A-MEGA-64	02623824	2	D	■	12,0	12,0	24,0	75,0	1,0	–	4	Weldon	■
760120R150Z4A-MEGA-64	02623827	2	D	■	12,0	12,0	24,0	75,0	1,5	–	4	Weldon	■
760120R400Z4A-MEGA-64	02623835	2	D	■	12,0	12,0	24,0	75,0	4,0	–	4	Weldon	■
760160R040Z4A-MEGA-64	02623839	2	D	■	16,0	16,0	40,0	90,0	0,4	–	4	Weldon	■
760160R100Z4A-MEGA-64	02623841	2	D	■	16,0	16,0	40,0	90,0	1,0	–	4	Weldon	■
760160R150Z4A-MEGA-64	02623843	2	D	■	16,0	16,0	40,0	90,0	1,5	–	4	Weldon	■
760160R200Z4A-MEGA-64	02623845	2	D	■	16,0	16,0	40,0	90,0	2,0	–	4	Weldon	■
760200R040Z4A-MEGA-64	02734054	2	D	■	20,0	20,0	45,0	100,0	0,4	–	4	Weldon	■
760200R080Z4A-MEGA-64	02623851	2	D	■	20,0	20,0	45,0	100,0	0,8	–	4	Weldon	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JHP760

Hochleistungsfräser – ISO-S – Eckfräser – 2-4 Schneiden – Weldon – Eckenradius – ICC





D

– Toleranzen:
– DMM=h5
– DC=-0,02/-0,04 mm
– RE= ±0,03 mm
– Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
760L080R040Z4.0A-MEGA-64W	02720459	3	D	■	8,0	8,0	28,0	65,0	0,4	4	Weldon	□
760L100R040Z4.0A-MEGA-64W	02669345	3	D	■	10,0	10,0	36,0	75,0	0,4	4	Weldon	□
760L100R100Z4.0A-MEGA-64W	02669346	3	D	■	10,0	10,0	36,0	75,0	1,0	4	Weldon	□
760L100R150Z4.0A-MEGA-64W	02669347	3	D	■	10,0	10,0	36,0	75,0	1,5	4	Weldon	□
760L100R200Z4.0A-MEGA-64W	02669348	3	D	■	10,0	10,0	36,0	75,0	2,0	4	Weldon	□
760L120R040Z4.0A-MEGA-64W	02669350	3	D	■	12,0	12,0	42,0	90,0	0,4	4	Weldon	□
760L120R100Z4.0A-MEGA-64W	02669351	3	D	■	12,0	12,0	42,0	90,0	1,0	4	Weldon	□
760L120R150Z4.0A-MEGA-64W	02669352	3	D	■	12,0	12,0	42,0	90,0	1,5	4	Weldon	□
760L160R040Z4.0A-MEGA-64W	02669356	3	D	■	16,0	16,0	50,0	100,0	0,4	4	Weldon	□
760L160R100Z4.0A-MEGA-64W	02669357	3	D	■	16,0	16,0	50,0	100,0	1,0	4	Weldon	□
760L160R150Z4.0A-MEGA-64W	02669358	3	D	■	16,0	16,0	50,0	100,0	1,5	4	Weldon	□

□ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JHP760 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z									v_c
				4	5	6	8	10	12	16	20	25	
M1	E	0.300 *0,300*	1.5 *1,5*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.17 *0,0065*	120 (97 — 130) *395 (320 — 420)*
M2	E	0.300 *0,300*	1.5 *1,5*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.13 *0,0050*	0.15 *0,0060*	100 (81 — 110) *330 (270 — 360)*
M3	E	0.300 *0,300*	1.4 *1,4*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	75 (58 — 91) *245 (200 — 290)*
M4	E	0.300 *0,300*	1.4 *1,4*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	60 (45 — 70) *195 (150 — 220)*
M5	E	0.300 *0,300*	1.4 *1,4*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	48 (37 — 59) *155 (130 — 190)*

Schnittdaten – JHP760 Nutfräsen

SMG		a_p/DC	f_z								v_c
			4	5	6	8	10	12	16	20	25	
M1	E	1.0 *1,0*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	110 (92 — 130) *360 (310 — 420)*
M2	E	1.0 *1,0*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	90 (74 — 100) *295 (250 — 320)*
M3	E	0.80 *0,80*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	70 (54 — 85) *230 (180 — 270)*
M4	E	0.80 *0,80*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	50 (40 — 63) *165 (140 — 200)*
M5	E	0.80 *0,80*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	43 (34 — 53) *140 (120 — 170)*

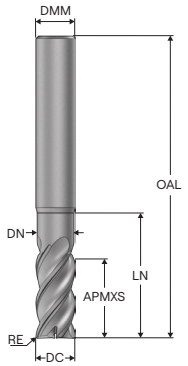
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JHP770

Hochleistungsfräser – Titan – Eckfräser – 4-5 Schneiden – Zylindrisch – Eckenradius





E

– Toleranzen:
– DMM = h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich



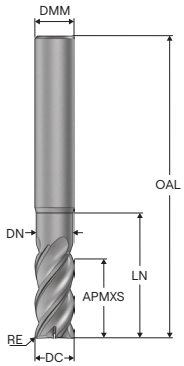
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JHP770060E2R030.0Z4A-SIRA	02760645	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	Cylindrical	■
JHP770080E2R040.0Z4A-SIRA	02760653	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	Cylindrical	■
JHP770080E2R050.0Z4A-SIRA	02823416	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,5	4	Cylindrical	■
JHP770100E2R040.0Z4A-SIRA	02760654	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	Cylindrical	■
JHP770100E2R050.0Z4A-SIRA	02823417	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,5	4	Cylindrical	■
JHP770120E2R040.0Z4A-SIRA	02760656	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	Cylindrical	■
JHP770120E2R050.0Z4A-SIRA	02823419	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,5	4	Cylindrical	■
JHP770120E2R100.0Z4A-SIRA	02823420	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	1,0	4	Cylindrical	■
JHP770120E2R250.0Z4A-SIRA	02760659	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	Cylindrical	■
JHP770140E2R050.0Z4A-SIRA	02823421	2	E	■	14,0	14,0	28,0	95,0	42,0	13,4	0,5	4	Cylindrical	■
JHP770160E2R040.0Z4A-SIRA	02760661	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	Cylindrical	■
JHP770160E2R050.0Z4A-SIRA	02823422	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	4	Cylindrical	■
JHP770160E2R080.0Z4A-SIRA	02760662	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	Cylindrical	■
JHP770160E2R100.0Z4A-SIRA	02823423	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	4	Cylindrical	■
JHP770160E2R250.0Z4A-SIRA	02760663	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	4	Cylindrical	■
JHP770160E2R310.0Z4A-SIRA	02760664	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	4	Cylindrical	■
JHP770160E2R400.0Z4A-SIRA	02760665	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	Cylindrical	■
JHP770200E2R050.0Z4A-SIRA	02823424	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	4	Cylindrical	■
JHP770200E2R100.0Z4A-SIRA	02823425	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	4	Cylindrical	■
JHP770200E2R250.0Z4A-SIRA	02760668	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	4	Cylindrical	■
JHP770200E2R310.0Z4A-SIRA	02760669	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	Cylindrical	■
JHP770200E2R400.0Z4A-SIRA	02760670	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	Cylindrical	■

■ **Lagerstandard.**
Anmerkung: bei Eckenradius >15% von DC → a_p=-30%, f_z= -20%

JHP770

Hochleistungsfräser – Titan – Eckfräser – 4-5 Schneiden – Zylindrisch – Eckenradius





E



—Toleranzen:
—DMM = h5
—DC= e7
—RE= ±0,02 mm
—Nachschleifen möglich

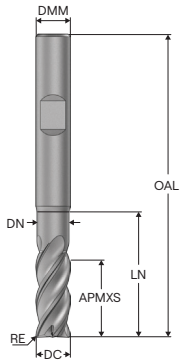
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JHP770160E2R050.0Z5A-SIRA	02810129	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	5	Cylindrical	■
JHP770160E2R100.0Z5A-SIRA	02810130	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	5	Cylindrical	■
JHP770160E2R250.0Z5A-SIRA	02810131	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	5	Cylindrical	■
JHP770160E2R310.0Z5A-SIRA	02810132	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	5	Cylindrical	■
JHP770160E2R400.0Z5A-SIRA	02810133	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	5	Cylindrical	■
JHP770200E2R050.0Z5A-SIRA	02810134	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	5	Cylindrical	■
JHP770200E2R100.0Z5A-SIRA	02810135	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	5	Cylindrical	■
JHP770200E2R250.0Z5A-SIRA	02810136	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	5	Cylindrical	■
JHP770200E2R310.0Z5A-SIRA	02810137	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	5	Cylindrical	■
JHP770200E2R400.0Z5A-SIRA	02810138	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	5	Cylindrical	■
JHP770250E2R050.0Z5A-SIRA	02810139	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	0,5	5	Cylindrical	■

■ **Lagerstandard.**
Anmerkung: bei Eckenradius >15% von DC → a_p= -30%, f_z= -20%

JHP770

Hochleistungsfräser – Titan – Eckfräser – 4-5 Schneiden – Weldon – Eckenradius





E



—Toleranzen:
—DMM = h5
—DC= e7
—RE= ±0,02 mm
—Nachschleifen möglich

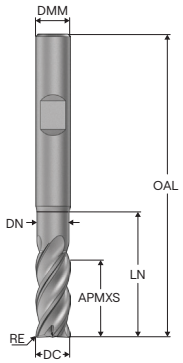
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JHP770060E2R030.3Z4A-SIRA	02760796	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	Weldon	■
JHP770080E2R040.3Z4A-SIRA	02760799	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	Weldon	□
JHP770080E2R050.3Z4A-SIRA	02823428	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,5	4	Weldon	■
JHP770100E2R040.3Z4A-SIRA	02760801	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	Weldon	□
JHP770100E2R050.3Z4A-SIRA	02823429	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,5	4	Weldon	■
JHP770120E2R040.3Z4A-SIRA	02760803	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	Weldon	□
JHP770120E2R050.3Z4A-SIRA	02823431	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,5	4	Weldon	■
JHP770120E2R100.3Z4A-SIRA	02823432	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	1,0	4	Weldon	■
JHP770120E2R250.3Z4A-SIRA	02760805	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	Weldon	□
JHP770140E2R050.3Z4A-SIRA	02823433	2	E	■	14,0	14,0	28,0	95,0	42,0	13,4	0,5	4	Weldon	■
JHP770160E2R040.3Z4A-SIRA	02760807	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	Weldon	□
JHP770160E2R050.3Z4A-SIRA	02823434	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	4	Weldon	■
JHP770160E2R080.3Z4A-SIRA	02760809	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	Weldon	□
JHP770160E2R100.3Z4A-SIRA	02823435	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	4	Weldon	■
JHP770160E2R250.3Z4A-SIRA	02760810	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	4	Weldon	■
JHP770160E2R310.3Z4A-SIRA	02760811	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	4	Weldon	□
JHP770160E2R400.3Z4A-SIRA	02760817	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	Weldon	□
JHP770200E2R050.3Z4A-SIRA	02823436	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	4	Weldon	■
JHP770200E2R100.3Z4A-SIRA	02823437	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	4	Weldon	■
JHP770200E2R250.3Z4A-SIRA	02760823	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	4	Weldon	□
JHP770200E2R310.3Z4A-SIRA	02760824	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	Weldon	□
JHP770200E2R400.3Z4A-SIRA	02760825	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	Weldon	□

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.
Anmerkung: bei Eckenradius >15% von DC → a_p=-30%, f_z=-20%
ICC = mit interner Kühlschmiermittelzufuhr

JHP770

Hochleistungsfräser – Titan – Eckfräser – 4-5 Schneiden – Weldon – Eckenradius





E



– Toleranzen:
– DMM = h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich

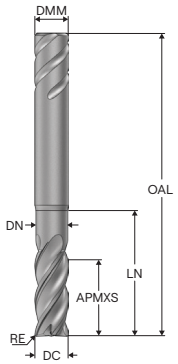
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JHP770160E2R050.3Z5A-SIRA	02810143	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	0,5	5	Weldon	■
JHP770160E2R100.3Z5A-SIRA	02810144	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	1,0	5	Weldon	■
JHP770160E2R250.3Z5A-SIRA	02810145	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	2,5	5	Weldon	□
JHP770160E2R310.3Z5A-SIRA	02810146	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	3,1	5	Weldon	■
JHP770160E2R400.3Z5A-SIRA	02810147	2	E	■	16,0	16,0	32,0	100,0	45,0	15,4	4,0	5	Weldon	□
JHP770200E2R050.3Z5A-SIRA	02810148	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	0,5	5	Weldon	■
JHP770200E2R100.3Z5A-SIRA	02810149	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	1,0	5	Weldon	■
JHP770200E2R250.3Z5A-SIRA	02810150	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	2,5	5	Weldon	□
JHP770200E2R310.3Z5A-SIRA	02810151	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	3,1	5	Weldon	■
JHP770200E2R400.3Z5A-SIRA	02810152	2	E	■	20,0	20,0	40,0	115,0	55,0	19,4	4,0	5	Weldon	■
JHP770250E2R050.3Z5A-SIRA	02810153	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	0,5	5	Weldon	■
JHP770250E2R100.3Z5A-SIRA	02810154	2	E	■	25,0	25,0	50,0	130,0	65,0	24,4	1,0	5	Weldon	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.
Anmerkung: bei Eckenradius >15% von DC → a_p=–30%, f_z=–20%
ICC = mit interner Kühlschmiermittelzufuhr

JHP770

Hochleistungsfräser – Titan – Eckfräser – 4-5 Schneiden – Safe-Lock – Eckenradius





E

– Toleranzen:
– DMM = h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich



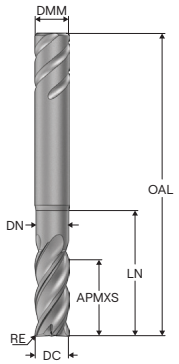
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JHP770060E2R030.9Z4A-SIRA	02927936	2	E	■	6,0	6,0	12,0	60,0	18,0	6,0	0,3	4	Safe-lock	☐
JHP770080E2R040.9Z4A-SIRA	02927937	2	E	■	8,0	8,0	16,0	65,0	24,0	7,0	0,4	4	Safe-lock	☐
JHP770080E2R050.9Z4A-SIRA	02927938	2	E	■	8,0	8,0	16,0	65,0	24,0	7,0	0,5	4	Safe-lock	☐
JHP770100E2R040.9Z4A-SIRA	02927939	2	E	■	10,0	10,0	20,0	75,0	30,0	9,0	0,4	4	Safe-lock	☐
JHP770100E2R050.9Z4A-SIRA	02927940	2	E	■	10,0	10,0	20,0	75,0	30,0	9,0	0,5	4	Safe-lock	☐
JHP770120E2R040.9Z4A-SIRA	02927943	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	0,4	4	Safe-lock	☐
JHP770120E2R050.9Z4A-SIRA	02927944	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	0,5	4	Safe-lock	☐
JHP770120E2R100.9Z4A-SIRA	02927946	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	1,0	4	Safe-lock	☐
JHP770120E2R250.9Z4A-SIRA	02927947	2	E	■	12,0	12,0	24,0	90,0	36,0	11,0	2,5	4	Safe-lock	☐
JHP770140E2R050.9Z4A-SIRA	02927950	2	E	■	14,0	14,0	28,0	95,0	42,0	13,0	0,5	4	Safe-lock	☐
JHP770160E2R040.9Z4A-SIRA	02927948	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,4	4	Safe-lock	☐
JHP770160E2R050.9Z4A-SIRA	02927978	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,5	4	Safe-lock	☐
JHP770160E2R080.9Z4A-SIRA	02927951	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,8	4	Safe-lock	☐
JHP770160E2R100.9Z4A-SIRA	02927952	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	1,0	4	Safe-lock	☐
JHP770160E2R250.9Z4A-SIRA	02927954	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	2,5	4	Safe-lock	☐
JHP770160E2R310.9Z4A-SIRA	02927956	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	3,1	4	Safe-lock	☐
JHP770160E2R400.9Z4A-SIRA	02927958	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	4,0	4	Safe-lock	☐
JHP770200E2R050.9Z4A-SIRA	02927960	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	0,5	4	Safe-lock	☐
JHP770200E2R100.9Z4A-SIRA	02927962	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	1,0	4	Safe-lock	☐
JHP770200E2R250.9Z4A-SIRA	02927964	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	2,5	4	Safe-lock	☐
JHP770200E2R310.9Z4A-SIRA	02927966	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	3,1	4	Safe-lock	☐
JHP770200E2R400.9Z4A-SIRA	02927968	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	4,0	4	Safe-lock	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.
Anmerkung: bei Eckenradius >15% von DC → a_p=-30%, f_z=-20%

JHP770

Hochleistungsfräser – Titan – Eckfräser – 4-5 Schneiden – Safe-Lock – Eckenradius





E



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JHP770160E2R050.9Z5A-SIRA	02927949	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	0,5	5	Safe-lock	☐
JHP770160E2R100.9Z5A-SIRA	02927953	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	1,0	5	Safe-lock	☐
JHP770160E2R250.9Z5A-SIRA	02927955	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	2,5	5	Safe-lock	☐
JHP770160E2R310.9Z5A-SIRA	02927957	2	E	■	16,0	16,0	32,0	100,0	45,0	15,0	3,1	5	Safe-lock	☐
JHP770200E2R050.9Z5A-SIRA	02927961	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	0,5	5	Safe-lock	☐
JHP770200E2R100.9Z5A-SIRA	02927963	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	1,0	5	Safe-lock	☐
JHP770200E2R250.9Z5A-SIRA	02927965	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	2,5	5	Safe-lock	☐
JHP770200E2R310.9Z5A-SIRA	02927967	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	3,1	5	Safe-lock	☐
JHP770200E2R400.9Z5A-SIRA	02927969	2	E	■	20,0	20,0	40,0	115,0	55,0	19,0	4,0	5	Safe-lock	☐
JHP770250E2R050.9Z5A-SIRA	02927971	2	E	■	25,0	25,0	50,0	130,0	65,0	24,0	0,5	5	Safe-lock	☐

☐ Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.
Anmerkung: bei Eckenradius >15% von DC → a_p=-30%, f_z=-20%

Schnittdaten – JHP770 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	14	16	20	25	
S11	E	0.400 *0,400*	1.8 *1,6*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	120 (110 — 130) *395 (370 — 420)*
S12	E	0.400 *0,400*	1.8 *1,6*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	0.16 *0,0065*	90 (80 — 100) *295 (270 — 320)*
S13	E	0.400 *0,400*	1.8 *1,6*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	0.11 *0,0044*	0.12 *0,0048*	0.14 *0,0055*	75 (64 — 81) *245 (210 — 260)*

Schnittdaten – JHP770 Nutfräsen

SMG		a_p/DC	f_z								v_c
			6	8	10	12	14	16	20	25	
S11	E	1.6 *1,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	105 (94 — 120) *345 (310 — 390)*
S12	E	1.6 *1,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	80 (72 — 92) *260 (240 — 300)*
S13	E	1.6 *1,6*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	65 (56 — 71) *215 (190 — 230)*

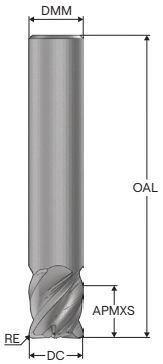
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JHP780

Hochleistungsfräser – Superlegierung – Eckfräser – 4-Schneiden – Zylindrisch – Eckenradius





D



—Toleranzen:
—DMM=h5
—DC=e7
—RE= ±0,02 mm
—Nachschleifen möglich

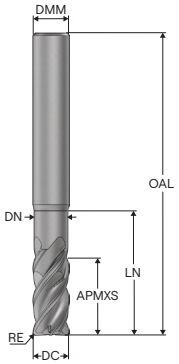
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JHP780060D1R030.0Z4A-M64	03134984	1	D	■	6,0	6,0	7,5	47,0	0,3	4	Cylindrical	■
JHP780060D1R080.0Z4A-M64	03134985	1	D	■	6,0	6,0	7,5	47,0	0,8	4	Cylindrical	■
JHP780080D1R040.0Z4A-M64	03134986	1	D	■	8,0	8,0	10,0	50,0	0,4	4	Cylindrical	■
JHP780080D1R080.0Z4A-M64	03134987	1	D	■	8,0	8,0	10,0	50,0	0,8	4	Cylindrical	■
JHP780100D1R040.0Z4A-M64	03134988	1	D	■	10,0	10,0	12,5	57,0	0,4	4	Cylindrical	■
JHP780100D1R080.0Z4A-M64	03134989	1	D	■	10,0	10,0	12,5	57,0	0,8	4	Cylindrical	■

■ **Lagerstandard.**

JHP780

Hochleistungsfräser – Superlegierung – Eckfräser – 4-Schneiden – Zylindrisch – Eckenradius





E



– Toleranzen:
– DMM=h5
– DC=e7
– RE= ±0,02 mm
– Nachschleifen möglich

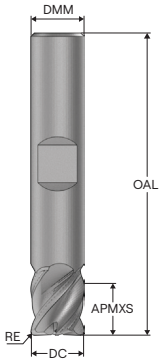
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JHP780060E2R030.0Z4A-M64	03134992	2	E	■	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	Cylindrical	■
JHP780060E2R030.0Z4-M64	02760834	2	E	–	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	Cylindrical	■
JHP780080E2R040.0Z4A-M64	03134993	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	Cylindrical	■
JHP780080E2R040.0Z4-M64	02760842	2	E	–	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	Cylindrical	■
JHP780100E2R040.0Z4A-M64	03134994	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	Cylindrical	■
JHP780100E2R040.0Z4-M64	02760846	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	Cylindrical	■
JHP780100E2R080.0Z4A-M64	03134995	2	E	■	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	Cylindrical	■
JHP780100E2R080.0Z4-M64	02760847	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	Cylindrical	■
JHP780120E2R040.0Z4A-M64	03134996	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	Cylindrical	■
JHP780120E2R040.0Z4-M64	02760848	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	Cylindrical	■
JHP780120E2R080.0Z4A-M64	03134997	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	Cylindrical	■
JHP780120E2R080.0Z4-M64	02760849	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	Cylindrical	■
JHP780120E2R150.0Z4-M64	02760850	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	1,5	4	Cylindrical	■
JHP780120E2R250.0Z4-M64	02760851	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	Cylindrical	■
JHP780140E2R040.0Z4-M64	02760852	2	E	–	14,0	14,0	28,0	95,0	42,0	13,4	0,4	4	Cylindrical	■
JHP780160E2R040.0Z4-M64	02760853	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	Cylindrical	■
JHP780160E2R080.0Z4-M64	02760861	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	Cylindrical	■
JHP780200E2R040.0Z4-M64	02760865	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,4	4	Cylindrical	■
JHP780200E2R400.0Z4-M64	02760868	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	4,0	4	Cylindrical	■
JHP780250E2R080.0Z4-M64	02760870	2	E	–	25,0	25,0	50,0	130,0	65,0	24,4	0,8	4	Cylindrical	■

■ **Lagerstandard.**

JHP780

Hochleistungsfräser – Superlegierung – Eckfräser – 4-Schneiden – Weldon – Eckenradius





D



- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich

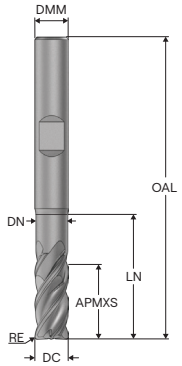
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JHP780060D1R030.3Z4A-M64	03135445	1	D	■	6,0	6,0	7,5	47,0	0,3	4	Weldon	■
JHP780060D1R080.3Z4A-M64	03135446	1	D	■	6,0	6,0	7,5	47,0	0,8	4	Weldon	■
JHP780080D1R040.3Z4A-M64	03135447	1	D	■	8,0	8,0	10,0	50,0	0,4	4	Weldon	■
JHP780080D1R080.3Z4A-M64	03135449	1	D	■	8,0	8,0	10,0	50,0	0,8	4	Weldon	■

■ **Lagerstandard.**

JHP780

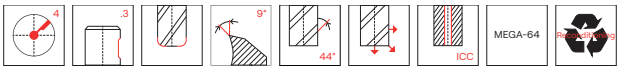
Hochleistungsfräser – Superlegierung – Eckfräser – 4-Schneiden – Weldon – Eckenradius





E

– Toleranzen:
– DMM=h5
– DC=e7
– RE= ±0,02 mm
– Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JHP780060E2R030.3Z4-M64	02760878	2	E	–	6,0	6,0	12,0	60,0	18,0	5,6	0,3	4	Weldon	■
JHP780080E2R040.3Z4-M64	02760879	2	E	–	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	Weldon	■
JHP780080E2R040.3Z4A-M64	03135455	2	E	■	8,0	8,0	16,0	65,0	24,0	7,4	0,4	4	Weldon	■
JHP780100E2R040.3Z4-M64	02760880	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,4	4	Weldon	■
JHP780100E2R080.3Z4-M64	02760881	2	E	–	10,0	10,0	20,0	75,0	30,0	9,4	0,8	4	Weldon	■
JHP780120E2R040.3Z4-M64	02760883	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	Weldon	■
JHP780120E2R040.3Z4A-M64	03134998	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,4	4	Weldon	■
JHP780120E2R080.3Z4-M64	02760885	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	Weldon	■
JHP780120E2R080.3Z4A-M64	03134999	2	E	■	12,0	12,0	24,0	90,0	36,0	11,4	0,8	4	Weldon	■
JHP780120E2R150.3Z4-M64	02760887	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	1,5	4	Weldon	■
JHP780120E2R250.3Z4-M64	02766989	2	E	–	12,0	12,0	24,0	90,0	36,0	11,4	2,5	4	Weldon	■
JHP780140E2R040.3Z4-M64	02760888	2	E	–	14,0	14,0	28,0	95,0	42,0	13,4	0,4	4	Weldon	■
JHP780160E2R040.3Z4-M64	02760889	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,4	4	Weldon	■
JHP780160E2R080.3Z4-M64	02760890	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	0,8	4	Weldon	■
JHP780160E2R400.3Z4-M64	02760893	2	E	–	16,0	16,0	32,0	100,0	45,0	15,4	4,0	4	Weldon	■
JHP780200E2R040.3Z4-M64	02760894	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,4	4	Weldon	■
JHP780200E2R080.3Z4-M64	02760896	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	0,8	4	Weldon	■
JHP780200E2R310.3Z4-M64	02760897	2	E	–	20,0	20,0	40,0	115,0	55,0	19,4	3,1	4	Weldon	■
JHP780250E2R080.3Z4-M64	02760901	2	E	–	25,0	25,0	50,0	130,0	65,0	24,4	0,8	4	Weldon	■

■ **Lagerstandard.**

Schnittdaten – JHP780 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z								v_c
				6	8	10	12	14	16	20	25	
S1	E	0.300 *0,300*	1.0 *1,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	50 (45 — 59) *165 (150 — 190)*
S2	E	0.300 *0,300*	1.0 *1,0*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.12 *0,0048*	42 (36 — 47) *140 (120 — 150)*
S3	E	0.300 *0,300*	0.80 *0,80*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	0.11 *0,0044*	28 (23 — 33) *90 (76 — 100)*

Schnittdaten – JHP780 Nutfräsen

SMG		a_p/DC	f_z								v_c
			6	8	10	12	14	16	20	25	
S1	E	0.80 *0,80*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	43 (38 — 49) *140 (130 — 160)*
S2	E	0.80 *0,80*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	35 (30 — 40) *115 (99 — 130)*
S3	E	0.60 *0,60*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.028 *0,0011*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	26 (21 — 30) *85 (69 — 98)*

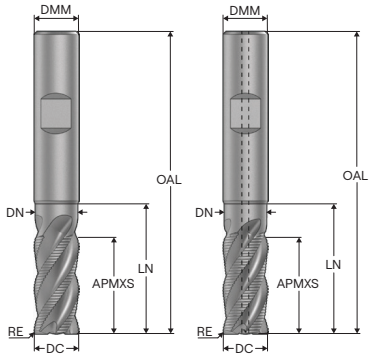
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JHP794

Hochleistungsfräser – ISO-M – Eckfräser – 4 Schneiden – Weldon – Eckenradius





– Toleranzen:
– DMM= h6
– DC= h12
– RE= ±0,05 mm
– Nachschleifen möglich, wenn DC ≥ Ø8 ist



Bezeichnung	Beschichtung	Produktnummer	Längenindex		Spanteiler	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Aufnahmen	Lagerstandard
							mm	mm	mm	mm	mm	mm	mm			
JHP794060E2R020.3Z4	TAN	10072338	2	E	■	–	6,0	6,0	13,0	57,0	18,5	2,0	0,2	4	Weldon	■
JHP794060E2R020.3Z4A	TAN	10072339	2	E	■	■	6,0	6,0	13,0	57,0	18,5	5,5	0,2	4	Weldon	■
JHP794080E2R020.3Z4	TAN	10072340	2	E	■	–	8,0	8,0	19,0	63,0	24,5	7,5	0,2	4	Weldon	■
JHP794080E2R020.3Z4A	TAN	10072341	2	E	■	■	8,0	8,0	19,0	63,0	24,5	7,5	0,2	4	Weldon	■
JHP794100E2R035.3Z4	TAN	10072342	2	E	■	–	10,0	10,0	22,0	72,0	29,5	9,5	0,35	4	Weldon	■
JHP794100E2R035.3Z4A	TAN	10072343	2	E	■	■	10,0	10,0	22,0	72,0	29,5	9,5	0,35	4	Weldon	■
JHP794120E2R035.3Z4	TAN	10072344	2	E	■	–	12,0	12,0	26,0	83,0	35,5	11,4	0,35	4	Weldon	■
JHP794120E2R035.3Z4A	TAN	10072345	2	E	■	■	12,0	12,0	26,0	92,0	35,5	11,4	0,35	4	Weldon	■
JHP794160E2R040.3Z4	TAN	10072346	2	E	■	–	16,0	16,0	32,0	92,0	41,5	15,2	0,4	4	Weldon	■
JHP794160E2R040.3Z4A	TAN	10072347	2	E	■	■	16,0	16,0	32,0	92,0	41,5	15,2	0,4	4	Weldon	■
JHP794200E2R040.3Z4	TAN	10072348	2	E	■	–	20,0	20,0	38,0	104,0	51,5	19,0	0,4	4	Weldon	■
JHP794250E2R040.3Z4	TAN	10072350	2	E	■	–	25,0	25,0	45,0	121,0	62,5	23,8	0,4	4	Weldon	■

■ Lagerstandard.

Schnittdaten – JHP794 Eckfräsen

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	1.3 *1,3*	0.032 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	0.10 *0,0040*	90 (61 — 120) *295 (210 — 390)*
M2	E	1.3 *1,3*	0.030 *0,0012*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.095 *0,0038*	75 (50 — 99) *245 (170 — 320)*
M3	E	1.3 *1,3*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.075 *0,0030*	60 (40 — 78) *195 (140 — 250)*
M4	E	1.3 *1,3*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	45 (31 — 60) *150 (110 — 190)*
M5	E	1.3 *1,3*	0.020 *0,00080*	0.028 *0,0011*	0.034 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.065 *0,0026*	38 (26 — 50) *125 (86 — 160)*

Schnittdaten – JHP794 Nutfräsen

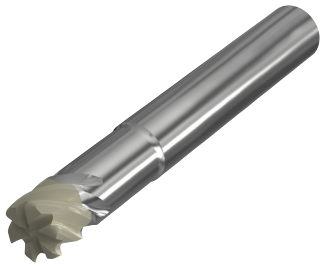
SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
M1	E	0.60 *0,60*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	75 (50 — 99) *245 (170 — 320)*
M2	E	0.60 *0,60*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.090 *0,0036*	60 (40 — 79) *195 (140 — 250)*
M3	E	0.60 *0,60*	0.022 *0,00085*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.060 *0,0024*	0.070 *0,0028*	47 (32 — 62) *155 (110 — 200)*
M4	E	0.60 *0,60*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	36 (24 — 47) *120 (79 — 150)*
M5	E	0.60 *0,60*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	30 (20 — 39) *100 (66 — 120)*

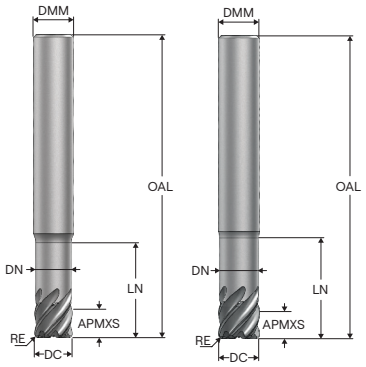
Schnittdaten, siehe Seite 699 - 707

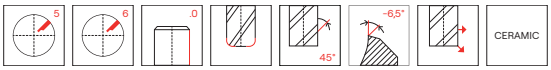
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JCG790

Hochleistungsfräser – Eckfräser – Superlegierung – 5-6 Schneiden – Zylindrisch – Eckenradius







—Toleranzen:
—DMM = h5
—DC= -0,02/-0,1 mm
—RE= ±0,05 mm

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JCG790060E2R050.0Z5	10010512	2	E	6,0	6,0	6,0	59,0	15,0	5,7	0,5	5	Cylindrical	■
JCG790080E2R050.0Z5	10010513	2	E	8,0	8,0	6,0	67,0	20,0	7,6	0,5	5	Cylindrical	■
JCG790094G2R100.0Z6	10010514	2	G	9,4	10,0	6,0	75,0	23,5	9,0	1,0	6	Cylindrical	■
JCG790100E2R100.0Z6	10010515	2	E	10,0	10,0	6,0	75,0	25,0	9,5	1,0	6	Cylindrical	■
JCG790114G2R150.0Z6	10010516	2	G	11,4	12,0	6,0	82,0	28,5	10,9	1,5	6	Cylindrical	■
JCG790120E2R150.0Z6	10010517	2	E	12,0	12,0	6,0	82,0	30,0	11,4	1,5	6	Cylindrical	■
JCG790160E2R200.0Z6	10010518	2	E	16,0	16,0	8,0	93,0	40,0	15,2	2,0	6	Cylindrical	■
JCG790200E2R300.0Z6	10010519	2	E	20,0	20,0	8,0	103,0	50,0	19,0	3,0	6	Cylindrical	■
JCG790250E2R400.0Z6	10010520	2	E	25,0	25,0	8,0	108,0	50,0	23,8	4,0	6	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JCG790 Eckfräsen/Schruppen

SMG		a_e/DC	APMXS	f_z							v_c
				6	8	10	12	16	20	25	
S1	A/D	0.0500 *0,0500*	1 *1*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	830 (420 — 1300) *2725 (1400 — 4200)*
S2	A/D	0.0500 *0,0500*	1 *1*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	670 (340 — 1100) *2200 (1200 — 3600)*
S3	A/D	0.0500 *0,0500*	1 *1*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	570 (290 — 950) *1875 (960 — 3100)*

Schnittdaten – JCG790 Nutfräsen

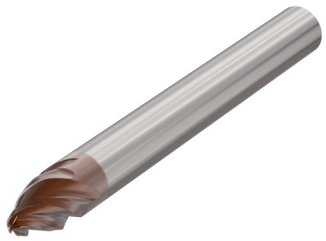
SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
S1	A/D	0.05 *0,05*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	830 (420 — 1300) *2725 (1400 — 4200)*
S2	A/D	0.05 *0,05*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	670 (340 — 1100) *2200 (1200 — 3600)*
S3	A/D	0.05 *0,05*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	570 (290 — 950) *1875 (960 — 3100)*

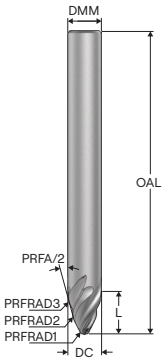
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH724

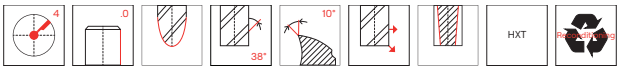
Hochgeschwindigkeitsfräsen – ISO– M und ISO– S – Konische Form – 4 Schneiden – Zylindrisch





T

—Toleranzen:
—DMM=h5
—PRFRAD1= ±0.03 mm
—Formtoleranz PRFRAD2= 0.02 mm
—Nachschleifen möglich, wenn PRFRAD ≥1,5 ist



Bezeichnung	Beschich-tung	Produkt-nummer	Läng-en-index		DC	DMM	L	APMXS	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	FCEDC	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm	mm					
	HXT	10106106	2	T	10,0	10,0	12,3	12,3	89,0	2,0	30,0	5,0	20,0	4	4	Cylindrical	■
	HXT	10106107	2	T	10,0	10,0	12,5	12,5	89,0	2,0	50,0	5,0	20,0	4	4	Cylindrical	■
	HXT	10106108	2	T	10,0	10,0	10,7	10,7	89,0	3,0	100,0	5,0	20,0	4	4	Cylindrical	■
	HXT	10106109	2	T	10,0	10,0	10,8	10,8	89,0	3,0	250,0	5,0	20,0	4	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH724 Kopierfräsen/ Feinbearbeitung

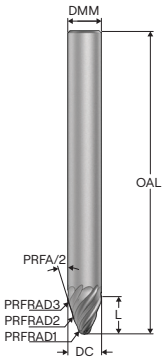
SMG		a_e/DC	f_z	v_c
			10	
P12	E	0,010 *0.010*	0,05 *0.0022*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,05 *0.0022*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,05 *0.0022*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,05 *0.0022*	130 (95 - 140) *425 (310- 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	65 (55 - 75) *215 (180 - 245)*
S11	E	0,010 *0.010*	0,05 *0.0022*	130 (95 - 140) *425 (310 - 475)*
S12	E	0.010 *0.010*	0,05 *0.0022*	120 (95 - 135) *400 (310 - 445)*
S13	E	0.010 *0.010*	0,05 *0.0022*	95 (80 - 100) *310 (260 - 320)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH726

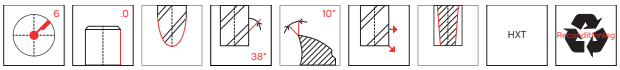
Hochgeschwindigkeitsfräsen – ISO– M und ISO– S – Konische Form – 6 Schneiden – Zylindrisch





T

—Toleranzen:
—DMM=h5
—PRFRAD1= ±0.03 mm
—Formtoleranz PRFRAD2= 0.02 mm
—Nachschleifen möglich, wenn PRFRAD ≥1,5 ist



Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index		DC	DMM	L	APMXS	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm	mm				
JH726100T2R2R030.0Z6	HXT	10106110	2	T	10,0	10,0	10,8	10,8	89,0	2,0	30,0	5,0	20,0	6	Cylindrical	■
JH726100T2R2R050.0Z6	HXT	10106111	2	T	10,0	10,0	10,7	10,7	89,0	2,0	50,0	5,0	20,0	6	Cylindrical	■
JH726100T2R3R100.0Z6	HXT	10106112	2	T	10,0	10,0	12,3	12,3	89,0	3,0	100,0	5,0	20,0	6	Cylindrical	■
JH726100T2R3R250.0Z6	HXT	10106113	2	T	10,0	10,0	12,5	12,5	89,0	3,0	250,0	5,0	20,0	6	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH726 Kopierfräsen/ Feinbearbeitung

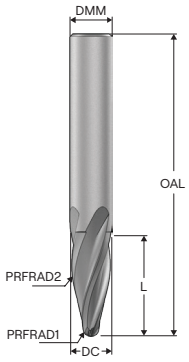
SMG		a_e/DC	f_z	v_c
			10	
P12	E	0,010 *0.010*	0,05 *0.0022*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,05 *0.0022*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,05 *0.0022*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,05 *0.0022*	130 (95 - 140) *425 (310- 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	65 (55 - 75) *215 (180 - 245)*
S11	E	0,010 *0.010*	0,05 *0.0022*	130 (95 - 140) *425 (310 - 475)*
S12	E	0.010 *0.010*	0,05 *0.0022*	120 (95 - 135) *400 (310 - 445)*
S13	E	0.010 *0.010*	0,05 *0.0022*	95 (80 - 100) *310 (260 - 320)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

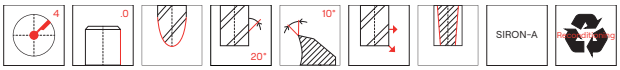
JH734

Hochgeschwindigkeitsfräsen – ISO– M und ISO– S – Tropfenform – 4 Schneiden – Zylindrisch





X



—Toleranzen:
—DMM= h5
—DC= e7
—RE= ±0,02 mm
—Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	L	APMXS	OAL	PRFRAD1	PRFRAD2	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JH734060X2R1R95.0Z4	SIRA	10044783	2	X	6,0	6,0	20,8	18,39	62,0	1,0	95,0	4	Cylindrical	■
JH734080X2R1R90.0Z4	SIRA	10044784	2	X	8,0	8,0	24,5	22,05	68,0	1,0	90,0	4	Cylindrical	■
JH734100X2R2R85.0Z4	SIRA	10044785	2	X	10,0	10,0	24,7	22,29	72,0	2,0	85,0	4	Cylindrical	■
JH734120X2R2R80.0Z4	SIRA	10044786	2	X	12,0	12,0	27,3	24,87	83,0	2,0	80,0	4	Cylindrical	■
JH734160X2R3R75.0Z4	SIRA	10044787	2	X	16,0	16,0	30,1	27,61	92,0	3,0	75,0	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH734 Kopierfräsen/ Feinbearbeitung

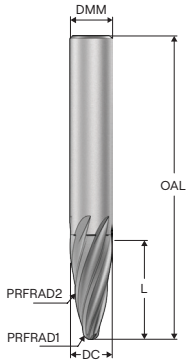
SMG		a_e/DC	f_z					v_c
			6	8	10	12	16	
P8	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH736

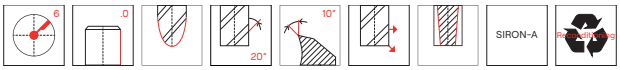
Hochgeschwindigkeitsfräsen – ISO– M und ISO– S – Tropfenform – 6 Schneiden – Zylindrisch





X

—Toleranzen:
—DMM= h5
—PRFRAD1= ±0.03mm
—Formtoleranz PRFRAD2= 0.02mm
—Nachschleifen möglich



Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	L	APMXS	OAL	PRFRAD1	PRFRAD2	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JH736100X2R2R85.0Z6	SIRA	10044834	2	X	10,0	10,0	24,7	22,29	72,0	2,0	85,0	6	Cylindrical	■
JH736120X2R2R80.0Z6	SIRA	10044835	2	X	12,0	12,0	27,3	24,87	83,0	2,0	80,0	6	Cylindrical	■
JH736160X2R3R75.0Z6	SIRA	10044836	2	X	16,0	16,0	30,1	27,61	92,0	3,0	75,0	6	Cylindrical	■

■ Lagerstandard.

Schnittdaten – JH736 Kopierfräsen/ Feinbearbeitung

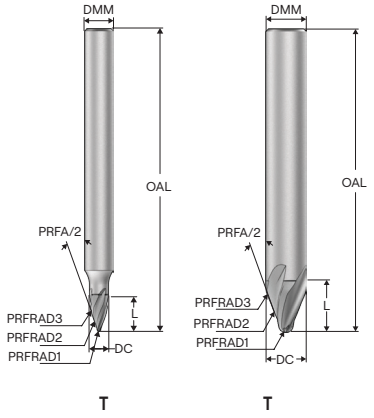
SMG		a_e/DC	f_z			v_c
			10	12	16	
P8	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

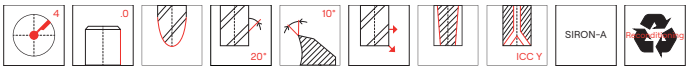
JH744

Hochgeschwindigkeitsfräsen – ISO– M und ISO– S – Konische Form – 4 Schneiden – Zylindrisch





—Toleranzen:
—DMM= h5
—PRFRAD1= ±0.03mm
—Formtoleranz PRFRAD2= 0.02mm
—Nachschleifen möglich, wenn PRFRAD1 ≥1,5 ist



Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index		CSP	DC	DMM	L	APMXS	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	PCEDC	Auf-nahmen	Lagerstand-ard
						mm	mm	mm	mm	mm	mm	mm	mm				
	SIRA	10044920	1	T	–	10,0	10,0	5,4	1,62	72,0	1,5	250,0	2,0	65,0	4	Cylindrical	■
	SIRA	10044921	1	T	–	12,0	12,0	10,5	5,33	89,0	3,0	250,0	6,0	32,5	4	Cylindrical	■
	SIRA	10044922	1	T	–	16,0	16,0	14,6	8,95	108,0	4,0	500,0	8,0	27,5	4	Cylindrical	■
	SIRA	10044923	2	T	–	4,0	6,0	7,6	4,7	62,0	0,5	250,0	3,0	17,5	4	Cylindrical	■
	SIRA	10044924	2	T	–	6,0	6,0	9,6	6,71	62,0	1,0	250,0	3,0	17,5	4	Cylindrical	■
	SIRA	10044925	2	T	–	8,0	8,0	10,7	7,42	68,0	1,5	250,0	4,0	20,0	4	Cylindrical	■
	SIRA	10044926	2	T	–	10,0	10,0	12,7	9,04	75,0	2,0	250,0	5,0	20,0	4	Cylindrical	■
	SIRA	10044927	2	T	–	12,0	12,0	13,7	9,71	89,0	3,0	250,0	6,0	20,0	4	Cylindrical	■
	SIRA	10044928	2	T	–	16,0	16,0	17,6	12,94	108,0	4,0	500,0	8,0	20,0	4	Cylindrical	■
	SIRA	10044929	2	T	–	16,0	16,0	31,3	28,27	108,0	2,0	1000,0	5,0	12,5	4	Cylindrical	■
	SIRA	10044930	2	T	–	16,0	16,0	24,1	21,02	108,0	4,0	1000,0	5,0	12,5	4	Cylindrical	■
	SIRA	10044931	4	T	■	16,0	16,0	24,1	21,02	150,0	4,0	1000,0	5,0	12,5	4	Cylindrical	■

Schnittdaten – JH744 Kopierfräsen/ Feinbearbeitung

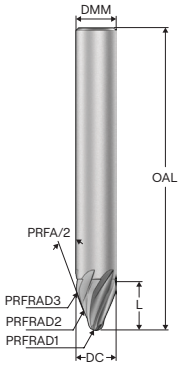
SMG		a_e/DC	f_z						v_c
			4	6	8	10	12	16	
P8	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH746

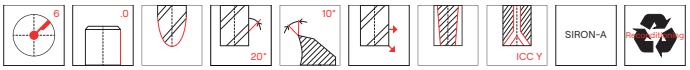
Hochgeschwindigkeitsfräsen – ISO– M und ISO– S – Konische Form – 6 Schneiden – Zylindrisch





T

—Toleranzen:
—DMM= h5
—PRFRAD1= ±0.03mm
—Formtoleranz PRFRAD2= 0.02mm
—Nachschleifen möglich



Bezeichnung	Beschich-tung	Produkt-nummer	Läng-en-index		CSP	DC	DMM	L	APMXS	OAL	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	FCEDC	PCEDC	Auf-nahmen	Lagerstand-ard
						mm	mm	mm	mm	mm	mm	mm	mm					
JH746100T2R2R250.0Z6	SIRA	10044958	2	T	–	10,0	10,0	12,7	9,04	75,0	2,0	250,0	5,0	20,0	6	6	Cylindrical	■
JH746120T2R3R250.0Z6	SIRA	10044959	2	T	–	12,0	12,0	13,7	9,71	89,0	3,0	250,0	6,0	20,0	6	6	Cylindrical	■
JH746160T2R4R500.0Z6	SIRA	10044960	2	T	–	16,0	16,0	17,6	12,94	108,0	4,0	500,0	8,0	20,0	6	6	Cylindrical	■
	SIRA	10044961	4	T	■	16,0	16,0	17,6	12,94	150,0	4,0	500,0	8,0	20,0	6	6	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH746 Kopierfräsen/ Feinbearbeitung

SMG		a_e/DC	f_z			v_c
			10	12	16	
P8	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JH746 Kopierfräsen/Schruppen

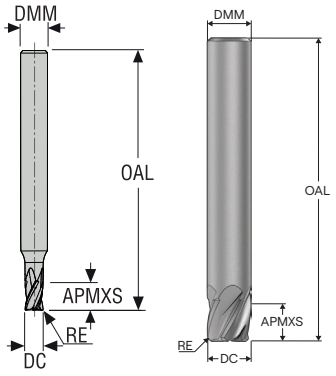
SMG		a_e/DC	f_z			v_c
			10	12	16	
P12	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	120 (95 - 135) *400 (310 - 445)*
M1	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	145 (120 - 150) *475 (400 - 490)*
M2	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	145 (120 - 150) *475 (400 - 490)*
S12	E	0.025 *0,025*	0.03 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	95 (80 - 100) *310 (270 - 320)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH770

Hochgeschwindigkeitsfräsen – CoCr/Titan – Eckfräser – 3-4-5-6 Schneiden – Zylindrisch – Eckenradius





—Toleranzen:
—DMM=h5
—DC=e7
—RE= ±0,02 mm
—Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JH770030F2R020.0Z3-HXT	03320783	2	F	3,0	6,0	5,0	58,0	0,2	3	Cylindrical	■
JH770040F2R020.0Z4-HXT	03320784	2	F	4,0	6,0	6,0	58,0	0,2	4	Cylindrical	■
JH770050F2R020.0Z4-HXT	10000170	2	F	5,0	6,0	7,0	58,0	0,2	4	Cylindrical	■
JH770060D2R050.0Z4-HXT	03127351	2	D	6,0	6,0	8,0	50,0	0,5	4	Cylindrical	■
JH770080D2R050.0Z4-HXT	03127352	2	D	8,0	8,0	10,0	58,0	0,5	4	Cylindrical	■
JH770080D2R050.0Z5-HXT	03127354	2	D	8,0	8,0	10,0	58,0	0,5	5	Cylindrical	■
JH770080D2R100.0Z5-HXT	03127355	2	D	8,0	8,0	10,0	58,0	1,0	5	Cylindrical	■
JH770080D2R100.0Z6-HXT	03127356	2	D	8,0	8,0	10,0	58,0	1,0	6	Cylindrical	■
JH770100D2R100.0Z5-HXT	03127357	2	D	10,0	10,0	12,0	66,0	1,0	5	Cylindrical	■
JH770100D2R100.0Z6-HXT	03127358	2	D	10,0	10,0	12,0	66,0	1,0	6	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH770 Eckfräsen/Schruppen PCEDC 3 und 4

SMG		a_e/DC	a_p/DC	f_z				v_c
				3	4	6	8	
S2	E	0.750 *0,750*	0.12 *0,12*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	50 (42 — 62) *165 (140 — 200)*
S11	E	0.250 *0,250*	0.32 *0,32*	0.0075 *0,00030*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	65 (53 — 91) *215 (180 — 290)*
S12	E	0.250 *0,250*	0.32 *0,32*	0.0075 *0,00030*	0.010 *0,00040*	0.015 *0,00060*	0.020 *0,00080*	50 (41 — 70) *165 (140 — 220)*

Schnittdaten – JH770 Eckfräsen/Schruppen PCEDC 6

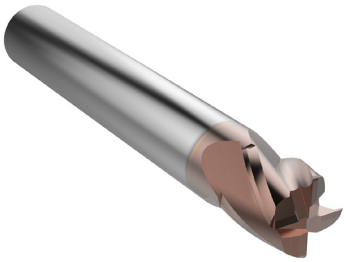
SMG		a_e/DC	a_p/DC	f_z		v_c
				8	10	
S2	E	0.750 *0,750*	0.12 *0,12*	0.050 *0,0020*	0.060 *0,0024*	55 (43 — 64) *180 (150 — 200)*
S11	E	0.250 *0,250*	0.32 *0,32*	0.022 *0,00085*	0.026 *0,0010*	65 (54 — 93) *215 (180 — 300)*
S12	E	0.250 *0,250*	0.32 *0,32*	0.022 *0,00085*	0.026 *0,0010*	50 (42 — 71) *165 (140 — 230)*

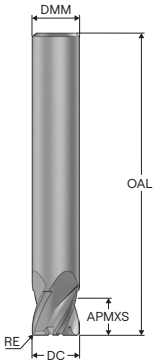
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

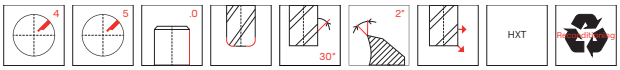
JH740

Hochgeschwindigkeitsfräsen – CoCr/Titan – Boden schlichten – 4-5 Schneiden – Zylindrisch – Eckenradius





D



- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JH740060D2R025.0Z4-HXT	03127359	2	D	6,0	6,0	6,0	50,0	0,25	4	Cylindrical	■
JH740060D2R050.0Z4-HXT	03127360	2	D	6,0	6,0	6,0	50,0	0,5	4	Cylindrical	■
JH740080D2R025.0Z4-HXT	03127361	2	D	8,0	8,0	8,0	58,0	0,25	4	Cylindrical	■
JH740080D2R050.0Z4-HXT	03127362	2	D	8,0	8,0	8,0	58,0	0,5	4	Cylindrical	■
JH740100D2R025.0Z5-HXT	03127363	2	D	10,0	10,0	10,0	66,0	0,25	5	Cylindrical	■
JH740100D2R050.0Z5-HXT	03127364	2	D	10,0	10,0	10,0	66,0	0,5	5	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH740 Planfräsen/Schlichten PCEDC 4

SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
S2	E	0.500 *0,500*	0.0060 *0,0060*	0.044 *0,0017*	0.060 *0,0024*	50 (40 — 59) *165 (140 — 190)*
S11	E	0.500 *0,500*	0.0060 *0,0060*	0.044 *0,0017*	0.060 *0,0024*	65 (52 — 77) *215 (180 — 250)*
S12	E	0.500 *0,500*	0.0060 *0,0060*	0.044 *0,0017*	0.060 *0,0024*	50 (40 — 59) *165 (140 — 190)*

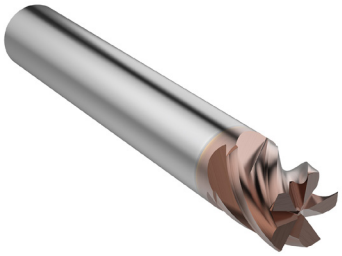
Schnittdaten – JH740 Planfräsen/Schlichten PCEDC 5

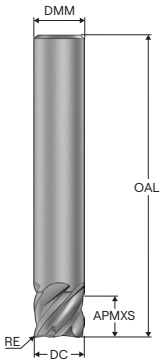
SMG		a_e/DC	a_p/DC	f_z	v_c
				10	
S2	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	48 (39 — 58) *155 (130 — 190)*
S11	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	65 (51 — 75) *215 (170 — 240)*
S12	E	0.500 *0,500*	0.0065 *0,0065*	0.046 *0,0018*	48 (39 — 58) *155 (130 — 190)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH710

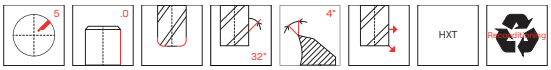
Hochgeschwindigkeitsfräsen – CoCr/Titan – Eckfräser – 5 Schneiden – Zylindrisch – Eckenradius





D

—Toleranzen:
—DMM=h5
—DC=e7
—RE= ±0,02 mm
—Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JH710060D2R025.0Z5-HXT	03127365	2	D	6,0	6,0	6,0	57,0	0,25	5	Cylindrical	■
JH710060D2R050.0Z5-HXT	03127366	2	D	6,0	6,0	6,0	57,0	0,5	5	Cylindrical	■
JH710080D2R025.0Z5-HXT	03127367	2	D	8,0	8,0	8,0	63,0	0,25	5	Cylindrical	■
JH710080D2R050.0Z5-HXT	03127368	2	D	8,0	8,0	8,0	63,0	0,5	5	Cylindrical	■
JH710080D2R100.0Z5-HXT	03127369	2	D	8,0	8,0	8,0	63,0	1,0	5	Cylindrical	■

■ **Lagerstandard.**

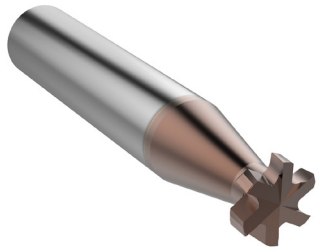
Schnittdaten – JH710 Eckfräsen/Schlichten

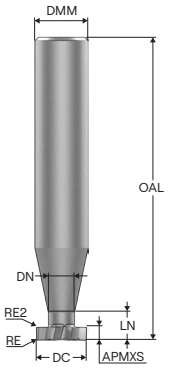
SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
S1	E	0.00800 *0,00800*	0.65 *0,65*	0.034 *0,0013*	0.044 *0,0017*	100 (79 — 110) *330 (260 — 360)*
S2	E	0.00800 *0,00800*	0.65 *0,65*	0.034 *0,0013*	0.044 *0,0017*	100 (79 — 110) *330 (260 — 360)*
S3	E	0.00800 *0,00800*	0.65 *0,65*	0.034 *0,0013*	0.044 *0,0017*	100 (79 — 110) *330 (260 — 360)*
S11	E	0.00800 *0,00800*	0.65 *0,65*	0.036 *0,0014*	0.046 *0,0018*	180 (160 — 200) *590 (530 — 650)*
S12	E	0.00800 *0,00800*	0.65 *0,65*	0.036 *0,0014*	0.046 *0,0018*	135 (120 — 150) *445 (400 — 490)*
S13	E	0.00800 *0,00800*	0.65 *0,65*	0.032 *0,0013*	0.040 *0,0016*	105 (92 — 120) *345 (310 — 390)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH790

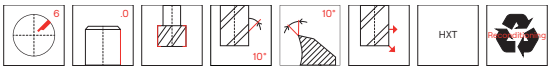
Hochgeschwindigkeitsfräsen – CoCr/Titan – T-Fräser – 6 Schneiden – Zylindrisch





G

—Toleranzen:
—DMM=h5
—DC= ±0,02 mm
—RE= ±0,02 mm
—Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	RE2	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm	mm				
JH790095G2R025.0Z6-HXT	03127370	2	G	9,5	10,0	2,0	66,0	5,0	5,0	0,25	0,25	0,94	6	Cylindrical	■
JH790095G2R050.0Z6-HXT	03127371	2	G	9,5	10,0	2,0	66,0	5,0	5,0	0,5	0,5	0,96	6	Cylindrical	■
JH790095G3R025.0Z6-HXT	03127372	3	G	9,5	10,0	2,54	66,0	5,0	5,0	0,25	0,25	0,94	6	Cylindrical	■
JH790095G3R050.0Z6-HXT	03127373	3	G	9,5	10,0	2,54	66,0	5,0	5,0	0,5	0,5	0,96	6	Cylindrical	■

■ **Lagerstandard.**

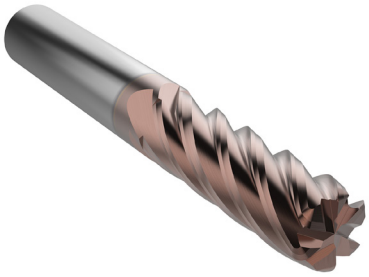
Schnittdaten – JH790 (T) Eckfräsen/Schruppen

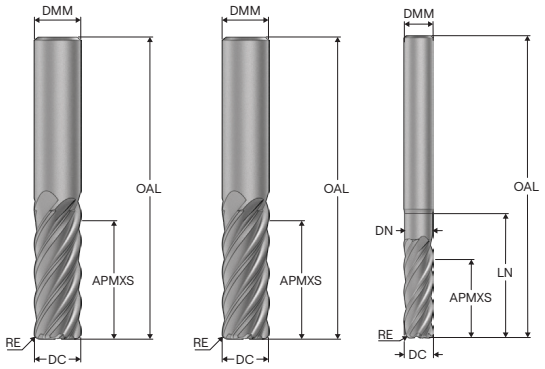
SMG		a_e/DC	a_p/DC	f_z	v_c
				9.5	
S2	E	0.189 *0,189*	0.19 *0,19*	0.030 *0,0012*	39 (31 — 50) *130 (110 — 160)*
S11	E	0.189 *0,189*	0.19 *0,19*	0.022 *0,00085*	85 (66 — 100) *280 (220 — 320)*
S12	E	0.189 *0,189*	0.19 *0,19*	0.022 *0,00085*	65 (51 — 80) *215 (170 — 260)*

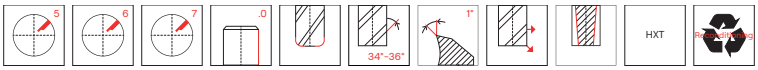
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH730

Hochgeschwindigkeitsfräsen – CoCr/Titan – Eckfräser – 5-6-7 Schneiden – Zylindrisch – Eckenradius







—Toleranzen:
—DMM=h5
—DC=e7
—RE= ±0,02 mm
—Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JH730060E2R050.0Z5-HXT	10217826	2	E	6,0	6,0	19,0	65,0	25,0	5,7	0,5	5	Cylindrical	■
JH730060E2R100.0Z5-HXT	10217827	2	E	6,0	6,0	19,0	65,0	25,0	5,7	1,0	5	Cylindrical	■
JH730060E2R150.0Z5-HXT	10217828	2	E	6,0	6,0	19,0	65,0	25,0	5,7	1,5	5	Cylindrical	■
JH730075F2R050.0Z6-HXT	10217829	2	F	7,5	8,0	24,0	63,0	–	–	0,5	6	Cylindrical	■
JH730075F2R100.0Z6-HXT	10217830	2	F	7,5	8,0	24,0	63,0	–	–	1,0	6	Cylindrical	■
JH730075F2R150.0Z6-HXT	10217831	2	F	7,5	8,0	24,0	63,0	–	–	1,5	6	Cylindrical	■
JH730080D2R050.0Z6-HXT	03127375	2	D	8,0	8,0	25,0	63,0	–	–	0,5	6	Cylindrical	■
JH730080D2R100.0Z6-HXT	03127377	2	D	8,0	8,0	25,0	63,0	–	–	1,0	6	Cylindrical	■
JH730080D2R150.0Z6-HXT	03127378	2	D	8,0	8,0	25,0	63,0	–	–	1,5	6	Cylindrical	■
JH730080D2R200.0Z6-HXT	03127379	2	D	8,0	8,0	25,0	63,0	–	–	2,0	6	Cylindrical	■
JH730100D2R100.0Z7-HXT	03127380	2	D	10,0	10,0	31,0	72,0	–	–	1,0	7	Cylindrical	■
JH730100D2R250.0Z7-HXT	03127381	2	D	10,0	10,0	31,0	72,0	–	–	2,5	7	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH730 Eckfräsen/Schlichten

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	7.5	8	10	
S2	E	0,065 *0.065*	1,3 *1.3*	0,015 *0.00060*	0,019 *0.00075*	0,020 *0.00080*	0,025 *0.0010*	80 (63 — 94) *260 (210 — 300)*
S11	E	0,065 *0.065*	1,3 *1.3*	0,012 *0.00048*	0,015 *0.00060*	0,017 *0.00065*	0,020 *0.00080*	135 (110 — 160) *445 (370 — 520)*
S12	E	0,065 *0.065*	1,3 *1.3*	0,012 *0.00048*	0,015 *0.00060*	0,017 *0.00065*	0,020 *0.00080*	105 (84 — 120) *345 (280 — 390)*

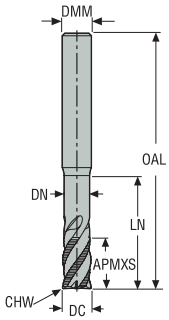
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JHP994

Hochleistungsfräser – CoCr/Titan – Eckfräser – 4 Schneiden – Zylindrisch – Fase





E

—Toleranzen:
—DMM=h5
—DC=-0,02/-0,1 mm
—CHW=0/-0,1 mm
—Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JHP994060E3C.0Z4-HXT	03127382	3	E	■	6,0	6,0	14,0	63,0	24,0	5,6	0,2	4	Cylindrical	■
JHP994080E3C.0Z4-HXT	03127383	3	E	■	8,0	8,0	18,0	69,0	32,0	7,4	0,2	4	Cylindrical	■
JHP994100E3C.0Z4-HXT	03127384	3	E	■	10,0	10,0	22,0	88,0	40,0	9,4	0,2	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JHP994 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z			v_c
				6	8	10	
S2	E	0.0480 *0,0480*	2.0 *2,0*	0.025 *0,0010*	0.032 *0,0013*	0.042 *0,0017*	55 (40 — 69) *180 (140 — 220)*
S11	E	0.450 *0,450*	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	50 (39 — 77) *165 (130 — 250)*
S12	E	0.450 *0,450*	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	40 (30 — 59) *130 (99 — 190)*

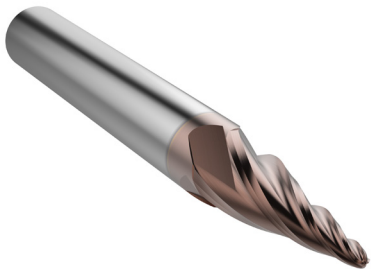
Schnittdaten – JHP994 Nutfräsen

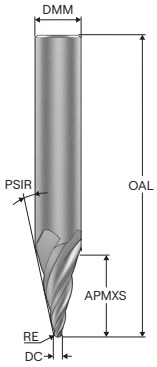
SMG		a_p/DC	f_z			v_c
			6	8	10	
S2	E	2.0 *2,0*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	33 (24 — 41) *110 (79 — 130)*
S11	E	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	42 (32 — 63) *140 (110 — 200)*
S12	E	0.60 *0,60*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	33 (25 — 48) *110 (83 — 150)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH780

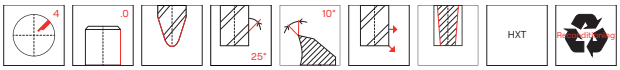
Hochgeschwindigkeitsfräsen – CoCr/Titan – Konischer Kugelkopf – 4 Schneiden – Zylindrisch





N

—Toleranzen:
—DMM=h5
—DC= ±0,04 mm
—RE= ±0,01 mm
—Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DCX	DC	DMM	APMXS	OAL	RE	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm				
JH780018N2R100.0Z4-HXT	03127386	2	N	8,0	1,827	8,0	23,5	63,0	1,0	5,1838	4	Cylindrical	■
JH780028N2R150.0Z4-HXT	03127387	2	N	8,0	2,803	8,0	23,5	63,0	1,5	3,8915	4	Cylindrical	■
JH780038N2R200.0Z4-HXT	03127388	2	N	8,0	3,823	8,0	23,5	63,0	2,0	2,5972	4	Cylindrical	■
JH780049N2R250.0Z4-HXT	03127389	2	N	8,0	4,888	8,0	23,5	63,0	2,5	1,3003	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH780 Eckfräsen

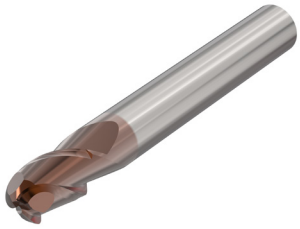
SMG		a_e/DC	a_p/DC	f_z				v_c
				1.8	2.8	3.8	4.9	
S2	E	0.0510 *0,0510*	4.2 *4,2*	0.0080 *0,00032*	0.012 *0,00048*	0.017 *0,00065*	0.022 *0,00085*	70 (54 — 86) *230 (180 — 280)*
S12	E	0.0510 *0,0510*	4.2 *4,2*	0.0060 *0,00024*	0.0090 *0,00036*	0.013 *0,00050*	0.016 *0,00065*	95 (76 — 110) *310 (250 — 360)*

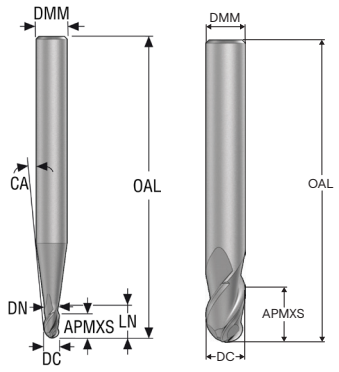
Schnittdaten, siehe Seite 699 - 707

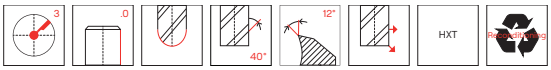
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JHB720

Hochgeschwindigkeitsfräsen – Titan – Kugelkopf – 3 Schneiden – Zylindrisch







—Toleranzen:
—DMM=h5
—DC=-0,02/-0,04 mm
—RE= ±0,01 mm
—Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm				
JHB720020G2B.0Z3	HXT	10072323	2	G	2,0	6,0	3,0	60,0	6,0	1,9	1,0	7,0	3	Cylindrical	■
JHB720030G2B.0Z3	HXT	10072324	2	G	3,0	6,0	4,5	60,0	6,5	2,8	1,5	5,0	3	Cylindrical	■
JHB720035G2B.0Z3	HXT	10072325	2	G	3,5	6,0	5,0	65,0	7,0	3,2	1,75	3,5	3	Cylindrical	■
JHB720040G2B.0Z3	HXT	10072326	2	G	4,0	6,0	6,0	65,0	8,0	3,7	2,0	3,0	3	Cylindrical	■
JHB720060D2B.0Z3	HXT	10072327	2	D	6,0	6,0	9,0	75,0	–	–	3,0	–	3	Cylindrical	■
JHB720080D2B.0Z3	HXT	10072328	2	D	8,0	8,0	12,0	75,0	–	–	4,0	–	3	Cylindrical	■
JHB720100D2B.0Z3	HXT	10072329	2	D	10,0	10,0	15,0	80,0	–	–	5,0	–	3	Cylindrical	■
JHB720120D2B.0Z3	HXT	10072330	2	D	12,0	12,0	18,0	90,0	–	–	6,0	–	3	Cylindrical	■
JHB720160D2B.0Z3	HXT	10072331	2	D	16,0	16,0	24,0	100,0	–	–	8,0	–	3	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JHB720 Eckfräsen

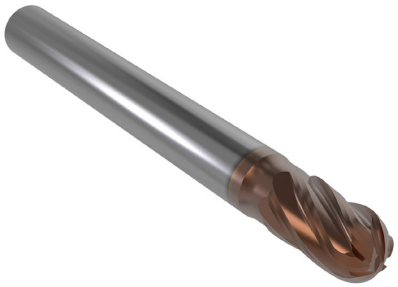
SMG		a_e/DC	a_p/DC	f_z									v_c
				2	3	3.5	4	6	8	10	12	16	
M1	E	0.200 *0,200*	1.2 *1,2*	0.0080 *0,00032*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	85 (62 — 110) *280 (210 — 360)*
M2	E	0.200 *0,200*	1.2 *1,2*	0.0080 *0,00032*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	70 (51 — 90) *230 (170 — 290)*
M3	E	0.200 *0,200*	1.2 *1,2*	0.0080 *0,00032*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	65 (46 — 84) *215 (160 — 270)*
M4	E	0.200 *0,200*	1.2 *1,2*	0.0070 *0,00028*	0.011 *0,00044*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	50 (35 — 65) *165 (120 — 210)*
M5	E	0.200 *0,200*	1.2 *1,2*	0.0070 *0,00028*	0.011 *0,00044*	0.012 *0,00048*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	42 (29 — 54) *140 (96 — 170)*
N1	E/M/A	0.400 *0,400*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	600 (500 — 690) *1975 (1700 — 2200)*
N2	E/M/A	0.400 *0,400*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.028 *0,0011*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	500 (400 — 600) *1650 (1400 — 1900)*
N3	E/M/A	0.400 *0,400*	1.2 *1,2*	0.016 *0,00065*	0.024 *0,00095*	0.028 *0,0011*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	335 (270 — 400) *1100 (890 — 1300)*
N11	E/M/A	0.300 *0,300*	1.2 *1,2*	0.012 *0,00048*	0.018 *0,00070*	0.022 *0,00085*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	300 (260 — 340) *980 (860 — 1100)*
S1	E	0.100 *0,100*	1.2 *1,2*	0.0065 *0,00026*	0.0095 *0,00038*	0.011 *0,00044*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	43 (29 — 57) *140 (96 — 180)*
S2	E	0.100 *0,100*	1.2 *1,2*	0.0065 *0,00026*	0.0095 *0,00038*	0.011 *0,00044*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	0.048 *0,0019*	35 (24 — 46) *115 (79 — 150)*
S3	E	0.100 *0,100*	1.2 *1,2*	0.0060 *0,00024*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	30 (21 — 39) *100 (69 — 120)*
S11	E	0.300 *0,300*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	90 (79 — 100) *295 (260 — 320)*
S12	E	0.300 *0,300*	1.2 *1,2*	0.010 *0,00040*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	70 (61 — 80) *230 (210 — 260)*
S13	E	0.300 *0,300*	1.2 *1,2*	0.0085 *0,00034*	0.013 *0,00050*	0.015 *0,00060*	0.017 *0,00065*	0.026 *0,0010*	0.034 *0,0013*	0.044 *0,0017*	0.050 *0,0020*	0.065 *0,0026*	55 (48 — 63) *180 (160 — 200)*
TS1	A	0.400 *0,400*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	500 (400 — 600) *1650 (1400 — 1900)*
TP1	M	0.400 *0,400*	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	500 (400 — 600) *1650 (1400 — 1900)*

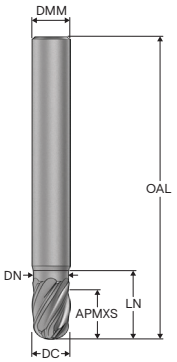
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH721

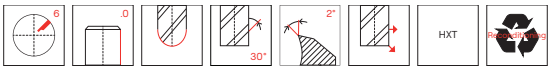
Hochgeschwindigkeitsfräsen – CoCr/Titan – Kugelkopf – 6 Schneiden – Zylindrisch





E

—Toleranzen:
—DMM=h5
—DC=e7
—RE= ±0,02 mm
—Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JH721060E2B.0Z6-HXT	03127390	2	E	6,0	6,0	10,0	57,0	12,0	5,6	2,987	6	Cylindrical	■
JH721080E2B.0Z6-HXT	03127391	2	E	8,0	8,0	13,0	58,0	16,0	7,4	3,98375	6	Cylindrical	■

■ **Lagerstandard.**

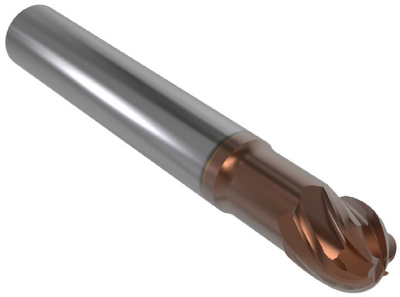
Schnittdaten – JH721 Kopierfräsen/ Feinbearbeitung

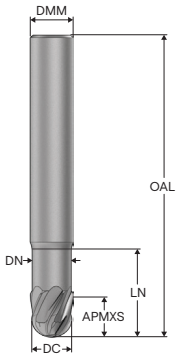
SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
S2	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	120 (110 — 140) *395 (370 — 450)*
S11	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	210 (140 — 230) *690 (460 — 750)*
S12	E	0.0424 *0,0424*	0.040 *0,040*	0.032 *0,0013*	0.042 *0,0017*	160 (110 — 180) *520 (370 — 590)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH722

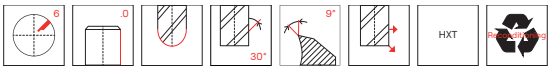
Hochgeschwindigkeitsfräsen – CoCr/Titan – Kugelkopf – 6 Schneiden – Zylindrisch





E

—Toleranzen:
—DMM=h5
—DC=e7
—RE= ±0,01 mm
—Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
JH722100E2B.0Z6-HXT	03127392	2	E	10,0	10,0	10,0	72,0	20,0	9,4	4,98375	6	Cylindrical	■

■ **Lagerstandard.**

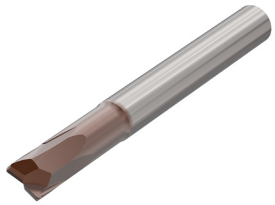
Schnittdaten – JH722 Kopierfräsen/ Feinbearbeitung

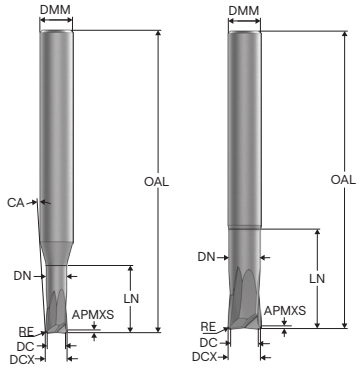
SMG		a_e/DC	a_p/DC	f_z	v_c
				10	
S2	E	0.0500 *0,0500*	0.15 *0,15*	0.065 *0,0026*	125 (110 — 150) *410 (370 — 490)*
S11	E	0.0500 *0,0500*	0.15 *0,15*	0.048 *0,0019*	210 (190 — 230) *690 (630 — 750)*
S12	E	0.0500 *0,0500*	0.15 *0,15*	0.048 *0,0019*	160 (150 — 180) *520 (500 — 590)*

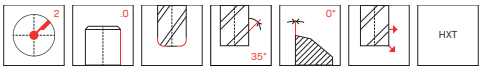
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

SHF712

Hochvorschubfräser – ISO– S – 2 Schneiden – Zylindrisch – Eckenradius







—Toleranzen:
—Rundlaufabweichung = <0,005 mm
—DMM = h5
—DC G- Form = 0/-0,01 mm
—DC E- Form = 0,005/-0,015 mm
—RE = ±0,005 mm

Bezeichnung	Beschich-tung	Produkt-nummer	Läng-en-index		DCX	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm	mm					
SHF712040G2R050.0Z2	HXT	10106493	2	G	4,0	3,0	6,0	0,5	55,0	12,0	3,8	0,5	3,9	1,5	2	Cylindrical	■
SHF712060E2R050.0Z2	HXT	10106494	2	E	6,0	5,0	6,0	0,5	55,0	18,0	5,7	0,5	–	1,5	2	Cylindrical	■
SHF712030G3R050.0Z2	HXT	10106495	3	G	3,0	2,0	6,0	0,5	55,0	12,0	2,85	0,5	5,65	1,5	2	Cylindrical	■
SHF712040G3R050.0Z2	HXT	10106496	3	G	4,0	3,0	6,0	0,5	55,0	16,0	3,8	0,5	3,07	1,5	2	Cylindrical	■
SHF712060E3R050.0Z2	HXT	10106497	3	E	6,0	5,0	6,0	0,5	55,0	25,0	5,7	0,5	–	1,5	2	Cylindrical	■
SHF712030G4R050.0Z2	HXT	10106498	4	G	3,0	2,0	6,0	0,5	55,0	16,0	2,85	0,5	4,47	1,5	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – SHF712 Eckfräsen

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				3	4	6	
S2	E	0,30 *0.30*	0,050 *0.050*	0,055 *0.0022*	0,075 *0.0030*	0,11 *0.0044*	65 (51 — 76) *215 (170 — 240)*
S12	E	0,30 *0.30*	0,050 *0.050*	0,085 *0.0034*	0,12 *0.0048*	0,17 *0.0065*	170 (150 — 190) *560 (500 — 620)*

Schnittdaten – SHF712 Nutfräsen

SMG		a_p/DCX	f_z			v_c
			3	4	6	
S2	E	0,050 *0.050*	0,046 *0.0018*	0,060 *0.0024*	0,090 *0.0036*	50 (41 — 60) *165 (140 — 190)*
S12	E	0,050 *0.050*	0,046 *0.0018*	0,060 *0.0024*	0,090 *0.0036*	145 (130 — 160) *475 (430 — 520)*

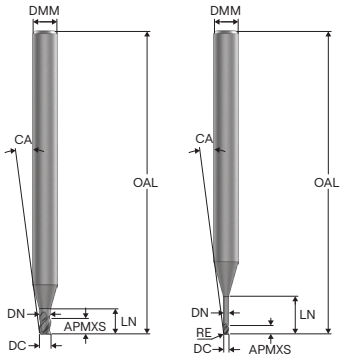
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

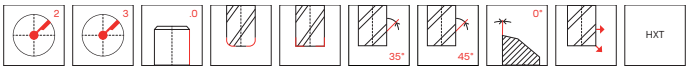
SME714/716

Mini – ISO– S – Eckfräser – 2-3 Schneiden – Zylindrisch – scharf oder Eckenradius





—Toleranzen:
—Rundlaufabweichung = <0,005 mm
—DMM = h5
—DC = 0/-0,01 mm
—RE = ±0,005 mm



Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm				
SME714020G1S.0Z3	HXT	10107349	1	G	2,0	4,0	2,0	50,0	4,0	1,9	–	6,86	3	Cylindrical	■
SME716020G1S.0Z3	HXT	10107360	1	G	2,0	6,0	2,0	50,0	4,0	1,9	–	9,42	3	Cylindrical	■
SME714020G3R010.0Z3	HXT	10107350	3	G	2,0	4,0	2,5	50,0	8,0	1,9	0,1	4,68	3	Cylindrical	■
SME716020G3R010.0Z3	HXT	10107361	3	G	2,0	6,0	2,5	50,0	8,0	1,9	0,1	7,14	3	Cylindrical	■
SME716010G4R010.0Z3	HXT	10107362	4	G	1,0	6,0	1,2	50,0	6,0	0,95	0,1	9,03	3	Cylindrical	■
SME716015G4R010.0Z3	HXT	10107363	4	G	1,5	6,0	1,8	50,0	10,0	1,4	0,1	6,79	3	Cylindrical	■
SME714010G4R010.0Z3	HXT	10107351	4	G	2,0	4,0	1,2	50,0	6,0	0,95	0,1	7,13	3	Cylindrical	■
SME714015G4R010.0Z3	HXT	10107352	4	G	2,0	4,0	1,8	50,0	10,0	1,4	0,1	4,72	3	Cylindrical	■
SME714020G4R010.0Z3	HXT	10107353	4	G	2,0	4,0	2,5	50,0	12,0	1,9	0,1	3,53	3	Cylindrical	■
SME716020G4R010.0Z3	HXT	10107364	4	G	2,0	6,0	2,5	50,0	12,0	1,9	0,1	5,72	3	Cylindrical	■
SME714015G5R010.0Z3	HXT	10107354	5	G	1,5	4,0	1,8	50,0	12,0	1,4	0,1	3,38	3	Cylindrical	■
SME716015G5R010.0Z3	HXT	10107365	5	G	1,5	6,0	1,8	50,0	12,0	1,4	0,1	6,15	3	Cylindrical	■
SME714020G5R010.0Z3	HXT	10107355	5	G	2,0	4,0	2,5	50,0	16,0	1,9	0,1	2,83	3	Cylindrical	■
SME716020G5R010.0Z3	HXT	10107366	5	G	2,0	6,0	2,5	50,0	16,0	1,9	0,1	4,77	3	Cylindrical	■
SME714005G6R005.0Z2	HXT	10107356	6	G	0,5	4,0	0,6	50,0	5,0	0,45	0,05	8,31	2	Cylindrical	■
SME716005G6R005.0Z2	HXT	10107367	6	G	0,5	6,0	0,6	50,0	5,0	0,45	0,05	9,93	2	Cylindrical	■
SME714010G6R010.0Z3	HXT	10107357	6	G	1,0	4,0	1,2	50,0	12,0	0,95	0,1	4,77	3	Cylindrical	■
SME716010G6R010.0Z3	HXT	10107368	6	G	1,0	6,0	1,6	50,0	12,0	0,95	0,1	6,56	3	Cylindrical	■
SME714015G6R010.0Z3	HXT	10107358	6	G	1,5	4,0	1,8	50,0	16,0	1,4	0,1	3,38	3	Cylindrical	■
SME716015G6R010.0Z3	HXT	10107369	6	G	1,5	6,0	1,8	50,0	16,0	1,4	0,1	5,16	3	Cylindrical	■
SME714010G7R010.0Z3	HXT	10107359	7	G	1,0	4,0	1,2	50,0	16,0	0,95	0,1	3,9	3	Cylindrical	■
SME716010G7R010.0Z3	HXT	10107370	7	G	1,0	6,0	1,2	50,0	16,0	0,95	0,1	5,55	3	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – SME714 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z				v_c
				0.5	1	1.5	2	
S2	E	0,0800 *0.0800*	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	60 (31 — 120) *195 (110 — 390)*
S12	E	0,0800 *0.0800*	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	65 (33 — 130) *215 (110 — 420)*

Schnittdaten – SME714 Nutfräsen

SMG		a_p/DC	f_z				v_c
			0.5	1	1.5	2	
S2	E	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	41 (21 — 82) *135 (69 — 260)*
S12	E	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	45 (23 — 89) *150 (76 — 290)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – SME716 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z				v_c
				0.5	1	1.5	2	
S2	E	0,0800 *0.0800*	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	60 (31 — 120) *195 (110 — 390)*
S12	E	0,0800 *0.0800*	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	65 (33 — 130) *215 (110 — 420)*

Schnittdaten – SME716 Nutfräsen

SMG		a_p/DC	f_z				v_c
			0.5	1	1.5	2	
S2	E	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	41 (21 — 82) *135 (69 — 260)*
S12	E	0,070 *0.070*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	45 (23 — 89) *150 (76 — 290)*

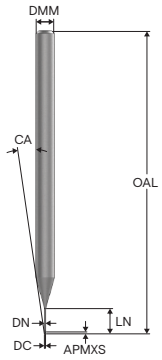
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

SMB713/714/716

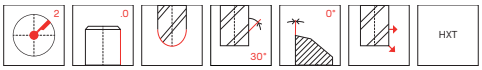
Mini – ISO– S – Kugelkopf – 2 Schneiden – Zylindrisch





G

—Toleranzen:
—Rundlaufabweichung = <0,005 mm
—DMM = h5
—DC = 0/-0,01 mm
—RE = ±0,005 mm



Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm				
SMB714020G2B.0Z2	HXT	10109582	2	G	2,0	4,0	2,0	50,0	6,0	1,9	1,0	6,13	2	Cylindrical	■
SMB716020G2B.0Z2	HXT	10109596	2	G	2,0	6,0	2,0	50,0	6,0	1,9	1,0	8,72	2	Cylindrical	■
SMB714030G2B.0Z2	HXT	10109583	2	G	3,0	4,0	3,0	50,0	9,0	2,85	1,5	2,85	2	Cylindrical	■
SMB716030G2B.0Z2	HXT	10109597	2	G	3,0	6,0	3,0	50,0	9,0	2,85	1,5	6,22	2	Cylindrical	■
SMB714030G3B.0Z2	HXT	10109584	3	G	3,0	4,0	3,0	50,0	12,0	2,85	1,5	2,2	2	Cylindrical	■
SMB716030G3B.0Z2	HXT	10109598	3	G	3,0	6,0	3,0	50,0	12,0	2,85	1,5	5,11	2	Cylindrical	■
SMB714015G4B.0Z2	HXT	10109585	4	G	1,5	4,0	1,5	50,0	9,0	1,4	0,75	5,29	2	Cylindrical	■
SMB716015G4B.0Z2	HXT	10109599	4	G	1,5	6,0	1,5	50,0	9,0	1,4	0,75	7,44	2	Cylindrical	■
SMB714020G4B.0Z2	HXT	10109586	4	G	2,0	4,0	2,0	50,0	10,0	1,9	1,0	4,3	2	Cylindrical	■
SMB716020G4B.0Z2	HXT	10109600	4	G	2,0	6,0	2,0	50,0	10,0	1,9	1,0	6,69	2	Cylindrical	■
SMB714005G5B.0Z2	HXT	10109587	5	G	0,5	4,0	0,5	50,0	4,0	0,45	0,25	9,23	2	Cylindrical	■
SMB716005G5B.0Z2	HXT	10109601	5	G	0,5	6,0	0,5	50,0	4,0	0,45	0,25	10,73	2	Cylindrical	■
SMB714010G5B.0Z2	HXT	10109588	5	G	1,0	4,0	1,0	50,0	10,0	0,95	0,5	5,5	2	Cylindrical	■
SMB716010G5B.0Z2	HXT	10109602	5	G	1,0	6,0	1,0	50,0	10,0	0,95	0,5	7,37	2	Cylindrical	■
SMB714015G5B.0Z2	HXT	10109589	5	G	1,5	4,0	1,5	50,0	12,0	1,4	0,75	4,41	2	Cylindrical	■
SMB716015G5B.0Z2	HXT	10109603	5	G	1,5	6,0	1,5	50,0	12,0	1,4	0,75	6,35	2	Cylindrical	■
SMB714020G5B.0Z2	HXT	10109590	5	G	2,0	4,0	2,0	50,0	16,0	1,9	1,0	2,96	2	Cylindrical	■
SMB716020G5B.0Z2	HXT	10109604	5	G	2,0	6,0	2,0	50,0	16,0	1,9	1,0	4,96	2	Cylindrical	■
SMB713003G6B.0Z2	HXT	10109581	6	G	0,3	3,0	0,3	50,0	4,0	0,28	0,15	8,24	2	Cylindrical	■
SMB714005G6B.0Z2	HXT	10109591	6	G	0,5	4,0	0,5	50,0	6,0	0,45	0,25	7,8	2	Cylindrical	■
SMB716005G6B.0Z2	HXT	10109605	6	G	0,5	6,0	0,5	50,0	6,0	0,45	0,25	9,46	2	Cylindrical	■
SMB714010G6B.0Z2	HXT	10109592	6	G	1,0	4,0	1,0	50,0	12,0	0,95	0,5	4,97	2	Cylindrical	■
SMB716010G6B.0Z2	HXT	10109606	6	G	1,0	6,0	1,0	50,0	12,0	0,95	0,5	6,69	2	Cylindrical	■
SMB714015G6B.0Z2	HXT	10109593	6	G	1,5	4,0	1,5	50,0	16,0	1,4	0,75	3,49	2	Cylindrical	■
SMB716015G6B.0Z2	HXT	10109607	6	G	1,5	6,0	1,5	55,0	16,0	1,4	0,75	5,31	2	Cylindrical	■
SMB714005G7B.0Z2	HXT	10109594	7	G	0,5	4,0	0,5	50,0	9,0	0,45	0,25	6,33	2	Cylindrical	■
SMB716005G7B.0Z2	HXT	10109608	7	G	0,5	6,0	0,5	50,0	9,0	0,45	0,25	8,03	2	Cylindrical	■
SMB714010G7B.0Z2	HXT	10109595	7	G	1,0	4,0	1,0	50,0	16,0	0,95	0,5	3,98	2	Cylindrical	■
SMB716010G7B.0Z2	HXT	10109609	7	G	1,0	6,0	1,0	55,0	16,0	0,95	0,5	5,64	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – SMB713 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z	v_c
				0.3	
S2	E	0,0600 *0.0600*	0,050 *0.050*	0,0020 *0.000080*	47 (26 — 64) *155 (86 — 200)*
S12	E	0,0600 *0.0600*	0,050 *0.050*	0,0020 *0.000080*	47 (26 — 64) *155 (86 — 200)*

Schnittdaten – SMB714 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z					v_c
				0.5	1	1.5	2	3	
S2	E	0,0600 *0.0600*	0,050 *0.050*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	0,020 *0.00080*	60 (33 — 81) *195 (110 — 260)*
S12	E	0,0600 *0.0600*	0,050 *0.050*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	0,020 *0.00080*	60 (33 — 81) *195 (110 — 260)*

Schnittdaten – SMB716 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z					v_c
				0.5	1	1.5	2	3	
S2	E	0,0600 *0.0600*	0,050 *0.050*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	0,020 *0.00080*	60 (33 — 81) *195 (110 — 260)*
S12	E	0,0600 *0.0600*	0,050 *0.050*	0,0036 *0.00014*	0,0070 *0.00028*	0,010 *0.00040*	0,014 *0.00055*	0,020 *0.00080*	60 (33 — 81) *195 (110 — 260)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte



NICHT-EISEN-METALLE

Das vollständige Programm an Hochleistungsvollhartmetallfräsern für hohe Produktivität in Nicht-Eisen-Metallen besteht aus Schaftfräsern und Kugelkopffräsern.

- JS412 und JS413 Schaftfräser mit scharfer Ecke
- JS452, JS453, S4521, S4531, S4651, JHP490, HP4931, S4931, JH40, JH421, JM403, JM404, JM406, JH410 und JH440 mit Eckenradius
- S4321, JH450, JH460, SMB413, SMB414, SMB416, JM413 und JM416 Kugelkopffräser.

Werkzeugauswahl NE-Metall

					 	 
Werkzeugbezeichnung		JS412	JS413	S4521	S4531	S4651
Seite(n)		443	446	449	454	463
Produktfamilie		SOLID²	SOLID²	SOLID²	SOLID²	SOLID²
Fräserausführung						
Aufnahmen	Zylindrisch	■	■	■	■	■
	Weldon	■	■	□	□	□
	Safe-Lock					
Schneidenzahl		2	3	2	3	5
CSP						■
	Metrisch	2-20	2-20	2-20	2-20	6-20
	Zoll					
Verfügbare Längen		2	2,3	2,3	2,3	2,4
Bearbeitung						
						
						
SMG						
N1		●	●	●	●	●
N2		●	●	●	●	
N3			●	●	●	
N11						●
TS1		●	●	●	●	
TP1		●	●	●	●	

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl NE-Metall

							
Werkzeugbezeichnung		HP4931	S4931	JH40	JH421	JH410	JH440
Seite(n)		466	470	474	477	481	483
Produktfamilie		HPM	Solid²	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO
Fräserausführung							
Auf-nahmen	Zylindrisch	■	■	■	■	■	■
	Weldon						
	Safe-Lock						
Schneidenzahl		3	3	2	2-3	1	2
CSP		■	■		■		
	Metrisch			2-20	2-25	2-17	6-8
	Zoll	1/4-1/2	1/4-1/2				
Verfügbare Längen		2,3,4	3,4,5	1,2	2,3	2,3	2
Bearbeitung							
							
							
SMG							
N1		●	●	●	●	●	●
N2		●	●				●
N3		●	●				●
N11				●	●	●	●
TS1				●	●	●	●
TP1					●		●

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl NE-Metall

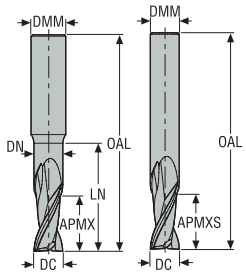
							
Werkzeugbezeichnung		S4321	JH450	JH460	SMB413/414/416	JM403/404/406	JM413/416
Seite(n)		485	488	490	496	494	496
Produktfamilie		SOLID²	HSM/TORNADO	HSM/TORNADO	MINI	MINI	MINI
Fräserausführung							
Aufnahmen	Zylindrisch	■	■	■	■	■	■
	Weldon	□					
	Safe-Lock						
Schneidenzahl		2	2	2	2	1	2
CSP							
	Metrisch	2-20	2-20	3-12	1-3	0,5-2	0,5-2
	Zoll						
Verfügbare Längen		2	2,3	2	2,3,5	1,2,5	2,3,5
Bearbeitung							
							
							
SMG							
N1		●	●	●	●	●	●
N2		●	●		●	●	●
N3		●	●		●	●	●
N11			●	●			●
TS1		●	●	●	●		●
TP1		●	●	●	●		●

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

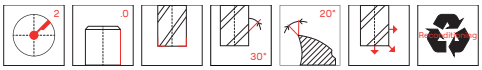
JS412

Allgemeine Anwendung – Aluminium – Eckfräser – 2 Schneiden – Zylindrisch – Scharfe Schneide





—Toleranzen:
—DMM= h5
—DC= e8
—Nachschleifen möglich, wenn DC ≥ Ø6 ist



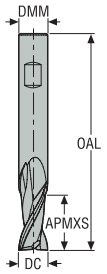
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm			
JS412020G2SZ2.0	02881760	2	G	2,0	6,0	4,0	57,0	7,0	1,9	2	Cylindrical	■
JS412030G2SZ2.0	02881761	2	G	3,0	6,0	6,0	57,0	10,0	2,8	2	Cylindrical	■
JS412040G2SZ2.0	02881762	2	G	4,0	6,0	8,0	57,0	14,0	3,8	2	Cylindrical	■
JS412050G2SZ2.0	02881763	2	G	5,0	6,0	10,0	57,0	17,0	4,7	2	Cylindrical	■
JS412060D2SZ2.0	02881764	2	D	6,0	6,0	12,0	57,0	–	–	2	Cylindrical	■
JS412080D2SZ2.0	02881765	2	D	8,0	8,0	16,0	63,0	–	–	2	Cylindrical	■
JS412100D2SZ2.0	02881766	2	D	10,0	10,0	20,0	75,0	–	–	2	Cylindrical	■
JS412120D2SZ2.0	02881767	2	D	12,0	12,0	24,0	88,0	–	–	2	Cylindrical	■
JS412160D2SZ2.0	02881769	2	D	16,0	16,0	32,0	100,0	–	–	2	Cylindrical	■
JS412200D2SZ2.0	02881770	2	D	20,0	20,0	40,0	124,0	–	–	2	Cylindrical	■

■ **Lagerstandard.**

JS412

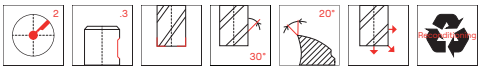
Allgemeine Anwendung – Aluminium – Eckfräser – 2 Schneiden – Weldon – Scharfe Schneide





D

—Toleranzen:
—DMM= h5
—DC= e8
—Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm			
JS412060D2SZ2.3	02881771	2	D	6,0	6,0	12,0	57,0	2	Weldon	■
JS412080D2SZ2.3	02881772	2	D	8,0	8,0	16,0	63,0	2	Weldon	■
JS412100D2SZ2.3	02881773	2	D	10,0	10,0	20,0	75,0	2	Weldon	■
JS412120D2SZ2.3	02881774	2	D	12,0	12,0	24,0	88,0	2	Weldon	■
JS412160D2SZ2.3	02881776	2	D	16,0	16,0	32,0	100,0	2	Weldon	■
JS412200D2SZ2.3	02881777	2	D	20,0	20,0	40,0	124,0	2	Weldon	■

■ **Lagerstandard.**

Schnittdaten – JS412 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	1.5 *1,5*	0.026 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	590 (470 — 700) *1925 (1600 — 2200)*
N2	E/M/A	0.300 *0,300*	1.4 *1,4*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	475 (360 — 590) *1550 (1200 — 1900)*
TS1	A/D	0.400 *0,400*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	600 (480 — 710) *1975 (1600 — 2300)*
TP1	A/D	0.400 *0,400*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	500 (380 — 630) *1650 (1300 — 2000)*

Schnittdaten – JS412 Nutfräsen

SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
N1	E	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400 — 1900)*
N2	E	1.0 *1,0*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	400 (310 — 500) *1300 (1100 — 1600)*
TS1	A	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	500 (410 — 590) *1650 (1400 — 1900)*
TP1	A	1.2 *1,2*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	420 (320 — 520) *1375 (1100 — 1700)*

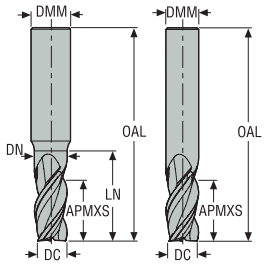
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JS413

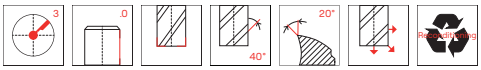
Allgemeine Anwendung – Aluminium – Eckfräser – 3 Schneiden – Zylindrisch – Scharfe Schneide





G D

– Toleranzen:
– DMM= h5
– DC= e8
– Nachschleifen möglich, wenn DC ≥ Ø6 ist



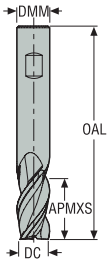
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm			
JS413020G2SZ3.0	02881797	2	G	2,0	6,0	4,0	57,0	7,0	1,9	3	Cylindrical	■
JS413030G2SZ3.0	02881798	2	G	3,0	6,0	6,0	57,0	10,0	2,8	3	Cylindrical	■
JS413040G2SZ3.0	02881799	2	G	4,0	6,0	8,0	57,0	14,0	3,8	3	Cylindrical	■
JS413050G2SZ3.0	02881800	2	G	5,0	6,0	10,0	57,0	17,0	4,7	3	Cylindrical	■
JS413060D2SZ3.0	02881801	2	D	6,0	6,0	12,0	57,0	–	–	3	Cylindrical	■
JS413080D2SZ3.0	02881802	2	D	8,0	8,0	16,0	63,0	–	–	3	Cylindrical	■
JS413100D2SZ3.0	02881803	2	D	10,0	10,0	20,0	72,0	–	–	3	Cylindrical	■
JS413120D2SZ3.0	02881804	2	D	12,0	12,0	24,0	88,0	–	–	3	Cylindrical	■
JS413160D2SZ3.0	02881806	2	D	16,0	16,0	32,0	100,0	–	–	3	Cylindrical	■
JS413200D2SZ3.0	02881807	2	D	20,0	20,0	40,0	124,0	–	–	3	Cylindrical	■
JS413060D3SZ3.0	02881815	3	D	6,0	6,0	24,0	70,0	–	–	3	Cylindrical	■
JS413080D3SZ3.0	02881816	3	D	8,0	8,0	32,0	85,0	–	–	3	Cylindrical	■
JS413100D3SZ3.0	02881817	3	D	10,0	10,0	40,0	100,0	–	–	3	Cylindrical	■
JS413120D3SZ3.0	02881818	3	D	12,0	12,0	50,0	115,0	–	–	3	Cylindrical	■
JS413160D3SZ3.0	02881820	3	D	16,0	16,0	55,0	125,0	–	–	3	Cylindrical	■
JS413200D3SZ3.0	02881821	3	D	20,0	20,0	75,0	150,0	–	–	3	Cylindrical	■

■ **Lagerstandard.**

JS413

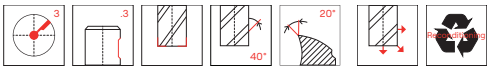
Allgemeine Anwendung – Aluminium – Eckfräser – 3 Schneiden – Weldon – Scharfe Schneide





D

—Toleranzen:
—DMM= h5
—DC= e8
—Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm			
JS413060D2SZ3.3	02881808	2	D	6,0	6,0	12,0	57,0	3	Weldon	■
JS413080D2SZ3.3	02881809	2	D	8,0	8,0	16,0	63,0	3	Weldon	■
JS413100D2SZ3.3	02881810	2	D	10,0	10,0	20,0	72,0	3	Weldon	■
JS413120D2SZ3.3	02881811	2	D	12,0	12,0	24,0	88,0	3	Weldon	■
JS413160D2SZ3.3	02881813	2	D	16,0	16,0	32,0	100,0	3	Weldon	■
JS413200D2SZ3.3	02881814	2	D	20,0	20,0	40,0	124,0	3	Weldon	■
JS413060D3SZ3.3	02881955	3	D	6,0	6,0	24,0	70,0	3	Weldon	□
JS413080D3SZ3.3	02881956	3	D	8,0	8,0	32,0	85,0	3	Weldon	□
JS413100D3SZ3.3	02881957	3	D	10,0	10,0	40,0	100,0	3	Weldon	□
JS413120D3SZ3.3	02881958	3	D	12,0	12,0	50,0	115,0	3	Weldon	□
JS413160D3SZ3.3	02881960	3	D	16,0	16,0	55,0	125,0	3	Weldon	■
JS413200D3SZ3.3	02881961	3	D	20,0	20,0	75,0	150,0	3	Weldon	■

. □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JS413 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	600 (480 — 710) *1975 (1600 — 2300)*
N2	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	470 (360 — 580) *1550 (1200 — 1900)*
N3	E/M/A	0.300 *0,300*	1.5 *1,5*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.18 *0,0070*	0.20 *0,0080*	315 (240 — 390) *1025 (790 — 1200)*
TS1	A/D	0.400 *0,400*	1.5 *1,5*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.17 *0,0065*	0.19 *0,0075*	610 (500 — 730) *2000 (1700 — 2300)*
TP1	A/D	0.400 *0,400*	1.5 *1,5*	0.022 *0,00085*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.17 *0,0065*	0.19 *0,0075*	330 (250 — 410) *1075 (830 — 1300)*

Schnittdaten – JS413 Nutfräsen

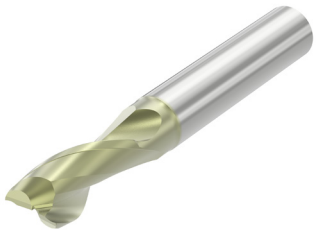
SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
N1	E	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	500 (400 — 600) *1650 (1400 — 1900)*
N2	E	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	400 (300 — 490) *1300 (990 — 1600)*
N3	E	1.0 *1,0*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	265 (200 — 330) *870 (660 — 1000)*
TS1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.19 *0,0075*	500 (400 — 600) *1650 (1400 — 1900)*
TP1	A	1.0 *1,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.19 *0,0075*	270 (210 — 330) *890 (690 — 1000)*

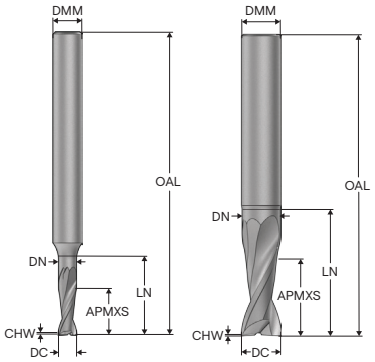
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

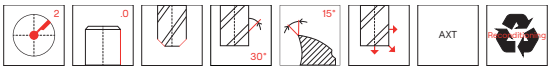
S4521

Hochleistungsfräser – Aluminium – Eckfräser – 2 Schneiden – Zylindrisch – Fase





- Toleranzen:
- DMM=h5
- DC= e7
- CHW= +0,04 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

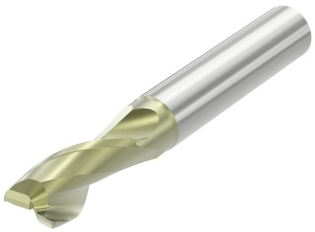


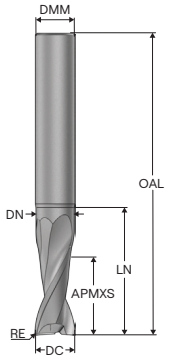
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm	mm	mm			
S4521-020G2C.0Z2	AXT	10228022	2	G	2,0	6,0	4,0	57,0	8,0	1,9	0,1	2	Cylindrical	■
S4521-030G2C.0Z2	AXT	10228023	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,1	2	Cylindrical	■
S4521-040G2C.0Z2	AXT	10228024	2	G	4,0	6,0	8,0	57,0	14,0	3,8	0,1	2	Cylindrical	■
S4521-050G2C.0Z2	AXT	10228025	2	G	5,0	6,0	10,0	57,0	17,0	4,75	0,1	2	Cylindrical	■
S4521-060E2C.0Z2	AXT	10228026	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,1	2	Cylindrical	■
S4521-080E2C.0Z2	AXT	10228029	2	E	8,0	8,0	16,0	63,0	24,0	7,6	0,1	2	Cylindrical	■
S4521-100E2C.0Z2	AXT	10228033	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,1	2	Cylindrical	■
S4521-120E2C.0Z2	AXT	10228037	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,1	2	Cylindrical	■
S4521-140E2C.0Z2	AXT	10228043	2	E	14,0	14,0	28,0	89,0	41,0	13,3	0,1	2	Cylindrical	■
S4521-160E2C.0Z2	AXT	10228044	2	E	16,0	16,0	32,0	100,0	48,0	15,2	0,1	2	Cylindrical	■
S4521-200E2C.0Z2	AXT	10228051	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,1	2	Cylindrical	■

■ **Lagerstandard.**

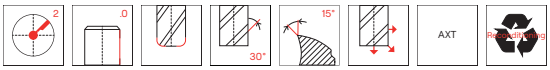
S4521

Hochleistungsfräser – Aluminium – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius





– Toleranzen:
– DMM=h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

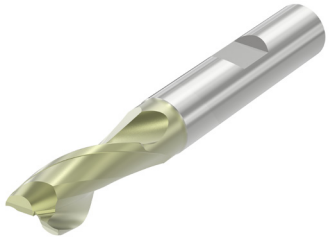


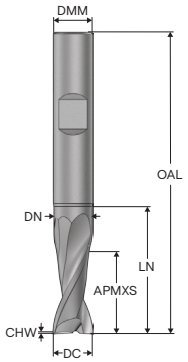
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm	mm	mm			
S4521-060E2R050.0Z2	AXT	10228027	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,5	2	Cylindrical	■
S4521-060E2R100.0Z2	AXT	10228028	2	E	6,0	6,0	12,0	57,0	19,0	5,7	1,0	2	Cylindrical	■
S4521-080E2R050.0Z2	AXT	10228030	2	E	8,0	8,0	16,0	63,0	24,0	7,6	0,5	2	Cylindrical	■
S4521-080E2R100.0Z2	AXT	10228031	2	E	8,0	8,0	16,0	63,0	24,0	7,6	1,0	2	Cylindrical	■
S4521-100E2R050.0Z2	AXT	10228034	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,5	2	Cylindrical	■
S4521-100E2R100.0Z2	AXT	10228035	2	E	10,0	10,0	20,0	72,0	31,0	9,5	1,0	2	Cylindrical	■
S4521-120E2R050.0Z2	AXT	10228038	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,5	2	Cylindrical	■
S4521-120E2R100.0Z2	AXT	10228039	2	E	12,0	12,0	24,0	88,0	37,0	11,4	1,0	2	Cylindrical	■
S4521-120E2R200.0Z2	AXT	10228040	2	E	12,0	12,0	24,0	88,0	37,0	11,4	2,0	2	Cylindrical	■
S4521-120E2R300.0Z2	AXT	10228041	2	E	12,0	12,0	24,0	88,0	37,0	11,4	3,0	2	Cylindrical	■
S4521-160E2R050.0Z2	AXT	10228045	2	E	16,0	16,0	32,0	100,0	48,0	15,2	0,5	2	Cylindrical	■
S4521-160E2R100.0Z2	AXT	10228046	2	E	16,0	16,0	32,0	100,0	48,0	15,2	1,0	2	Cylindrical	■
S4521-160E2R200.0Z2	AXT	10228047	2	E	16,0	16,0	32,0	100,0	48,0	15,2	2,0	2	Cylindrical	■
S4521-160E2R300.0Z2	AXT	10228048	2	E	16,0	16,0	32,0	100,0	48,0	15,2	3,0	2	Cylindrical	■
S4521-160E2R400.0Z2	AXT	10228049	2	E	16,0	16,0	32,0	100,0	48,0	15,2	4,0	2	Cylindrical	■
S4521-200E2R050.0Z2	AXT	10228052	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,5	2	Cylindrical	■
S4521-200E2R100.0Z2	AXT	10228053	2	E	20,0	20,0	40,0	114,0	60,0	19,0	1,0	2	Cylindrical	■
S4521-200E2R200.0Z2	AXT	10228054	2	E	20,0	20,0	40,0	114,0	60,0	19,0	2,0	2	Cylindrical	■
S4521-200E2R300.0Z2	AXT	10228055	2	E	20,0	20,0	40,0	114,0	60,0	19,0	3,0	2	Cylindrical	■
S4521-200E2R400.0Z2	AXT	10228056	2	E	20,0	20,0	40,0	114,0	60,0	19,0	4,0	2	Cylindrical	■
S4521-080E3R020.0Z2	AXT	10228032	3	E	8,0	8,0	12,0	79,0	41,0	7,6	0,2	2	Cylindrical	■
S4521-100E3R050.0Z2	AXT	10228036	3	E	10,0	10,0	15,0	99,0	57,0	9,5	0,5	2	Cylindrical	■
S4521-120E3R050.0Z2	AXT	10228042	3	E	12,0	12,0	18,0	119,0	72,0	11,4	0,5	2	Cylindrical	■
S4521-160E3R050.0Z2	AXT	10228050	3	E	16,0	16,0	24,0	129,0	79,0	15,2	0,5	2	Cylindrical	■
S4521-200E3R050.0Z2	AXT	10228057	3	E	20,0	20,0	30,0	164,0	111,0	19,0	0,5	2	Cylindrical	■

■ **Lagerstandard.**

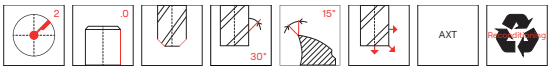
S4521

Hochleistungsfräser – Aluminium – Eckfräser – 2 Schneiden – Weldon – Fase





– Toleranzen:
– DMM=h5
– DC= e7
– CHW= +0,04 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

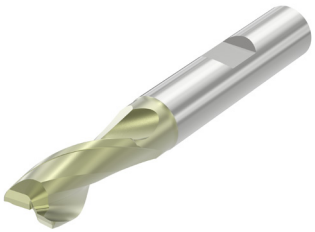


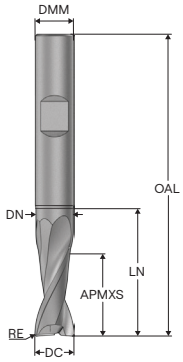
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm	mm	mm			
S4521-060E2C.3Z2	AXT	10286908	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,1	2	Weldon	☐
S4521-080E2C.3Z2	AXT	10286911	2	E	8,0	8,0	16,0	63,0	24,0	7,6	0,1	2	Weldon	☐
S4521-100E2C.3Z2	AXT	10286915	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,1	2	Weldon	☐
S4521-120E2C.3Z2	AXT	10286919	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,1	2	Weldon	☐
S4521-140E2C.3Z2	AXT	10286925	2	E	14,0	14,0	28,0	89,0	41,0	13,3	0,1	2	Weldon	☐
S4521-160E2C.3Z2	AXT	10286926	2	E	16,0	16,0	32,0	100,0	48,0	15,2	0,1	2	Weldon	☐
S4521-200E2C.3Z2	AXT	10286933	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,1	2	Weldon	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

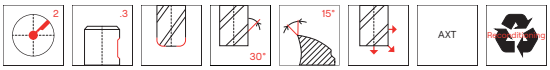
S4521

Hochleistungsfräser – Aluminium – Eckfräser – 2 Schneiden – Weldon – Eckenradius





– Toleranzen:
– DMM=h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist



Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm	mm	mm			
S4521-060E2R050.3Z2	AXT	10286909	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,5	2	Weldon	☐
S4521-060E2R100.3Z2	AXT	10286910	2	E	6,0	6,0	12,0	57,0	19,0	5,7	1,0	2	Weldon	☐
S4521-080E3R020.3Z2	AXT	10286914	2	E	8,0	8,0	12,0	79,0	41,0	7,6	0,2	2	Weldon	☐
S4521-080E2R050.3Z2	AXT	10286912	2	E	8,0	8,0	16,0	63,0	24,0	7,6	0,5	2	Weldon	☐
S4521-080E2R100.3Z2	AXT	10286913	2	E	8,0	8,0	16,0	63,0	24,0	7,6	1,0	2	Weldon	☐
S4521-100E2R050.3Z2	AXT	10286916	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,5	2	Weldon	☐
S4521-100E3R050.3Z2	AXT	10286918	2	E	10,0	10,0	15,0	99,0	57,0	9,5	0,5	2	Weldon	☐
S4521-100E2R100.3Z2	AXT	10286917	2	E	10,0	10,0	20,0	72,0	31,0	9,5	1,0	2	Weldon	☐
S4521-120E2R050.3Z2	AXT	10286920	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,5	2	Weldon	☐
S4521-120E2R100.3Z2	AXT	10286921	2	E	12,0	12,0	24,0	88,0	37,0	11,4	1,0	2	Weldon	☐
S4521-120E2R200.3Z2	AXT	10286922	2	E	12,0	12,0	24,0	88,0	37,0	11,4	2,0	2	Weldon	☐
S4521-120E2R300.3Z2	AXT	10286923	2	E	12,0	12,0	24,0	88,0	37,0	11,4	3,0	2	Weldon	☐
S4521-160E2R050.3Z2	AXT	10286927	2	E	16,0	16,0	32,0	100,0	48,0	15,2	0,5	2	Weldon	☐
S4521-160E2R100.3Z2	AXT	10286928	2	E	16,0	16,0	32,0	100,0	48,0	15,2	1,0	2	Weldon	☐
S4521-160E2R200.3Z2	AXT	10286929	2	E	16,0	16,0	32,0	100,0	48,0	15,2	2,0	2	Weldon	☐
S4521-160E2R300.3Z2	AXT	10286930	2	E	16,0	16,0	32,0	100,0	48,0	15,2	3,0	2	Weldon	☐
S4521-160E2R400.3Z2	AXT	10286931	2	E	16,0	16,0	32,0	100,0	48,0	15,2	4,0	2	Weldon	☐
S4521-200E2R050.3Z2	AXT	10286934	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,5	2	Weldon	☐
S4521-200E2R100.3Z2	AXT	10286935	2	E	20,0	20,0	40,0	114,0	60,0	19,0	1,0	2	Weldon	☐
S4521-200E2R200.3Z2	AXT	10286936	2	E	20,0	20,0	40,0	114,0	60,0	19,0	2,0	2	Weldon	☐
S4521-200E2R300.3Z2	AXT	10286937	2	E	20,0	20,0	40,0	114,0	60,0	19,0	3,0	2	Weldon	☐
S4521-200E2R400.3Z2	AXT	10286938	2	E	20,0	20,0	40,0	114,0	60,0	19,0	4,0	2	Weldon	☐
S4521-120E3R050.3Z2	AXT	10286924	3	E	12,0	12,0	18,0	119,0	72,0	11,4	0,5	2	Weldon	☐
S4521-160E3R050.3Z2	AXT	10286932	3	E	16,0	16,0	24,0	129,0	79,0	15,2	0,5	2	Weldon	☐
S4521-200E3R050.3Z2	AXT	10286939	3	E	20,0	20,0	30,0	164,0	111,0	19,0	0,5	2	Weldon	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – S4521 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	3	4	5	6	8	10	12	14	16	20	
N1	E/M/A	0,40 *0.40*	1,5 *1.5*	0,030 *0.0012*	0,046 *0.0018*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	560 (450 — 660) *1825 (1500 — 2100)*
N2	E/M/A	0,30 *0.30*	1,5 *1.5*	0,024 *0.00095*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	480 (370 — 600) *1575 (1300 — 1900)*
N3	E/M/A	0,30 *0.30*	1,5 *1.5*	0,024 *0.00095*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	320 (250 — 400) *1050 (830 — 1300)*
TS1	A/D	0,40 *0.40*	1,5 *1.5*	0,030 *0.0012*	0,046 *0.0018*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	560 (450 — 660) *1825 (1500 — 2100)*
TP1	A/D	0,40 *0.40*	1,5 *1.5*	0,030 *0.0012*	0,046 *0.0018*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	445 (340 — 550) *1450 (1200 — 1800)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – S4521 Nutfräsen

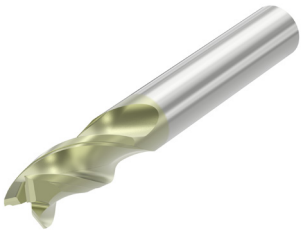
SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	14	16	20	
N1	E	1,5 *1.5*	0,020 *0.00080*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,20 *0.0080*	495 (400 — 590) *1625 (1400 — 1900)*
N2	E	1,2 *1.2*	0,016 *0.00065*	0,024 *0.00095*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	395 (300 — 490) *1300 (990 — 1600)*
N3	E	1,2 *1.2*	0,016 *0.00065*	0,024 *0.00095*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	265 (200 — 320) *870 (660 — 1000)*
TS1	A	1,5 *1.5*	0,020 *0.00080*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,20 *0.0080*	495 (400 — 590) *1625 (1400 — 1900)*
TP1	A	1,5 *1.5*	0,020 *0.00080*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,20 *0.0080*	395 (300 — 490) *1300 (990 — 1600)*

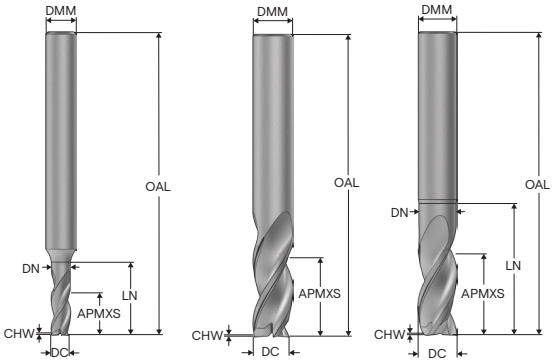
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

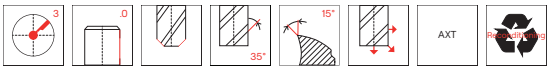
S4531

Hochleistungsfräser – Aluminium – Eckfräser – 3 Schneiden – Zylindrisch – Fase





– Toleranzen:
– DMM=h5
– DC= e7
– CHW= +0,04 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

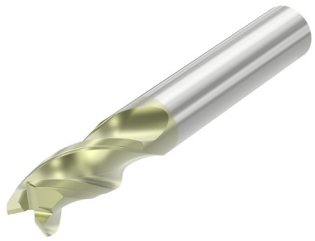


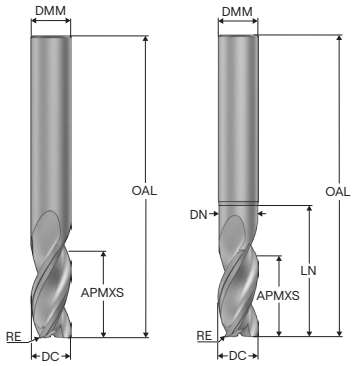
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm	mm	mm			
S4531-020G2C.0Z3	AXT	10228067	2	G	2,0	6,0	4,0	57,0	7,0	1,9	0,1	3	Cylindrical	■
S4531-030G2C.0Z3	AXT	10228068	2	G	3,0	6,0	6,0	57,0	10,0	2,85	0,1	3	Cylindrical	■
S4531-040G2C.0Z3	AXT	10228069	2	G	4,0	6,0	8,0	57,0	13,0	3,8	0,1	3	Cylindrical	■
S4531-050G2C.0Z3	AXT	10228070	2	G	5,0	6,0	10,0	57,0	15,0	4,75	0,1	3	Cylindrical	■
S4531-060D2C.0Z3	AXT	10228071	2	D	6,0	6,0	12,0	57,0	–	–	0,1	3	Cylindrical	■
S4531-060E2C.0Z3	AXT	10228074	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,1	3	Cylindrical	■
S4531-080D2C.0Z3	AXT	10228077	2	D	8,0	8,0	16,0	63,0	–	–	0,1	3	Cylindrical	■
S4531-080E2C.0Z3	AXT	10228080	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	3	Cylindrical	■
S4531-100D2C.0Z3	AXT	10228083	2	D	10,0	10,0	20,0	72,0	–	–	0,1	3	Cylindrical	■
S4531-100E2C.0Z3	AXT	10228087	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,1	3	Cylindrical	■
S4531-120D2C.0Z3	AXT	10228091	2	D	12,0	12,0	24,0	88,0	–	–	0,1	3	Cylindrical	■
S4531-120E2C.0Z3	AXT	10228096	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,1	3	Cylindrical	■
S4531-140D2C.0Z3	AXT	10228102	2	D	14,0	14,0	28,0	89,0	–	–	0,1	3	Cylindrical	■
S4531-160D2C.0Z3	AXT	10228103	2	D	16,0	16,0	32,0	100,0	–	–	0,1	3	Cylindrical	■
S4531-200E2C.0Z3	AXT	10228114	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,1	3	Cylindrical	■
S4531-030G3C.0Z3	AXT	10228058	3	G	3,0	6,0	10,0	63,0	14,0	2,85	0,1	3	Cylindrical	■
S4531-040G3C.0Z3	AXT	10228059	3	G	4,0	6,0	13,0	63,0	18,0	3,8	0,1	3	Cylindrical	■
S4531-050G3C.0Z3	AXT	10228060	3	G	5,0	6,0	16,0	63,0	20,0	4,75	0,1	3	Cylindrical	■
S4531-060D3C.0Z3	AXT	10228061	3	D	6,0	6,0	19,0	63,0	–	–	0,1	3	Cylindrical	■
S4531-080D3C.0Z3	AXT	10228062	3	D	8,0	8,0	26,0	74,0	–	–	0,1	3	Cylindrical	■
S4531-100D3C.0Z3	AXT	10228063	3	D	10,0	10,0	32,0	84,0	–	–	0,1	3	Cylindrical	■
S4531-120D3C.0Z3	AXT	10228064	3	D	12,0	12,0	38,0	99,0	–	–	0,1	3	Cylindrical	■
S4531-160D3C.0Z3	AXT	10228065	3	D	16,0	16,0	50,0	114,0	–	–	0,1	3	Cylindrical	■
S4531-200D3C.0Z3	AXT	10228066	3	D	20,0	20,0	62,0	150,0	–	–	0,1	3	Cylindrical	■
S4531-200E3C.0Z3	AXT	10228120	3	E	20,0	20,0	40,0	150,0	90,0	19,0	0,1	3	Cylindrical	■

■ **Lagerstandard.**

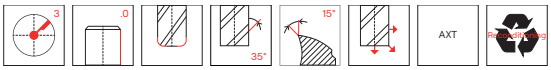
S4531

Hochleistungsfräser – Aluminium – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius





- Toleranzen:
- DMM=h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

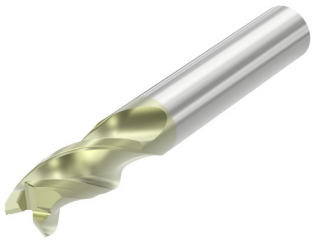


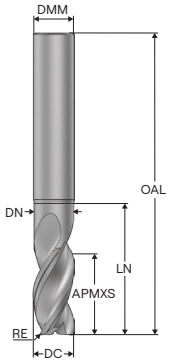
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm	mm	mm			
S4531-060D2R050.0Z3	AXT	10228072	2	D	6,0	6,0	12,0	57,0	–	–	0,5	3	Cylindrical	■
S4531-060E2R050.0Z3	AXT	10228075	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,5	3	Cylindrical	■
S4531-060D2R100.0Z3	AXT	10228073	2	D	6,0	6,0	12,0	57,0	–	–	1,0	3	Cylindrical	■
S4531-060E2R100.0Z3	AXT	10228076	2	E	6,0	6,0	12,0	57,0	19,0	5,7	1,0	3	Cylindrical	■
S4531-080D2R050.0Z3	AXT	10228078	2	D	8,0	8,0	16,0	63,0	–	–	0,5	3	Cylindrical	■
S4531-080E2R050.0Z3	AXT	10228081	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	3	Cylindrical	■
S4531-080D2R100.0Z3	AXT	10228079	2	D	8,0	8,0	16,0	63,0	–	–	1,0	3	Cylindrical	■
S4531-080E2R100.0Z3	AXT	10228082	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	3	Cylindrical	■
S4531-100D2R050.0Z3	AXT	10228084	2	D	10,0	10,0	20,0	72,0	–	–	0,5	3	Cylindrical	■
S4531-100E2R050.0Z3	AXT	10228088	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,5	3	Cylindrical	■
S4531-100D2R100.0Z3	AXT	10228085	2	D	10,0	10,0	20,0	72,0	–	–	1,0	3	Cylindrical	■
S4531-100E2R100.0Z3	AXT	10228089	2	E	10,0	10,0	20,0	72,0	31,0	9,5	1,0	3	Cylindrical	■
S4531-100D2R200.0Z3	AXT	10228086	2	D	10,0	10,0	20,0	72,0	–	–	2,0	3	Cylindrical	■
S4531-100E2R200.0Z3	AXT	10228090	2	E	10,0	10,0	20,0	72,0	31,0	9,5	2,0	3	Cylindrical	■
S4531-120D2R050.0Z3	AXT	10228092	2	D	12,0	12,0	24,0	88,0	–	–	0,5	3	Cylindrical	■
S4531-120E2R050.0Z3	AXT	10228097	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,5	3	Cylindrical	■
S4531-120D2R100.0Z3	AXT	10228093	2	D	12,0	12,0	24,0	88,0	–	–	1,0	3	Cylindrical	■
S4531-120E2R100.0Z3	AXT	10228098	2	E	12,0	12,0	24,0	88,0	37,0	11,4	1,0	3	Cylindrical	■
S4531-120D2R200.0Z3	AXT	10228094	2	D	12,0	12,0	24,0	88,0	–	–	2,0	3	Cylindrical	■
S4531-120E2R200.0Z3	AXT	10228099	2	E	12,0	12,0	24,0	88,0	37,0	11,4	2,0	3	Cylindrical	■
S4531-120D2R300.0Z3	AXT	10228095	2	D	12,0	12,0	24,0	88,0	–	–	3,0	3	Cylindrical	■
S4531-120E2R300.0Z3	AXT	10228100	2	E	12,0	12,0	24,0	88,0	37,0	11,4	3,0	3	Cylindrical	■
S4531-160D2R050.0Z3	AXT	10228104	2	D	16,0	16,0	32,0	100,0	–	–	0,5	3	Cylindrical	■
S4531-160E2R100.0Z3	AXT	10228105	2	E	16,0	16,0	32,0	100,0	48,0	15,2	1,0	3	Cylindrical	■
S4531-160E2R200.0Z3	AXT	10228106	2	E	16,0	16,0	32,0	100,0	48,0	15,2	2,0	3	Cylindrical	■
S4531-160E2R250.0Z3	AXT	10228107	2	E	16,0	16,0	32,0	100,0	48,0	15,2	2,5	3	Cylindrical	■
S4531-160E2R300.0Z3	AXT	10228108	2	E	16,0	16,0	32,0	100,0	48,0	15,2	3,0	3	Cylindrical	■
S4531-160E2R400.0Z3	AXT	10228109	2	E	16,0	16,0	32,0	100,0	48,0	15,2	4,0	3	Cylindrical	■
S4531-200E2R050.0Z3	AXT	10228115	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,5	3	Cylindrical	■
S4531-200E2R100.0Z3	AXT	10228116	2	E	20,0	20,0	40,0	114,0	60,0	19,0	1,0	3	Cylindrical	■
S4531-200E2R200.0Z3	AXT	10228117	2	E	20,0	20,0	40,0	114,0	60,0	19,0	2,0	3	Cylindrical	■
S4531-200E2R300.0Z3	AXT	10228118	2	E	20,0	20,0	40,0	114,0	60,0	19,0	3,0	3	Cylindrical	■
S4531-200E2R400.0Z3	AXT	10228119	2	E	20,0	20,0	40,0	114,0	60,0	19,0	4,0	3	Cylindrical	■

■ **Lagerstandard.**

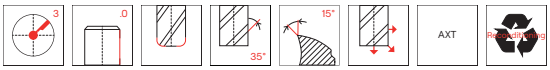
S4531

Hochleistungsfräser – Aluminium – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius





- Toleranzen:
- DMM=h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

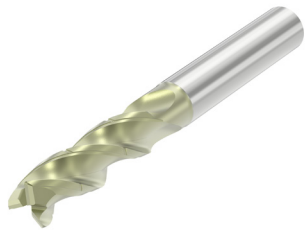


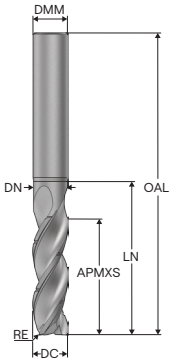
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm	mm	mm			
S4531-120E3R300.0Z3	AXT	10228101	3	E	12,0	12,0	24,0	110,0	54,0	11,4	3,0	3	Cylindrical	■
S4531-160E3R100.0Z3	AXT	10228110	3	E	16,0	16,0	32,0	129,0	77,0	15,2	1,0	3	Cylindrical	■
S4531-160E3R200.0Z3	AXT	10228111	3	E	16,0	16,0	32,0	129,0	77,0	15,2	2,0	3	Cylindrical	■
S4531-160E3R300.0Z3	AXT	10228112	3	E	16,0	16,0	32,0	129,0	77,0	15,2	3,0	3	Cylindrical	■
S4531-160E3R400.0Z3	AXT	10228113	3	E	16,0	16,0	32,0	129,0	77,0	15,2	4,0	3	Cylindrical	■
S4531-200E3R050.0Z3	AXT	10228121	3	E	20,0	20,0	40,0	150,0	90,0	19,0	0,5	3	Cylindrical	■
S4531-200E3R100.0Z3	AXT	10228122	3	E	20,0	20,0	40,0	150,0	90,0	19,0	1,0	3	Cylindrical	■
S4531-200E3R200.0Z3	AXT	10228123	3	E	20,0	20,0	40,0	150,0	90,0	19,0	2,0	3	Cylindrical	■
S4531-200E3R300.0Z3	AXT	10228124	3	E	20,0	20,0	40,0	150,0	90,0	19,0	3,0	3	Cylindrical	■
S4531-200E3R400.0Z3	AXT	10228125	3	E	20,0	20,0	40,0	150,0	90,0	19,0	4,0	3	Cylindrical	■

■ **Lagerstandard.**

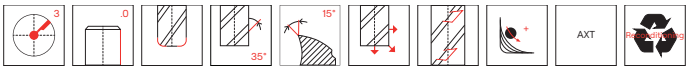
S4531

Hochleistungsfräser – Aluminium – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius





- Toleranzen:
- DMM=h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

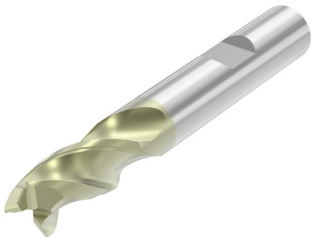


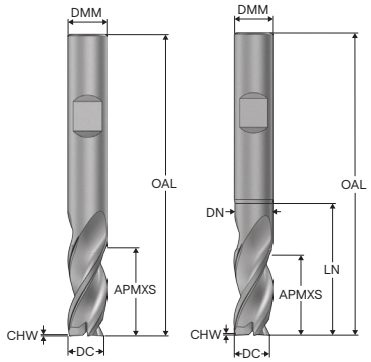
Bezeichnung	Beschichtung	Produktnummer	Längenindex		Spanteiler	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Aufnahmen	Lagerstandard
						mm	mm	mm	mm	mm	mm	mm			
S4531-060E3R050.0Z3C	AXT	10228126	3	E	■	6,0	6,0	19,0	63,0	25,0	5,7	0,5	3	Cylindrical	■
S4531-060E3R100.0Z3C	AXT	10228127	3	E	■	6,0	6,0	19,0	63,0	25,0	5,7	1,0	3	Cylindrical	■
S4531-080E3R050.0Z3C	AXT	10228128	3	E	■	8,0	8,0	26,0	74,0	34,0	7,6	0,5	3	Cylindrical	■
S4531-080E3R100.0Z3C	AXT	10228129	3	E	■	8,0	8,0	26,0	74,0	34,0	7,6	1,0	3	Cylindrical	■
S4531-080E3R200.0Z3C	AXT	10228130	3	E	■	8,0	8,0	26,0	74,0	34,0	7,6	2,0	3	Cylindrical	■
S4531-100E3R050.0Z3C	AXT	10228131	3	E	■	10,0	10,0	32,0	84,0	42,0	9,5	0,5	3	Cylindrical	■
S4531-100E3R100.0Z3C	AXT	10228132	3	E	■	10,0	10,0	32,0	84,0	42,0	9,5	1,0	3	Cylindrical	■
S4531-100E3R200.0Z3C	AXT	10228133	3	E	■	10,0	10,0	32,0	84,0	42,0	9,5	2,0	3	Cylindrical	■
S4531-120E3R050.0Z3C	AXT	10228134	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	0,5	3	Cylindrical	■
S4531-120E3R100.0Z3C	AXT	10228135	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	1,0	3	Cylindrical	■
S4531-120E3R200.0Z3C	AXT	10228136	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	2,0	3	Cylindrical	■
S4531-120E3R300.0Z3C	AXT	10228137	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	3,0	3	Cylindrical	■
S4531-160E3R050.0Z3C	AXT	10228138	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	0,5	3	Cylindrical	■
S4531-160E3R100.0Z3C	AXT	10228139	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	1,0	3	Cylindrical	■
S4531-160E3R200.0Z3C	AXT	10228140	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	2,0	3	Cylindrical	■
S4531-160E3R300.0Z3C	AXT	10228141	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	3,0	3	Cylindrical	■
S4531-200E3R050.0Z3C	AXT	10228142	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	0,5	3	Cylindrical	■
S4531-200E3R100.0Z3C	AXT	10228143	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	1,0	3	Cylindrical	■
S4531-200E3R200.0Z3C	AXT	10228144	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	2,0	3	Cylindrical	■
S4531-200E3R300.0Z3C	AXT	10228145	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	3,0	3	Cylindrical	■

■ Lagerstandard.

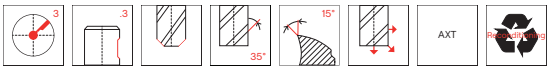
S4531

Hochleistungsfräser – Aluminium – Eckfräser – 3 Schneiden – Weldon – Fase





– Toleranzen:
– DMM=h5
– DC= e7
– CHW= +0,04 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

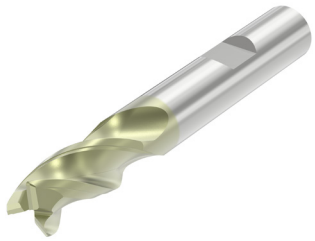


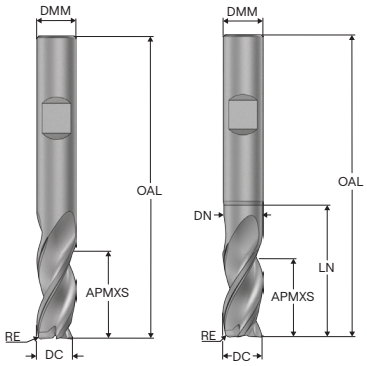
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm	mm	mm			
S4531-060D2C.3Z3	AXT	10286946	2	D	6,0	6,0	12,0	57,0	–	–	0,1	3	Weldon	☐
S4531-060E2C.3Z3	AXT	10286949	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,1	3	Weldon	☐
S4531-080D2C.3Z3	AXT	10286952	2	D	8,0	8,0	16,0	63,0	–	–	0,1	3	Weldon	☐
S4531-080E2C.3Z3	AXT	10286955	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,1	3	Weldon	☐
S4531-100D2C.3Z3	AXT	10286958	2	D	10,0	10,0	20,0	72,0	–	–	0,1	3	Weldon	☐
S4531-100E2C.3Z3	AXT	10286962	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,1	3	Weldon	☐
S4531-120D2C.3Z3	AXT	10286966	2	D	12,0	12,0	24,0	88,0	–	–	0,1	3	Weldon	☐
S4531-120E2C.3Z3	AXT	10286971	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,1	3	Weldon	☐
S4531-140D2C.3Z3	AXT	10286977	2	D	14,0	14,0	28,0	89,0	–	–	0,1	3	Weldon	☐
S4531-160D2C.3Z3	AXT	10286978	2	D	16,0	16,0	32,0	100,0	–	–	0,1	3	Weldon	☐
S4531-200E2C.3Z3	AXT	10286989	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,1	3	Weldon	☐
S4531-060D3C.3Z3	AXT	10286940	3	D	6,0	6,0	19,0	63,0	–	–	0,1	3	Weldon	☐
S4531-080D3C.3Z3	AXT	10286941	3	D	8,0	8,0	26,0	74,0	–	–	0,1	3	Weldon	☐
S4531-100D3C.3Z3	AXT	10286942	3	D	10,0	10,0	32,0	84,0	–	–	0,1	3	Weldon	☐
S4531-120D3C.3Z3	AXT	10286943	3	D	12,0	12,0	38,0	99,0	–	–	0,1	3	Weldon	☐
S4531-160D3C.3Z3	AXT	10286944	3	D	16,0	16,0	50,0	114,0	–	–	0,1	3	Weldon	☐
S4531-200D3C.3Z3	AXT	10286945	3	D	20,0	20,0	62,0	150,0	–	–	0,1	3	Weldon	☐
S4531-200E3C.3Z3	AXT	10286995	3	E	20,0	20,0	40,0	150,0	90,0	19,0	0,1	3	Weldon	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

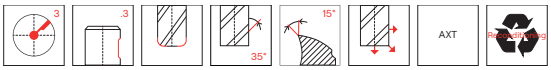
S4531

Hochleistungsfräser – Aluminium – Eckfräser – 3 Schneiden – Weldon – Eckenradius





– Toleranzen:
– DMM=h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

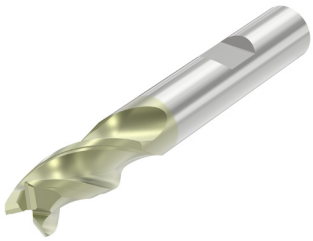


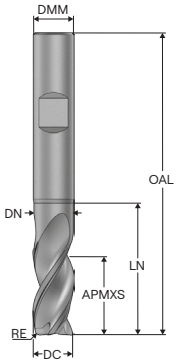
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
S4531-060D2R050.3Z3	AXT	10286947	2	D	6,0	6,0	12,0	57,0	–	–	0,5	3	Weldon	□
S4531-060E2R050.3Z3	AXT	10286950	2	E	6,0	6,0	12,0	57,0	19,0	5,7	0,5	3	Weldon	□
S4531-060D2R100.3Z3	AXT	10286948	2	D	6,0	6,0	12,0	57,0	–	–	1,0	3	Weldon	□
S4531-060E2R100.3Z3	AXT	10286951	2	E	6,0	6,0	12,0	57,0	19,0	5,7	1,0	3	Weldon	□
S4531-080D2R050.3Z3	AXT	10286953	2	D	8,0	8,0	16,0	63,0	–	–	0,5	3	Weldon	□
S4531-080E2R050.3Z3	AXT	10286956	2	E	8,0	8,0	16,0	63,0	25,0	7,6	0,5	3	Weldon	□
S4531-080D2R100.3Z3	AXT	10286954	2	D	8,0	8,0	16,0	63,0	–	–	1,0	3	Weldon	□
S4531-080E2R100.3Z3	AXT	10286957	2	E	8,0	8,0	16,0	63,0	25,0	7,6	1,0	3	Weldon	□
S4531-100D2R050.3Z3	AXT	10286959	2	D	10,0	10,0	20,0	72,0	–	–	0,5	3	Weldon	□
S4531-100E2R050.3Z3	AXT	10286963	2	E	10,0	10,0	20,0	72,0	31,0	9,5	0,5	3	Weldon	□
S4531-100D2R100.3Z3	AXT	10286960	2	D	10,0	10,0	20,0	72,0	–	–	1,0	3	Weldon	□
S4531-100E2R100.3Z3	AXT	10286964	2	E	10,0	10,0	20,0	72,0	31,0	9,5	1,0	3	Weldon	□
S4531-100D2R200.3Z3	AXT	10286961	2	D	10,0	10,0	20,0	72,0	–	–	2,0	3	Weldon	□
S4531-100E2R200.3Z3	AXT	10286965	2	E	10,0	10,0	20,0	72,0	31,0	9,5	2,0	3	Weldon	□
S4531-120D2R050.3Z3	AXT	10286967	2	D	12,0	12,0	24,0	88,0	–	–	0,5	3	Weldon	□
S4531-120E2R050.3Z3	AXT	10286972	2	E	12,0	12,0	24,0	88,0	37,0	11,4	0,5	3	Weldon	□
S4531-120D2R100.3Z3	AXT	10286968	2	D	12,0	12,0	24,0	88,0	–	–	1,0	3	Weldon	□
S4531-120E2R100.3Z3	AXT	10286973	2	E	12,0	12,0	24,0	88,0	37,0	11,4	1,0	3	Weldon	□
S4531-120D2R200.3Z3	AXT	10286969	2	D	12,0	12,0	24,0	88,0	–	–	2,0	3	Weldon	□
S4531-120E2R200.3Z3	AXT	10286974	2	E	12,0	12,0	24,0	88,0	37,0	11,4	2,0	3	Weldon	□
S4531-120D2R300.3Z3	AXT	10286970	2	D	12,0	12,0	24,0	88,0	–	–	3,0	3	Weldon	□
S4531-120E2R300.3Z3	AXT	10286975	2	E	12,0	12,0	24,0	88,0	37,0	11,4	3,0	3	Weldon	□
S4531-160D2R050.3Z3	AXT	10286979	2	D	16,0	16,0	32,0	100,0	–	–	0,5	3	Weldon	□
S4531-160E2R100.3Z3	AXT	10286980	2	E	16,0	16,0	32,0	100,0	48,0	15,2	1,0	3	Weldon	□
S4531-160E2R200.3Z3	AXT	10286981	2	E	16,0	16,0	32,0	100,0	48,0	15,2	2,0	3	Weldon	□
S4531-160E2R250.3Z3	AXT	10286982	2	E	16,0	16,0	32,0	100,0	48,0	15,2	2,5	3	Weldon	□
S4531-160E2R300.3Z3	AXT	10286983	2	E	16,0	16,0	32,0	100,0	48,0	15,2	3,0	3	Weldon	□
S4531-160E2R400.3Z3	AXT	10286984	2	E	16,0	16,0	32,0	100,0	48,0	15,2	4,0	3	Weldon	□

□ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

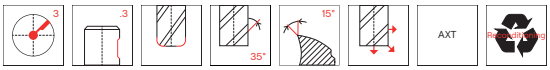
S4531

Hochleistungsfräser – Aluminium – Eckfräser – 3 Schneiden – Weldon – Eckenradius





—Toleranzen:
—DMM=h5
—DC= e7
—RE= ±0,02 mm
—Nachschleifen möglich, wenn DC ≥ Ø6 ist

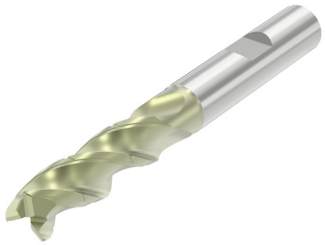


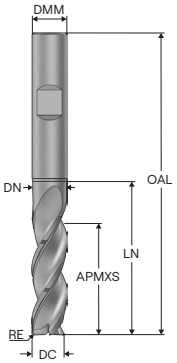
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm	mm	mm			
S4531-200E2R050.3Z3	AXT	10286990	2	E	20,0	20,0	40,0	114,0	60,0	19,0	0,5	3	Weldon	☐
S4531-200E2R100.3Z3	AXT	10286991	2	E	20,0	20,0	40,0	114,0	60,0	19,0	1,0	3	Weldon	☐
S4531-200E2R200.3Z3	AXT	10286992	2	E	20,0	20,0	40,0	114,0	60,0	19,0	2,0	3	Weldon	☐
S4531-200E2R300.3Z3	AXT	10286993	2	E	20,0	20,0	40,0	114,0	60,0	19,0	3,0	3	Weldon	☐
S4531-200E2R400.3Z3	AXT	10286994	2	E	20,0	20,0	40,0	114,0	60,0	19,0	4,0	3	Weldon	☐
S4531-120E3R300.3Z3	AXT	10286976	3	E	12,0	12,0	24,0	110,0	54,0	11,4	3,0	3	Weldon	☐
S4531-160E3R100.3Z3	AXT	10286985	3	E	16,0	16,0	32,0	129,0	77,0	15,2	1,0	3	Weldon	☐
S4531-160E3R200.3Z3	AXT	10286986	3	E	16,0	16,0	32,0	129,0	77,0	15,2	2,0	3	Weldon	☐
S4531-160E3R300.3Z3	AXT	10286987	3	E	16,0	16,0	32,0	129,0	77,0	15,2	3,0	3	Weldon	☐
S4531-160E3R400.3Z3	AXT	10286988	3	E	16,0	16,0	32,0	129,0	77,0	15,2	4,0	3	Weldon	☐
S4531-200E3R050.3Z3	AXT	10286996	3	E	20,0	20,0	40,0	150,0	90,0	19,0	0,5	3	Weldon	☐
S4531-200E3R100.3Z3	AXT	10286997	3	E	20,0	20,0	40,0	150,0	90,0	19,0	1,0	3	Weldon	☐
S4531-200E3R200.3Z3	AXT	10286998	3	E	20,0	20,0	40,0	150,0	90,0	19,0	2,0	3	Weldon	☐
S4531-200E3R300.3Z3	AXT	10286999	3	E	20,0	20,0	40,0	150,0	90,0	19,0	3,0	3	Weldon	☐
S4531-200E3R400.3Z3	AXT	10287000	3	E	20,0	20,0	40,0	150,0	90,0	19,0	4,0	3	Weldon	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

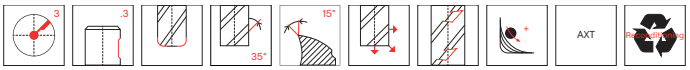
S4531

Hochleistungsfräser – Aluminium – Eckfräser – 3 Schneiden – Weldon – Eckenradius





– Toleranzen:
– DMM=h5
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist



Bezeichnung	Beschichtung	Produktnummer	Längenindex		Spanteiler	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Aufnahmen	Lagerstandard
						mm	mm	mm	mm	mm	mm	mm			
S4531-060E3R050.3Z3C	AXT	10287001	3	E	■	6,0	6,0	19,0	63,0	25,0	5,7	0,5	3	Weldon	□
S4531-060E3R100.3Z3C	AXT	10287002	3	E	■	6,0	6,0	19,0	63,0	25,0	5,7	1,0	3	Weldon	□
S4531-080E3R050.3Z3C	AXT	10287004	3	E	■	8,0	8,0	26,0	74,0	34,0	7,6	0,5	3	Weldon	□
S4531-080E3R100.3Z3C	AXT	10287005	3	E	■	8,0	8,0	26,0	74,0	34,0	7,6	1,0	3	Weldon	□
S4531-080E3R200.3Z3C	AXT	10287006	3	E	■	8,0	8,0	26,0	74,0	34,0	7,6	2,0	3	Weldon	□
S4531-100E3R050.3Z3C	AXT	10287007	3	E	■	10,0	10,0	32,0	84,0	42,0	9,5	0,5	3	Weldon	□
S4531-100E3R100.3Z3C	AXT	10287008	3	E	■	10,0	10,0	32,0	84,0	42,0	9,5	1,0	3	Weldon	□
S4531-100E3R200.3Z3C	AXT	10287009	3	E	■	10,0	10,0	32,0	84,0	42,0	9,5	2,0	3	Weldon	□
S4531-120E3R050.3Z3C	AXT	10287010	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	0,5	3	Weldon	□
S4531-120E3R100.3Z3C	AXT	10287011	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	1,0	3	Weldon	□
S4531-120E3R200.3Z3C	AXT	10287012	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	2,0	3	Weldon	□
S4531-120E3R300.3Z3C	AXT	10287013	3	E	■	12,0	12,0	39,0	99,0	51,0	11,4	3,0	3	Weldon	□
S4531-160E3R050.3Z3C	AXT	10287014	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	0,5	3	Weldon	□
S4531-160E3R100.3Z3C	AXT	10287015	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	1,0	3	Weldon	□
S4531-160E3R200.3Z3C	AXT	10287016	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	2,0	3	Weldon	□
S4531-160E3R300.3Z3C	AXT	10287017	3	E	■	16,0	16,0	52,0	125,0	68,0	15,2	3,0	3	Weldon	□
S4531-200E3R050.3Z3C	AXT	10287018	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	0,5	3	Weldon	□
S4531-200E3R100.3Z3C	AXT	10287019	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	1,0	3	Weldon	□
S4531-200E3R200.3Z3C	AXT	10287020	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	2,0	3	Weldon	□
S4531-200E3R300.3Z3C	AXT	10287021	3	E	■	20,0	20,0	65,0	150,0	85,0	19,0	3,0	3	Weldon	□

□ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – S4531 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	3	4	5	6	8	10	12	14	16	20	
N1	E/M/A	0,40 *0.40*	1,5 *1.5*	0,030 *0.0012*	0,046 *0.0018*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	560 (450 — 660) *1825 (1500 — 2100)*
N2	E/M/A	0,30 *0.30*	1,7 *1.7*	0,024 *0.00095*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	480 (370 — 600) *1575 (1300 — 1900)*
N3	E/M/A	0,30 *0.30*	1,7 *1.7*	0,024 *0.00095*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	0,20 *0.0080*	320 (250 — 400) *1050 (830 — 1300)*
TS1	A/D	0,40 *0.40*	1,5 *1.5*	0,030 *0.0012*	0,046 *0.0018*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	560 (450 — 660) *1825 (1500 — 2100)*
TP1	A/D	0,40 *0.40*	1,5 *1.5*	0,030 *0.0012*	0,046 *0.0018*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	445 (340 — 550) *1450 (1200 — 1800)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – S4531 Nutfräsen

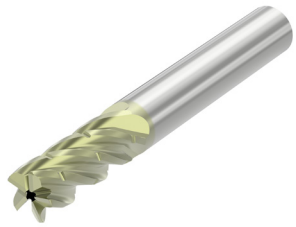
SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	14	16	20	
N1	E	1,5 *1.5*	0,020 *0.00080*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,20 *0.0080*	495 (400 — 590) *1625 (1400 — 1900)*
N2	E	1,2 *1.2*	0,016 *0.00065*	0,024 *0.00095*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	395 (300 — 490) *1300 (990 — 1600)*
N3	E	1,2 *1.2*	0,016 *0.00065*	0,024 *0.00095*	0,032 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	265 (200 — 320) *870 (660 — 1000)*
TS1	A	1,5 *1.5*	0,020 *0.00080*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,20 *0.0080*	495 (400 — 590) *1625 (1400 — 1900)*
TP1	A	1,5 *1.5*	0,020 *0.00080*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,20 *0.0080*	395 (300 — 490) *1300 (990 — 1600)*

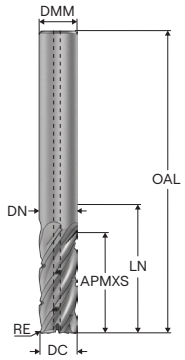
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

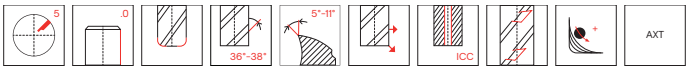
S4651

Hochleistungsfräser – Aluminium – Eckfräser – 5 Schneiden – Zylindrisch





- Toleranzen:
- DMM=h5
- DC= e7
- RE= ±0,02 mm

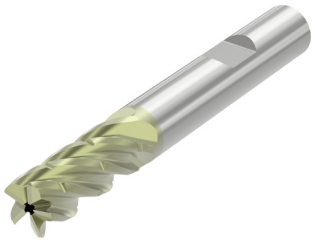


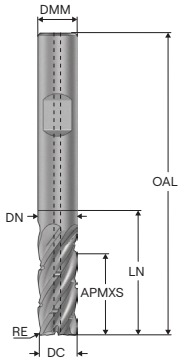
Bezeichnung	Beschichtung	Produktnummer	Längenindex		Spanteiler	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Aufnahmen	Lagerstandard
							mm	mm	mm	mm	mm	mm	mm			
S4651-060E2R050.0Z5AC	AXT	10228163	2	E	■	■	6,0	6,0	14,0	57,0	20,0	5,7	0,5	5	Cylindrical	■
S4651-060E2R100.0Z5AC	AXT	10228164	2	E	■	■	6,0	6,0	14,0	57,0	20,0	5,7	1,0	5	Cylindrical	■
S4651-080E2R050.0Z5AC	AXT	10228167	2	E	■	■	8,0	8,0	18,0	63,0	26,0	7,6	0,5	5	Cylindrical	■
S4651-080E2R100.0Z5AC	AXT	10228168	2	E	■	■	8,0	8,0	18,0	63,0	26,0	7,6	1,0	5	Cylindrical	■
S4651-100E2R050.0Z5AC	AXT	10228171	2	E	■	■	10,0	10,0	23,0	75,0	33,0	9,5	0,5	5	Cylindrical	■
S4651-100E2R100.0Z5AC	AXT	10228172	2	E	■	■	10,0	10,0	23,0	75,0	33,0	9,5	1,0	5	Cylindrical	■
S4651-120E2R050.0Z5AC	AXT	10228175	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	0,5	5	Cylindrical	■
S4651-120E2R100.0Z5AC	AXT	10228176	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	1,0	5	Cylindrical	■
S4651-120E2R200.0Z5AC	AXT	10228177	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	2,0	5	Cylindrical	■
S4651-120E2R300.0Z5AC	AXT	10228178	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	3,0	5	Cylindrical	■
S4651-160E2R050.0Z5AC	AXT	10228183	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	0,5	5	Cylindrical	■
S4651-160E2R100.0Z5AC	AXT	10228184	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	1,0	5	Cylindrical	■
S4651-160E2R200.0Z5AC	AXT	10228185	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	2,0	5	Cylindrical	■
S4651-160E2R300.0Z5AC	AXT	10228186	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	3,0	5	Cylindrical	■
S4651-200E2R050.0Z5AC	AXT	10228191	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	0,5	5	Cylindrical	■
S4651-200E2R100.0Z5AC	AXT	10228193	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	1,0	5	Cylindrical	■
S4651-200E2R200.0Z5AC	AXT	10228194	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	2,0	5	Cylindrical	■
S4651-200E2R300.0Z5AC	AXT	10228195	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	3,0	5	Cylindrical	■
S4651-060E4R050.0Z5AC	AXT	10228165	4	E	■	■	6,0	6,0	26,0	70,0	32,0	5,7	0,5	5	Cylindrical	■
S4651-060E4R100.0Z5AC	AXT	10228166	4	E	■	■	6,0	6,0	26,0	70,0	32,0	5,7	1,0	5	Cylindrical	■
S4651-080E4R050.0Z5AC	AXT	10228169	4	E	■	■	8,0	8,0	34,0	80,0	42,0	7,6	0,5	5	Cylindrical	■
S4651-080E4R100.0Z5AC	AXT	10228170	4	E	■	■	8,0	8,0	34,0	80,0	42,0	7,6	1,0	5	Cylindrical	■
S4651-100E4R050.0Z5AC	AXT	10228173	4	E	■	■	10,0	10,0	43,0	95,0	53,0	9,5	0,5	5	Cylindrical	■
S4651-100E4R100.0Z5AC	AXT	10228174	4	E	■	■	10,0	10,0	43,0	95,0	53,0	9,5	1,0	5	Cylindrical	■
S4651-120E4R050.0Z5AC	AXT	10228179	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	0,5	5	Cylindrical	■
S4651-120E4R100.0Z5AC	AXT	10228180	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	1,0	5	Cylindrical	■
S4651-120E4R200.0Z5AC	AXT	10228181	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	2,0	5	Cylindrical	■
S4651-120E4R300.0Z5AC	AXT	10228182	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	3,0	5	Cylindrical	■
S4651-160E4R050.0Z5AC	AXT	10228187	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	0,5	5	Cylindrical	■
S4651-160E4R100.0Z5AC	AXT	10228188	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	1,0	5	Cylindrical	■
S4651-160E4R200.0Z5AC	AXT	10228189	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	2,0	5	Cylindrical	■
S4651-160E4R300.0Z5AC	AXT	10228190	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,8	3,0	5	Cylindrical	■
S4651-200E4R050.0Z5AC	AXT	10228196	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	0,5	5	Cylindrical	■
S4651-200E4R100.0Z5AC	AXT	10228197	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	1,0	5	Cylindrical	■
S4651-200E4R200.0Z5AC	AXT	10228198	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	2,0	5	Cylindrical	■
S4651-200E4R300.0Z5AC	AXT	10228199	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	3,0	5	Cylindrical	■

■ Lagerstandard.

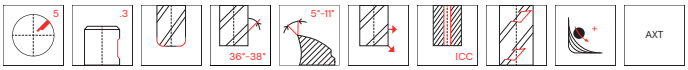
S4651

Hochleistungsfräser – Aluminium – Eckfräser – 5 Schneiden – Weldon





– Toleranzen:
– DMM=h5
– DC= e7
– RE= ±0,02 mm



Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index		Spanteil-er	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
							mm	mm	mm	mm	mm	mm	mm			
S4651-060E2R050.3Z5AC	AXT	10287053	2	E	■	■	6,0	6,0	14,0	57,0	20,0	5,7	0,5	5	Weldon	□
S4651-060E2R100.3Z5AC	AXT	10287054	2	E	■	■	6,0	6,0	14,0	57,0	20,0	5,7	1,0	5	Weldon	□
S4651-080E2R050.3Z5AC	AXT	10287057	2	E	■	■	8,0	8,0	18,0	63,0	26,0	7,6	0,5	5	Weldon	□
S4651-080E2R100.3Z5AC	AXT	10287058	2	E	■	■	8,0	8,0	18,0	63,0	26,0	7,6	1,0	5	Weldon	□
S4651-100E2R050.3Z5AC	AXT	10287061	2	E	■	■	10,0	10,0	23,0	75,0	33,0	9,5	0,5	5	Weldon	□
S4651-100E2R100.3Z5AC	AXT	10287062	2	E	■	■	10,0	10,0	23,0	75,0	33,0	9,5	1,0	5	Weldon	□
S4651-120E2R050.3Z5AC	AXT	10287065	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	0,5	5	Weldon	□
S4651-120E2R100.3Z5AC	AXT	10287066	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	1,0	5	Weldon	□
S4651-120E2R200.3Z5AC	AXT	10287067	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	2,0	5	Weldon	□
S4651-120E2R300.3Z5AC	AXT	10287068	2	E	■	■	12,0	12,0	27,0	88,0	39,0	11,4	3,0	5	Weldon	□
S4651-160E2R050.3Z5AC	AXT	10287073	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	0,5	5	Weldon	□
S4651-160E2R100.3Z5AC	AXT	10287074	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	1,0	5	Weldon	□
S4651-160E2R200.3Z5AC	AXT	10287075	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	2,0	5	Weldon	□
S4651-160E2R300.3Z5AC	AXT	10287076	2	E	■	■	16,0	16,0	36,0	105,0	52,0	15,2	3,0	5	Weldon	□
S4651-200E2R050.3Z5AC	AXT	10287081	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	0,5	5	Weldon	□
S4651-200E2R100.3Z5AC	AXT	10287082	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	1,0	5	Weldon	□
S4651-200E2R200.3Z5AC	AXT	10287083	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	2,0	5	Weldon	□
S4651-200E2R300.3Z5AC	AXT	10287084	2	E	■	■	20,0	20,0	45,0	120,0	65,0	19,0	3,0	5	Weldon	□
S4651-060E4R050.3Z5AC	AXT	10287055	4	E	■	■	6,0	6,0	26,0	70,0	32,0	5,7	0,5	5	Weldon	□
S4651-060E4R100.3Z5AC	AXT	10287056	4	E	■	■	6,0	6,0	26,0	70,0	32,0	5,7	1,0	5	Weldon	□
S4651-080E4R050.3Z5AC	AXT	10287059	4	E	■	■	8,0	8,0	34,0	80,0	42,0	7,6	0,5	5	Weldon	□
S4651-080E4R100.3Z5AC	AXT	10287060	4	E	■	■	8,0	8,0	34,0	80,0	42,0	7,6	1,0	5	Weldon	□
S4651-100E4R050.3Z5AC	AXT	10287063	4	E	■	■	10,0	10,0	43,0	95,0	53,0	9,5	0,5	5	Weldon	□
S4651-100E4R100.3Z5AC	AXT	10287064	4	E	■	■	10,0	10,0	43,0	95,0	53,0	9,5	1,0	5	Weldon	□
S4651-120E4R050.3Z5AC	AXT	10287069	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	0,5	5	Weldon	□
S4651-120E4R100.3Z5AC	AXT	10287070	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	1,0	5	Weldon	□
S4651-120E4R200.3Z5AC	AXT	10287071	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	2,0	5	Weldon	□
S4651-120E4R300.3Z5AC	AXT	10287072	4	E	■	■	12,0	12,0	51,0	110,0	63,0	11,4	3,0	5	Weldon	□
S4651-160E4R050.3Z5AC	AXT	10287077	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	0,5	5	Weldon	□
S4651-160E4R100.3Z5AC	AXT	10287078	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	1,0	5	Weldon	□
S4651-160E4R200.3Z5AC	AXT	10287079	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	2,0	5	Weldon	□
S4651-160E4R300.3Z5AC	AXT	10287080	4	E	■	■	16,0	16,0	68,0	135,0	84,0	15,2	3,0	5	Weldon	□
S4651-200E4R050.3Z5AC	AXT	10287085	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	0,5	5	Weldon	□
S4651-200E4R100.3Z5AC	AXT	10287086	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	1,0	5	Weldon	□
S4651-200E4R200.3Z5AC	AXT	10287087	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	2,0	5	Weldon	□
S4651-200E4R300.3Z5AC	AXT	10287088	4	E	■	■	20,0	20,0	85,0	160,0	105,0	19,0	3,0	5	Weldon	□

□ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – S4651 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
N1	E	0,40 *0.40*	2,2 *2.2*	0,055 *0.0022*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	330 (260 — 410) *1075 (860 — 1300)*
N2	E	0,40 *0.40*	2,0 *2.0*	0,046 *0.0018*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	280 (220 — 350) *920 (730 — 1100)*
N3	E	0,40 *0.40*	2,0 *2.0*	0,046 *0.0018*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	185 (150 — 230) *610 (500 — 750)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – S4651 Eckfräsen dynamisches Fräsen a_e/DC=0,07

SMG		a_p/DC	f_z						v_c
			6	8	10	12	16	20	
N1	E	2,2 *2.2*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*	0,24 *0.0095*	475 (370 — 600) *1550 (1300 — 1900)*
N2	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	410 (320 — 520) *1350 (1100 — 1700)*
N3	E	2,0 *2.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	275 (210 — 350) *900 (690 — 1100)*

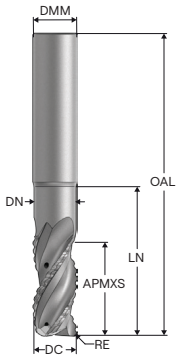
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

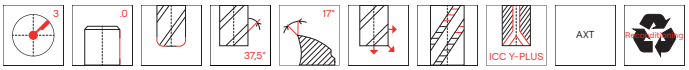
HP4931

Hochleistungsfräser – Aluminium – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius





E



– Toleranzen:
– DMM=h5
– DC -0,02/-0,1 mm
– RE=+/-0,05 mm
– Nachschleifen möglich

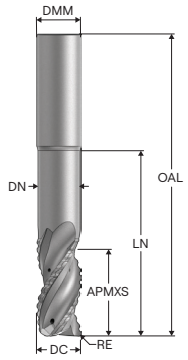
Bezeichnung	Beschichtung	Produktnummer	Längenindex		Spanteiler	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	Aufnahmen	Lagerstandard
							mm	mm	mm	mm	mm	mm	mm		
HP4931-200E2R050.0Z3A	AXT	10318812	2	E	■	■	20,0	20,0	34,0	100,0	50,0	19,0	0,5	Cylindrical	■
HP4931-200E2R100.0Z3A	AXT	10318813	2	E	■	■	20,0	20,0	34,0	100,0	50,0	19,0	1,0	Cylindrical	■
HP4931-200E2R200.0Z3A	AXT	10318814	2	E	■	■	20,0	20,0	34,0	100,0	50,0	19,0	2,0	Cylindrical	■
HP4931-200E2R300.0Z3A	AXT	10318815	2	E	■	■	20,0	20,0	34,0	100,0	50,0	19,0	3,0	Cylindrical	■
HP4931-200E2R400.0Z3A	AXT	10318816	2	E	■	■	20,0	20,0	34,0	100,0	50,0	19,0	4,0	Cylindrical	■
HP4931-200E2R500.0Z3A	AXT	10318817	2	E	■	■	20,0	20,0	34,0	100,0	50,0	19,0	5,0	Cylindrical	□
HP4931-250E2R050.0Z3A	AXT	10318824	2	E	■	■	25,0	25,0	42,0	110,0	60,0	23,8	0,5	Cylindrical	■
HP4931-250E2R100.0Z3A	AXT	10318825	2	E	■	■	25,0	25,0	42,0	110,0	60,0	23,8	1,0	Cylindrical	■
HP4931-250E2R200.0Z3A	AXT	10318826	2	E	■	■	25,0	25,0	42,0	110,0	60,0	23,8	2,0	Cylindrical	■
HP4931-250E2R300.0Z3A	AXT	10318827	2	E	■	■	25,0	25,0	42,0	110,0	60,0	23,8	3,0	Cylindrical	■
HP4931-250E2R400.0Z3A	AXT	10318828	2	E	■	■	25,0	25,0	42,0	110,0	60,0	23,8	4,0	Cylindrical	■
HP4931-250E2R500.0Z3A	AXT	10318829	2	E	■	■	25,0	25,0	42,0	110,0	60,0	23,8	5,0	Cylindrical	□
HP4931-120E3R050.0Z3A	AXT	10318795	3	E	■	■	12,0	12,0	26,0	83,0	40,0	11,4	0,5	Cylindrical	■
HP4931-120E3R100.0Z3A	AXT	10318796	3	E	■	■	12,0	12,0	26,0	83,0	40,0	11,4	1,0	Cylindrical	■
HP4931-120E3R200.0Z3A	AXT	10318797	3	E	■	■	12,0	12,0	26,0	83,0	40,0	11,4	2,0	Cylindrical	■
HP4931-120E3R300.0Z3A	AXT	10318798	3	E	■	■	12,0	12,0	26,0	83,0	40,0	11,4	3,0	Cylindrical	■
HP4931-120E3R400.0Z3A	AXT	10318799	3	E	■	■	12,0	12,0	26,0	83,0	40,0	11,4	4,0	Cylindrical	□
HP4931-160E3R050.0Z3A	AXT	10318800	3	E	■	■	16,0	16,0	34,0	95,0	52,0	15,2	0,5	Cylindrical	■
HP4931-160E3R100.0Z3A	AXT	10318801	3	E	■	■	16,0	16,0	34,0	95,0	52,0	15,2	1,0	Cylindrical	■
HP4931-160E3R200.0Z3A	AXT	10318802	3	E	■	■	16,0	16,0	34,0	95,0	52,0	15,2	2,0	Cylindrical	■
HP4931-160E3R300.0Z3A	AXT	10318803	3	E	■	■	16,0	16,0	34,0	95,0	52,0	15,2	3,0	Cylindrical	■
HP4931-160E3R400.0Z3A	AXT	10318804	3	E	■	■	16,0	16,0	34,0	95,0	52,0	15,2	4,0	Cylindrical	■
HP4931-160E3R500.0Z3A	AXT	10318805	3	E	■	■	16,0	16,0	34,0	95,0	52,0	15,2	5,0	Cylindrical	□
HP4931-200E3R050.0Z3A	AXT	10318818	3	E	■	■	20,0	20,0	34,0	115,0	65,0	19,0	0,5	Cylindrical	■
HP4931-200E3R100.0Z3A	AXT	10318819	3	E	■	■	20,0	20,0	34,0	115,0	65,0	19,0	1,0	Cylindrical	■
HP4931-200E3R200.0Z3A	AXT	10318820	3	E	■	■	20,0	20,0	34,0	115,0	65,0	19,0	2,0	Cylindrical	■
HP4931-200E3R300.0Z3A	AXT	10318821	3	E	■	■	20,0	20,0	34,0	115,0	65,0	19,0	3,0	Cylindrical	■
HP4931-200E3R400.0Z3A	AXT	10318822	3	E	■	■	20,0	20,0	34,0	115,0	65,0	19,0	4,0	Cylindrical	■
HP4931-200E3R500.0Z3A	AXT	10318823	3	E	■	■	20,0	20,0	34,0	115,0	65,0	19,0	5,0	Cylindrical	□
HP4931-250E3R050.0Z3A	AXT	10318830	3	E	■	■	25,0	25,0	35,0	130,0	80,0	23,8	0,5	Cylindrical	■
HP4931-250E3R100.0Z3A	AXT	10318831	3	E	■	■	25,0	25,0	35,0	130,0	80,0	23,8	1,0	Cylindrical	■
HP4931-250E3R200.0Z3A	AXT	10318832	3	E	■	■	25,0	25,0	35,0	130,0	80,0	23,8	2,0	Cylindrical	■
HP4931-250E3R300.0Z3A	AXT	10318833	3	E	■	■	25,0	25,0	35,0	130,0	80,0	23,8	3,0	Cylindrical	■
HP4931-250E3R400.0Z3A	AXT	10318834	3	E	■	■	25,0	25,0	35,0	130,0	80,0	23,8	4,0	Cylindrical	■
HP4931-250E3R500.0Z3A	AXT	10318835	3	E	■	■	25,0	25,0	35,0	130,0	80,0	23,8	5,0	Cylindrical	□

■ **Lagerstandard.**

HP4931

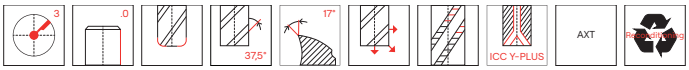
Hochleistungsfräser – Aluminium – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius





E

– Toleranzen:
– DMM=h5
– DC -0,02/-0,1 mm
– RE=+/-0,05 mm
– Nachschleifen möglich



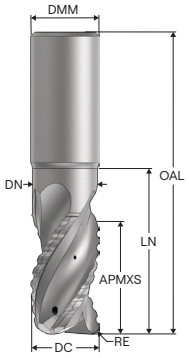
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index		Spanteiler	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	Auf-nahmen	Lagerstand-ard
							mm	mm	mm	mm	mm	mm	mm		
HP4931-160E4R050.0Z3A	AXT	10318806	4	E	■	■	16,0	16,0	34,0	110,0	67,0	15,2	0,5	Cylindrical	■
HP4931-160E4R100.0Z3A	AXT	10318807	4	E	■	■	16,0	16,0	34,0	110,0	67,0	15,2	1,0	Cylindrical	■
HP4931-160E4R200.0Z3A	AXT	10318808	4	E	■	■	16,0	16,0	34,0	110,0	67,0	15,2	2,0	Cylindrical	■
HP4931-160E4R300.0Z3A	AXT	10318809	4	E	■	■	16,0	16,0	34,0	110,0	67,0	15,2	3,0	Cylindrical	■
HP4931-160E4R400.0Z3A	AXT	10318810	4	E	■	■	16,0	16,0	34,0	110,0	67,0	15,2	4,0	Cylindrical	■
HP4931-160E4R500.0Z3A	AXT	10318811	4	E	■	■	16,0	16,0	34,0	110,0	67,0	15,2	5,0	Cylindrical	□

■ **Lagerstandard.**

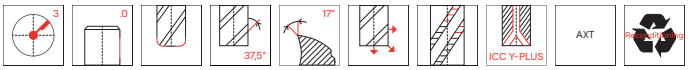
HP4931

Hochleistungsfräser – Aluminium – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius – Zoll





– Toleranzen:
– DMM=h5
– DC -0.001"/-0.004"
– RE=+/-0.002"
– Nachschleifen möglich



Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index		Spanteiler	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	Auf-nahmen	Lagerstand-ard
							Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zoll		
HP4931-.750E2R020.0Z3A	AXT	10318851	2	E	■	■	0.750	0.750	1.250	3.750	2.000	0.720	0.020	Cylindrical	■
HP4931-.750E2R030.0Z3A	AXT	10318852	2	E	■	■	0.750	0.750	1.250	3.750	2.000	0.720	0.030	Cylindrical	■
HP4931-.750E2R060.0Z3A	AXT	10318853	2	E	■	■	0.750	0.750	1.250	3.750	2.000	0.720	0.060	Cylindrical	■
HP4931-.750E2R090.0Z3A	AXT	10318854	2	E	■	■	0.750	0.750	1.250	3.750	2.000	0.720	0.090	Cylindrical	■
HP4931-.750E2R120.0Z3A	AXT	10318855	2	E	■	■	0.750	0.750	1.250	3.750	2.000	0.720	0.120	Cylindrical	■
HP4931-1.000E2R020.0Z3A	AXT	10318861	2	E	■	■	1.000	1.000	1.625	4.375	2.250	0.960	0.020	Cylindrical	■
HP4931-1.000E2R030.0Z3A	AXT	10318862	2	E	■	■	1.000	1.000	1.625	4.375	2.250	0.960	0.030	Cylindrical	■
HP4931-1.000E2R060.0Z3A	AXT	10318863	2	E	■	■	1.000	1.000	1.625	4.375	2.250	0.960	0.060	Cylindrical	■
HP4931-1.000E2R090.0Z3A	AXT	10318864	2	E	■	■	1.000	1.000	1.625	4.375	2.250	0.960	0.090	Cylindrical	■
HP4931-1.000E2R120.0Z3A	AXT	10318865	2	E	■	■	1.000	1.000	1.625	4.375	2.250	0.960	0.120	Cylindrical	■
HP4931-.500E3R020.0Z3A	AXT	10318836	3	E	■	■	0.500	0.500	1.000	3.250	1.625	0.470	0.020	Cylindrical	■
HP4931-.500E3R030.0Z3A	AXT	10318837	3	E	■	■	0.500	0.500	1.000	3.250	1.625	0.470	0.030	Cylindrical	■
HP4931-.500E3R060.0Z3A	AXT	10318838	3	E	■	■	0.500	0.500	1.000	3.250	1.625	0.470	0.060	Cylindrical	■
HP4931-.500E3R090.0Z3A	AXT	10318839	3	E	■	■	0.500	0.500	1.000	3.250	1.625	0.470	0.090	Cylindrical	■
HP4931-.500E3R120.0Z3A	AXT	10318840	3	E	■	■	0.500	0.500	1.000	3.250	1.625	0.470	0.120	Cylindrical	■
HP4931-.625E3R020.0Z3A	AXT	10318841	3	E	■	■	0.625	0.625	1.250	3.750	2.031	0.600	0.020	Cylindrical	■
HP4931-.625E3R030.0Z3A	AXT	10318842	3	E	■	■	0.625	0.625	1.250	3.750	2.031	0.600	0.030	Cylindrical	■
HP4931-.625E3R060.0Z3A	AXT	10318843	3	E	■	■	0.625	0.625	1.250	3.750	2.031	0.600	0.060	Cylindrical	■
HP4931-.625E3R090.0Z3A	AXT	10318844	3	E	■	■	0.625	0.625	1.250	3.750	2.031	0.600	0.090	Cylindrical	■
HP4931-.625E3R120.0Z3A	AXT	10318845	3	E	■	■	0.625	0.625	1.250	3.750	2.031	0.600	0.120	Cylindrical	■
HP4931-.750E3R020.0Z3A	AXT	10318856	3	E	■	■	0.750	0.750	1.250	4.375	2.625	0.720	0.020	Cylindrical	■
HP4931-.750E3R030.0Z3A	AXT	10318857	3	E	■	■	0.750	0.750	1.250	4.375	2.625	0.720	0.030	Cylindrical	■
HP4931-.750E3R060.0Z3A	AXT	10318858	3	E	■	■	0.750	0.750	1.250	4.375	2.625	0.720	0.060	Cylindrical	■
HP4931-.750E3R090.0Z3A	AXT	10318859	3	E	■	■	0.750	0.750	1.250	4.375	2.625	0.720	0.090	Cylindrical	■
HP4931-.750E3R120.0Z3A	AXT	10318860	3	E	■	■	0.750	0.750	1.250	4.375	2.625	0.720	0.120	Cylindrical	■
HP4931-1.000E3R020.0Z3A	AXT	10318866	3	E	■	■	1.000	1.000	1.375	5.125	3.125	0.960	0.020	Cylindrical	■
HP4931-1.000E3R030.0Z3A	AXT	10318867	3	E	■	■	1.000	1.000	1.375	5.125	3.125	0.960	0.030	Cylindrical	■
HP4931-1.000E3R060.0Z3A	AXT	10318868	3	E	■	■	1.000	1.000	1.375	5.125	3.125	0.960	0.060	Cylindrical	■
HP4931-1.000E3R090.0Z3A	AXT	10318869	3	E	■	■	1.000	1.000	1.375	5.125	3.125	0.960	0.090	Cylindrical	■
HP4931-1.000E3R120.0Z3A	AXT	10318870	3	E	■	■	1.000	1.000	1.375	5.125	3.125	0.960	0.120	Cylindrical	■
HP4931-.625E4R020.0Z3A	AXT	10318846	4	E	■	■	0.625	0.625	1.250	4.375	2.656	0.600	0.020	Cylindrical	■
HP4931-.625E4R030.0Z3A	AXT	10318847	4	E	■	■	0.625	0.625	1.250	4.375	2.656	0.600	0.030	Cylindrical	■
HP4931-.625E4R060.0Z3A	AXT	10318848	4	E	■	■	0.625	0.625	1.250	4.375	2.656	0.600	0.060	Cylindrical	■
HP4931-.625E4R090.0Z3A	AXT	10318849	4	E	■	■	0.625	0.625	1.250	4.375	2.656	0.600	0.090	Cylindrical	■
HP4931-.625E4R120.0Z3A	AXT	10318850	4	E	■	■	0.625	0.625	1.250	4.375	2.656	0.600	0.120	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – HP4931 Nutfräsen

SMG		a_p/DC	f_z				v_c
			12	16	20	25	
N1	E/M/A	1,0 *1.0*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	1500 (800 — 2400) *4925 (2700 — 7800)*
N2	E/M/A	1,0 *1.0*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	960 (520 — 1600) *3150 (1800 — 5200)*
N3	E/M/A	1,0 *1.0*	0,11 *0.0044*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	1400 (750 — 2300) *4600 (2500 — 7500)*

Schnittdaten – HP4931 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z				v_c
				12	16	20	25	
N1	E/M/A	0,40 *0.40*	1,5 *1.5*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	1825 (980 — 3000) *6000 (3300 — 9800)*
N2	E/M/A	0,40 *0.40*	1,5 *1.5*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	1175 (630 — 1900) *3850 (2100 — 6200)*
N3	E/M/A	0,40 *0.40*	1,5 *1.5*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	1700 (910 — 2800) *5575 (3000 — 9100)*

Schnittdaten – HP4931 Eckfräsen/Schruppen – Zoll

SMG		a_e/DC	a_p/DC	f_z				v_c
				1/2	5/8	3/4	1	
N1	E/M/A	0,40 *0.40*	1,5 *1.5*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	0,25 *0.010*	1850 (990 — 3000) *6075 (3300 — 9800)*
N2	E/M/A	0,40 *0.40*	1,5 *1.5*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	0,25 *0.010*	1200 (640 — 1900) *3925 (2100 — 6200)*
N3	E/M/A	0,40 *0.40*	1,5 *1.5*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	0,25 *0.010*	1725 (930 — 2800) *5650 (3100 — 9100)*

Schnittdaten – HP4931 Nutfräsen – Zoll

SMG		a_p/DC	f_z				v_c
			1/2	5/8	3/4	1	
N1	E/M/A	1,0 *1.0*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	1525 (810 — 2500) *5000 (2700 — 8200)*
N2	E/M/A	1,0 *1.0*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	980 (530 — 1600) *3225 (1800 — 5200)*
N3	E/M/A	1,0 *1.0*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,22 *0.0085*	1425 (760 — 2300) *4675 (2500 — 7500)*

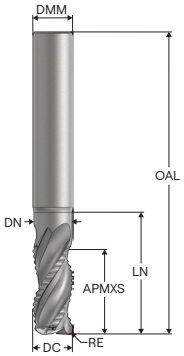
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

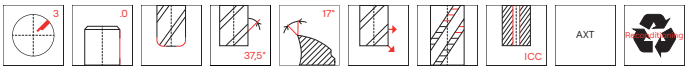
S4931

Allgemeine Anwendung – Aluminium – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius





– Toleranzen:
– DMM=-.0001"/-.0004"
– SIG= ±1°
– Nachschleifen möglich, wenn DMM ≥ Ø.375" ist

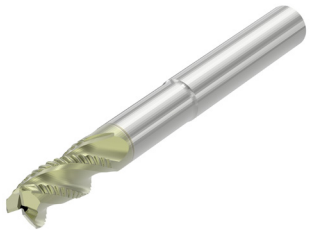


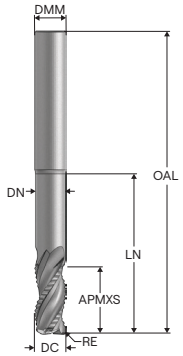
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index		Spanteiler	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	Auf-nahmen	Lagerstand-ard
							mm	mm	mm	mm	mm	mm	mm		
S4931-060E3R050.0Z3A	AXT	10318871	3	E	■	■	6,0	6,0	13,0	60,0	19,5	5,7	0,5	Cylindrical	■
S4931-080E3R050.0Z3A	AXT	10318873	3	E	■	■	8,0	8,0	18,0	65,0	26,0	7,6	0,5	Cylindrical	■
S4931-100E3R050.0Z3A	AXT	10318876	3	E	■	■	10,0	10,0	22,0	75,0	32,5	9,5	0,5	Cylindrical	■
S4931-100E3R100.0Z3A	AXT	10318879	3	E	■	■	10,0	10,0	22,0	75,0	32,5	9,5	1,0	Cylindrical	■
S4931-120E3R050.0Z3A	AXT	10318882	3	E	■	■	12,0	12,0	26,0	90,0	39,0	11,4	0,5	Cylindrical	■
S4931-120E3R100.0Z3A	AXT	10318885	3	E	■	■	12,0	12,0	26,0	90,0	39,0	11,4	1,0	Cylindrical	■
S4931-120E3R200.0Z3A	AXT	10318888	3	E	■	■	12,0	12,0	26,0	90,0	39,0	11,4	2,0	Cylindrical	■
S4931-120E3R300.0Z3A	AXT	10318891	3	E	■	■	12,0	12,0	26,0	90,0	39,0	11,4	3,0	Cylindrical	■
S4931-160E3R050.0Z3A	AXT	10318894	3	E	■	■	16,0	16,0	35,0	105,0	52,0	15,2	0,5	Cylindrical	■
S4931-160E3R100.0Z3A	AXT	10318897	3	E	■	■	16,0	16,0	35,0	105,0	52,0	15,2	1,0	Cylindrical	■
S4931-160E3R200.0Z3A	AXT	10318900	3	E	■	■	16,0	16,0	35,0	105,0	52,0	15,2	2,0	Cylindrical	■
S4931-160E3R300.0Z3A	AXT	10318903	3	E	■	■	16,0	16,0	35,0	105,0	52,0	15,2	3,0	Cylindrical	■
S4931-060E4R050.0Z3A	AXT	10318872	4	E	■	■	6,0	6,0	13,0	70,0	25,5	5,7	0,5	Cylindrical	■
S4931-080E4R050.0Z3A	AXT	10318874	4	E	■	■	8,0	8,0	18,0	80,0	34,0	7,6	0,5	Cylindrical	■
S4931-100E4R050.0Z3A	AXT	10318877	4	E	■	■	10,0	10,0	22,0	95,0	42,5	9,5	0,5	Cylindrical	■
S4931-100E4R100.0Z3A	AXT	10318880	4	E	■	■	10,0	10,0	22,0	95,0	42,5	9,5	1,0	Cylindrical	■
S4931-120E4R050.0Z3A	AXT	10318883	4	E	■	■	12,0	12,0	26,0	110,0	51,0	11,4	0,5	Cylindrical	■
S4931-120E4R100.0Z3A	AXT	10318886	4	E	■	■	12,0	12,0	26,0	110,0	51,0	11,4	1,0	Cylindrical	■
S4931-120E4R200.0Z3A	AXT	10318889	4	E	■	■	12,0	12,0	26,0	110,0	51,0	11,4	2,0	Cylindrical	■
S4931-120E4R300.0Z3A	AXT	10318892	4	E	■	■	12,0	12,0	26,0	110,0	51,0	11,4	3,0	Cylindrical	■
S4931-160E4R050.0Z3A	AXT	10318895	4	E	■	■	16,0	16,0	35,0	135,0	65,0	15,2	0,5	Cylindrical	■
S4931-160E4R100.0Z3A	AXT	10318898	4	E	■	■	16,0	16,0	35,0	135,0	65,0	15,2	1,0	Cylindrical	■
S4931-160E4R200.0Z3A	AXT	10318901	4	E	■	■	16,0	16,0	35,0	135,0	65,0	15,2	2,0	Cylindrical	■
S4931-160E4R300.0Z3A	AXT	10318904	4	E	■	■	16,0	16,0	35,0	135,0	65,0	15,2	3,0	Cylindrical	■
S4931-200E4R200.0Z3A	AXT	10336122	4	E	■	■	20,0	20,0	42,0	135,0	81,0	19,0	2,0	Cylindrical	■
S4931-200E4R300.0Z3A	AXT	10336123	4	E	■	■	20,0	20,0	42,0	135,0	81,0	19,0	3,0	Cylindrical	■
S4931-250E4R200.0Z3A	AXT	10336124	4	E	■	■	25,0	25,0	52,0	160,0	101,0	23,8	2,0	Cylindrical	■
S4931-250E4R300.0Z3A	AXT	10336125	4	E	■	■	25,0	25,0	52,0	160,0	101,0	23,8	3,0	Cylindrical	■

■ **Lagerstandard.**

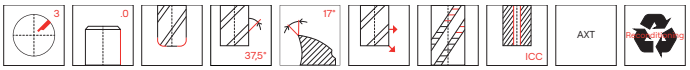
S4931

Allgemeine Anwendung – Aluminium – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius





—Toleranzen:
—DMM=-.0001"/-.0004"
—SIG= ±1°
—Nachschleifen möglich, wenn DMM ≥ Ø.375" ist

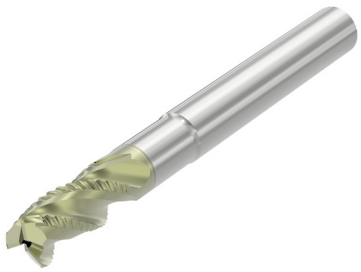


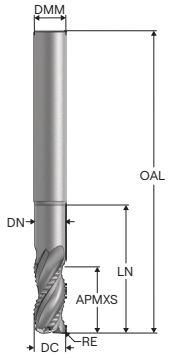
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index		Spanteiler	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	Auf-nahmen	Lagerstand-ard
							mm	mm	mm	mm	mm	mm	mm		
S4931-080E5R050.0Z3A	AXT	10318875	5	E	■	■	8,0	8,0	18,0	80,0	42,0	7,6	0,5	Cylindrical	■
S4931-100E5R050.0Z3A	AXT	10318878	5	E	■	■	10,0	10,0	22,0	95,0	52,5	9,5	0,5	Cylindrical	■
S4931-100E5R100.0Z3A	AXT	10318881	5	E	■	■	10,0	10,0	22,0	95,0	52,5	9,5	1,0	Cylindrical	■
S4931-120E5R050.0Z3A	AXT	10318884	5	E	■	■	12,0	12,0	26,0	110,0	63,0	11,4	0,5	Cylindrical	■
S4931-120E5R100.0Z3A	AXT	10318887	5	E	■	■	12,0	12,0	26,0	110,0	63,0	11,4	1,0	Cylindrical	■
S4931-120E5R200.0Z3A	AXT	10318890	5	E	■	■	12,0	12,0	26,0	110,0	63,0	11,4	2,0	Cylindrical	■
S4931-120E5R300.0Z3A	AXT	10318893	5	E	■	■	12,0	12,0	26,0	110,0	63,0	11,4	3,0	Cylindrical	■
S4931-160E5R050.0Z3A	AXT	10318896	5	E	■	■	16,0	16,0	35,0	135,0	82,0	15,2	0,5	Cylindrical	■
S4931-160E5R100.0Z3A	AXT	10318899	5	E	■	■	16,0	16,0	35,0	135,0	82,0	15,2	1,0	Cylindrical	■
S4931-160E5R200.0Z3A	AXT	10318902	5	E	■	■	16,0	16,0	35,0	135,0	82,0	15,2	2,0	Cylindrical	■
S4931-160E5R300.0Z3A	AXT	10318905	5	E	■	■	16,0	16,0	35,0	135,0	82,0	15,2	3,0	Cylindrical	■

■ **Lagerstandard.**

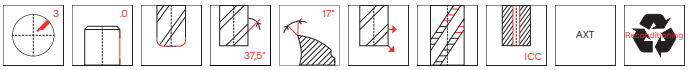
S4931

Allgemeine Anwendung – Aluminium – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius – Zoll





—Toleranzen:
—DMM=h5
—DC -0.001"/-0.004"
—RE=+/-0.002"
—Nachschleifen möglich, wenn DC ≥ Ø.500 ist



Bezeichnung	Beschichtung	Produktnummer	Längenindex		Spanteiler	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	Aufnahmen	Lagerstandard
							Zoll	Zoll	Zoll	Zoll	Zoll	Zoll	Zoll		
S4931-.250E3R030.0Z3A	AXT	10318906	3	E	■	■	0.250	0.250	0.500	2.250	0.750	0.234	0.030	Cylindrical	■
S4931-.313E3R030.0Z3A	AXT	10318908	3	E	■	■	0.313	0.313	0.625	2.500	1.000	0.297	0.030	Cylindrical	■
S4931-.375E3R030.0Z3A	AXT	10318910	3	E	■	■	0.375	0.375	0.750	3.000	1.250	0.355	0.030	Cylindrical	■
S4931-.375E3R060.0Z3A	AXT	10318912	3	E	■	■	0.375	0.375	0.750	3.000	1.250	0.355	0.060	Cylindrical	■
S4931-.500E3R030.0Z3A	AXT	10318914	3	E	■	■	0.500	0.500	1.000	3.500	1.500	0.473	0.030	Cylindrical	■
S4931-.500E3R060.0Z3A	AXT	10318917	3	E	■	■	0.500	0.500	1.000	3.500	1.500	0.473	0.060	Cylindrical	■
S4931-.500E3R090.0Z3A	AXT	10318920	3	E	■	■	0.500	0.500	1.000	3.500	1.500	0.473	0.090	Cylindrical	■
S4931-.500E3R120.0Z3A	AXT	10318923	3	E	■	■	0.500	0.500	1.000	3.500	1.500	0.473	0.120	Cylindrical	■
S4931-.625E3R030.0Z3A	AXT	10318926	3	E	■	■	0.625	0.625	1.250	4.000	2.000	0.598	0.030	Cylindrical	■
S4931-.625E3R060.0Z3A	AXT	10318928	3	E	■	■	0.625	0.625	1.250	4.000	2.000	0.598	0.060	Cylindrical	■
S4931-.625E3R090.0Z3A	AXT	10318930	3	E	■	■	0.625	0.625	1.250	4.000	2.000	0.598	0.090	Cylindrical	■
S4931-.625E3R120.0Z3A	AXT	10318932	3	E	■	■	0.625	0.625	1.250	4.000	2.000	0.598	0.120	Cylindrical	■
S4931-.250E4R030.0Z3A	AXT	10318907	4	E	■	■	0.250	0.250	0.500	2.500	1.000	0.234	0.030	Cylindrical	■
S4931-.313E4R030.0Z3A	AXT	10318909	4	E	■	■	0.313	0.313	0.625	3.000	1.250	0.297	0.030	Cylindrical	■
S4931-.375E4R030.0Z3A	AXT	10318911	4	E	■	■	0.375	0.375	0.750	3.250	1.625	0.355	0.030	Cylindrical	■
S4931-.375E4R060.0Z3A	AXT	10318913	4	E	■	■	0.375	0.375	0.750	3.250	1.625	0.355	0.060	Cylindrical	■
S4931-.500E4R030.0Z3A	AXT	10318915	4	E	■	■	0.500	0.500	1.000	4.000	2.000	0.473	0.030	Cylindrical	■
S4931-.500E4R060.0Z3A	AXT	10318918	4	E	■	■	0.500	0.500	1.000	4.000	2.000	0.473	0.060	Cylindrical	■
S4931-.500E4R090.0Z3A	AXT	10318921	4	E	■	■	0.500	0.500	1.000	4.000	2.000	0.473	0.090	Cylindrical	■
S4931-.500E4R120.0Z3A	AXT	10318924	4	E	■	■	0.500	0.500	1.000	4.000	2.000	0.473	0.120	Cylindrical	■
S4931-.625E4R030.0Z3A	AXT	10318927	4	E	■	■	0.625	0.625	1.250	4.750	2.625	0.598	0.030	Cylindrical	■
S4931-.625E4R060.0Z3A	AXT	10318929	4	E	■	■	0.625	0.625	1.250	4.750	2.625	0.598	0.060	Cylindrical	■
S4931-.625E4R090.0Z3A	AXT	10318931	4	E	■	■	0.625	0.625	1.250	4.750	2.625	0.598	0.090	Cylindrical	■
S4931-.625E4R120.0Z3A	AXT	10318933	4	E	■	■	0.625	0.625	1.250	4.750	2.625	0.598	0.120	Cylindrical	■
S4931-.500E5R030.0Z3A	AXT	10318916	5	E	■	■	0.500	0.500	1.000	4.500	2.500	0.473	0.030	Cylindrical	■
S4931-.500E5R060.0Z3A	AXT	10318919	5	E	■	■	0.500	0.500	1.000	4.500	2.500	0.473	0.060	Cylindrical	■
S4931-.500E5R090.0Z3A	AXT	10318922	5	E	■	■	0.500	0.500	1.000	4.500	2.500	0.473	0.090	Cylindrical	■
S4931-.500E5R120.0Z3A	AXT	10318925	5	E	■	■	0.500	0.500	1.000	4.500	2.500	0.473	0.120	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – S4931 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z							v_c
				6	8	10	12	16	20	25	
N1	E	0,40 *0.40*	1,5 *1.5*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,20 *0.0080*	940 (360 — 1700) *3075 (1200 — 5500)*
N2	E	0,40 *0.40*	1,5 *1.5*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,20 *0.0080*	610 (230 — 1100) *2000 (760 — 3600)*
N3	E	0,40 *0.40*	1,5 *1.5*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,20 *0.0080*	940 (360 — 1700) *3075 (1200 — 5500)*

Schnittdaten – S4931 Nutfräsen

SMG		a_p/DC	f_z							v_c
			6	8	10	12	16	20	25	
N1	E	1,0 *1.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	800 (300 — 1400) *2625 (990 — 4500)*
N2	E	1,0 *1.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	510 (200 — 960) *1675 (660 — 3100)*
N3	E	1,0 *1.0*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,19 *0.0075*	800 (300 — 1400) *2625 (990 — 4500)*

Schnittdaten – S4931 Eckfräsen/Schruppen – Zoll

SMG		a_e/DC	a_p/DC	f_z					v_c
				1/4	5/16	3/8	1/2	5/8	
N1	E	0,40 *0.40*	1,4 *1.4*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,15 *0.0060*	950 (360 — 1700) *3125 (1200 — 5500)*
N2	E	0,40 *0.40*	1,4 *1.4*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,15 *0.0060*	610 (240 — 1100) *2000 (790 — 3600)*
N3	E	0,40 *0.40*	1,4 *1.4*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,15 *0.0060*	950 (360 — 1700) *3125 (1200 — 5500)*

Schnittdaten – S4931 Nutfräsen – Zoll

SMG		a_p/DC	f_z					v_c
			1/4	5/16	3/8	1/2	5/8	
N1	E	1,0 *1.0*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	810 (310 — 1500) *2650 (1100 — 4900)*
N2	E	1,0 *1.0*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	520 (200 — 970) *1700 (660 — 3100)*
N3	E	1,0 *1.0*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,10 *0.0040*	0,13 *0.0050*	810 (310 — 1500) *2650 (1100 — 4900)*

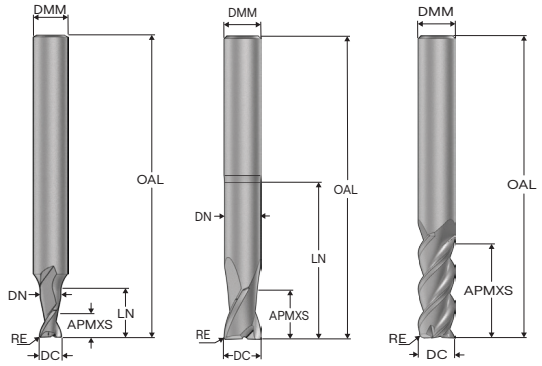
Schnittdaten, siehe Seite 699 - 707

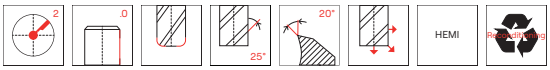
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH40

Hochleistungsfräser – Aluminium – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius







– Toleranzen:
– DMM=h5
– DC=-0,02/-0,04 mm
– RE= ±0,1 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

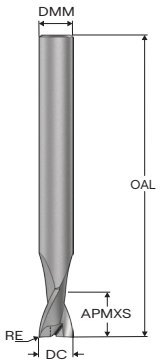
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
40K060-HEMI	00022089	1	D	6,0	6,0	13,0	50,0	–	–	0,1	–	2	Cylindrical	■
40K080-HEMI	00022090	1	D	8,0	8,0	13,0	50,0	–	–	0,1	–	2	Cylindrical	■
40K100-HEMI	00022091	1	D	10,0	10,0	16,0	50,0	–	–	0,1	–	2	Cylindrical	■
40K120-HEMI	00022092	1	D	12,0	12,0	16,0	65,0	–	–	0,1	–	2	Cylindrical	■
40020-HEMI	00022093	2	G	2,0	3,0	3,0	40,0	6,0	1,9	0,1	3,5	2	Cylindrical	■
40030-HEMI	00022094	2	E	3,0	3,0	4,0	40,0	8,0	2,9	0,1	–	2	Cylindrical	■
40040-HEMI	00022095	2	E	4,0	4,0	5,0	50,0	12,0	3,8	0,1	–	2	Cylindrical	■
40050-HEMI	00022120	2	E	5,0	5,0	8,0	50,0	14,0	4,8	0,1	–	2	Cylindrical	■
40060-HEMI	00022250	2	E	6,0	6,0	8,0	65,0	18,0	5,7	0,1	–	2	Cylindrical	■
40080-HEMI	00022580	2	E	8,0	8,0	10,0	70,0	22,0	7,7	0,1	–	2	Cylindrical	■
40100-HEMI	00022663	2	E	10,0	10,0	14,0	80,0	28,0	9,7	0,1	–	2	Cylindrical	■
40120-HEMI	00022667	2	E	12,0	12,0	16,0	90,0	35,0	11,5	0,1	–	2	Cylindrical	■
40160-HEMI	00022668	2	E	16,0	16,0	20,0	90,0	40,0	15,5	0,1	–	2	Cylindrical	■
40200-HEMI	00022701	2	E	20,0	20,0	25,0	100,0	50,0	19,5	0,1	–	2	Cylindrical	■

■ **Lagerstandard.**

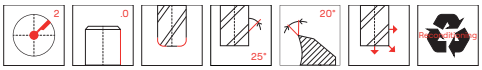
JH40

Hochleistungsfräser – Aluminium – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius





P



– Toleranzen:
– DMM= h5
– DC= -0,02/-0,04 mm
– RE= ±0,1 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
40020-RS	02479642	2	P	2,0	1,9	3,0	40,0	0,1	2	Cylindrical	■
40030-RS	02479643	2	P	3,0	2,9	4,0	60,0	0,1	2	Cylindrical	■
40040-RS	02479644	2	P	4,0	3,8	5,0	60,0	0,1	2	Cylindrical	■
40050-RS	02479645	2	P	5,0	4,8	8,0	70,0	0,1	2	Cylindrical	■
40060-RS	02479646	2	P	6,0	5,8	8,0	65,0	0,1	2	Cylindrical	■
40080-RS	02479647	2	P	8,0	7,8	10,0	70,0	0,1	2	Cylindrical	■
40100-RS	02479648	2	P	10,0	9,7	14,0	100,0	0,1	2	Cylindrical	■
40120-RS	02479649	2	P	12,0	11,7	16,0	90,0	0,1	2	Cylindrical	■
40L060-RS	02479650	3	P	6,0	5,8	8,0	100,0	0,1	2	Cylindrical	■
40L080-RS	02479651	3	P	8,0	7,8	10,0	100,0	0,1	2	Cylindrical	■
40L120-RS	02479652	3	P	12,0	11,7	16,0	125,0	0,1	2	Cylindrical	■
40L160-RS	02479653	3	P	16,0	15,7	20,0	125,0	0,1	2	Cylindrical	■
40L200-RS	02479654	3	P	20,0	19,7	25,0	125,0	0,1	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH40 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	1.2 *1,2*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.22 *0,0085*	0.25 *0,010*	730 (610 — 840) *2400 (2100 — 2700)*
N11	E/M/A	0.400 *0,400*	1.0 *1,0*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.22 *0,0085*	0.26 *0,010*	425 (320 — 520) *1400 (1100 — 1700)*
TS1	A	0.400 *0,400*	1.2 *1,2*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.22 *0,0085*	0.25 *0,010*	730 (610 — 840) *2400 (2100 — 2700)*

Schnittdaten – JH40 Nutfräsen

SMG		a_p/DC	f_z										v_c
			2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.60 *0,60*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	0.25 *0,010*	600 (510 — 700) *1975 (1700 — 2200)*
N11	E/M/A	0.40 *0,40*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	400 (310 — 500) *1300 (1100 — 1600)*
TS1	A	1.0 *1,0*	0.026 *0,0010*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	0.20 *0,0080*	0.25 *0,010*	600 (510 — 700) *1975 (1700 — 2200)*

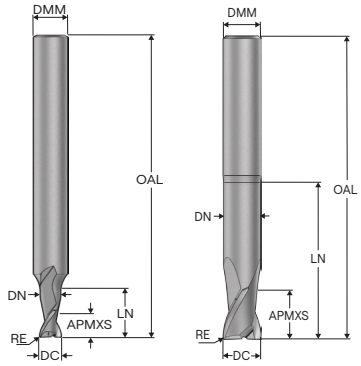
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH421

Hochleistungsfräser – Aluminium – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius







– Toleranzen:
– DMM=h5
– DC=-0,02/-0,04 mm
– RE= ±0,05 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

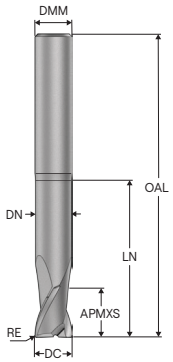
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm				
421020R020Z2-MEGA-T	02434927	2	G	–	2,0	3,0	3,0	40,0	8,0	1,8	0,2	3,0	2	Cylindrical	■
421030R020Z2-MEGA-T	02434939	2	E	–	3,0	3,0	4,0	40,0	12,0	2,7	0,2	–	2	Cylindrical	■
421040R020Z2-MEGA-T	02434940	2	G	–	4,0	6,0	5,0	50,0	16,0	3,6	0,2	3,0	2	Cylindrical	■
421040R030Z2-MEGA-T	02434941	2	G	–	4,0	6,0	5,0	50,0	16,0	3,6	0,3	3,0	2	Cylindrical	■
421050R100Z2-MEGA-T	02434942	2	G	–	5,0	6,0	6,0	50,0	18,0	4,5	1,0	1,5	2	Cylindrical	■
421060R025Z2-MEGA-T	02434946	2	E	–	6,0	6,0	8,0	50,0	20,0	5,4	0,25	–	2	Cylindrical	■
421060R050Z2-MEGA-T	02434947	2	E	–	6,0	6,0	8,0	50,0	20,0	5,4	0,5	–	2	Cylindrical	■
421060R100Z2-MEGA-T	02434958	2	E	–	6,0	6,0	8,0	50,0	20,0	5,4	1,0	–	2	Cylindrical	■
421080R030Z2-MEGA-T	02434960	2	E	–	8,0	8,0	10,0	65,0	30,0	7,2	0,3	–	2	Cylindrical	■
421080R060Z2-MEGA-T	02434964	2	E	–	8,0	8,0	10,0	65,0	30,0	7,2	0,6	–	2	Cylindrical	■
421080R100Z2-MEGA-T	02434967	2	E	–	8,0	8,0	10,0	65,0	30,0	7,2	1,0	–	2	Cylindrical	■
421100R030Z2-MEGA-T	02434968	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	0,3	–	2	Cylindrical	■
421100R080Z2-MEGA-T	02434970	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	0,8	–	2	Cylindrical	■
421100R150Z2-MEGA-T	02434971	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	1,5	–	2	Cylindrical	■
421100R250Z2-MEGA-T	02438614	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	2,5	–	2	Cylindrical	■
421100R310Z2-MEGA-T	02438683	2	E	–	10,0	10,0	12,0	80,0	36,0	9,0	3,1	–	2	Cylindrical	■
421120R030Z2-MEGA-T	02434983	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	0,3	–	2	Cylindrical	■
421120R050Z2-MEGA-T	02434986	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	0,5	–	2	Cylindrical	■
421120R100Z2-MEGA-T	02434988	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	1,0	–	2	Cylindrical	■
421120R150Z2-MEGA-T	02434989	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	1,5	–	2	Cylindrical	■
421120R200Z2-MEGA-T	02434990	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	2,0	–	2	Cylindrical	■
421120R250Z2AMEGA-T	02435008	2	E	■	12,0	12,0	14,0	90,0	40,0	11,0	2,5	–	2	Cylindrical	■
421120R250Z2-MEGA-T	02435007	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	2,5	–	2	Cylindrical	■
421120R310Z2-MEGA-T	02435009	2	E	–	12,0	12,0	14,0	90,0	40,0	11,0	3,1	–	2	Cylindrical	■

■ **Lagerstandard.**
ICC = mit interner Kühlschmiermittelzufuhr

JH421

Hochleistungsfräser – Aluminium – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius





E



– Toleranzen:
– DMM=h5
– DC=-0,02/-0,04 mm
– RE= ±0,05 mm
– Nachschleifen möglich

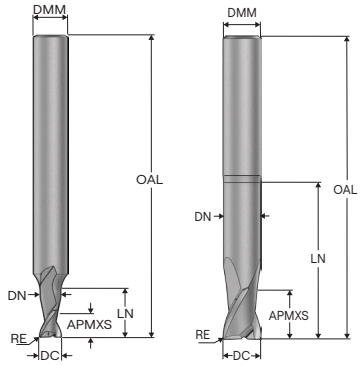
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
421160R050Z2-MEGA-T	02435010	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	0,5	2	Cylindrical	■
421160R200Z2-MEGA-T	02435014	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	2,0	2	Cylindrical	■
421160R250Z2AMEGA-T	02435020	2	E	■	16,0	16,0	18,0	100,0	45,0	14,5	2,5	2	Cylindrical	■
421160R250Z2-MEGA-T	02435012	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	2,5	2	Cylindrical	■
421160R310Z2-MEGA-T	02435036	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	3,1	2	Cylindrical	■
421160R400Z2AMEGA-T	02438684	2	E	■	16,0	16,0	18,0	100,0	45,0	14,5	4,0	2	Cylindrical	■
421160R400Z2-MEGA-T	02435039	2	E	–	16,0	16,0	18,0	100,0	45,0	14,5	4,0	2	Cylindrical	■
421200R160Z2-MEGA-T	02435042	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	1,6	2	Cylindrical	■
421200R200Z2-MEGA-T	02435044	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	2,0	2	Cylindrical	■
421200R250Z2AMEGA-T	02438685	2	E	■	20,0	20,0	24,0	100,0	45,0	18,0	2,5	2	Cylindrical	■
421200R250Z2-MEGA-T	02435046	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	2,5	2	Cylindrical	■
421200R310Z2-MEGA-T	02435049	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	3,1	2	Cylindrical	■
421200R400Z2-MEGA-T	02435051	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	4,0	2	Cylindrical	■
421200R500Z2-MEGA-T	02435055	2	E	–	20,0	20,0	24,0	100,0	45,0	18,0	5,0	2	Cylindrical	■

■ **Lagerstandard.**
ICC = mit interner Kühlschmiermittelzufuhr

JH421

Hochleistungsfräser – Aluminium – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius







– Toleranzen:
– DMM=h5
– DC=-0,02/-0,04 mm
– RE= ±0,05 mm
– Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
421L080R020Z2-MEGA-T	02435068	3	E	–	8,0	8,0	6,0	75,0	40,0	7,2	0,2	2	Cylindrical	■
421L100R050Z2-MEGA-T	02435070	3	E	–	10,0	10,0	8,0	90,0	50,0	9,0	0,5	2	Cylindrical	■
421L100R250Z2-MEGA-T	02435074	3	E	–	10,0	10,0	8,0	90,0	50,0	9,0	2,5	2	Cylindrical	■
421L100R310Z2-MEGA-T	02438690	3	E	–	10,0	10,0	8,0	90,0	50,0	9,0	3,1	2	Cylindrical	■
421L120R050Z2-MEGA-T	02435340	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	0,5	2	Cylindrical	■
421L120R100Z2-MEGA-T	02435343	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	1,0	2	Cylindrical	■
421L120R200Z2-MEGA-T	02435373	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	2,0	2	Cylindrical	■
421L120R250Z2-MEGA-T	02435374	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	2,5	2	Cylindrical	■
421L120R310Z2-MEGA-T	02438692	3	E	–	12,0	12,0	10,0	110,0	70,0	11,0	3,1	2	Cylindrical	■
421L160R050Z2-MEGA-T	02435375	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	0,5	2	Cylindrical	■
421L160R100Z2-MEGA-T	02435380	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	1,0	2	Cylindrical	■
421L160R200Z2-MEGA-T	02435381	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	2,0	2	Cylindrical	■
421L160R250Z2AMEGA-T	02435383	3	E	■	16,0	16,0	13,0	125,0	80,0	14,5	2,5	2	Cylindrical	■
421L160R250Z2-MEGA-T	02435382	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	2,5	2	Cylindrical	■
421L160R310Z2-MEGA-T	02435384	3	E	–	16,0	16,0	13,0	125,0	80,0	14,5	3,1	2	Cylindrical	■
421L160R400Z2AMEGA-T	02435386	3	E	■	16,0	16,0	13,0	125,0	80,0	14,5	4,0	2	Cylindrical	■
421L200R050Z2-MEGA-T	02435387	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	0,5	2	Cylindrical	■
421L200R200Z2-MEGA-T	02435391	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	2,0	2	Cylindrical	■
421L200R310Z2-MEGA-T	02435398	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	3,1	2	Cylindrical	■
421L200R500Z2-MEGA-T	02435401	3	E	–	20,0	20,0	16,0	150,0	100,0	18,0	5,0	2	Cylindrical	■

■ **Lagerstandard.**
ICC = mit interner Kühlschmiermittelzufuhr

Schnittdaten – JH421 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z												v_c
				2	3	4	5	6	8	10	12	14	16	20	25	
N1	E/M/A	0.400	1.0	0.030	0.044	0.060	0.075	0.090	0.12	0.15	0.18	0.20	0.22	0.25	0.28	620 (520 — 720)
		0,400	*1,0*	*0,0012*	*0,0017*	*0,0024*	*0,0030*	*0,0036*	*0,0048*	*0,0060*	*0,0070*	*0,0080*	*0,0085*	*0,010*	*0,011*	*2025 (1800 — 2300)*
N11	E/M/A	0.400	1.0	0.020	0.030	0.040	0.050	0.060	0.080	0.10	0.12	0.13	0.15	0.17	0.19	410 (310 — 510)
		0,400	*1,0*	*0,00080*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0032*	*0,0040*	*0,0048*	*0,0050*	*0,0060*	*0,0065*	*0,0075*	*1350 (1100 — 1600)*
TS1	A	0.400	1.0	0.030	0.044	0.060	0.075	0.090	0.12	0.15	0.18	0.20	0.22	0.25	0.28	620 (520 — 720)
		0,400	*1,0*	*0,0012*	*0,0017*	*0,0024*	*0,0030*	*0,0036*	*0,0048*	*0,0060*	*0,0070*	*0,0080*	*0,0085*	*0,010*	*0,011*	*2025 (1800 — 2300)*
TP1	M	0.400	1.0	0.024	0.036	0.048	0.060	0.070	0.095	0.12	0.14	0.16	0.18	0.20	0.24	410 (310 — 500)
		0,400	*1,0*	*0,00095*	*0,0014*	*0,0019*	*0,0024*	*0,0028*	*0,0038*	*0,0048*	*0,0055*	*0,0065*	*0,0070*	*0,0080*	*0,0095*	*1350 (1100 — 1600)*

Schnittdaten – JH421 Nutfräsen

SMG		a_p/DC	f_z												v_c
			2	3	4	5	6	8	10	12	14	16	20	25	
N1	E/M/A	0.50	0.014	0.022	0.028	0.036	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.18	610 (510 — 700)
		0,50	*0,00055*	*0,00085*	*0,0011*	*0,0014*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0070*	*2000 (1700 — 2200)*
N11	E/M/A	0.50	0.0080	0.012	0.016	0.020	0.025	0.032	0.040	0.050	0.055	0.065	0.080	0.10	405 (310 — 500)
		0,50	*0,00032*	*0,00048*	*0,00065*	*0,00080*	*0,0010*	*0,0013*	*0,0016*	*0,0020*	*0,0022*	*0,0026*	*0,0032*	*0,0040*	*1325 (1100 — 1600)*
TS1	A	0.50	0.014	0.022	0.028	0.036	0.042	0.055	0.070	0.085	0.10	0.11	0.14	0.18	610 (510 — 700)
		0,50	*0,00055*	*0,00085*	*0,0011*	*0,0014*	*0,0017*	*0,0022*	*0,0028*	*0,0034*	*0,0040*	*0,0044*	*0,0055*	*0,0070*	*2000 (1700 — 2200)*
TP1	M	0.50	0.010	0.015	0.020	0.025	0.030	0.040	0.050	0.060	0.070	0.080	0.10	0.13	405 (310 — 500)
		0,50	*0,00040*	*0,00060*	*0,00080*	*0,0010*	*0,0012*	*0,0016*	*0,0020*	*0,0024*	*0,0028*	*0,0032*	*0,0040*	*0,0050*	*1325 (1100 — 1600)*

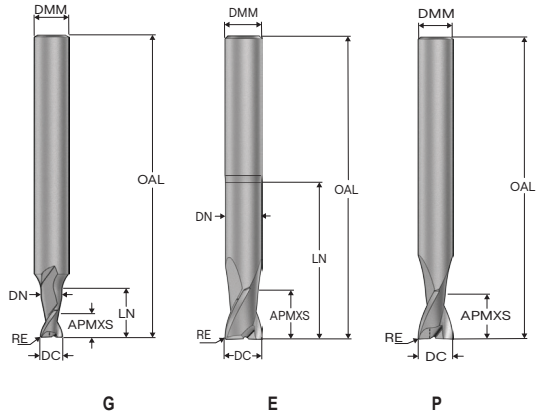
Schnittdaten, siehe Seite 699 - 707

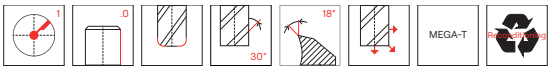
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH410

Hochleistungsfräser – Aluminium – Eckfräser – 1 Schneide – Zylindrisch – Eckenradius







– Toleranzen:
– DMM= h5
– DC= -0,02/-0,04 mm
– RE= ±0,02 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	RE2	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm	mm				
410020R050-MEGA-T	02451548	2	G	2,0	6,0	3,0	50,0	6,0	1,7	0,5	2,0	12,0	1	Cylindrical	■
410030R050-MEGA-T	02451578	2	G	3,0	6,0	4,0	50,0	8,0	2,7	0,5	2,0	7,5	1	Cylindrical	■
410ML030R050-MEGA-T	02451580	2	G	3,0	6,0	4,0	60,0	15,0	2,7	0,5	2,0	5,0	1	Cylindrical	■
410040R050-MEGA-T	02451581	2	G	4,0	6,0	5,0	60,0	8,0	3,6	0,5	2,0	5,5	1	Cylindrical	■
410ML040R050-MEGA-T	02451585	2	G	4,0	6,0	5,0	60,0	15,0	3,6	0,5	2,0	3,5	1	Cylindrical	■
410050R050-MEGA-T	02451586	2	G	5,0	6,0	7,0	65,0	11,0	4,5	0,5	2,0	2,5	1	Cylindrical	■
410ML050R050-MEGA-T	02451589	2	G	5,0	6,0	7,0	65,0	18,0	4,5	0,5	2,0	1,5	1	Cylindrical	■
410TL050R050-MEGA-T	02451587	2	G	5,0	6,0	7,0	65,0	26,0	4,5	0,5	2,0	1,5	1	Cylindrical	■
410060R050-MEGA-T	02451591	2	E	6,0	6,0	8,0	70,0	11,0	5,3	0,5	2,0	–	1	Cylindrical	■
410ML060R050-MEGA-T	02451593	2	E	6,0	6,0	8,0	70,0	18,0	5,3	0,5	2,0	–	1	Cylindrical	■
410TL060R050-MEGA-T	02451592	2	E	6,0	6,0	8,0	70,0	31,0	5,3	0,5	2,0	–	1	Cylindrical	■
410070RSR050-MEGA-T	02451594	2	P	7,0	6,0	9,0	65,0	–	–	0,5	3,0	–	1	Cylindrical	■
410090RSR050-MEGA-T	02451596	2	P	9,0	8,0	11,0	65,0	–	–	0,5	3,0	–	1	Cylindrical	■
410110RSR050-MEGA-T	02451598	2	P	11,0	10,0	13,0	70,0	–	–	0,5	3,0	–	1	Cylindrical	■
410130RSR100-MEGA-T	02451600	2	P	13,0	12,0	15,0	70,0	–	–	1,0	3,0	–	1	Cylindrical	■
410150RSR100-MEGA-T	02451603	2	P	15,0	14,0	17,0	80,0	–	–	1,0	3,0	–	1	Cylindrical	■
410170RSR100-MEGA-T	02451605	2	P	17,0	16,0	19,0	80,0	–	–	1,0	3,0	–	1	Cylindrical	■
410L070RSR200-MEGA-T	02451595	3	P	7,0	6,0	9,0	85,0	–	–	2,0	3,0	–	1	Cylindrical	■
410L090RSR200-MEGA-T	02451597	3	P	9,0	8,0	11,0	85,0	–	–	2,0	3,0	–	1	Cylindrical	■
410L110RSR200-MEGA-T	02451599	3	P	11,0	10,0	13,0	90,0	–	–	2,0	3,0	–	1	Cylindrical	■
410L130RSR200-MEGA-T	02451601	3	P	13,0	12,0	15,0	90,0	–	–	2,0	3,0	–	1	Cylindrical	■
410L150RSR200-MEGA-T	02451604	3	P	15,0	14,0	17,0	110,0	–	–	2,0	3,0	–	1	Cylindrical	■
410L170RSR200-MEGA-T	02451606	3	P	17,0	16,0	19,0	110,0	–	–	2,0	3,0	–	1	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH410 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	3	4	5	6	7	9	11	13	15	17	
N1	E/M/A	0.410 *0,410*	1.0 *1,0*	0.070 *0,0028*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.25 *0,010*	0.32 *0,013*	0.40 *0,016*	0.46 *0,018*	0.50 *0,020*	0.55 *0,022*	710 (600 — 820) *2325 (2000 — 2600)*
N11	E/M/A	0.318 *0,318*	0.65 *0,65*	0.026 *0,0010*	0.040 *0,0016*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	0.19 *0,0075*	0.22 *0,0085*	495 (380 — 610) *1625 (1300 — 2000)*
TS1	A	0.410 *0,410*	1.0 *1,0*	0.070 *0,0028*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.25 *0,010*	0.32 *0,013*	0.40 *0,016*	0.46 *0,018*	0.50 *0,020*	0.55 *0,022*	710 (600 — 820) *2325 (2000 — 2600)*

Schnittdaten – JH410 Nutfräsen

SMG		a_p/DC	f_z											v_c
			2	3	4	5	6	7	9	11	13	15	17	
N1	E/M/A	0.75 *0,75*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	0.25 *0,010*	0.30 *0,012*	0.36 *0,014*	0.40 *0,016*	0.46 *0,018*	630 (530 — 730) *2075 (1800 — 2300)*
N11	E/M/A	0.36 *0,36*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	0.15 *0,0060*	420 (320 — 520) *1375 (1100 — 1700)*
TS1	A	1.0 *1,0*	0.055 *0,0022*	0.080 *0,0032*	0.11 *0,0044*	0.14 *0,0055*	0.16 *0,0065*	0.19 *0,0075*	0.25 *0,010*	0.30 *0,012*	0.36 *0,014*	0.40 *0,016*	0.46 *0,018*	630 (530 — 730) *2075 (1800 — 2300)*

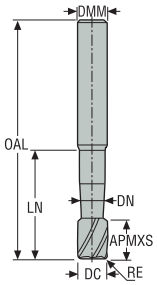
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH440

Hochgeschwindigkeitsfräsen – Aluminium – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius





E

- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	NA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
440060-MEGA-T	00022702	2	E	6,0	6,0	8,0	60,0	30,0	5,4	1,5	2,09	2	Cylindrical	■
440080-MEGA-T	00022865	2	E	8,0	8,0	10,0	60,0	30,0	7,2	2,0	3,12	2	Cylindrical	■

Schnittdaten – JH440 Kopierfräsen/Schruppen

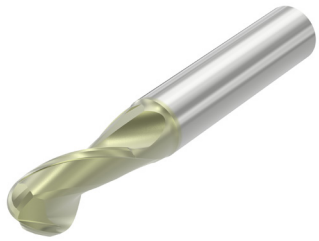
SMG		a_e/DC	a_p/DC	f_z		v_c
				6	8	
N1	E/M/A	0.300 *0,300*	0.50 *0,50*	0.080 *0,0032*	0.10 *0,0040*	780 (650 — 900) *2550 (2200 — 2900)*
N2	E/M/A	0.300 *0,300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	510 (390 — 640) *1675 (1300 — 2000)*
N3	E/M/A	0.300 *0,300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	340 (260 — 420) *1125 (860 — 1300)*
N11	E/M/A	0.300 *0,300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	255 (130 — 370) *840 (430 — 1200)*
TS1	A	0.300 *0,300*	0.50 *0,50*	0.080 *0,0032*	0.10 *0,0040*	780 (650 — 900) *2550 (2200 — 2900)*
TP1	A	0.300 *0,300*	0.60 *0,60*	0.060 *0,0024*	0.080 *0,0032*	510 (380 — 630) *1675 (1300 — 2000)*

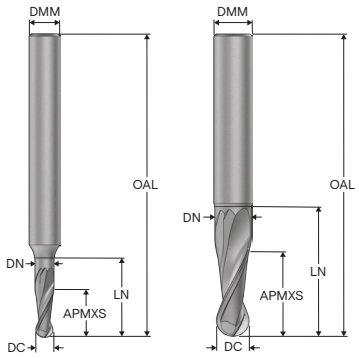
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

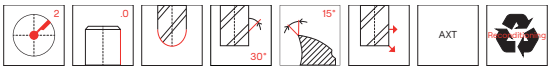
S4321

Hochleistungsfräser – Aluminium – Kugelkopf – 2 Schneiden – Zylindrisch





– Toleranzen:
– DMM=h5
– DC= e7
– RE= ±0,01 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

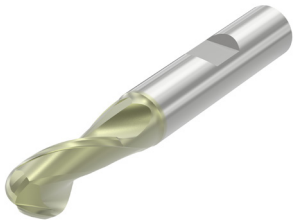


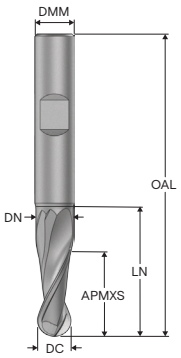
Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm	mm	mm			
S4321-020G2B.0Z2	AXT	10228152	2	G	2,0	6,0	4,0	57,0	8,0	1,9	1,0	2	Cylindrical	■
S4321-030G2B.0Z2	AXT	10228153	2	G	3,0	6,0	6,0	57,0	10,0	2,85	1,5	2	Cylindrical	■
S4321-040G2B.0Z2	AXT	10228154	2	G	4,0	6,0	8,0	57,0	14,0	3,8	2,0	2	Cylindrical	■
S4321-050G2B.0Z2	AXT	10228155	2	G	5,0	6,0	10,0	57,0	17,0	4,75	2,5	2	Cylindrical	■
S4321-060E2B.0Z2	AXT	10228156	2	E	6,0	6,0	12,0	57,0	19,0	5,7	3,0	2	Cylindrical	■
S4321-080E2B.0Z2	AXT	10228157	2	E	8,0	8,0	16,0	63,0	24,0	7,6	4,0	2	Cylindrical	■
S4321-100E2B.0Z2	AXT	10228158	2	E	10,0	10,0	20,0	72,0	31,0	9,5	5,0	2	Cylindrical	■
S4321-120E2B.0Z2	AXT	10228159	2	E	12,0	12,0	24,0	88,0	37,0	11,4	6,0	2	Cylindrical	■
S4321-160E2B.0Z2	AXT	10228160	2	E	16,0	16,0	32,0	100,0	48,0	15,2	8,0	2	Cylindrical	■
S4321-200E2B.0Z2	AXT	10228161	2	E	20,0	20,0	40,0	114,0	60,0	19,0	10,0	2	Cylindrical	■

■ **Lagerstandard.**

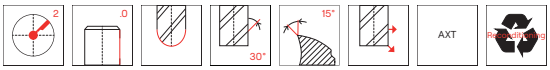
S4321

Hochleistungsfräser – Aluminium – Kugelkopf – 2 Schneiden – Weldon





—Toleranzen:
—DMM=h5
—DC= e7
—RE= ±0,01 mm
—Nachschleifen möglich, wenn DC ≥ Ø6 ist



Bezeichnung	Beschichtung	Produktnummer	Längenindex	Werkzeugform	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Aufnahmen	Lagerstandard
					mm	mm	mm	mm	mm	mm	mm			
S4321-060E2B.3Z2	AXT	10287043	2	E	6,0	6,0	12,0	57,0	19,0	5,7	3,0	2	Weldon	☐
S4321-080E2B.3Z2	AXT	10287044	2	E	8,0	8,0	16,0	63,0	24,0	7,6	4,0	2	Weldon	☐
S4321-100E2B.3Z2	AXT	10287045	2	E	10,0	10,0	20,0	72,0	31,0	9,5	5,0	2	Weldon	☐
S4321-120E2B.3Z2	AXT	10287046	2	E	12,0	12,0	24,0	88,0	37,0	11,4	6,0	2	Weldon	☐
S4321-160E2B.3Z2	AXT	10287047	2	E	16,0	16,0	32,0	100,0	48,0	15,2	8,0	2	Weldon	☐
S4321-200E2B.3Z2	AXT	10287048	2	E	20,0	20,0	40,0	114,0	60,0	19,0	10,0	2	Weldon	☐

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – S4321 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0,30 *0.30*	1,5 *1.5*	0,020 *0.00080*	0,032 *0.0013*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*	0,17 *0.0065*	0,20 *0.0080*	560 (510 — 680) *1825 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	1,5 *1.5*	0,018 *0.00070*	0,026 *0.0010*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	355 (270 — 440) *1175 (890 — 1400)*
N3	E/M/A	0,30 *0.30*	1,5 *1.5*	0,018 *0.00070*	0,026 *0.0010*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	235 (180 — 290) *770 (600 — 950)*
TS1	A/D	0,30 *0.30*	1,5 *1.5*	0,022 *0.00085*	0,034 *0.0013*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,17 *0.0065*	0,19 *0.0075*	670 (560 — 770) *2200 (1900 — 2500)*
TP1	A/D	0,30 *0.30*	1,5 *1.5*	0,0036 *0.00014*	0,0050 *0.00020*	0,0070 *0.00028*	0,0090 *0.00036*	0,010 *0.00040*	0,014 *0.00055*	0,018 *0.00070*	0,020 *0.00080*	0,028 *0.0011*	0,036 *0.0014*	460 (350 — 570) *1500 (1200 — 1800)*

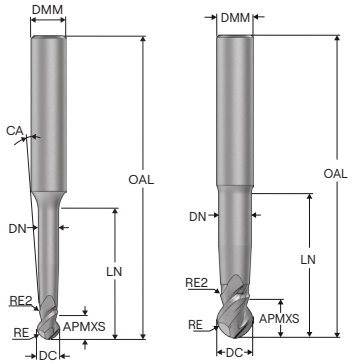
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH450

Hochgeschwindigkeitsfräsen – Aluminium – Kugelkopf – 2 Schneiden – Zylindrisch







- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	RE2	CA°	NA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm	mm					
450020-MEGA-T	00022977	2	G	2,0	3,0	1,75	40,0	10,0	1,8	1,0	1,0	3,0	2,24	2	Cylindrical	■
450030-MEGA-T	00022978	2	E	3,0	3,0	2,5	40,0	12,0	2,7	1,5	2,0	–	2,497	2	Cylindrical	■
450040-MEGA-T	00022979	2	G	4,0	6,0	3,5	50,0	21,0	3,6	2,0	2,0	3,0	5,053	2	Cylindrical	■
450050-MEGA-T	00022980	2	G	5,0	6,0	4,5	50,0	22,5	4,5	2,5	2,0	2,0	3,576	2	Cylindrical	■
450060-MEGA-T	00023020	2	E	6,0	6,0	5,5	55,0	25,0	5,4	3,0	2,0	–	2,465	2	Cylindrical	■
450080-MEGA-T	00023032	2	E	8,0	8,0	7,0	65,0	30,0	7,2	4,0	2,0	–	2,491	2	Cylindrical	■
450100-MEGA-T	00023040	2	E	10,0	10,0	8,5	75,0	35,0	9,0	5,0	3,0	–	3,086	2	Cylindrical	■
450120-MEGA-T	00029842	2	E	12,0	12,0	10,5	75,0	40,0	11,0	6,0	3,0	–	2,735	2	Cylindrical	■
450160-MEGA-T	00023050	2	E	16,0	16,0	14,0	90,0	50,0	14,5	8,0	4,0	–	3,45	2	Cylindrical	■
450200-MEGA-T	00023053	2	E	20,0	20,0	17,0	100,0	50,0	18,0	10,0	4,0	–	5,321	2	Cylindrical	■
450L100-MEGA-T	00023056	3	G	10,0	12,0	8,5	125,0	50,0	9,0	5,0	3,0	1,5	3,16	2	Cylindrical	■
450L120-MEGA-T	00023091	3	E	12,0	12,0	10,5	150,0	60,0	11,0	6,0	3,0	–	2,79	2	Cylindrical	■
450L160-MEGA-T	00023095	3	E	16,0	16,0	14,0	150,0	70,0	14,5	8,0	4,0	–	3,51	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH450 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
N1	E/M/A	0.400 *0,400*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	690 (670 — 930) *2275 (2200 — 3000)*
N2	E/M/A	0.300 *0,300*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	470 (410 — 680) *1550 (1400 — 2200)*
N3	E/M/A	0.300 *0,300*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.40 *0,016*	315 (280 — 450) *1025 (920 — 1400)*
N11	E/M/A	0.300 *0,300*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.38 *0,015*	470 (420 — 680) *1550 (1400 — 2200)*
TS1	A	0.500 *0,500*	0.50 *0,50*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.30 *0,012*	0.34 *0,013*	700 (630 — 860) *2300 (2100 — 2800)*
TP1	M	0.300 *0,300*	0.24 *0,24*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	0.32 *0,013*	0.38 *0,015*	470 (410 — 680) *1550 (1400 — 2200)*

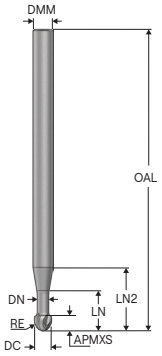
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

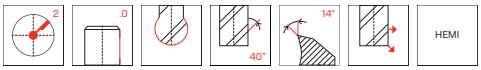
JH460

Hochgeschwindigkeitsfräsen – Aluminium – Kugelkopf – 2 Schneiden – Zylindrisch





E



– Toleranzen:
– DMM=h5
– DC=-0,02/-0,06 mm
– RE= ±0.02 mm
– SA=250°

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
460030-HEMI	00040372	2	E	3,0	3,0	2,3	60,0	4,8	1,5	1,5	2	Cylindrical	■
460040-HEMI	00040373	2	E	4,0	4,0	3,1	60,0	5,6	2,0	2,0	2	Cylindrical	■
460050-HEMI	00040376	2	E	5,0	5,0	3,9	70,0	6,4	2,5	2,5	2	Cylindrical	■
460060-HEMI	00040377	2	E	6,0	6,0	4,7	80,0	9,7	3,0	3,0	2	Cylindrical	■
460080-HEMI	00040378	2	E	8,0	8,0	6,2	85,0	11,2	4,0	4,0	2	Cylindrical	■
460100-HEMI	00040379	2	E	10,0	10,0	7,8	100,0	15,6	5,0	5,0	2	Cylindrical	■
460120-HEMI	00040380	2	E	12,0	12,0	9,4	125,0	17,2	6,0	6,0	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH460 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
N1	E/M/A	0.500 *0,500*	0.20 *0,20*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.15 *0,0060*	0.19 *0,0075*	0.22 *0,0085*	590 (500 — 680) *1925 (1700 — 2200)*
N11	E/M/A	0.300 *0,300*	0.20 *0,20*	0.046 *0,0018*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	610 (510 — 700) *2000 (1700 — 2200)*
S11	E/M/A	0.300 *0,300*	0.20 *0,20*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	120 (110 — 130) *395 (370 — 420)*
S12	E/M/A	0.300 *0,300*	0.20 *0,20*	0.034 *0,0013*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	90 (82 — 100) *295 (270 — 320)*
S13	E/M/A	0.300 *0,300*	0.20 *0,20*	0.030 *0,0012*	0.038 *0,0015*	0.048 *0,0019*	0.060 *0,0024*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	75 (65 — 81) *245 (220 — 260)*
TS1	A	0.500 *0,500*	0.50 *0,50*	0.055 *0,0022*	0.070 *0,0028*	0.13 *0,0050*	0.15 *0,0060*	0.20 *0,0080*	0.25 *0,010*	0.30 *0,012*	620 (520 — 720) *2025 (1800 — 2300)*
TP1	M	0.300 *0,300*	0.20 *0,20*	0.046 *0,0018*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	405 (360 — 450) *1325 (1200 — 1400)*

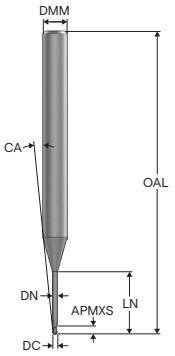
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

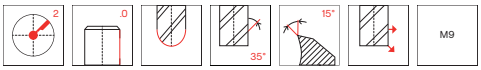
SMB413/414/416

Mini – Aluminium – Kugelkopf – 2 Schneiden – Zylindrisch





G



– Toleranzen:
– Rundlaufabweichung = <0,005 mm
– DMM = h5
– DC = 0/-0,01 mm
– RE = ±0,005 mm

Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm				
SMB414020G4B.0Z2	M9	10109139	4	G	2,0	4,0	2,0	50,0	12,0	1,9	1,0	3,75	2	Cylindrical	■
SMB414030G4B.0Z2	M9	10109140	4	G	3,0	4,0	3,0	50,0	16,0	2,85	1,5	1,68	2	Cylindrical	■
SMB413025G5B.0Z2	M9	10109136	5	G	2,5	3,0	2,5	50,0	20,0	2,4	1,25	0,71	2	Cylindrical	■
SMB414025G5B.0Z2	M9	10109141	5	G	2,5	4,0	2,5	50,0	20,0	2,4	1,25	1,94	2	Cylindrical	■
SMB416025G5B.0Z2	M9	10109145	5	G	2,5	6,0	1,0	55,0	20,0	0,95	1,25	3,87	2	Cylindrical	■
SMB414010G6B.0Z2	M9	10109142	6	G	1,0	4,0	1,0	50,0	10,0	0,95	0,5	5,5	2	Cylindrical	■
SMB413015G6B.0Z2	M9	10109137	6	G	1,5	3,0	1,5	50,0	20,0	1,4	0,75	1,9	2	Cylindrical	■
SMB414015G6B.0Z2	–	10109388	6	G	1,5	4,0	2,5	55,0	20,0	2,4	0,75	2,92	2	Cylindrical	■
SMB414015G6B.0Z2	M9	10109143	6	G	1,5	4,0	1,5	55,0	20,0	1,4	0,75	2,92	2	Cylindrical	■
SMB416015G6B.0Z2	M9	10109146	6	G	1,5	6,0	1,5	55,0	20,0	1,4	0,75	4,56	2	Cylindrical	■
SMB413010G7B.0Z2	M9	10109138	7	G	1,0	3,0	1,0	50,0	18,0	0,95	0,5	2,63	2	Cylindrical	■
SMB414010G7B.0Z2	M9	10109144	7	G	1,0	4,0	1,0	50,0	18,0	0,95	0,5	3,64	2	Cylindrical	■
SMB416010G7B.0Z2	M9	10109147	7	G	1,0	6,0	1,0	55,0	18,0	0,95	0,5	5,23	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – SMB413 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z			v_c
				1	1.5	2.5	
N1	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*
N2	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	85 (55 — 100) *280 (190 — 320)*
N3	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	55 (37 — 73) *180 (130 — 230)*
TS1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*
TP1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*

Schnittdaten – SMB414 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z					v_c
				1	1.5	2	2.5	3	
N1	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	135 (86 — 170) *445 (290 — 550)*
N2	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	85 (55 — 100) *280 (190 — 320)*
N3	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	55 (37 — 73) *180 (130 — 230)*
TS1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	135 (86 — 170) *445 (290 — 550)*
TP1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,026 *0.0010*	0,032 *0.0013*	0,040 *0.0016*	135 (86 — 170) *445 (290 — 550)*

Schnittdaten – SMB416 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z			v_c
				1	1.5	2.5	
N1	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*
N2	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	85 (55 — 100) *280 (190 — 320)*
N3	E	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	55 (37 — 73) *180 (130 — 230)*
TS1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*
TP1	A	0,0500 *0.0500*	0,080 *0.080*	0,013 *0.00050*	0,020 *0.00080*	0,032 *0.0013*	135 (86 — 170) *445 (290 — 550)*

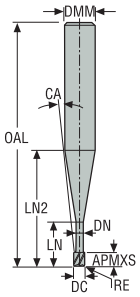
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JM403/JM404/JM406

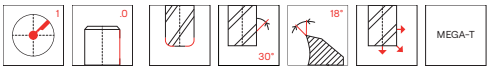
Mini – Aluminium – Eckfräser – 1 Schneide – Zylindrisch – Eckenradius





G

– Toleranzen:
– Rundlaufabweichung =<0,005 mm
– DMM= h5
– DC= < Ø0,6= -0,005/-0,013 mm
– DC= ≥ Ø0,6= -0,005/-0,015 mm
– RE= ±0,01 mm



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
403ML005R005-MEGA-T	02568434	2	G	0,5	3,0	0,5	40,0	1,5	0,45	0,05	11,0	1	Cylindrical	■
403ML008R005-MEGA-T	02568450	2	G	0,8	3,0	0,8	40,0	2,5	0,75	0,05	9,0	1	Cylindrical	■
403ML010R010-MEGA-T	02568456	2	G	1,0	3,0	1,0	40,0	4,0	0,95	0,1	7,5	1	Cylindrical	■
406ML015R010-MEGA-T	02568478	5	G	1,5	6,0	1,5	50,0	5,0	1,4	0,1	9,5	1	Cylindrical	■
404ML020R010-MEGA-T	02577246	5	G	2,0	4,0	2,0	40,0	6,0	1,9	0,1	6,0	1	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JM403/JM404/406 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z					v_c
				0.5	0.8	1	1.5	2	
N1	E	0.500 *0,500*	0.70 *0,70*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	365 (310 — 420) *1200 (1100 — 1300)*
N2	E	0.500 *0,500*	0.70 *0,70*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	235 (200 — 270) *770 (660 — 880)*
N3	E	0.500 *0,500*	0.70 *0,70*	0.015 *0,00060*	0.024 *0,00095*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	155 (140 — 180) *510 (460 — 590)*

Schnittdaten – JM403/JM404/406 Nutfräsen

SMG		a_p/DC	f_z					v_c
			0.5	0.8	1	1.5	2	
N1	E	0.40 *0,40*	0.015 *0,00060*	0.025 *0,0010*	0.030 *0,0012*	0.044 *0,0017*	0.050 *0,0020*	315 (270 — 360) *1025 (890 — 1100)*
N2	E	0.40 *0,40*	0.015 *0,00060*	0.025 *0,0010*	0.030 *0,0012*	0.044 *0,0017*	0.050 *0,0020*	200 (170 — 230) *660 (560 — 750)*
N3	E	0.40 *0,40*	0.015 *0,00060*	0.025 *0,0010*	0.030 *0,0012*	0.044 *0,0017*	0.050 *0,0020*	135 (120 — 150) *445 (400 — 490)*

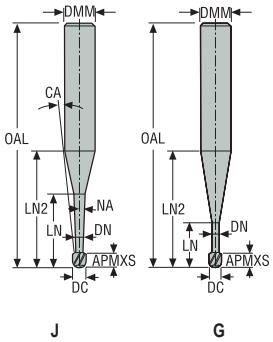
Schnittdaten, siehe Seite 699 - 707

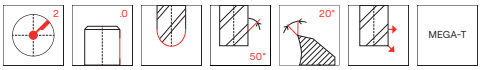
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JM413/JM416

Mini – Aluminium – Kugelkopf – 2 Schneide – Zylindrisch







—Toleranzen:
—Rundlaufabweichung =<0,005 mm
—DMM=h5
—DC= < Ø 0,6= -0,005/-0,013 mm
—DC= ≥ Ø 0,6= -0,005/-0,015 mm
—RE= ±0,005 mm

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm					
413ML005TN-MEGA-T	02568709	2	J	0,5	3,0	0,375	40,0	1,5	0,45	0,25	11,5	0,9	2	Cylindrical	■
413L005-MEGA-T	02568711	3	G	0,5	3,0	0,375	40,0	2,5	0,45	0,25	10,0	–	2	Cylindrical	■
413L008-MEGA-T	02568727	3	G	0,8	3,0	0,6	40,0	4,0	0,75	0,4	8,0	–	2	Cylindrical	■
413L010-MEGA-T	02568736	3	G	1,0	3,0	0,75	40,0	5,0	0,95	0,5	7,0	–	2	Cylindrical	■
416L015-MEGA-T	02568772	3	G	1,5	6,0	1,125	50,0	7,5	1,4	0,75	8,5	–	2	Cylindrical	■
416L020-MEGA-T	02568779	3	G	2,0	6,0	1,5	50,0	10,0	1,9	1,0	7,0	–	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JM413/416 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z					v_c
				0,5	0.8	1	1.5	2	
N1	E	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	385 (370 — 510) *1275 (1300 — 1600)*
N2	E	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	245 (240 — 320) *800 (790 — 1000)*
N3	E	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	165 (160 — 210) *540 (530 — 680)*
N11	E	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	320 (300 — 430) *1050 (990 — 1400)*
TS1	A	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	385 (370 — 510) *1275 (1300 — 1600)*
TP1	A	0.300 *0,300*	0.30 *0,30*	0.030 *0,0012*	0.048 *0,0019*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	385 (370 — 510) *1275 (1300 — 1600)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte



HART

Das vollständige Programm an Hochleistungsvollhartmetallfräsern für hohe Produktivität in harten Werkstoffen besteht aus Schaft- und Kugelkopffräsern.

- JHP170, JHF181, JH120, JH130, JH930, JH142, JME142 und JME144 mit Eckenradius
- JH112, JH150, JH160 und JMB112 Kugelkopffräser

Werkzeugauswahl Hart

							
Werkzeugbezeichnung		JHP170	JHF181	JH120	JH130	JH930	JH142
Seite(n)		501	504	507	509	226, 511	303, 514
Produktfamilie		HPM	HFM	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	HSM/TORNADO
Fräserausführung							
Aufnahmen	Zylindrisch	■	■	■	■	■	■
	Weldon	■					
Schneidenzahl		3-4	3-4-5	4	5-6, 8	5-6, 8	2-4-5-6
CSP			■				
	Metrisch	2-20	1-10	2-16	6-20	6-20	2-12
	Zoll						
Verfügbare Längen		2	1,2,3,4	2	2	2	2,3,6
Bearbeitung							
							
							
SMG							
H3		●	●	●	●	●	●
H5		●	●	●	●	●	●
H7		●	●	●	●	●	●
H8		●	●	●	●	●	●
H11		●	●	●	●	●	
H12		●	●	●	●	●	
H21		●	●	●	●	●	●
H31		●	●	●	●	●	●

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl Hart

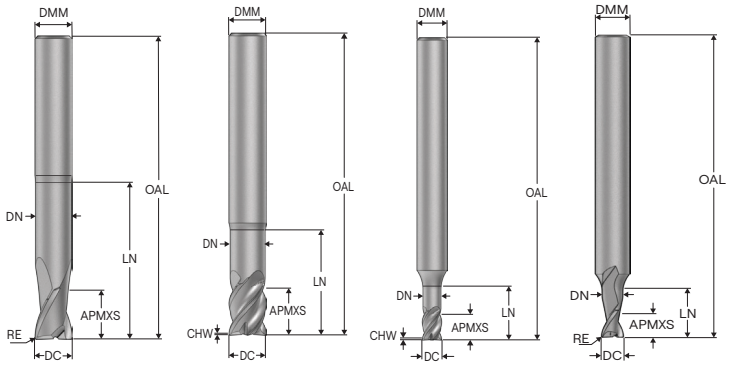
							
Werkzeugbezeichnung		JH112	JH150	JH160	JME142	JME144	JMB112
Seite(n)		313, 517	520	522	524	529	531
Produktfamilie		HSM/TORNADO	HSM/TORNADO	HSM/TORNADO	MINI	MINI	MINI
Fräserausführung							
Auf-nahmen	**Zylindrisch**	■	■	■	■	■	■
	Weldon						
Schneidenzahl		2	4	4	2	4	2
CSP							
	Metrisch	2-12	6-12	3-12	0,2-3,0	1,0-3,0	0,2-3,0
	Zoll						
Verfügbare Längen		1,2,3,4,5,6	2	2	1,2,3,4,5,6	2,3,4	1,2,3,4,5,6
Bearbeitung							
							
							
SMG							
H3		●	●	●	●	●	●
H5		●	●	●	●	●	●
H7		●	●	●	●	●	●
H8		●	●	●	●	●	●
H11			●	●	●	●	●
H12			●	●	●	●	●
H21		●	●	●	●	●	●
H31		●	●	●	●	●	●

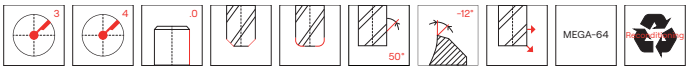
■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

JHP170

Hochleistungsfräser – Gehärteter Stahl – Eckfräser – 3-4 Schneiden – Zylindrisch – Eckenradius oder Fase







- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- CHW= Ø2- Ø4=+0,05 mm
- CHW= Ø5-Ø16=+0,1 mm
- RE= ±0,05 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

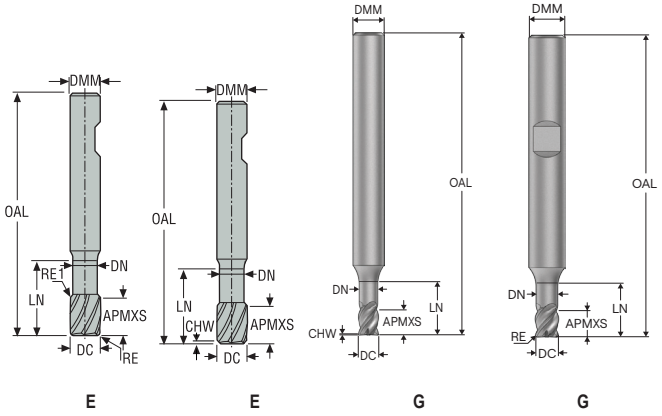
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm	mm				
170020.0-MEGA-64	02462685	2	G	2,0	6,0	2,0	50,0	4,0	1,9	0,08	–	14,5	3	Cylindrical	■
170020R020.0-MEGA-64	02587615	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,2	14,5	3	Cylindrical	■
170020R050.0-MEGA-64	02587617	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,5	15,0	3	Cylindrical	■
170030.0-MEGA-64	02462686	2	G	3,0	6,0	3,0	50,0	6,0	2,8	0,08	–	9,0	3	Cylindrical	■
170030R020.0-MEGA-64	02587618	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,2	9,5	3	Cylindrical	■
170030R050.0-MEGA-64	02587619	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,5	9,5	3	Cylindrical	■
170040.0-MEGA-64	02462687	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,1	–	5,5	4	Cylindrical	■
170040R020.0-MEGA-64	02587620	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,2	5,5	4	Cylindrical	■
170040R050.0-MEGA-64	02587621	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,5	5,5	4	Cylindrical	■
170050.0-MEGA-64	02462688	2	G	5,0	6,0	5,0	50,0	10,0	4,6	0,12	–	2,5	4	Cylindrical	■
170050R020.0-MEGA-64	02587622	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,2	2,5	4	Cylindrical	■
170050R050.0-MEGA-64	02587623	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,5	2,5	4	Cylindrical	■
170060.0-MEGA-64	02462689	2	E	6,0	6,0	6,0	50,0	11,5	5,6	0,14	–	–	4	Cylindrical	■
170060R020.0-MEGA-64	02587624	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,2	–	4	Cylindrical	■
170060R050.0-MEGA-64	02587625	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,5	–	4	Cylindrical	■
170080.0-MEGA-64	02462690	2	E	8,0	8,0	8,0	55,0	16,0	7,4	0,16	–	–	4	Cylindrical	■
170080R020.0-MEGA-64	02587626	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,2	–	4	Cylindrical	■
170080R050.0-MEGA-64	02587627	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,5	–	4	Cylindrical	■
170080R100.0-MEGA-64	02587628	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	1,0	–	4	Cylindrical	■
170100.0-MEGA-64	02462691	2	E	10,0	10,0	10,0	65,0	22,0	9,4	0,18	–	–	4	Cylindrical	■
170100R050.0-MEGA-64	02587629	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	0,5	–	4	Cylindrical	■
170100R100.0-MEGA-64	02587630	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	1,0	–	4	Cylindrical	■
170120.0-MEGA-64	02462692	2	E	12,0	12,0	12,0	75,0	27,0	11,4	0,2	–	–	4	Cylindrical	■
170120R050.0-MEGA-64	02587631	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	0,5	–	4	Cylindrical	■
170120R100.0-MEGA-64	02587632	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	1,0	–	4	Cylindrical	■
170160.0-MEGA-64	02462693	2	E	16,0	16,0	16,0	80,0	29,0	15,4	0,3	–	–	4	Cylindrical	■
170160R050.0-MEGA-64	02587633	2	E	16,0	16,0	16,0	80,0	29,0	15,4	–	0,5	–	4	Cylindrical	■

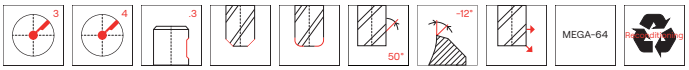
■ **Lagerstandard.**

JHP170

Hochleistungsfräser – Gehärteter Stahl – Eckfräser – 3-4 Schneiden – Weldon – Eckenradius oder Fase







– Toleranzen:
– DMM= h5
– DC= -0,02/-0,04 mm
– CHW= Ø2-Ø4=+0,05 mm
– CHW= Ø5-Ø16= +0,1 mm
– RE= ±0,05 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	CHW	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm	mm				
170020-MEGA-64	02452924	2	G	2,0	6,0	2,0	50,0	4,0	1,9	0,08	–	14,5	3	Weldon	■
170020R020.0-MEGA-64W	02669319	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,2	–	3	Weldon	□
170020R050.0-MEGA-64W	02669320	2	G	2,0	6,0	2,0	50,0	4,0	1,9	–	0,5	–	3	Weldon	□
170030-MEGA-64	02452925	2	G	3,0	6,0	3,0	50,0	6,0	2,8	0,08	–	9,0	3	Weldon	■
170030R020.0-MEGA-64W	02669321	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,2	–	3	Weldon	□
170030R050.0-MEGA-64W	02669322	2	G	3,0	6,0	3,0	50,0	6,0	2,8	–	0,5	–	3	Weldon	□
170040-MEGA-64	02452927	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,1	–	5,5	4	Weldon	■
170040R020.0-MEGA-64W	02669323	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,2	–	4	Weldon	□
170040R050.0-MEGA-64W	02669324	2	G	4,0	6,0	4,0	50,0	8,0	3,7	–	0,5	–	4	Weldon	□
170050-MEGA-64	02452928	2	G	5,0	6,0	5,0	50,0	10,0	4,6	0,12	–	2,5	4	Weldon	■
170050R020.0-MEGA-64W	02669325	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,2	–	4	Weldon	□
170050R050.0-MEGA-64W	02669326	2	G	5,0	6,0	5,0	50,0	10,0	4,6	–	0,5	–	4	Weldon	□
170060-MEGA-64	02452929	2	E	6,0	6,0	6,0	50,0	11,5	5,6	0,14	–	–	4	Weldon	■
170060R020.0-MEGA-64W	02669327	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,2	–	4	Weldon	□
170060R050.0-MEGA-64W	02669328	2	E	6,0	6,0	6,0	50,0	11,5	5,6	–	0,5	–	4	Weldon	□
170080-MEGA-64	02452930	2	E	8,0	8,0	8,0	55,0	16,0	7,4	0,16	–	–	4	Weldon	■
170080R020.0-MEGA-64W	02669329	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,2	–	4	Weldon	□
170080R050.0-MEGA-64W	02669331	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	0,5	–	4	Weldon	□
170080R100.0-MEGA-64W	02669332	2	E	8,0	8,0	8,0	55,0	16,0	7,4	–	1,0	–	4	Weldon	□
170100-MEGA-64	02452931	2	E	10,0	10,0	10,0	65,0	22,0	9,4	0,18	–	–	4	Weldon	■
170100R050.0-MEGA-64W	02669333	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	0,5	–	4	Weldon	□
170100R100.0-MEGA-64W	02669334	2	E	10,0	10,0	10,0	65,0	22,0	9,4	–	1,0	–	4	Weldon	□
170120-MEGA-64	02452932	2	E	12,0	12,0	12,0	75,0	27,0	11,4	0,2	–	–	4	Weldon	■
170120R050.0-MEGA-64W	02669335	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	0,5	–	4	Weldon	□
170120R100.0-MEGA-64W	02669336	2	E	12,0	12,0	12,0	75,0	27,0	11,4	–	1,0	–	4	Weldon	□
170160-MEGA-64	02452933	2	E	16,0	16,0	16,0	80,0	29,0	15,4	0,3	–	–	4	Weldon	■
170160R050.0-MEGA-64W	02669337	2	E	16,0	16,0	16,0	80,0	29,0	15,4	–	0,5	–	4	Weldon	□
170200R050-MEGA-64	02611637	2	E	20,0	20,0	20,0	100,0	40,0	19,2	–	0,5	–	4	Weldon	■

■ **Lagerstandard.** □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Schnittdaten – JHP170 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z										v_c
				2	3	4	5	6	8	10	12	16	20	
H3	M	0.150 *0,150*	0.60 *0,60*	0.0055 *0,00022*	0.0085 *0,00034*	0.011 *0,00044*	0.014 *0,00055*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	29 (22 — 35) *95 (73 — 110)*
H5	M	0.300 *0,300*	0.80 *0,80*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	60 (56 — 68) *195 (190 — 220)*
H7	M	0.150 *0,150*	0.60 *0,60*	0.0055 *0,00022*	0.0085 *0,00034*	0.011 *0,00044*	0.014 *0,00055*	0.017 *0,00065*	0.022 *0,00085*	0.028 *0,0011*	0.034 *0,0013*	0.042 *0,0017*	0.048 *0,0019*	29 (22 — 35) *95 (73 — 110)*
H8	M	0.300 *0,300*	0.80 *0,80*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	65 (59 — 71) *215 (200 — 230)*
H11	M	0.300 *0,300*	0.80 *0,80*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	80 (71 — 86) *260 (240 — 280)*
H12	M	0.300 *0,300*	0.80 *0,80*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	75 (69 — 83) *245 (230 — 270)*
H21	M	0.300 *0,300*	0.80 *0,80*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	65 (59 — 71) *215 (200 — 230)*
H31	M	0.300 *0,300*	0.80 *0,80*	0.012 *0,00048*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	60 (56 — 68) *195 (190 — 220)*

Schnittdaten – JHP170 Nutfräsen

SMG		a_p/DC	f_z									v_c
			2	3	4	5	6	8	10	12	16	20	
H3	M	0.40 *0,40*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	20 (16 — 25) *65 (53 — 82)*
H5	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	50 (46 — 55) *165 (160 — 180)*
H7	M	0.40 *0,40*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	20 (16 — 25) *65 (53 — 82)*
H8	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	50 (46 — 55) *165 (160 — 180)*
H11	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	65 (58 — 70) *215 (200 — 220)*
H12	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	60 (53 — 64) *195 (180 — 200)*
H21	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	50 (46 — 55) *165 (160 — 180)*
H31	M	0.60 *0,60*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	50 (46 — 55) *165 (160 — 180)*

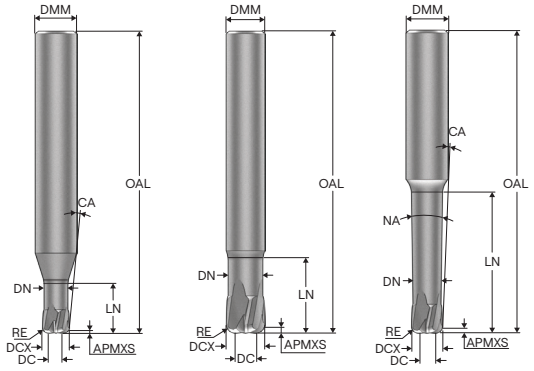
Schnittdaten, siehe Seite 699 - 707

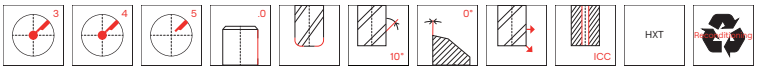
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JHF181

Hochvorschubfräser – Gehärteter Stahl – Eckfräser – 3-5 Schneiden – Zylindrisch – Eckenradius







– Toleranzen:
– DMM=h5
– DC=-0,02/-0,04 mm
– RE= ±0,01 mm
– Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index		CSP	DCX	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm	mm					
JHF181020G1R050.0Z4-HXT	03067297	1	G	–	2,0	1,0	6,0	0,5	50,0	4,0	1,8	0,5	10,0	–	4	Cylindrical	■
JHF181030G1R075.0Z4-HXT	03067298	1	G	–	3,0	1,5	6,0	0,75	50,0	6,0	2,7	0,75	7,5	–	4	Cylindrical	■
JHF181040G1R100.0Z4-HXT	03067299	1	G	–	4,0	2,0	6,0	1,0	50,0	8,0	3,6	1,0	5,0	–	4	Cylindrical	■
JHF181060E1R150.0Z4-HXT	03067300	1	E	–	6,0	3,0	6,0	1,5	50,0	12,0	5,4	1,5	–	–	4	Cylindrical	■
JHF181080E1R200.0Z4-HXT	03067301	1	E	–	8,0	4,0	8,0	2,0	55,0	16,0	7,3	2,0	–	–	4	Cylindrical	■
JHF181100E1R200.0Z4-HXT	03067302	1	E	–	10,0	6,0	10,0	2,0	65,0	20,0	9,2	2,0	–	–	4	Cylindrical	■
JHF181100E1R200.0Z5-HXT	03067303	1	E	–	10,0	6,0	10,0	2,0	65,0	20,0	9,2	2,0	–	–	5	Cylindrical	■
JHF181120E1R300.0Z4-HXT	03067304	1	E	–	12,0	6,0	12,0	3,0	75,0	24,0	11,0	3,0	–	–	4	Cylindrical	■
JHF181120E1R300.0Z5-HXT	03067305	1	E	–	12,0	6,0	12,0	3,0	75,0	24,0	11,0	3,0	–	–	5	Cylindrical	■
JHF181160E1R300.0Z4-HXT	03067306	1	E	–	16,0	10,0	16,0	3,0	80,0	32,0	14,8	3,0	–	–	4	Cylindrical	■
JHF181020G2R050.0Z4-HXT	03067307	2	G	–	2,0	1,0	6,0	0,5	50,0	8,0	1,8	0,5	7,5	–	4	Cylindrical	■
JHF181030G2R075.0Z4-HXT	03067308	2	G	–	3,0	1,5	6,0	0,75	50,0	12,0	2,7	0,75	5,0	–	4	Cylindrical	■
JHF181040G2R100.0Z4-HXT	03067309	2	G	–	4,0	2,0	6,0	1,0	50,0	16,0	3,6	1,0	3,0	–	4	Cylindrical	■
JHF181060E2R150.0Z4A-HXT	03067311	2	E	■	6,0	3,0	6,0	1,5	65,0	24,0	5,4	1,5	–	–	4	Cylindrical	■
JHF181060E2R150.0Z4-HXT	03067310	2	E	–	6,0	3,0	6,0	1,5	65,0	24,0	5,4	1,5	–	–	4	Cylindrical	■
JHF181080E2R200.0Z4A-HXT	03067313	2	E	■	8,0	4,0	8,0	2,0	70,0	32,0	7,3	2,0	–	–	4	Cylindrical	■
JHF181080E2R200.0Z4-HXT	03067312	2	E	–	8,0	4,0	8,0	2,0	70,0	32,0	7,3	2,0	–	–	4	Cylindrical	■
JHF181100E2R200.0Z4A-HXT	03067315	2	E	■	10,0	6,0	10,0	2,0	85,0	40,0	9,2	2,0	–	–	4	Cylindrical	■
JHF181100E2R200.0Z4-HXT	03067314	2	E	–	10,0	6,0	10,0	2,0	85,0	40,0	9,2	2,0	–	–	4	Cylindrical	■
JHF181120E2R300.0Z4A-HXT	03067317	2	E	■	12,0	6,0	12,0	3,0	100,0	48,0	11,0	3,0	–	–	4	Cylindrical	■
JHF181120E2R300.0Z4-HXT	03067316	2	E	–	12,0	6,0	12,0	3,0	100,0	48,0	11,0	3,0	–	–	4	Cylindrical	■
JHF181020J3R050.0Z4-HXT	03067318	3	J	–	2,0	1,0	6,0	0,5	50,0	10,0	1,8	0,5	6,8	0,9	4	Cylindrical	■
JHF181030J3R075.0Z4-HXT	03067319	3	J	–	3,0	1,5	6,0	0,75	50,0	15,0	2,7	0,75	4,4	0,9	4	Cylindrical	■
JHF181040J3R100.0Z4-HXT	03067320	3	J	–	4,0	2,0	6,0	1,0	60,0	20,0	3,6	1,0	2,6	0,9	4	Cylindrical	■
JHF181060J3R150.0Z4-HXT	03067321	3	J	–	6,0	3,0	8,0	1,5	65,0	30,0	5,4	1,5	1,9	0,9	4	Cylindrical	■
JHF181080J3R200.0Z4-HXT	03067325	3	J	–	8,0	4,0	10,0	2,0	85,0	40,0	7,3	2,0	1,5	0,9	4	Cylindrical	■
JHF181100J3R200.0Z4-HXT	03067327	3	J	–	10,0	6,0	12,0	2,0	100,0	50,0	9,2	2,0	1,2	0,9	4	Cylindrical	■
JHF181020J4R050.0Z3-HXT	03067329	4	J	–	2,0	1,0	6,0	0,5	50,0	14,0	1,8	0,5	5,6	0,9	3	Cylindrical	■
JHF181030J4R075.0Z3-HXT	03067330	4	J	–	3,0	1,5	6,0	0,75	60,0	21,0	2,7	0,75	3,4	0,9	3	Cylindrical	■
JHF181040J4R100.0Z3-HXT	03067331	4	J	–	4,0	2,0	6,0	1,0	65,0	28,0	3,6	1,0	2,0	0,9	3	Cylindrical	■
JHF181060J4R150.0Z3-HXT	03067332	4	J	–	6,0	3,0	8,0	1,5	80,0	42,0	5,4	1,5	1,4	0,9	3	Cylindrical	■
JHF181080J4R200.0Z3-HXT	03067333	4	J	–	8,0	4,0	10,0	2,0	100,0	56,0	7,3	2,0	1,1	0,9	3	Cylindrical	■
JHF181100J4R200.0Z3-HXT	03067334	4	J	–	10,0	6,0	12,0	2,0	125,0	70,0	9,2	2,0	0,9	0,9	3	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JHF181 Eckfräsen/Schruppen

SMG		a_e/DCX	a_p/DCX	f_z								v_c
				2	3	4	6	8	10	12	16	
P6	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	305 (290 — 320) *1000 (960 — 1000)*
P7	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	290 (270 — 300) *950 (890 — 980)*
P8	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	270 (260 — 290) *890 (860 — 950)*
P11	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	280 (270 — 290) *920 (890 — 950)*
K1	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	210 (190 — 240) *690 (630 — 780)*
K2	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	185 (160 — 200) *610 (530 — 650)*
K3	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	155 (140 — 170) *510 (460 — 550)*
K4	E/M/A	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	150 (130 — 160) *490 (430 — 520)*
K5	E/M/A	0.30 *0,30*	0.040 *0,040*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	150 (120 — 170) *490 (400 — 550)*
K6	E/M/A	0.30 *0,30*	0.040 *0,040*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	220 (180 — 260) *720 (600 — 850)*
K7	E/M/A	0.30 *0,30*	0.040 *0,040*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	190 (160 — 220) *620 (530 — 720)*
S1	E	0.18 *0,18*	0.014 *0,014*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.075 *0,0030*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	60 (40 — 79) *195 (140 — 250)*
S2	E	0.18 *0,18*	0.014 *0,014*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.075 *0,0030*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	0.19 *0,0075*	48 (33 — 64) *155 (110 — 200)*
S3	E	0.18 *0,18*	0.014 *0,014*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.070 *0,0028*	0.095 *0,0038*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	42 (28 — 55) *140 (92 — 180)*
S11	E	0.18 *0,18*	0.034 *0,034*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.26 *0,010*	200 (180 — 220) *660 (600 — 720)*
S12	E	0.18 *0,18*	0.034 *0,034*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.11 *0,0044*	0.14 *0,0055*	0.18 *0,0070*	0.22 *0,0085*	0.26 *0,010*	155 (140 — 170) *510 (460 — 550)*
S13	E	0.18 *0,18*	0.034 *0,034*	0.032 *0,0013*	0.046 *0,0018*	0.065 *0,0026*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	0.24 *0,0095*	125 (110 — 130) *410 (370 — 420)*
H3	M/A/D	0.30 *0,30*	0.020 *0,020*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	85 (73 — 96) *280 (240 — 310)*
H5	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	165 (150 — 180) *540 (500 — 590)*
H7	M/A/D	0.30 *0,30*	0.020 *0,020*	0.050 *0,0020*	0.080 *0,0032*	0.10 *0,0040*	0.16 *0,0065*	0.20 *0,0080*	0.26 *0,010*	0.32 *0,013*	0.42 *0,017*	85 (73 — 96) *280 (240 — 310)*
H8	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	165 (150 — 180) *540 (500 — 590)*
H11	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	210 (190 — 230) *690 (630 — 750)*
H12	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	190 (180 — 210) *620 (600 — 680)*
H21	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	165 (150 — 180) *540 (500 — 590)*
H31	M/A/D	0.30 *0,30*	0.040 *0,040*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.20 *0,0080*	0.28 *0,011*	0.34 *0,013*	0.40 *0,016*	0.55 *0,022*	125 (120 — 130) *410 (400 — 420)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JHF181 Nutfräsen

SMG		a_p/DCX	f_z								v_c
			2	3	4	6	8	10	12	16	
P6	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	270 (260 — 280) *890 (860 — 910)*
P7	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	255 (240 — 270) *840 (790 — 880)*
P8	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	240 (230 — 250) *790 (760 — 820)*
P11	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	250 (240 — 260) *820 (790 — 850)*
K1	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	185 (170 — 210) *610 (560 — 680)*
K2	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	160 (140 — 180) *520 (460 — 590)*
K3	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	135 (120 — 150) *445 (400 — 490)*
K4	E/M/A	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	130 (120 — 140) *425 (400 — 450)*
K5	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	130 (110 — 150) *425 (370 — 490)*
K6	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	195 (160 — 230) *640 (530 — 750)*
K7	E/M/A	0.040 *0,040*	0.030 *0,0012*	0.046 *0,0018*	0.060 *0,0024*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	0.24 *0,0095*	170 (140 — 200) *560 (460 — 650)*
S1	E	0.014 *0,014*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	48 (33 — 64) *155 (110 — 200)*
S2	E	0.014 *0,014*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	39 (26 — 51) *130 (86 — 160)*
S3	E	0.014 *0,014*	0.0090 *0,00036*	0.014 *0,00055*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	33 (23 — 44) *110 (76 — 140)*
S11	E	0.034 *0,034*	0.011 *0,00044*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	170 (150 — 190) *560 (500 — 620)*
S12	E	0.034 *0,034*	0.011 *0,00044*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	130 (120 — 140) *425 (400 — 450)*
S13	E	0.034 *0,034*	0.011 *0,00044*	0.017 *0,00065*	0.022 *0,00085*	0.034 *0,0013*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	100 (89 — 110) *330 (300 — 360)*
H3	M/A/D	0.020 *0,020*	0.034 *0,0013*	0.050 *0,0020*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	0.28 *0,011*	75 (63 — 83) *245 (210 — 270)*
H5	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	145 (130 — 160) *475 (430 — 520)*
H7	M/A/D	0.020 *0,020*	0.034 *0,0013*	0.050 *0,0020*	0.070 *0,0028*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	0.28 *0,011*	75 (63 — 83) *245 (210 — 270)*
H8	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	145 (130 — 160) *475 (430 — 520)*
H11	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	185 (170 — 200) *610 (560 — 650)*
H12	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	170 (160 — 180) *560 (530 — 590)*
H21	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	145 (130 — 160) *475 (430 — 520)*
H31	M/A/D	0.040 *0,040*	0.042 *0,0017*	0.065 *0,0026*	0.085 *0,0034*	0.13 *0,0050*	0.17 *0,0065*	0.20 *0,0080*	0.25 *0,010*	0.34 *0,013*	110 (98 — 120) *360 (330 — 390)*

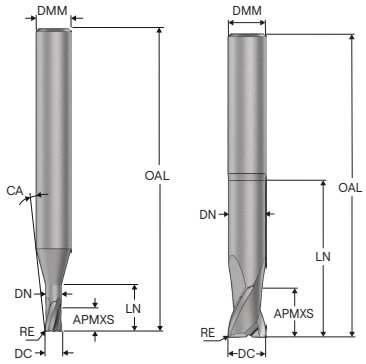
Schnittdaten, siehe Seite 699 - 707

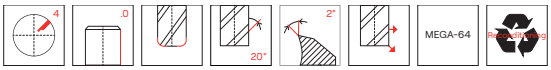
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH120

Hochgeschwindigkeitsfräsen – Gehärteter Stahl – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius







—Toleranzen:
—DMM=h5
—DC=-0,02/-0,03 mm
—RE= ±0,01 mm
—Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
120020-MEGA-64	00019437	2	G	2,0	6,0	2,5	50,0	5,0	1,9	0,2	10,5	4	Cylindrical	■
120025-MEGA-64	00019448	2	G	2,5	6,0	3,0	50,0	6,0	2,4	0,25	8,5	4	Cylindrical	■
120030-MEGA-64	00019450	2	G	3,0	6,0	4,0	50,0	7,0	2,8	0,3	7,0	4	Cylindrical	■
120035-MEGA-64	00019460	2	G	3,5	6,0	4,5	50,0	8,0	3,2	0,35	5,5	4	Cylindrical	■
120040-MEGA-64	00019462	2	G	4,0	6,0	5,0	50,0	9,0	3,7	0,4	4,5	4	Cylindrical	■
120050-MEGA-64	00019476	2	G	5,0	6,0	6,0	50,0	12,0	4,6	0,5	2,5	4	Cylindrical	■
120060-MEGA-64	00019479	2	E	6,0	6,0	7,0	55,0	14,0	5,6	0,6	–	4	Cylindrical	■
120080-MEGA-64	00019481	2	E	8,0	8,0	10,0	60,0	18,0	7,4	0,8	–	4	Cylindrical	■
120100-MEGA-64	00019494	2	E	10,0	10,0	12,0	70,0	25,0	9,4	1,0	–	4	Cylindrical	■
120120-MEGA-64	00019501	2	E	12,0	12,0	15,0	80,0	30,0	11,4	1,2	–	4	Cylindrical	■
120160-MEGA-64	00019503	2	E	16,0	16,0	18,0	90,0	35,0	15,4	1,6	–	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH120 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z											v_c
				2	2.5	3	3.5	4	5	6	8	10	12	16	
H3	M	0.0150 *0,0150*	0.50 *0,50*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	90 (57 — 130) *295 (190 — 420)*
H5	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	215 (180 — 250) *710 (600 — 820)*
H7	M	0.0150 *0,0150*	0.50 *0,50*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.019 *0,00075*	0.024 *0,00095*	0.028 *0,0011*	0.038 *0,0015*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	90 (57 — 130) *295 (190 — 420)*
H8	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	215 (180 — 250) *710 (600 — 820)*
H11	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	275 (230 — 320) *900 (760 — 1000)*
H12	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	250 (210 — 290) *820 (690 — 950)*
H21	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	215 (180 — 250) *710 (600 — 820)*
H31	M	0.0300 *0,0300*	1.0 *1,0*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.095 *0,0038*	135 (120 — 150) *445 (400 — 490)*

Schnittdaten – JH120 Nutfräsen

SMG		a_p/DC	f_z										v_c
			2	2.5	3	3.5	4	5	6	8	10	12	16	
H3	M	0.050 *0,050*	0.0050 *0,00020*	0.0065 *0,00026*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	55 (34 — 78) *180 (120 — 250)*
H5	M	0.18 *0,18*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	120 (98 — 140) *395 (330 — 450)*
H7	M	0.050 *0,050*	0.0050 *0,00020*	0.0065 *0,00026*	0.0075 *0,00030*	0.0090 *0,00036*	0.010 *0,00040*	0.013 *0,00050*	0.015 *0,00060*	0.020 *0,00080*	0.025 *0,0010*	0.030 *0,0012*	0.038 *0,0015*	55 (34 — 78) *180 (120 — 250)*
H8	M	0.18 *0,18*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	125 (110 — 140) *410 (370 — 450)*
H11	M	0.18 *0,18*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.014 *0,00055*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	150 (130 — 170) *490 (430 — 550)*
H12	M	0.18 *0,18*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	145 (120 — 170) *475 (400 — 550)*
H21	M	0.18 *0,18*	0.0060 *0,00024*	0.0075 *0,00030*	0.0090 *0,00036*	0.011 *0,00044*	0.012 *0,00048*	0.015 *0,00060*	0.018 *0,00070*	0.025 *0,0010*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	125 (110 — 140) *410 (370 — 450)*
H31	M	0.18 *0,18*	0.0055 *0,00022*	0.0065 *0,00026*	0.0080 *0,00032*	0.0090 *0,00036*	0.011 *0,00044*	0.013 *0,00050*	0.016 *0,00065*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	80 (70 — 92) *260 (230 — 300)*

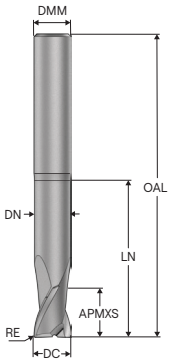
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH130

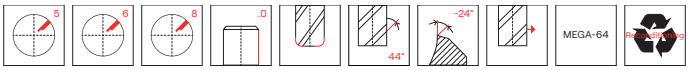
Hochgeschwindigkeitsfräsen – Gehärteter Stahl – Eckfräser – 5-8 Schneiden – Zylindrisch – Eckenradius





E

—Toleranzen:
—DMM=h5
—DC=-0,02/-0,04 mm
—RE= ±0,05 mm
—Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
130060-MEGA-64	00019504	2	E	6,0	6,0	6,0	55,0	12,0	5,6	0,2	5	Cylindrical	■
130080-MEGA-64	00019507	2	E	8,0	8,0	8,0	60,0	16,0	7,4	0,2	5	Cylindrical	■
130100-MEGA-64	00019511	2	E	10,0	10,0	10,0	70,0	20,0	9,4	0,3	6	Cylindrical	■
130120-MEGA-64	00019512	2	E	12,0	12,0	12,0	80,0	24,0	11,4	0,5	6	Cylindrical	■
130160-MEGA-64	00019514	2	E	16,0	16,0	16,0	90,0	30,0	15,4	0,5	8	Cylindrical	■
130200-MEGA-64	00019542	2	E	20,0	20,0	20,0	100,0	35,0	19,2	0,5	8	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH130 Eckfräsen/Schlichten

SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
H3	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H5	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	255 (240 — 270) *840 (790 — 880)*
H7	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H8	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	260 (240 — 270) *850 (790 — 880)*
H11	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	320 (300 — 340) *1050 (990 — 1100)*
H12	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	300 (280 — 320) *980 (920 — 1000)*
H21	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	260 (240 — 270) *850 (790 — 880)*
H31	M	0.0300 *0,0300*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	155 (140 — 170) *510 (460 — 550)*

Schnittdaten – JH130 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
H3	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H5	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	255 (240 — 270) *840 (790 — 880)*
H7	M	0.0300 *0,0300*	0.50 *0,50*	0.013 *0,00050*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	85 (73 — 93) *280 (240 — 300)*
H8	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	260 (240 — 270) *850 (790 — 880)*
H11	M	0.0300 *0,0300*	1.0 *1,0*	0.032 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	320 (300 — 340) *1050 (990 — 1100)*
H12	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	300 (280 — 320) *980 (920 — 1000)*
H21	M	0.0300 *0,0300*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.060 *0,0024*	0.065 *0,0026*	260 (240 — 270) *850 (790 — 880)*
H31	M	0.0300 *0,0300*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	155 (140 — 170) *510 (460 — 550)*

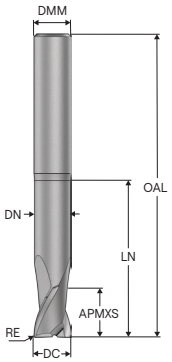
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH930

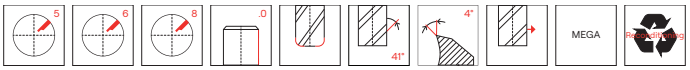
Hochgeschwindigkeitsfräsen – Universell – Eckfräser – 5-8 Schneiden – Zylindrisch – Eckenradius





E

—Toleranzen:
—DMM=h5
—DC=-0,02/-0,04 mm
—RE= ±0,05 mm
—Nachschleifen möglich



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
930060R020-MEGA	00022026	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,2	5	Cylindrical	■
930060R050-MEGA	00022027	2	E	6,0	6,0	9,0	55,0	15,0	5,6	0,5	5	Cylindrical	■
930080R020-MEGA	00022028	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,2	5	Cylindrical	■
930080R050-MEGA	00022029	2	E	8,0	8,0	12,0	60,0	18,0	7,4	0,5	5	Cylindrical	■
930100R030-MEGA	00022030	2	E	10,0	10,0	15,0	70,0	25,0	9,4	0,3	6	Cylindrical	■
930100R100-MEGA	00022031	2	E	10,0	10,0	15,0	70,0	25,0	9,4	1,0	6	Cylindrical	■
930120R050-MEGA	00022033	2	E	12,0	12,0	18,0	80,0	30,0	11,4	0,5	6	Cylindrical	■
930120R100-MEGA	00022034	2	E	12,0	12,0	18,0	80,0	30,0	11,4	1,0	6	Cylindrical	■
930160R050-MEGA	00022035	2	E	16,0	16,0	24,0	90,0	35,0	15,4	0,5	8	Cylindrical	■
930160R100-MEGA	00022040	2	E	16,0	16,0	24,0	90,0	35,0	15,4	1,0	8	Cylindrical	■
930200R050-MEGA	00022044	2	E	20,0	20,0	30,0	100,0	38,0	19,2	0,5	8	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH930 Eckfräsen

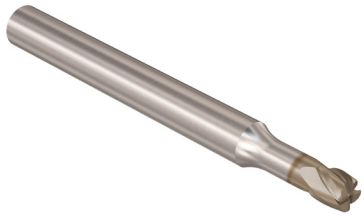
SMG		a_e/DC	a_p/DC	f_z						v_c
				6	8	10	12	16	20	
P1	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.085 *0,0034*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.18 *0,0070*	440 (370 — 490) *1450 (1300 — 1600)*
P2	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	430 (360 — 480) *1400 (1200 — 1500)*
P3	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	375 (320 — 420) *1225 (1100 — 1300)*
P4	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	330 (280 — 370) *1075 (920 — 1200)*
P5	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	315 (270 — 350) *1025 (890 — 1100)*
P6	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	355 (300 — 390) *1175 (990 — 1200)*
P7	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	335 (280 — 370) *1100 (920 — 1200)*
P8	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (270 — 350) *1025 (890 — 1100)*
P11	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	325 (280 — 360) *1075 (920 — 1100)*
P12	M/E/A	0.0400 *0,0400*	0.70 *0,70*	0.040 *0,0016*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	0.11 *0,0044*	200 (170 — 220) *660 (560 — 720)*
K1	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	255 (210 — 300) *840 (690 — 980)*
K2	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	225 (180 — 260) *740 (600 — 850)*
K3	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	190 (160 — 220) *620 (530 — 720)*
K4	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	180 (150 — 210) *590 (500 — 680)*
K5	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	205 (160 — 250) *670 (530 — 820)*
K6	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.065 *0,0026*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.16 *0,0065*	0.19 *0,0075*	300 (230 — 370) *980 (760 — 1200)*
K7	E/M/A	0.0300 *0,0300*	0.50 *0,50*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	260 (200 — 320) *850 (660 — 1000)*
S1	E/M/A	0.0300 *0,0300*	0.44 *0,44*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	80 (62 — 100) *260 (210 — 320)*
S2	E/M/A	0.0300 *0,0300*	0.44 *0,44*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	65 (50 — 82) *215 (170 — 260)*
S3	E/M/A	0.0200 *0,0200*	0.70 *0,70*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	0.15 *0,0060*	41 (31 — 50) *135 (110 — 160)*
S11	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	160 (140 — 180) *520 (460 — 590)*
S12	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	120 (110 — 140) *395 (370 — 450)*
S13	E/M/A	0.0400 *0,0400*	0.70 *0,70*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.13 *0,0050*	0.15 *0,0060*	95 (81 — 110) *310 (270 — 360)*
H3	M/A	0.0200 *0,0200*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	55 (41 — 71) *180 (140 — 230)*
H5	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	250 (210 — 300) *820 (690 — 980)*
H7	M/A	0.0200 *0,0200*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	55 (41 — 71) *180 (140 — 230)*
H8	M/A	0.0300 *0,0300*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	255 (210 — 300) *840 (690 — 980)*
H11	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	320 (260 — 380) *1050 (860 — 1200)*
H12	M/A	0.0400 *0,0400*	0.70 *0,70*	0.030 *0,0012*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.085 *0,0034*	270 (220 — 320) *890 (730 — 1000)*
H21	M/A	0.0300 *0,0300*	0.50 *0,50*	0.018 *0,00070*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	255 (210 — 300) *840 (690 — 980)*
H31	M/A	0.0300 *0,0300*	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	155 (130 — 180) *510 (430 — 590)*

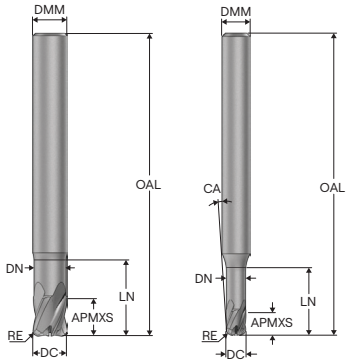
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

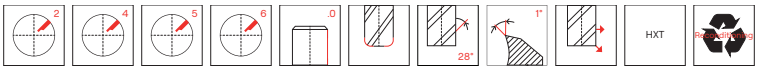
JH142

Hochgeschwindigkeitsfräsen – Hochpräzise – Torisch – Gehärteter Stahl – 2-6 Schneiden – Zylindrisch – Eckenra-





—Toleranzen:
—Rundlaufabweichung = <0,005 mm
—DMM = h5
—DC= 0-0,01 mm
—RE= ±0,005 mm
—Nachschleifen möglich, wenn DC ≥ Ø6 ist



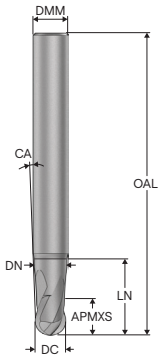
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
JH142020G2R030.0Z2-HXT	02968223	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	2	Cylindrical	■
JH142020G2R030.0Z4-HXT	02968224	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,3	6,64	4	Cylindrical	■
JH142020G2R050.0Z2-HXT	02968225	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	2	Cylindrical	■
JH142020G2R050.0Z4-HXT	02968226	2	G	2,0	4,0	2,0	40,0	6,0	1,9	0,5	6,79	4	Cylindrical	■
JH142030G2R050.0Z2-HXT	02968227	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	2	Cylindrical	■
JH142030G2R050.0Z4-HXT	02968228	2	G	3,0	4,0	3,0	40,0	8,0	2,8	0,5	2,95	4	Cylindrical	■
JH142030G2R100.0Z2-HXT	02968229	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	2	Cylindrical	■
JH142030G2R100.0Z4-HXT	02968230	2	G	3,0	4,0	3,0	40,0	8,0	2,8	1,0	3,1	4	Cylindrical	■
JH142040G2R030.0Z2-HXT	02968231	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	2	Cylindrical	■
JH142040G2R030.0Z4-HXT	02970110	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,3	5,34	4	Cylindrical	■
JH142040G2R050.0Z4-HXT	02968232	2	G	4,0	6,0	4,0	50,0	8,0	3,7	0,5	5,44	4	Cylindrical	■
JH142040G2R100.0Z4-HXT	02968233	2	G	4,0	6,0	4,0	50,0	8,0	3,7	1,0	5,69	4	Cylindrical	■
JH142060E2R050.0Z4-HXT	02968235	2	E	6,0	6,0	6,0	50,0	12,0	5,6	0,5	–	4	Cylindrical	■
JH142060E2R100.0Z4-HXT	02968237	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	4	Cylindrical	■
JH142060E2R100.0Z5-HXT	02968238	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,0	–	5	Cylindrical	■
JH142060E2R150.0Z5-HXT	02968240	2	E	6,0	6,0	6,0	50,0	12,0	5,6	1,5	–	5	Cylindrical	■
JH142060E2R200.0Z5-HXT	02968241	2	E	6,0	6,0	6,0	50,0	12,0	5,6	2,0	–	5	Cylindrical	■
JH142080E2R050.0Z5-HXT	02968242	2	E	8,0	8,0	8,0	60,0	16,0	7,4	0,5	–	5	Cylindrical	■
JH142080E2R100.0Z5-HXT	02968243	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,0	–	5	Cylindrical	■
JH142080E2R150.0Z5-HXT	02968244	2	E	8,0	8,0	8,0	60,0	16,0	7,4	1,5	–	5	Cylindrical	■
JH142080E2R200.0Z5-HXT	02968245	2	E	8,0	8,0	8,0	60,0	16,0	7,4	2,0	–	5	Cylindrical	■
JH142080E2R300.0Z5-HXT	02968246	2	E	8,0	8,0	8,0	60,0	16,0	7,4	3,0	–	5	Cylindrical	■
JH142100E2R050.0Z5-HXT	02968247	2	E	10,0	10,0	10,0	70,0	20,0	9,4	0,5	–	5	Cylindrical	■
JH142100E2R100.0Z5-HXT	02968248	2	E	10,0	10,0	10,0	70,0	20,0	9,4	1,0	–	5	Cylindrical	■
JH142100E2R200.0Z5-HXT	02968249	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,0	–	5	Cylindrical	■
JH142100E2R250.0Z5-HXT	02968250	2	E	10,0	10,0	10,0	70,0	20,0	9,4	2,5	–	5	Cylindrical	■
JH142120E2R100.0Z6-HXT	02968251	2	E	12,0	12,0	12,0	75,0	24,0	11,4	1,0	–	6	Cylindrical	■
JH142120E2R200.0Z6-HXT	02968252	2	E	12,0	12,0	12,0	75,0	24,0	11,4	2,0	–	6	Cylindrical	■
JH142120E2R300.0Z6-HXT	02968253	2	E	12,0	12,0	12,0	75,0	24,0	11,4	3,0	–	6	Cylindrical	■

■ **Lagerstandard.**

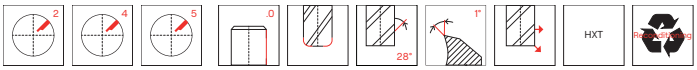
JH142

Hochgeschwindigkeitsfräsen – Hochpräzise – Torisch – Gehärteter Stahl – 2-5 Schneiden – Zylindrisch – Eckenra-





J



- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm					
JH142020J3R030.0Z2-HXT	02968255	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	0,9	2	Cylindrical	■
JH142020J3R030.0Z4-HXT	02968256	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,3	6,72	0,9	4	Cylindrical	■
JH142020J3R050.0Z2-HXT	02968257	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	0,9	2	Cylindrical	■
JH142020J3R050.0Z4-HXT	02968258	3	J	2,0	6,0	2,0	60,0	10,0	1,9	0,5	6,79	0,9	4	Cylindrical	■
JH142030J3R050.0Z2-HXT	02968259	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	0,9	2	Cylindrical	■
JH142030J3R050.0Z4-HXT	02968260	3	J	3,0	6,0	3,0	60,0	15,0	2,8	0,5	4,3	0,9	4	Cylindrical	■
JH142030J3R100.0Z2-HXT	02968261	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	0,9	2	Cylindrical	■
JH142030J3R100.0Z4-HXT	02968262	3	J	3,0	6,0	3,0	60,0	15,0	2,8	1,0	4,4	0,9	4	Cylindrical	■
JH142040J3R030.0Z2-HXT	02968263	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	0,9	2	Cylindrical	■
JH142040J3R030.0Z4-HXT	02970111	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,3	2,45	0,9	4	Cylindrical	■
JH142040J3R050.0Z2-HXT	02968265	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	0,9	2	Cylindrical	■
JH142040J3R050.0Z4-HXT	02968264	3	J	4,0	6,0	4,0	60,0	20,0	3,7	0,5	2,48	0,9	4	Cylindrical	■
JH142040J3R100.0Z2-HXT	02968266	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	0,9	2	Cylindrical	■
JH142040J3R100.0Z4-HXT	02968267	3	J	4,0	6,0	4,0	60,0	20,0	3,7	1,0	2,53	0,9	4	Cylindrical	■
JH142060J3R050.0Z4-HXT	02968268	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	0,9	4	Cylindrical	■
JH142060J3R050.0Z5-HXT	02968269	3	J	6,0	8,0	6,0	75,0	30,0	5,6	0,5	1,75	0,9	5	Cylindrical	■
JH142060J3R100.0Z4-HXT	02968270	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	0,9	4	Cylindrical	■
JH142060J3R100.0Z5-HXT	02968271	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,0	1,77	0,9	5	Cylindrical	■
JH142060J3R150.0Z5-HXT	02968272	3	J	6,0	8,0	6,0	75,0	30,0	5,6	1,5	1,8	0,9	5	Cylindrical	■
JH142060J3R200.0Z5-HXT	02968273	3	J	6,0	8,0	6,0	75,0	30,0	5,6	2,0	1,83	0,9	5	Cylindrical	■
JH142080J3R050.0Z5-HXT	02968274	3	J	8,0	10,0	8,0	85,0	40,0	7,4	0,5	1,34	0,9	5	Cylindrical	■
JH142080J3R100.0Z5-HXT	02968275	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,0	1,36	0,9	5	Cylindrical	■
JH142080J3R150.0Z5-HXT	02968276	3	J	8,0	10,0	8,0	85,0	40,0	7,4	1,5	1,37	0,9	5	Cylindrical	■
JH142080J3R200.0Z5-HXT	02968277	3	J	8,0	10,0	8,0	85,0	40,0	7,4	2,0	1,39	0,9	5	Cylindrical	■
JH142100J3R050.0Z5-HXT	02968278	3	J	10,0	12,0	10,0	100,0	50,0	9,4	0,5	1,1	0,9	5	Cylindrical	■
JH142100J3R100.0Z5-HXT	02968279	3	J	10,0	12,0	10,0	100,0	50,0	9,4	1,0	1,11	0,9	5	Cylindrical	■
JH142100J3R200.0Z5-HXT	02968280	3	J	10,0	12,0	10,0	100,0	50,0	9,4	2,0	1,13	0,9	5	Cylindrical	■
JH142020J6R030.0Z4-HXT	02968282	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,3	4,33	0,9	4	Cylindrical	■
JH142020J6R050.0Z4-HXT	02968283	6	J	2,0	6,0	2,0	75,0	20,0	1,9	0,5	4,36	0,9	4	Cylindrical	■
JH142030J6R050.0Z4-HXT	02968284	6	J	3,0	6,0	3,0	75,0	30,0	2,8	0,5	2,52	0,9	4	Cylindrical	■
JH142030J6R100.0Z4-HXT	02968285	6	J	3,0	6,0	3,0	75,0	30,0	2,8	1,0	2,56	0,9	4	Cylindrical	■
JH142040J6R030.0Z4-HXT	02968286	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,3	1,36	0,9	4	Cylindrical	■
JH142040J6R050.0Z4-HXT	02968287	6	J	4,0	6,0	4,0	80,0	40,0	3,7	0,5	1,37	0,9	4	Cylindrical	■
JH142040J6R100.0Z4-HXT	02968288	6	J	4,0	6,0	4,0	80,0	40,0	3,7	1,0	1,38	0,9	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH142 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z								v_c
				2	3	4	6	8	10	12	16	
P1	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.14 *0,0055*	485 (460 — 530) *1600 (1600 — 1700)*
P2	M/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	470 (450 — 520) *1550 (1500 — 1700)*
P3	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	405 (390 — 450) *1325 (1300 — 1400)*
P4	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	360 (340 — 390) *1175 (1200 — 1200)*
P5	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
P6	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	385 (370 — 420) *1275 (1300 — 1300)*
P7	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	365 (350 — 400) *1200 (1200 — 1300)*
P8	M/E	0.0500 *0,0500*	0.050 *0,050*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.055 *0,0022*	0.075 *0,0030*	0.095 *0,0038*	0.11 *0,0044*	0.14 *0,0055*	340 (330 — 380) *1125 (1100 — 1200)*
P11	M/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	355 (340 — 390) *1175 (1200 — 1200)*
K1	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
K2	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	300 (290 — 330) *980 (960 — 1000)*
K3	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	255 (240 — 280) *840 (790 — 910)*
K4	A/E	0.0500 *0,0500*	0.050 *0,050*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.050 *0,0020*	0.065 *0,0026*	0.085 *0,0034*	0.10 *0,0040*	0.12 *0,0048*	245 (230 — 260) *800 (760 — 850)*
K5	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	345 (330 — 380) *1125 (1100 — 1200)*
K6	A/E	0.0500 *0,0500*	0.050 *0,050*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	500 (480 — 550) *1650 (1600 — 1800)*
K7	A/E	0.0500 *0,0500*	0.050 *0,050*	0.018 *0,00070*	0.028 *0,0011*	0.036 *0,0014*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.13 *0,0050*	440 (420 — 490) *1450 (1400 — 1600)*
H3	M/A	0.0200 *0,0200*	0.020 *0,020*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	95 (72 — 110) *310 (240 — 360)*
H5	M/A	0.0400 *0,0400*	0.040 *0,040*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	305 (290 — 330) *1000 (960 — 1000)*
H7	M/A	0.0200 *0,0200*	0.020 *0,020*	0.014 *0,00055*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.080 *0,0032*	0.10 *0,0040*	95 (72 — 110) *310 (240 — 360)*
H8	M/A	0.0400 *0,0400*	0.040 *0,040*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	310 (290 — 330) *1025 (960 — 1000)*
H11	M/A	0.0400 *0,0400*	0.040 *0,040*	0.014 *0,00055*	0.022 *0,00085*	0.028 *0,0011*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	390 (360 — 420) *1275 (1200 — 1300)*
H12	M/A	0.0500 *0,0500*	0.050 *0,050*	0.0095 *0,00038*	0.014 *0,00055*	0.019 *0,00075*	0.028 *0,0011*	0.038 *0,0015*	0.046 *0,0018*	0.055 *0,0022*	0.070 *0,0028*	345 (320 — 370) *1125 (1100 — 1200)*
H21	M/A	0.0400 *0,0400*	0.040 *0,040*	0.011 *0,00044*	0.016 *0,00065*	0.022 *0,00085*	0.032 *0,0013*	0.042 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	0.080 *0,0032*	310 (290 — 330) *1025 (960 — 1000)*
H31	M/A	0.0300 *0,0300*	0.030 *0,030*	0.013 *0,00050*	0.019 *0,00075*	0.025 *0,0010*	0.038 *0,0015*	0.050 *0,0020*	0.065 *0,0026*	0.075 *0,0030*	0.090 *0,0036*	140 (120 — 160) *460 (400 — 520)*

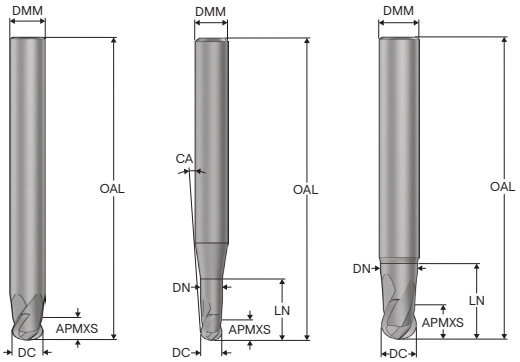
Schnittdaten, siehe Seite 699 - 707

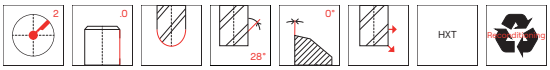
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH112

Hochgeschwindigkeitsfräsen – Hochpräzise – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch







- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

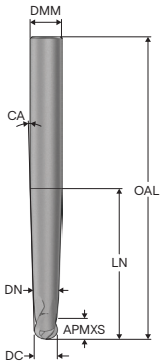
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
JH112020G1B.0Z2-HXT	02970112	1	G	2,0	4,0	2,0	40,0	4,0	1,9	1,0	6,45	2	Cylindrical	■
JH112030G1B.0Z2-HXT	02970113	1	G	3,0	4,0	3,0	40,0	6,0	2,8	1,5	3,3	2	Cylindrical	■
JH112040D1B.0Z2-HXT	02970114	1	D	4,0	4,0	4,0	40,0	–	–	2,0	–	2	Cylindrical	■
JH112050G1B.0Z2-HXT	02970115	1	G	5,0	6,0	5,0	50,0	10,0	4,6	2,5	2,0	2	Cylindrical	■
JH112060D1B.0Z2-HXT	02970116	1	D	6,0	6,0	6,0	50,0	–	–	3,0	–	2	Cylindrical	■
JH112080D1B.0Z2-HXT	02970117	1	D	8,0	8,0	8,0	65,0	–	–	4,0	–	2	Cylindrical	■
JH112100D1B.0Z2-HXT	02970118	1	D	10,0	10,0	10,0	65,0	–	–	5,0	–	2	Cylindrical	■
JH112020G2B.0Z2-HXT	02970119	2	G	2,0	3,0	2,0	50,0	10,0	1,9	1,0	2,5	2	Cylindrical	■
JH112030D2B.0Z2-HXT	02970120	2	D	3,0	3,0	3,0	50,0	–	–	1,5	–	2	Cylindrical	■
JH112040D2B.0Z2-HXT	02970121	2	D	4,0	4,0	4,0	60,0	–	–	2,0	–	2	Cylindrical	■
JH112050D2B.0Z2-HXT	02970122	2	D	5,0	5,0	5,0	60,0	–	–	2,5	–	2	Cylindrical	■
JH112060D2B.0Z2-HXT	02970123	2	D	6,0	6,0	6,0	75,0	–	–	3,0	–	2	Cylindrical	■
JH112020G3B.0Z2-HXT	02970124	3	G	2,0	6,0	2,0	60,0	4,0	1,9	1,0	8,12	2	Cylindrical	■
JH112025G3B.0Z2-HXT	02970125	3	G	2,5	6,0	2,5	60,0	5,0	2,4	1,25	7,39	2	Cylindrical	■
JH112030G3B.0Z2-HXT	02970126	3	G	3,0	6,0	3,0	60,0	6,0	2,8	1,5	5,5	2	Cylindrical	■
JH112035G3B.0Z2-HXT	02968289	3	G	3,5	6,0	3,5	65,0	7,0	3,2	1,75	3,81	2	Cylindrical	■
JH112040G3B.0Z2-HXT	02970127	3	G	4,0	6,0	4,0	65,0	8,0	3,7	2,0	3,34	2	Cylindrical	■
JH112050G3B.0Z2-HXT	02970128	3	G	5,0	6,0	5,0	65,0	10,0	4,6	2,5	2,0	2	Cylindrical	■
JH112060G3B.0Z2-HXT	02970129	3	G	6,0	8,0	6,0	75,0	12,0	5,6	3,0	2,78	2	Cylindrical	■
JH112080E3B.0Z2-HXT	02968290	3	E	8,0	8,0	8,0	75,0	16,0	7,4	4,0	–	2	Cylindrical	■
JH112100E3B.0Z2-HXT	02968291	3	E	10,0	10,0	10,0	80,0	20,0	9,4	5,0	–	2	Cylindrical	■
JH112120E3B.0Z2-HXT	02968292	3	E	12,0	12,0	12,0	90,0	24,0	11,4	6,0	–	2	Cylindrical	■
JH112020G4B.0Z2-HXT	02970130	4	G	2,0	6,0	2,0	80,0	20,0	1,9	1,0	3,82	2	Cylindrical	■
JH112030G4B.0Z2-HXT	02970131	4	G	3,0	6,0	3,0	80,0	20,0	2,8	1,5	2,91	2	Cylindrical	■
JH112040G4B.0Z2-HXT	02970132	4	G	4,0	6,0	4,0	80,0	20,0	3,7	2,0	1,97	2	Cylindrical	■
JH112050G4B.0Z2-HXT	02970133	4	G	5,0	6,0	5,0	100,0	50,0	4,6	2,5	0,53	2	Cylindrical	■
JH112060D4B.0Z2-HXT	02968293	4	D	6,0	6,0	6,0	100,0	–	–	3,0	–	2	Cylindrical	■
JH112080D4B.0Z2-HXT	02968294	4	D	8,0	8,0	8,0	110,0	–	–	4,0	–	2	Cylindrical	■
JH112100D4B.0Z2-HXT	02968295	4	D	10,0	10,0	10,0	125,0	–	–	5,0	–	2	Cylindrical	■
JH112120D4B.0Z2-HXT	02968296	4	D	12,0	12,0	12,0	125,0	–	–	6,0	–	2	Cylindrical	■

■ **Lagerstandard.**

JH112

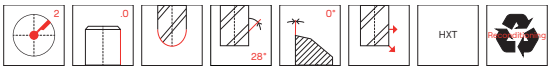
Hochgeschwindigkeitsfräsen – Hochpräzise – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch





J

—Toleranzen:
—Rundlaufabweichung = <0,005 mm
—DMM = h5
—DC= 0-0,01 mm
—RE= ±0,005 mm
—Nachschleifen möglich, wenn DC ≥ Ø6 ist



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm					
JH112020J5B.0Z2-HXT	02970134	5	J	2,0	6,0	2,0	80,0	35,0	1,9	1,0	3,3	3,55	2	Cylindrical	■
JH112030J5B.0Z2-HXT	02970135	5	J	3,0	6,0	3,0	80,0	40,0	2,8	1,5	2,2	2,5	2	Cylindrical	■
JH112040J5B.0Z2-HXT	02970136	5	J	4,0	6,0	4,0	80,0	52,0	3,7	2,0	1,2	1,4	2	Cylindrical	■
JH112050J5B.0Z2-HXT	02970137	5	J	5,0	8,0	5,0	100,0	56,0	4,6	2,5	1,6	1,95	2	Cylindrical	■
JH112060J5B.0Z2-HXT	02970138	5	J	6,0	8,0	6,0	100,0	56,0	5,6	3,0	1,1	1,4	2	Cylindrical	■
JH112080J5B.0Z2-HXT	02970139	5	J	8,0	10,0	8,0	125,0	62,0	7,4	4,0	1,0	1,43	2	Cylindrical	■
JH112100J5B.0Z2-HXT	02970140	5	J	10,0	12,0	10,0	125,0	61,0	9,4	5,0	1,0	1,5	2	Cylindrical	■
JH112060J6B.0Z2-HXT	02970141	6	J	6,0	10,0	6,0	125,0	62,0	5,6	3,0	2,0	2,3	2	Cylindrical	■
JH112080J6B.0Z2-HXT	02970142	6	J	8,0	12,0	8,0	150,0	67,0	7,4	4,0	1,8	2,3	2	Cylindrical	■
JH112100J6B.0Z2-HXT	02970143	6	J	10,0	12,0	10,0	150,0	79,0	9,4	5,0	0,8	1,1	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH112 Kopierfräsen/ Feinbearbeitung

SMG		a_p/DC	f_z										v_c
			2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	520 (500 — 730) *1700 (1700 — 2300)*
K2	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	445 (430 — 630) *1450 (1500 — 2000)*
K3	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	380 (360 — 530) *1250 (1200 — 1700)*
K4	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	360 (350 — 510) *1175 (1200 — 1600)*
K5	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	415 (370 — 610) *1350 (1300 — 2000)*
K6	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	610 (550 — 900) *2000 (1900 — 2900)*
K7	E	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	680 (560 — 790) *2225 (1900 — 2500)*
H3	M	0.16 *0,16*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (150 — 230) *510 (500 — 750)*
H5	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H7	M	0.16 *0,16*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	155 (150 — 230) *510 (500 — 750)*
H8	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H11	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	360 (300 — 420) *1175 (990 — 1300)*
H12	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	330 (280 — 380) *1075 (920 — 1200)*
H21	M	0.30 *0,30*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	285 (240 — 330) *940 (790 — 1000)*
H31	M	0.30 *0,30*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	300 (290 — 430) *980 (960 — 1400)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JH112 Kopierfräsen/Schruppen

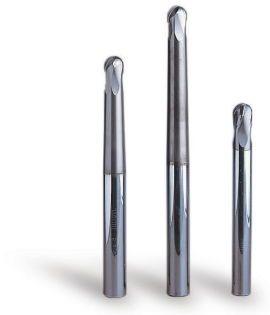
SMG		a_e/DC	a_p/DC	f_z										v_c
				2	2.5	3	3.5	4	5	6	8	10	12	
K1	E	0.250 *0,250*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	315 (310 — 450) *1025 (1100 — 1400)*
K2	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	280 (270 — 390) *920 (890 — 1200)*
K3	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	235 (230 — 330) *770 (760 — 1000)*
K4	E	0.250 *0,250*	0.15 *0,15*	0.028 *0,0011*	0.036 *0,0014*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	0.085 *0,0034*	0.12 *0,0048*	0.14 *0,0055*	0.17 *0,0065*	225 (220 — 320) *740 (730 — 1000)*
K5	E	0.160 *0,160*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	280 (250 — 410) *920 (830 — 1300)*
K6	E	0.160 *0,160*	0.15 *0,15*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	415 (370 — 610) *1350 (1300 — 2000)*
K7	E	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	420 (350 — 490) *1375 (1200 — 1600)*
H3	M	0.120 *0,120*	0.040 *0,040*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	110 (100 — 160) *360 (330 — 520)*
H5	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H7	M	0.120 *0,120*	0.040 *0,040*	0.028 *0,0011*	0.036 *0,0014*	0.042 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	110 (100 — 160) *360 (330 — 520)*
H8	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H11	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	225 (190 — 260) *740 (630 — 850)*
H12	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	205 (170 — 240) *670 (560 — 780)*
H21	M	0.250 *0,250*	0.10 *0,10*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	175 (150 — 200) *570 (500 — 650)*
H31	M	0.200 *0,200*	0.10 *0,10*	0.026 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	200 (200 — 280) *660 (660 — 910)*

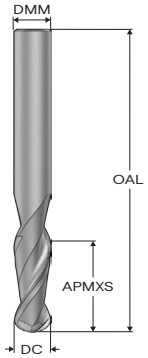
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

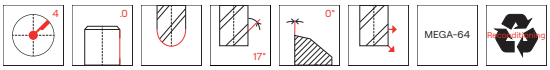
JH150

Hochgeschwindigkeitsfräsen – Gehärteter Stahl – Kugelkopf – 4 Schneiden – Zylindrisch





D



- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- Nachschleifen möglich

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
150060-MEGA-64	00019198	2	D	6,0	6,0	6,0	80,0	3,0	4	Cylindrical	■
150080-MEGA-64	00019208	2	D	8,0	8,0	8,0	85,0	4,0	4	Cylindrical	■
150100-MEGA-64	00019219	2	D	10,0	10,0	10,0	100,0	5,0	4	Cylindrical	■
150120-MEGA-64	00019254	2	D	12,0	12,0	12,0	100,0	6,0	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH150 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
K1	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	290 (310 — 370) *950 (1100 — 1200)*
K2	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	250 (270 — 320) *820 (890 — 1000)*
K3	A	0.300 *0,300*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	210 (230 — 270) *690 (760 — 880)*
K5	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	255 (270 — 330) *840 (890 — 1000)*
K6	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	375 (390 — 500) *1225 (1300 — 1600)*
K7	A	0.200 *0,200*	0.15 *0,15*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	325 (340 — 430) *1075 (1200 — 1400)*
H3	M	0.0500 *0,0500*	0.020 *0,020*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	85 (88 — 120) *280 (290 — 390)*
H5	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H7	M	0.0500 *0,0500*	0.020 *0,020*	0.085 *0,0034*	0.11 *0,0044*	0.14 *0,0055*	0.17 *0,0065*	85 (88 — 120) *280 (290 — 390)*
H8	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H11	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	230 (210 — 250) *750 (690 — 820)*
H12	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	210 (190 — 230) *690 (630 — 750)*
H21	M	0.200 *0,200*	0.060 *0,060*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	180 (160 — 200) *590 (530 — 650)*
H31	M	0.150 *0,150*	0.060 *0,060*	0.090 *0,0036*	0.12 *0,0048*	0.15 *0,0060*	0.18 *0,0070*	125 (130 — 180) *410 (430 — 590)*

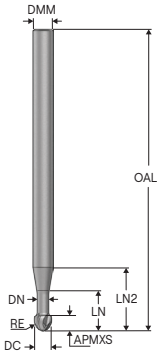
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JH160

Hochgeschwindigkeitsfräsen – Gehärteter Stahl – Kugelkopf – 4 Schneiden – Zylindrisch





E



—Toleranzen:
—DMM= h5
—DC= 0,02/-0,06 mm
—SA=250°

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
160030-MEGA-64	00040365	2	E	3,0	3,0	2,3	60,0	4,5	1,8	1,5	4	Cylindrical	■
160040-MEGA-64	00040366	2	E	4,0	4,0	3,1	60,0	5,6	2,4	2,0	4	Cylindrical	■
160050-MEGA-64	00040367	2	E	5,0	5,0	3,9	70,0	6,4	3,0	2,5	4	Cylindrical	■
160060-MEGA-64	00040368	2	E	6,0	6,0	4,7	80,0	9,7	3,6	3,0	4	Cylindrical	■
160080-MEGA-64	00040369	2	E	8,0	8,0	6,2	85,0	11,2	4,8	4,0	4	Cylindrical	■
160100-MEGA-64	00040370	2	E	10,0	10,0	7,8	100,0	15,6	6,0	5,0	4	Cylindrical	■
160120-MEGA-64	00040371	2	E	12,0	12,0	9,4	125,0	17,2	7,2	6,0	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JH160 Kopierfräsen/ Feinbearbeitung

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
P1	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	550 (450 — 700) *1800 (1500 — 2200)*
P2	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	530 (440 — 680) *1750 (1500 — 2200)*
P3	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	460 (380 — 590) *1500 (1300 — 1900)*
P4	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	405 (340 — 520) *1325 (1200 — 1700)*
P5	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	385 (320 — 490) *1275 (1100 — 1600)*
P6	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	430 (360 — 560) *1400 (1200 — 1800)*
P7	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	410 (340 — 520) *1350 (1200 — 1700)*
P8	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	385 (320 — 490) *1275 (1100 — 1600)*
P11	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	395 (330 — 510) *1300 (1100 — 1600)*
P12	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	235 (200 — 300) *770 (660 — 980)*
H3	M/E/A	0.0100 *0,0100*	0.0075 *0,0075*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	85 (91 — 110) *280 (300 — 360)*
H5	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H7	M/E/A	0.0100 *0,0100*	0.0075 *0,0075*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	85 (91 — 110) *280 (300 — 360)*
H8	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H11	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	430 (400 — 460) *1400 (1400 — 1500)*
H12	M/E/A	0.0200 *0,0200*	0.024 *0,024*	0.050 *0,0020*	0.070 *0,0028*	0.085 *0,0034*	0.10 *0,0040*	0.14 *0,0055*	0.17 *0,0065*	0.20 *0,0080*	355 (340 — 380) *1175 (1200 — 1200)*
H21	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	340 (320 — 360) *1125 (1100 — 1100)*
H31	M/E/A	0.0100 *0,0100*	0.016 *0,016*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	165 (180 — 210) *540 (600 — 680)*

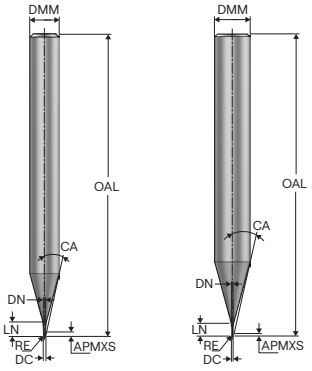
Schnittdaten, siehe Seite 699 - 707

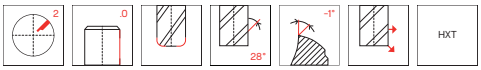
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JME142

Mini – Gehärteter Stahl – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius







- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC= < Ø0,6= 0/-0,008 mm
- DC= ≥ Ø0,6= 0/-0,01 mm
- RE = ±0,005 mm

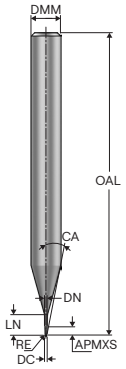
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm						
JME142002G1R005Z2.0-HXT	03205080	1	G	0,2	4,0	0,15	40,0	0,4	0,18	0,05	15,12	–	-1,0	2	Cylindrical	■
JME142003G1R005Z2.0-HXT	03205082	1	G	0,3	4,0	0,225	40,0	0,6	0,28	0,05	14,77	–	-1,0	2	Cylindrical	■
JME142004G1R005Z2.0-HXT	03205084	1	G	0,4	4,0	0,3	40,0	0,8	0,37	0,05	14,39	–	-1,0	2	Cylindrical	■
JME142005G1R005Z2.0-HXT	03205086	1	G	0,5	4,0	0,375	40,0	0,75	0,46	0,05	14,01	–	-1,0	2	Cylindrical	■
JME142006G1R005Z2.0-HXT	03205099	1	G	0,6	4,0	0,45	40,0	0,9	0,56	0,05	13,67	–	-1,0	2	Cylindrical	■
JME142008G1R005Z2.0-HXT	03205121	1	G	0,8	6,0	0,6	50,0	1,2	0,76	0,05	13,98	–	-1,0	2	Cylindrical	■
JME142010G1R005Z2.0-HXT	03205139	1	G	1,0	6,0	0,75	50,0	1,5	0,95	0,05	13,49	–	-1,0	2	Cylindrical	■
JME142012G1R005Z2.0-HXT	03205151	1	G	1,2	6,0	0,9	50,0	1,8	1,15	0,05	13,02	–	-1,0	2	Cylindrical	■
JME142015G1R005Z2.0-HXT	03205161	1	G	1,5	6,0	1,125	50,0	2,25	1,45	0,05	12,3	–	-1,0	2	Cylindrical	■
JME142002J2R005Z2.0-HXT	03205081	2	J	0,2	4,0	0,15	40,0	0,6	0,18	0,05	14,23	0,9	-1,0	2	Cylindrical	■
JME142003J2R005Z2.0-HXT	03205083	2	J	0,3	4,0	0,225	40,0	0,9	0,28	0,05	13,67	0,9	-1,0	2	Cylindrical	■
JME142004J2R005Z2.0-HXT	03205085	2	J	0,4	4,0	0,3	40,0	1,2	0,37	0,05	13,1	0,9	-1,0	2	Cylindrical	■
JME142005J2R005Z2.0-HXT	03205087	2	J	0,5	4,0	0,375	40,0	1,5	0,46	0,05	12,54	0,9	-1,0	2	Cylindrical	■
JME142005J2R010Z2.0-HXT	03205093	2	J	0,5	4,0	0,375	40,0	1,5	0,46	0,1	12,61	0,9	-1,0	2	Cylindrical	■
JME142005G2R005Z2.0-HXT	03205088	2	G	0,5	6,0	0,375	50,0	1,5	0,46	0,05	13,5	–	-1,0	2	Cylindrical	■
JME142005G2R010Z2.0-HXT	03205094	2	G	0,5	6,0	0,375	50,0	1,5	0,46	0,1	13,55	–	-1,0	2	Cylindrical	■
JME142006J2R005Z2.0-HXT	03205100	2	J	0,6	4,0	0,45	40,0	2,0	0,56	0,05	11,76	0,9	-1,0	2	Cylindrical	■
JME142006J2R010Z2.0-HXT	03205107	2	J	0,6	4,0	0,45	40,0	2,0	0,56	0,1	11,83	0,9	-1,0	2	Cylindrical	■
JME142006G2R005Z2.0-HXT	03205101	2	G	0,6	6,0	0,45	50,0	2,0	0,56	0,05	9,48	–	-1,0	2	Cylindrical	■
JME142006G2R010Z2.0-HXT	03205108	2	G	0,6	6,0	0,45	50,0	2,0	0,56	0,1	9,51	–	-1,0	2	Cylindrical	■
JME142008J2R005Z2.0-HXT	03205122	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,05	10,92	0,9	-1,0	2	Cylindrical	■
JME142008J2R010Z2.0-HXT	03205129	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,1	10,98	0,9	-1,0	2	Cylindrical	■
JME142008J2R020Z2.0-HXT	03205135	2	J	0,8	4,0	0,6	40,0	2,5	0,76	0,2	11,1	0,9	-1,0	2	Cylindrical	■
JME142008G2R005Z2.0-HXT	03205123	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,05	9,15	–	-1,0	2	Cylindrical	■
JME142008G2R010Z2.0-HXT	03205130	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,1	9,17	–	-1,0	2	Cylindrical	■
JME142008G2R020Z2.0-HXT	03205136	2	G	0,8	6,0	0,6	50,0	2,5	0,76	0,2	9,22	–	-1,0	2	Cylindrical	■
JME142010G2R005Z2.0-HXT	03205140	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,05	8,29	–	-1,0	2	Cylindrical	■
JME142010G2R010Z2.0-HXT	03205145	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,1	8,31	–	-1,0	2	Cylindrical	■
JME142010G2R020Z2.0-HXT	03205148	2	G	1,0	6,0	0,75	50,0	4,0	0,95	0,2	8,36	–	-1,0	2	Cylindrical	■
JME142012G2R005Z2.0-HXT	03205152	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,05	7,97	–	-1,0	2	Cylindrical	■
JME142012G2R010Z2.0-HXT	03205155	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,1	7,99	–	-1,0	2	Cylindrical	■
JME142012G2R020Z2.0-HXT	03205158	2	G	1,2	6,0	0,9	50,0	4,5	1,15	0,2	8,04	–	-1,0	2	Cylindrical	■
JME142015G2R005Z2.0-HXT	03205162	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,05	7,6	–	-1,0	2	Cylindrical	■
JME142015G2R010Z2.0-HXT	03205167	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,1	9,7	–	-1,0	2	Cylindrical	■
JME142015G2R020Z2.0-HXT	03205171	2	G	1,5	6,0	1,125	50,0	5,0	1,45	0,2	9,76	–	-1,0	2	Cylindrical	■

■ **Lagerstandard.**

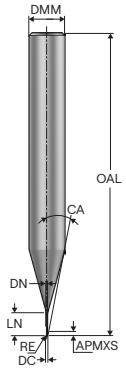
JME142

Mini – Gehärteter Stahl – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius



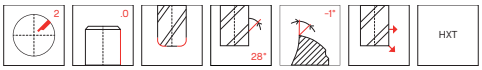


J



G

– Toleranzen:
– Rundlaufabweichung = <0,005 mm
– DMM = h5
– DC= < Ø0,6= 0/-0,008 mm
– DC= ≥ Ø0,6= 0/-0,01 mm
– RE = ±0,005 mm



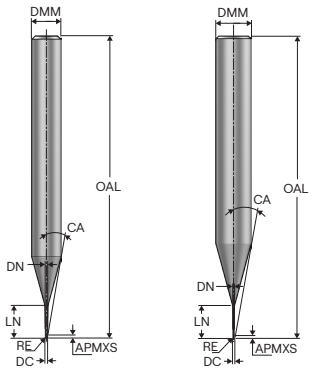
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm						
JME142020G2R005Z2.0-HXT	03205180	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,05	8,52	–	-1,0	2	Cylindrical	■
JME142020G2R010Z2.0-HXT	03205185	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,1	8,55	–	-1,0	2	Cylindrical	■
JME142020G2R020Z2.0-HXT	03205188	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,2	8,6	–	-1,0	2	Cylindrical	■
JME142020G2R030Z2.0-HXT	03205191	2	G	2,0	6,0	1,5	50,0	6,0	1,94	0,3	8,66	–	-1,0	2	Cylindrical	■
JME142030G2R005Z2.0-HXT	03205201	2	G	3,0	6,0	2,25	50,0	9,0	2,85	0,05	5,81	–	-1,0	2	Cylindrical	■
JME142005J3R005Z2.0-HXT	03205089	3	J	0,5	4,0	0,375	40,0	2,5	0,46	0,05	11,24	0,9	-1,0	2	Cylindrical	■
JME142005J3R010Z2.0-HXT	03205095	3	J	0,5	4,0	0,375	40,0	2,5	0,46	0,1	11,29	0,9	-1,0	2	Cylindrical	■
JME142005G3R005Z2.0-HXT	03205090	3	G	0,5	6,0	0,375	50,0	3,5	0,46	0,05	11,55	–	-1,0	2	Cylindrical	■
JME142005G3R010Z2.0-HXT	03205096	3	G	0,5	6,0	0,375	50,0	3,5	0,46	0,1	11,59	–	-1,0	2	Cylindrical	■
JME142006J3R005Z2.0-HXT	03205103	3	J	0,6	4,0	0,45	40,0	3,0	0,56	0,05	10,58	0,9	-1,0	2	Cylindrical	■
JME142006J3R010Z2.0-HXT	03205109	3	J	0,6	4,0	0,45	40,0	3,0	0,56	0,1	10,63	0,9	-1,0	2	Cylindrical	■
JME142006G3R005Z2.0-HXT	03205104	3	G	0,6	6,0	0,45	50,0	4,0	0,56	0,05	8,46	–	-1,0	2	Cylindrical	■
JME142006G3R010Z2.0-HXT	03205110	3	G	0,6	6,0	0,45	50,0	4,0	0,56	0,1	8,48	–	-1,0	2	Cylindrical	■
JME142008J3R005Z2.0-HXT	03205124	3	J	0,8	4,0	0,6	40,0	4,0	0,76	0,05	9,36	0,9	-1,0	2	Cylindrical	■
JME142008G3R005Z2.0-HXT	03205126	3	G	0,8	6,0	0,6	50,0	5,5	0,76	0,05	9,89	–	-1,0	2	Cylindrical	■
JME142010G3R005Z2.0-HXT	03205141	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,05	8,84	–	-1,0	2	Cylindrical	■
JME142010G3R010Z2.0-HXT	03205146	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,1	8,86	–	-1,0	2	Cylindrical	■
JME142010G3R020Z2.0-HXT	03205149	3	G	1,0	6,0	0,75	50,0	7,0	0,95	0,2	8,91	–	-1,0	2	Cylindrical	■
JME142015G3R005Z2.0-HXT	03205163	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,05	7,05	–	-1,0	2	Cylindrical	■
JME142015G3R010Z2.0-HXT	03205169	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,1	7,06	–	-1,0	2	Cylindrical	■
JME142015G3R020Z2.0-HXT	03205172	3	G	1,5	6,0	1,125	50,0	10,0	1,45	0,2	7,1	–	-1,0	2	Cylindrical	■

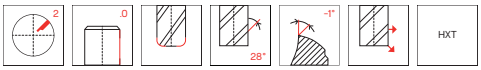
■ **Lagerstandard.**

JME142

Mini – Gehärteter Stahl – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius







– Toleranzen:
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– DC= < Ø0,6= 0/-0,008 mm
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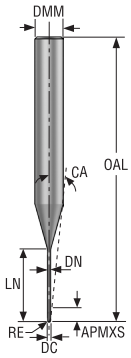
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm						
JME142020G3R005Z2.0-HXT	03205181	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,05	5,9	–	-1,0	2	Cylindrical	■
JME142020G3R010Z2.0-HXT	03205186	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,1	5,92	–	-1,0	2	Cylindrical	■
JME142020G3R020Z2.0-HXT	03205189	3	G	2,0	6,0	1,5	50,0	12,0	1,94	0,2	5,95	–	-1,0	2	Cylindrical	■
JME142030G3R010Z2.0-HXT	03205206	3	G	3,0	6,0	2,25	60,0	15,0	2,85	0,1	4,15	–	-1,0	2	Cylindrical	■
JME142005J4R010Z2.0-HXT	03205097	4	J	0,5	4,0	0,375	40,0	4,0	0,46	0,1	9,76	0,9	-1,0	2	Cylindrical	■
JME142005G4R005Z2.0-HXT	03205092	4	G	0,5	6,0	0,375	50,0	5,0	0,46	0,05	10,42	–	-1,0	2	Cylindrical	■
JME142005G4R010Z2.0-HXT	03205098	4	G	0,5	6,0	0,375	50,0	5,0	0,46	0,1	10,45	–	-1,0	2	Cylindrical	■
JME142006J4R005Z2.0-HXT	03205105	4	J	0,6	4,0	0,45	40,0	5,0	0,56	0,05	8,79	0,9	-1,0	2	Cylindrical	■
JME142008G4R005Z2.0-HXT	03205128	4	G	0,8	6,0	0,6	50,0	8,0	0,76	0,05	8,49	–	-1,0	2	Cylindrical	■
JME142010G4R010Z2.0-HXT	03205147	4	G	1,0	6,0	0,75	50,0	10,0	0,95	0,1	7,48	–	-1,0	2	Cylindrical	■
JME142010G4R020Z2.0-HXT	03205150	4	G	1,0	6,0	0,75	50,0	10,0	0,95	0,2	7,52	–	-1,0	2	Cylindrical	■
JME142012G4R010Z2.0-HXT	03205157	4	G	1,2	6,0	0,9	50,0	12,0	1,15	0,1	6,62	–	-1,0	2	Cylindrical	■
JME142012G4R020Z2.0-HXT	03205160	4	G	1,2	6,0	0,9	50,0	12,0	1,15	0,2	6,65	–	-1,0	2	Cylindrical	■
JME142015G4R010Z2.0-HXT	03205170	4	G	1,5	6,0	1,125	60,0	15,0	1,45	0,1	5,55	–	-1,0	2	Cylindrical	■
JME142015G4R020Z2.0-HXT	03205173	4	G	1,5	6,0	1,125	60,0	15,0	1,45	0,2	5,58	–	-1,0	2	Cylindrical	■

■ **Lagerstandard.**

JME142

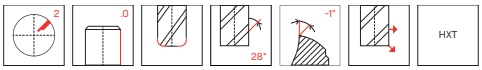
Mini – Gehärteter Stahl – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius





G

—Toleranzen:
—Rundlaufabweichung = <0,005 mm
—DMM = h5
—DC= < Ø0,6= 0/-0,008 mm
—DC= ≥ Ø0,6= 0/-0,01 mm
—RE = ±0,005 mm



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm					
JME142020G4R010Z2.0-HXT	03205187	4	G	2,0	6,0	1,5	60,0	20,0	1,94	0,1	4,19	-1,0	2	Cylindrical	■
JME142020G4R020Z2.0-HXT	03205190	4	G	2,0	6,0	1,5	60,0	20,0	1,94	0,2	4,21	-1,0	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JME142 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z													v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1,5	1,8	2	2,5	3	
H3	M/A	0.0500	0.30	0.0036	0.0055	0.0070	0.0090	0.011	0.014	0.018	0.022	0.026	0.032	0.036	0.044	0.055	90 (59 — 110)
		0,0500	*0,30*	*0,00014*	*0,00022*	*0,00028*	*0,00036*	*0,00044*	*0,00055*	*0,00070*	*0,00085*	*0,0010*	*0,0013*	*0,0014*	*0,0017*	*0,0022*	*295 (200 — 360)*
H5	M/A	0.0500	0.46	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	160 (140 — 190)
		0,0500	*0,46*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*520 (460 — 620)*
H7	M/A	0.0500	0.30	0.0036	0.0055	0.0070	0.0090	0.011	0.014	0.018	0.022	0.026	0.032	0.036	0.044	0.055	90 (59 — 110)
		0,0500	*0,30*	*0,00014*	*0,00022*	*0,00028*	*0,00036*	*0,00044*	*0,00055*	*0,00070*	*0,00085*	*0,0010*	*0,0013*	*0,0014*	*0,0017*	*0,0022*	*295 (200 — 360)*
H8	M/A	0.0500	0.46	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	160 (140 — 190)
		0,0500	*0,46*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*520 (460 — 620)*
H11	M/A	0.0500	0.46	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	205 (170 — 240)
		0,0500	*0,46*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*670 (560 — 780)*
H12	M/A	0.0500	0.46	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	190 (160 — 220)
		0,0500	*0,46*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*620 (530 — 720)*
H21	M/A	0.0500	0.46	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	160 (140 — 190)
		0,0500	*0,46*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*520 (460 — 620)*
H31	M/A	0.0500	0.46	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	120 (110 — 140)
		0,0500	*0,46*	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*395 (370 — 450)*

Schnittdaten – JME142 Nutfräsen

SMG		a_p/DC	f_z													v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	1,8	2	2,5	3	
H3	M/A	0.012	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.018	0.022	0.024	0.030	0.036	65 (43 — 85)
		0,012	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00070*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*215 (150 — 270)*
H5	M/A	0.020	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	120 (97 — 130)
		0,020	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*395 (320 — 420)*
H7	M/A	0.012	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.018	0.022	0.024	0.030	0.036	65 (43 — 85)
		0,012	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00070*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*215 (150 — 270)*
H8	M/A	0.020	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	120 (97 — 130)
		0,020	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*395 (320 — 420)*
H11	M/A	0.020	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	150 (130 — 170)
		0,020	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*490 (430 — 550)*
H12	M/A	0.020	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	135 (120 — 160)
		0,020	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*445 (400 — 520)*
H21	M/A	0.012	0.0024	0.0036	0.0048	0.0060	0.0070	0.0095	0.012	0.014	0.018	0.022	0.024	0.030	0.036	120 (98 — 140)
		0,012	*0,000095*	*0,00014*	*0,00019*	*0,00024*	*0,00028*	*0,00038*	*0,00048*	*0,00055*	*0,00070*	*0,00085*	*0,00095*	*0,0012*	*0,0014*	*395 (330 — 450)*
H31	M/A	0.020	0.0040	0.0060	0.0080	0.010	0.012	0.016	0.020	0.024	0.030	0.036	0.040	0.050	0.060	90 (73 — 100)
		0,020	*0,00016*	*0,00024*	*0,00032*	*0,00040*	*0,00048*	*0,00065*	*0,00080*	*0,00095*	*0,0012*	*0,0014*	*0,0016*	*0,0020*	*0,0024*	*295 (240 — 320)*

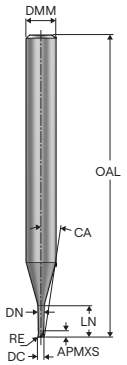
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

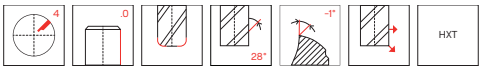
JME144

Mini – Gehärteter Stahl – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius





J



—Toleranzen:
—Rundlaufabweichung = <0,005 mm
—DMM=h5
—DC = 0-0,01 mm
—RE= ±0,005 mm

Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm						
JME144010J2R005Z4.0-HXT	03205214	2	J	1,0	4,0	0,75	40,0	4,0	0,95	0,05	9,08	0,9	-1,0	4	Cylindrical	■
JME144010J2R010Z4.0-HXT	03205217	2	J	1,0	4,0	0,75	40,0	4,0	0,95	0,1	9,13	0,9	-1,0	4	Cylindrical	■
JME144010J2R020Z4.0-HXT	03205220	2	J	1,0	4,0	0,75	40,0	4,0	0,95	0,2	9,22	0,9	-1,0	4	Cylindrical	■
JME144015J2R005Z4.0-HXT	03205227	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,05	7,52	0,9	-1,0	4	Cylindrical	■
JME144015J2R010Z4.0-HXT	03205229	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,1	7,56	0,9	-1,0	4	Cylindrical	■
JME144015J2R020Z4.0-HXT	03205232	2	J	1,5	4,0	1,125	50,0	5,0	1,45	0,2	7,63	0,9	-1,0	4	Cylindrical	■
JME144020J2R005Z4.0-HXT	03205234	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,05	5,97	0,9	-1,0	4	Cylindrical	■
JME144020J2R010Z4.0-HXT	03205236	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,1	6,0	0,9	-1,0	4	Cylindrical	■
JME144020J2R020Z4.0-HXT	03205239	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,2	6,06	0,9	-1,0	4	Cylindrical	■
JME144020J2R030Z4.0-HXT	03205241	2	J	2,0	4,0	1,5	50,0	6,0	1,94	0,3	6,12	0,9	-1,0	4	Cylindrical	■
JME144030J2R010Z4.0-HXT	03205243	2	J	3,0	4,0	2,25	50,0	9,0	2,85	0,1	2,66	0,9	-1,0	4	Cylindrical	■
JME144030J2R020Z4.0-HXT	03205246	2	J	3,0	4,0	2,25	50,0	9,0	2,85	0,2	2,69	0,9	-1,0	4	Cylindrical	■
JME144010J3R010Z4.0-HXT	03205218	3	J	1,0	4,0	0,75	40,0	5,0	0,95	0,1	8,3	0,9	-1,0	4	Cylindrical	■
JME144015J3R010Z4.0-HXT	03205230	3	J	1,5	4,0	1,125	50,0	7,5	1,45	0,1	6,06	0,9	-1,0	4	Cylindrical	■
JME144020J3R005Z4.0-HXT	03205235	3	J	2,0	4,0	1,5	50,0	10,0	1,94	0,05	4,29	0,9	-1,0	4	Cylindrical	■
JME144020J3R010Z4.0-HXT	03205237	3	J	2,0	4,0	1,5	50,0	10,0	1,94	0,1	4,31	0,9	-1,0	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JME144 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z					v_c
				1.0	1.2	1.5	2.0	3	
H3	M/A	0.0500 *0,0500*	0.095 *0,095*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	95 (65 — 120) *310 (220 — 390)*
H5	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	165 (140 — 190) *540 (460 — 620)*
H7	M/A	0.0500 *0,0500*	0.095 *0,095*	0.013 *0,00050*	0.016 *0,00065*	0.020 *0,00080*	0.026 *0,0010*	0.040 *0,0016*	95 (65 — 120) *310 (220 — 390)*
H8	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	165 (140 — 190) *540 (460 — 620)*
H11	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	210 (180 — 240) *690 (600 — 780)*
H12	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	190 (160 — 220) *620 (530 — 720)*
H21	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	165 (140 — 190) *540 (460 — 620)*
H31	M/A	0.0500 *0,0500*	0.22 *0,22*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	0.028 *0,0011*	0.042 *0,0017*	125 (110 — 140) *410 (370 — 450)*

Schnittdaten – JME144 Nutfräsen

SMG		a_p/DC	f_z					v_c
			1.0	1.2	1.5	2.0	3,0	
H3	M/A	0.0090 *0,0090*	0.0065 *0,00026*	0.0075 *0,00030*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	65 (43 — 84) *215 (150 — 270)*
H5	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	115 (96 — 130) *375 (320 — 420)*
H7	M/A	0.0090 *0,0090*	0.0065 *0,00026*	0.0075 *0,00030*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	65 (43 — 84) *215 (150 — 270)*
H8	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	115 (96 — 130) *375 (320 — 420)*
H11	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	150 (130 — 170) *490 (430 — 550)*
H12	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	135 (120 — 160) *445 (400 — 520)*
H21	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	115 (96 — 130) *375 (320 — 420)*
H31	M/A	0.019 *0,019*	0.012 *0,00048*	0.014 *0,00055*	0.018 *0,00070*	0.024 *0,00095*	0.036 *0,0014*	90 (73 — 100) *295 (240 — 320)*

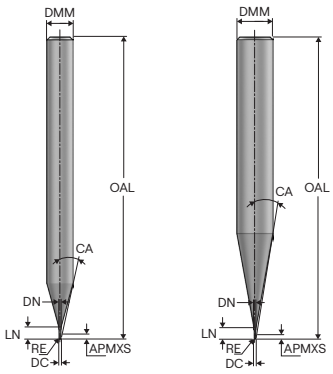
Schnittdaten, siehe Seite 699 - 707

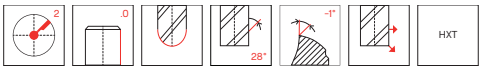
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JMB112

Mini – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch







—Toleranzen:
—Rundlaufabweichung = <0,005 mm
—DMM = h5
—DC= <Ø0,6= 0/-0,008 mm
—DC= ≥Ø0,6= 0/-0,01 mm
—RE=DC <Ø1,5= ±0,004 mm
—RE=DC ≥Ø1,5= ±0,005 mm

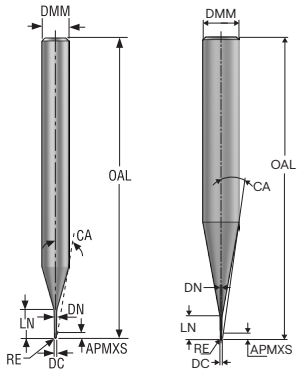
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm						
JMB112002G1BZ2.0-HXT	03204964	1	G	0,2	4,0	0,15	40,0	0,4	0,18	0,1	15,11	–	-1,0	2	Cylindrical	■
JMB112003G1BZ2.0-HXT	03204966	1	G	0,3	4,0	0,225	40,0	0,6	0,28	0,15	14,77	–	-1,0	2	Cylindrical	■
JMB112004G1BZ2.0-HXT	03204968	1	G	0,4	4,0	0,3	40,0	0,8	0,37	0,2	14,32	–	-1,0	2	Cylindrical	■
JMB112005G1BZ2.0-HXT	03204970	1	G	0,5	4,0	0,5	40,0	1,0	0,46	0,25	13,97	–	-1,0	2	Cylindrical	■
JMB112006G1BZ2.0-HXT	03204977	1	G	0,6	4,0	0,6	40,0	1,2	0,56	0,3	13,64	–	-1,0	2	Cylindrical	■
JMB112008G1BZ2.0-HXT	03204984	1	G	0,8	6,0	0,8	50,0	1,6	0,76	0,4	13,96	–	-1,0	2	Cylindrical	■
JMB112010G1BZ2.0-HXT	03204991	1	G	1,0	6,0	1,0	50,0	2,0	0,95	0,5	13,49	–	-1,0	2	Cylindrical	■
JMB112012G1BZ2.0-HXT	03205000	1	G	1,2	6,0	1,2	50,0	2,4	1,15	0,6	13,02	–	-1,0	2	Cylindrical	■
JMB112015G1BZ2.0-HXT	03205009	1	G	1,5	6,0	1,5	50,0	3,0	1,45	0,75	12,2	–	-1,0	2	Cylindrical	■
JMB112002J2BZ2.0-HXT	03204965	2	J	0,2	4,0	0,15	40,0	0,6	0,18	0,1	14,33	0,9	-1,0	2	Cylindrical	■
JMB112003J2BZ2.0-HXT	03204967	2	J	0,3	4,0	0,225	40,0	0,9	0,28	0,15	13,85	0,9	-1,0	2	Cylindrical	■
JMB112004J2BZ2.0-HXT	03204969	2	J	0,4	4,0	0,3	40,0	1,2	0,37	0,2	13,3	0,9	-1,0	2	Cylindrical	■
JMB112005J2BZ2.0-HXT	03204971	2	J	0,5	4,0	0,5	40,0	1,5	0,46	0,25	12,85	0,9	-1,0	2	Cylindrical	■
JMB112005G2BZ2.0-HXT	03204972	2	G	0,5	6,0	0,5	50,0	1,5	0,46	0,25	9,91	–	-1,0	2	Cylindrical	■
JMB112006J2BZ2.0-HXT	03204978	2	J	0,6	4,0	0,6	50,0	2,0	0,56	0,3	12,09	0,9	-1,0	2	Cylindrical	■
JMB112006G2BZ2.0-HXT	03204979	2	G	0,6	6,0	0,6	50,0	2,0	0,56	0,3	9,62	–	-1,0	2	Cylindrical	■
JMB112008J2BZ2.0-HXT	03204985	2	J	0,8	4,0	0,8	50,0	2,5	0,76	0,4	11,34	0,9	-1,0	2	Cylindrical	■
JMB112008G2BZ2.0-HXT	03204986	2	G	0,8	6,0	0,8	50,0	2,5	0,76	0,4	9,33	–	-1,0	2	Cylindrical	■
JMB112010J2BZ2.0-HXT	03204992	2	J	1,0	4,0	1,0	40,0	4,0	0,95	0,5	9,49	0,9	-1,0	2	Cylindrical	■
JMB112010G2BZ2.0-HXT	03204993	2	G	1,0	6,0	1,0	50,0	4,0	0,95	0,5	8,49	–	-1,0	2	Cylindrical	■
JMB112012J2BZ2.0-HXT	03205001	2	J	1,2	4,0	1,2	50,0	4,5	1,15	0,6	8,83	0,9	-1,0	2	Cylindrical	■
JMB112012G2BZ2.0-HXT	03205002	2	G	1,2	6,0	1,2	50,0	4,5	1,15	0,6	8,21	–	-1,0	2	Cylindrical	■
JMB112015J2BZ2.0-HXT	03205010	2	J	1,5	4,0	1,5	50,0	5,0	1,45	0,75	8,1	0,9	-1,0	2	Cylindrical	■
JMB112015G2BZ2.0-HXT	03205011	2	G	1,5	6,0	1,5	50,0	5,0	1,45	0,75	10,14	–	-1,0	2	Cylindrical	■
JMB112020J2BZ2.0-HXT	03205024	2	J	2,0	4,0	2,0	50,0	6,0	1,94	1,0	6,6	0,9	-1,0	2	Cylindrical	■
JMB112020G2BZ2.0-HXT	03205025	2	G	2,0	6,0	2,0	50,0	6,0	1,94	1,0	9,1	–	-1,0	2	Cylindrical	■
JMB112030J2BZ2.0-HXT	03205037	2	J	3,0	4,0	3,0	50,0	9,0	2,85	1,5	3,04	0,9	-1,0	2	Cylindrical	■
JMB112030G2BZ2.0-HXT	03205038	2	G	3,0	6,0	3,0	50,0	9,0	2,85	1,5	6,35	–	-1,0	2	Cylindrical	■

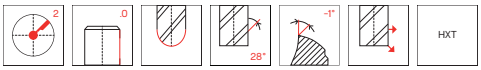
■ **Lagerstandard.**

JMB112

Mini – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch







– Toleranzen:
– Rundlaufabweichung = <0,005 mm
– DMM = h5
– DC= <Ø0,6= 0/-0,008 mm
– DC= ≥Ø0,6= 0/-0,01 mm
– RE=DC <Ø1,5= ±0,004 mm
– RE=DC ≥Ø1,5= ±0,005 mm

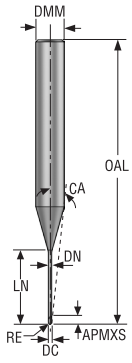
Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA°	NA°	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm						
JMB112005J3BZ2.0-HXT	03204973	3	J	0,5	4,0	0,5	40,0	2,5	0,46	0,25	11,49	0,9	-1,0	2	Cylindrical	■
JMB112005G3BZ2.0-HXT	03204974	3	G	0,5	6,0	0,5	50,0	3,5	0,46	0,25	8,81	–	-1,0	2	Cylindrical	■
JMB112006J3BZ2.0-HXT	03204980	3	J	0,6	4,0	0,6	40,0	3,0	0,56	0,3	10,83	0,9	-1,0	2	Cylindrical	■
JMB112006G3BZ2.0-HXT	03204981	3	G	0,6	6,0	0,6	50,0	4,0	0,56	0,3	8,56	–	-1,0	2	Cylindrical	■
JMB112008J3BZ2.0-HXT	03204987	3	J	0,8	4,0	0,8	40,0	4,0	0,76	0,4	9,67	0,9	-1,0	2	Cylindrical	■
JMB112008G3BZ2.0-HXT	03204988	3	G	0,8	6,0	0,8	50,0	5,5	0,76	0,4	10,1	–	-1,0	2	Cylindrical	■
JMB112010J3BZ2.0-HXT	03204994	3	J	1,0	4,0	1,0	40,0	5,0	0,95	0,5	8,6	0,9	-1,0	2	Cylindrical	■
JMB112010G3BZ2.0-HXT	03204995	3	G	1,0	6,0	1,0	50,0	7,0	0,95	0,5	9,06	–	-1,0	2	Cylindrical	■
JMB112012J3BZ2.0-HXT	03205003	3	J	1,2	4,0	1,2	50,0	6,0	1,15	0,6	7,65	0,9	-1,0	2	Cylindrical	■
JMB112012G3BZ2.0-HXT	03205004	3	G	1,2	6,0	1,2	50,0	8,0	1,15	0,6	8,42	–	-1,0	2	Cylindrical	■
JMB112015J3BZ2.0-HXT	03205012	3	J	1,5	4,0	1,5	40,0	7,5	1,45	0,75	6,4	0,9	-1,0	2	Cylindrical	■
JMB112015G3BZ2.0-HXT	03205013	3	G	1,5	6,0	1,5	50,0	10,0	1,45	0,75	7,31	–	-1,0	2	Cylindrical	■
JMB112020J3BZ2.0-HXT	03205026	3	J	2,0	4,0	2,0	50,0	10,0	1,94	1,0	4,61	0,9	-1,0	2	Cylindrical	■
JMB112020G3BZ2.0-HXT	03205027	3	G	2,0	6,0	2,0	50,0	12,0	1,94	1,0	6,19	–	-1,0	2	Cylindrical	■
JMB112030J3BZ2.0-HXT	03205039	3	J	3,0	4,0	3,0	50,0	15,0	2,85	1,5	1,91	0,9	-1,0	2	Cylindrical	■
JMB112030G3BZ2.0-HXT	03205040	3	G	3,0	6,0	3,0	60,0	15,0	2,85	1,5	4,41	–	-1,0	2	Cylindrical	■

■ **Lagerstandard.**

JMB112

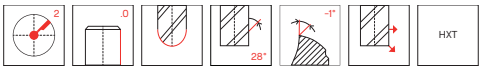
Mini – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch





G

- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC= <Ø0,6= 0/-0,008 mm
- DC= ≥Ø0,6= 0/-0,01 mm
- RE=DC <Ø1,5= ±0,004 mm
- RE=DC ≥Ø1,5= ±0,005 mm



Bezeichnung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PSIR°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm					
JMB112006G4BZ2.0-HXT	03204983	4	G	0,6	6,0	0,6	50,0	6,0	0,56	0,3	9,86	-1,0	2	Cylindrical	■
JMB112008G4BZ2.0-HXT	03204990	4	G	0,8	6,0	0,8	50,0	8,0	0,76	0,4	8,65	-1,0	2	Cylindrical	■
JMB112010G4BZ2.0-HXT	03204998	4	G	1,0	6,0	1,0	50,0	10,0	0,95	0,5	7,63	-1,0	2	Cylindrical	■
JMB112015G4BZ2.0-HXT	03205015	4	G	1,5	6,0	1,5	70,0	15,0	1,45	0,75	5,7	-1,0	2	Cylindrical	■
JMB112020G4BZ2.0-HXT	03205029	4	G	2,0	6,0	2,0	60,0	18,0	1,94	1,0	4,68	-1,0	2	Cylindrical	■
JMB112030G4BZ2.0-HXT	03205042	4	G	3,0	6,0	3,0	80,0	30,0	2,85	1,5	2,51	-1,0	2	Cylindrical	■
JMB112010G6BZ2.0-HXT	03205054	6	G	1,0	6,0	1,0	60,0	20,0	0,95	0,5	4,99	-1,0	2	Cylindrical	■

■ Lagerstandard.

Schnittdaten – JMB112 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z												v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	1,8	2	2,5	3	
H3	M	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.048 *0,0019*	150 (130 — 170) *490 (430 — 550)*
H5	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	220 (200 — 240) *720 (660 — 780)*
H7	M	0.0500 *0,0500*	0.30 *0,30*	0.0036 *0,00014*	0.0055 *0,00022*	0.0070 *0,00028*	0.0090 *0,00036*	0.011 *0,00044*	0.014 *0,00055*	0.018 *0,00070*	0.022 *0,00085*	0.026 *0,0010*	0.032 *0,0013*	0.036 *0,0014*	0.044 *0,0017*	0.048 *0,0019*	150 (130 — 170) *490 (430 — 550)*
H8	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.048 *0,0019*	0.050 *0,0020*	220 (200 — 240) *720 (660 — 780)*
H11	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	280 (250 — 310) *920 (830 — 1000)*
H12	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.048 *0,0019*	0.050 *0,0020*	255 (230 — 280) *840 (760 — 910)*
H21	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.040 *0,0016*	0.048 *0,0019*	0.050 *0,0020*	220 (200 — 240) *720 (660 — 780)*
H31	M	0.0500 *0,0500*	0.44 *0,44*	0.0040 *0,00016*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.024 *0,00095*	0.030 *0,0012*	0.034 *0,0013*	0.036 *0,0014*	0.042 *0,0017*	0.044 *0,0017*	165 (150 — 180) *540 (500 — 590)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte



KUNSTSTOFFE UND COMPOSITE

Seco präsentiert ein Komplettprogramm an Vollhartmetallfräsern für die Bearbeitung glasfaser- und kohlenstofffaserverstärkter Kunststoffe. Es besteht aus diamantbeschichteten, unbeschichteten und PKD-Fräsern mit verschiedenen
Geometrien sowie Fräser mit eingelöteter PKD-Spitze. Die Werkzeuge sind speziell für schwierige Zerspanungsbedingungen in anspruchsvollen Werkstoffen optimiert.

- JC860, JC870, JC871, JC899, JPD890, J93F und J28 Schaftfräser mit scharfer Ecke.
- JC845, JC880, JC885 und JC898 Schaftfräser mit Eckenradius
- D8961, JC875, JC876, JC877 und JPD880 mit 45° Fase
- JC850 und JPD850 Kugelkopffräser

Werkzeugauswahl Kunststoff und CFK

							
Werkzeugbezeichnung		D8961	JC845	JC850	JC860	JC870	JC871
Seite(n)		539	542	544	546	548	554
Produktfamilie		COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE
Fräserausführung							
Auf-nahmen	**Zylindrisch**	■	■	■	■	■	■
	Weldon						
Schneidenzahl		6	3	4	5,6,8,9		
CSP							
	Metrisch		6-8	3-12	6-12	3-12	3-12
	Zoll					1/4 -1/2	1/4 -1/2
Verfügbare Längen		2,3	2	2	2	2	2
Bearbeitung							
							
							
SMG							
TS1							
TS2		●	●	●	●	●	●
TS3		●	●	●	●	●	●
TP1							
TP2		●	●	●	●	●	●
TP3		●	●	●	●	●	●
Honeycomb*					●	●	●

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl Kunststoff und CFK

								
Werkzeugbezeichnung		JC875	JC876	JC877	JC880	JC885	JC898	JC899
Seite(n)		560	564	568	572	574	576	578
Produktfamilie		COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE	COMPOSITE
Fräserausführung								
Aufnahmen	Zylindrisch	■	■	■	■	■	■	■
	Weldon							
Schneidenzahl		5,6,10	6,8,10,12,14	6,8,10,12,14	4	4	4	4
CSP							■	
	Metrisch	3-10	3-12	3-12	4-20	4-10	8-15	8,5-14,8
	Zoll	1/4 -1/2	1/4-1/2	1/4-1/2				
Verfügbare Längen		2	2	2	2	2	2	2
Bearbeitung								
								
SMG								
TS1								
TS2		●	●	●	●	●		
TS3		●	●	●	●	●		
TP1								
TP2		●	●	●	●	●		
TP3		●	●	●	●	●		
Honeycomb*								

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl Kunststoff und CFK

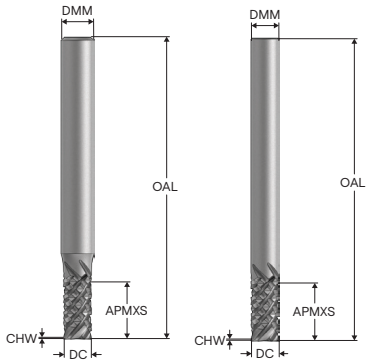
						
Werkzeugbezeichnung		JPD850	JPD880	JPD890	J93F	J28
Seite(n)		581	583	585	587	589
Produktfamilie		PCD	PCD	PCD	VHM	VHM
Fräserausführung						
Aufnahmen	Zylindrisch	■	■	■	■	■
	Weldon					
Schneidenzahl		2	2	2	2	1
CSP		■	■	■		
	Metrisch	4-10	6-16	6-12	1,5-20	3-12
	Zoll					
Verfügbare Längen		2	2,3	2,3	1,2,3,4	2
Bearbeitung						
						
						
SMG						
TS1					●	●
TS2		●	●	●		
TS3		●	●	●		
TP1					●	
TP2		●	●	●		
TP3		●	●	●		
Honeycomb*						

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

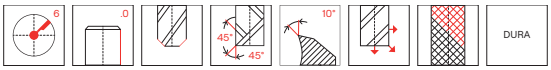
D8961

Verbundwerkstoff – Fräser – 6 Schneiden – Zylindrisch – Fase





—Toleranzen:
—DMM= h5
—DC= -0/-0,05 mm



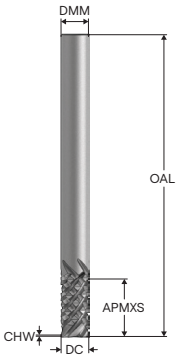
Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm		
D8961-050F2C.0Z6	DURA	10318178	2	F	5,0	6,0	10,0	65,0	0,152	Cylindrical	■
D8961-060D2C.0Z6	DURA	10318180	2	D	6,0	6,0	12,0	65,0	0,152	Cylindrical	■
D8961-080D2C.0Z6	DURA	10318182	2	D	8,0	8,0	16,0	70,0	0,203	Cylindrical	■
D8961-100D2C.0Z6	DURA	10318184	2	D	10,0	10,0	20,0	75,0	0,203	Cylindrical	■
D8961-120D2C.0Z6	DURA	10318186	2	D	12,0	12,0	24,0	76,0	0,254	Cylindrical	■
D8961-140D2C.0Z6	DURA	10318188	2	D	14,0	14,0	28,0	82,0	0,254	Cylindrical	■
D8961-160D2C.0Z6	DURA	10318190	2	D	16,0	16,0	32,0	94,0	0,254	Cylindrical	■
D8961-050F3C.0Z6	DURA	10318179	3	F	5,0	6,0	15,0	70,0	0,152	Cylindrical	■
D8961-060D3C.0Z6	DURA	10318181	3	D	6,0	6,0	18,0	70,0	0,152	Cylindrical	■
D8961-080D3C.0Z6	DURA	10318183	3	D	8,0	8,0	24,0	75,0	0,203	Cylindrical	■
D8961-100D3C.0Z6	DURA	10318185	3	D	10,0	10,0	30,0	90,0	0,203	Cylindrical	■
D8961-120D3C.0Z6	DURA	10318187	3	D	12,0	12,0	36,0	90,0	0,254	Cylindrical	■
D8961-140D3C.0Z6	DURA	10318189	3	D	14,0	14,0	42,0	96,0	0,254	Cylindrical	■
D8961-160D3C.0Z6	DURA	10318191	3	D	16,0	16,0	48,0	110,0	0,254	Cylindrical	■

■ **Lagerstandard.**

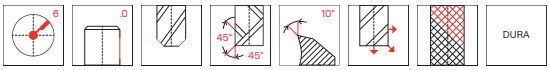
D8961

Verbundwerkstoff – Fräser – 6 Schneiden – Zylindrisch – Fase – Zoll





—Toleranzen:
—DMM=-.0001"/-.0004"
—DC=0/ -0.002"



Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CHW	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll		
D8961-.250D2C.0Z6	DURA	10318192	2	D	0.250	0.250	0.500	2.500	0.006	Cylindrical	■
D8961-.313D2C.0Z6	DURA	10318194	2	D	0.313	0.313	0.625	2.500	0.008	Cylindrical	■
D8961-.375D2C.0Z6	DURA	10318196	2	D	0.375	0.375	0.750	2.500	0.008	Cylindrical	■
D8961-.500D2C.0Z6	DURA	10318198	2	D	0.500	0.500	1.000	3.000	0.010	Cylindrical	■
D8961-.625D2C.0Z6	DURA	10318200	2	D	0.625	0.625	1.250	3.500	0.010	Cylindrical	■
D8961-.250D3C.0Z6	DURA	10318193	3	D	0.250	0.250	0.750	3.000	0.006	Cylindrical	■
D8961-.313D3C.0Z6	DURA	10318195	3	D	0.313	0.313	0.937	3.000	0.008	Cylindrical	■
D8961-.375D3C.0Z6	DURA	10318197	3	D	0.375	0.375	1.125	3.000	0.008	Cylindrical	■
D8961-.500D3C.0Z6	DURA	10318199	3	D	0.500	0.500	1.500	4.000	0.010	Cylindrical	■
D8961-.625D3C.0Z6	DURA	10318201	3	D	0.625	0.625	1.875	4.000	0.010	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – D8961 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z							v_c
				5	6	8	10	12	14	16	
TS2	D	0,2 *0.20*	2 *2.0*	0,025 *0.0010*	0,03 *0.0012*	0,034 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	0,06 *0.0024*	170 (150 — 190) *560 (500 — 620)*
TS3	D	0,2 *0.20*	2 *2.0*	0,025 *0.0010*	0,03 *0.0012*	0,034 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	0,06 *0.0024*	115 (91 — 140) *375 (300 — 450)*
TP2	D	0,2 *0.20*	2 *2.0*	0,025 *0.0010*	0,03 *0.0012*	0,034 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	0,06 *0.0024*	115 (91 — 160) *375 (300 — 520)*
TP3	D	0,2 *0.20*	2 *2.0*	0,025 *0.0010*	0,03 *0.0012*	0,034 *0.0013*	0,04 *0.0016*	0,048 *0.0019*	0,055 *0.0022*	0,06 *0.0024*	85 (52 — 110) *280 (180 — 360)*

Schnittdaten – D8961 Nutfräsen

SMG		a_p/DC	f_z							v_c
			5	6	8	10	12	14	16	
TS2	D	1 *1.0*	0,02 *0.00080*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,026 *0.0010*	0,03 *0.0012*	0,032 *0.0013*	130 (110 — 140) *425 (370 — 450)*
TS3	D	1 *1.0*	0,02 *0.00080*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,026 *0.0010*	0,03 *0.0012*	0,032 *0.0013*	90 (70 — 100) *295 (230 — 320)*
TP2	D	1 *1.0*	0,02 *0.00080*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,026 *0.0010*	0,03 *0.0012*	0,032 *0.0013*	90 (70 — 120) *295 (230 — 390)*
TP3	D	1 *1.0*	0,02 *0.00080*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,026 *0.0010*	0,03 *0.0012*	0,032 *0.0013*	65 (40 — 89) *215 (140 — 290)*

Schnittdaten – D8961 Eckfräsen – Zoll

SMG		a_e/DC	a_p/DC	f_z					v_c
				1/4	5/16	3/8	1/2	5/8	
TS2	D	0,2 *0.20*	2 *2.0*	0,032 *0.0013*	0,034 *0.0013*	0,038 *0.0015*	0,05 *0.0020*	0,06 *0.0024*	170 (150 — 190) *560 (500 — 620)*
TS3	D	0,2 *0.20*	2 *2.0*	0,032 *0.0013*	0,034 *0.0013*	0,038 *0.0015*	0,05 *0.0020*	0,06 *0.0024*	115 (91 — 140) *375 (300 — 450)*
TP2	D	0,2 *0.20*	2 *2.0*	0,032 *0.0013*	0,034 *0.0013*	0,038 *0.0015*	0,05 *0.0020*	0,06 *0.0024*	115 (91 — 160) *375 (300 — 520)*
TP3	D	0,2 *0.20*	2 *2.0*	0,032 *0.0013*	0,034 *0.0013*	0,038 *0.0015*	0,05 *0.0020*	0,06 *0.0024*	85 (52 — 110) *280 (180 — 360)*

Schnittdaten – D8961 Nutfräsen – Zoll

SMG		a_p/DC	f_z					v_c
			1/4	5/16	3/8	1/2	5/8	
TS2	D	1 *1.0*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,028 *0.0011*	0,032 *0.0013*	130 (110 — 140) *425 (370 — 450)*
TS3	D	1 *1.0*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,028 *0.0011*	0,032 *0.0013*	90 (70 — 100) *295 (230 — 320)*
TP2	D	1 *1.0*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,028 *0.0011*	0,032 *0.0013*	90 (70 — 120) *295 (230 — 390)*
TP3	D	1 *1.0*	0,02 *0.00080*	0,022 *0.00085*	0,022 *0.00085*	0,028 *0.0011*	0,032 *0.0013*	65 (40 — 89) *215 (140 — 290)*

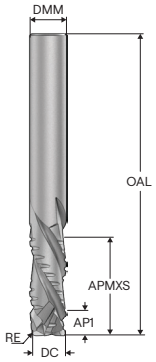
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

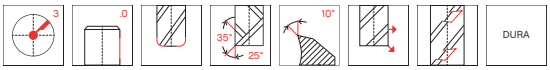
JC845

Verbundwerkstoff – Kompression – 3 Schneiden – Zylindrisch – Eckenradius





– Toleranzen:
– DMM=h5
– DC=-0,02/-0,04 mm
– RE=±0,01 mm



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	AP1	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm			
JC845060D2R050.0Z3-DURA	02843006	2	D	■	6,0	6,0	18,0	4,2	65,0	0,5	3	Cylindrical	■
JC845080D2R050.0Z3-DURA	02843007	2	D	■	8,0	8,0	24,0	5,2	75,0	0,5	3	Cylindrical	■
JC845100D2R050.0Z3-DURA	02843008	2	D	■	10,0	10,0	30,0	6,3	85,0	0,5	3	Cylindrical	■
JC845120D2R050.0Z5-DURA	02843009	2	D	■	12,0	12,0	36,0	8,3	100,0	0,5	5	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JC845 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
TS2	E/A/D	0.376 *0,376*	1.5 *1,5*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	185 (130 — 240) *610 (430 — 780)*
TS3	E/A/D	0.376 *0,376*	1.4 *1,4*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	125 (87 — 160) *410 (290 — 520)*
TP2	E/A/D	0.376 *0,376*	1.5 *1,5*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	125 (87 — 180) *410 (290 — 590)*
TP3	E/A/D	0.376 *0,376*	1.4 *1,4*	0.038 *0,0015*	0.050 *0,0020*	0.060 *0,0024*	0.075 *0,0030*	85 (62 — 110) *280 (210 — 360)*

Schnittdaten – JC845 Nutfräsen

SMG		a_p/DC	f_z				v_c
			6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	160 (110 — 210) *520 (370 — 680)*
TS3	E/A/D	0.75 *0,75*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	105 (76 — 130) *345 (250 — 420)*
TP2	E/A/D	1.0 *1,0*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	105 (75 — 160) *345 (250 — 520)*
TP3	E/A/D	0.75 *0,75*	0.025 *0,0010*	0.032 *0,0013*	0.040 *0,0016*	0.050 *0,0020*	75 (54 — 96) *245 (180 — 310)*

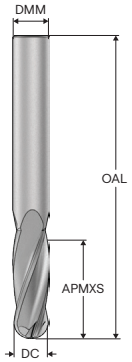
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

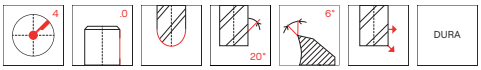
JC850

Verbundwerkstoff – Kugelkopf – 4 Schneiden – Zylindrisch





D



– Toleranzen:
– DMM=h5
– DC=-0,02/-0,04 mm
– RE= ±0,02 mm

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
850030Z4.0-DURA	02719949	2	D	3,0	3,0	9,0	50,0	1,5	4	Cylindrical	■
850040Z4.0-DURA	02719952	2	D	4,0	4,0	12,0	50,0	2,0	4	Cylindrical	■
850060Z4.0-DURA	02719953	2	D	6,0	6,0	18,0	65,0	3,0	4	Cylindrical	■
850080Z4.0-DURA	02719954	2	D	8,0	8,0	24,0	70,0	4,0	4	Cylindrical	■
850100Z4.0-DURA	02719955	2	D	10,0	10,0	30,0	85,0	5,0	4	Cylindrical	■
850120Z4.0-DURA	02719956	2	D	12,0	12,0	36,0	100,0	6,0	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JC850 Kopierfräser

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
TS2	E/A/D	0.200 *0,200*	2.0 *2,0*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	265 (220 — 320) *870 (730 — 1000)*
TS3	E/A/D	0.200 *0,200*	2.0 *2,0*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	160 (110 — 210) *520 (370 — 680)*
TP2	E/A/D	0.200 *0,200*	2.0 *2,0*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	215 (110 — 320) *710 (370 — 1000)*
TP3	E/A/D	0.200 *0,200*	2.0 *2,0*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	105 (54 — 150) *345 (180 — 490)*

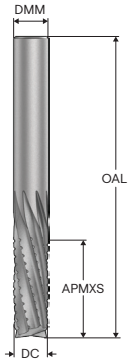
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JC860

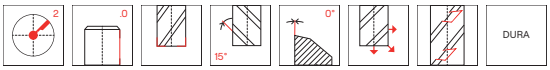
Honeycomb – Eckfräser – 5-9 Schneiden – Zylindrisch – Scharfe Schneide





D

—Toleranzen:
—DMM=h5
—DC= -0.02-0.08 mm
—FCEDC=Stirnverzahnung



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	L	APMXS	OAL	FCEDC	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm				
860060Z5.0-DURA	02720211	2	D	■	6,0	6,0	18,0	18,0	70,0	2	5	Cylindrical	■
860080Z6.0-DURA	02720212	2	D	■	8,0	8,0	24,0	24,0	80,0	2	6	Cylindrical	■
860100Z8.0-DURA	02720216	2	D	■	10,0	10,0	30,0	30,0	90,0	2	8	Cylindrical	■
860120Z9.0-DURA	02720217	2	D	■	12,0	12,0	36,0	36,0	110,0	2	9	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JC860 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
TS2	E/A/D	0.100 *0,100*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	235 (200 — 270) *770 (660 — 880)*
TS3	E/A/D	0.100 *0,100*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	160 (130 — 180) *520 (430 — 590)*
TP2	E/A/D	0.100 *0,100*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	165 (130 — 200) *540 (430 — 650)*
TP3	E/A/D	0.100 *0,100*	1.0 *1,0*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	65 (50 — 110) *215 (170 — 360)*

Schnittdaten – JC860 Nutfräsen

SMG		a_p/DC	f_z				v_c
			6	8	10	12	
TS2	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	160 (140 — 180) *520 (460 — 590)*
TS3	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	105 (85 — 120) *345 (280 — 390)*
TP2	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	110 (84 — 130) *360 (280 — 420)*
TP3	E/A/D	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	44 (34 — 78) *145 (120 — 250)*

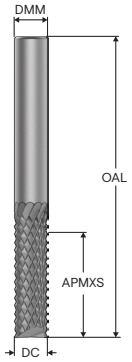
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JC870

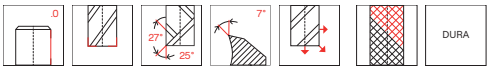
Verbundwerkstoff – Fräser – Eckfräser – Zylindrisch – Scharfe Schneide





D

—Toleranzen:
—DMM=h5
—DC=-0,02/-0,08 mm
—Fräser (Linksdrall)*



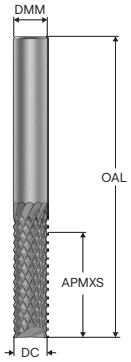
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	L	APMXS	OAL	FCEDC	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm				
870030.0-DURA	02720219	2	D	■	3,0	3,0	9,0	9,0	50,0	2	8	Cylindrical	■
870040.0-DURA	02720226	2	D	■	4,0	4,0	12,0	12,0	50,0	2	8	Cylindrical	■
870060.0-DURA	02720228	2	D	■	6,0	6,0	18,0	18,0	65,0	2	10	Cylindrical	■
870080.0-DURA	02720229	2	D	■	8,0	8,0	24,0	24,0	75,0	2	12	Cylindrical	■
870100.0-DURA	02720231	2	D	■	10,0	10,0	30,0	30,0	85,0	2	12	Cylindrical	■
870120.0-DURA	02720232	2	D	■	12,0	12,0	36,0	36,0	100,0	2	14	Cylindrical	■

■ **Lagerstandard.**
* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

JC870

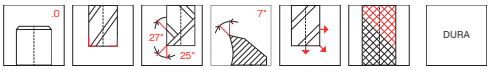
Verbundwerkstoff – Fräser – Eckfräser – Zylindrisch – Scharfe Schneide – Zoll





D

—Toleranzen:
—DMM=h5
—DC=-0,02/-0,08 mm
—Fräser (Linksdrall)*



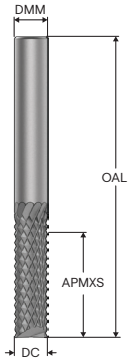
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	FCEDC	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll				
8700250.0-DURA	02720784	2	D	■	0.250	0.250	0.750	2.250	2	10	Cylindrical	■
8700375.0-DURA	02720785	2	D	■	0.375	0.375	1.250	3.500	2	12	Cylindrical	■

■ **Lagerstandard.**
* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

JC870

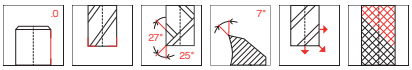
Verbundwerkstoff – Fräser – Eckfräser – Zylindrisch – Scharfe Schneide





D

—Toleranzen:
—DMM=h5
—DC=-0,02/-0,08 mm
—Fräser (Linksdrall)*



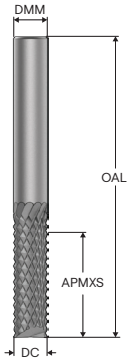
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	L	APMXS	OAL	FCEDC	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm				
870030.0	02742789	2	D	■	3,0	3,0	9,0	9,0	50,0	2	8	Cylindrical	■
870040.0	02742792	2	D	■	4,0	4,0	12,0	12,0	50,0	2	8	Cylindrical	■
870050.0	02742793	2	D	■	5,0	5,0	15,0	15,0	50,0	2	10	Cylindrical	■
870060.0	02742794	2	D	■	6,0	6,0	18,0	18,0	65,0	2	10	Cylindrical	■
870080.0	02742795	2	D	■	8,0	8,0	24,0	24,0	75,0	2	12	Cylindrical	■
870100.0	02742796	2	D	■	10,0	10,0	30,0	30,0	85,0	2	12	Cylindrical	■
870120.0	02742797	2	D	■	12,0	12,0	36,0	36,0	100,0	2	14	Cylindrical	■

■ **Lagerstandard.**
* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

JC870

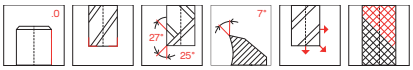
Verbundwerkstoff – Fräser – Eckfräser – Zylindrisch – Scharfe Schneide – Zoll





D

—Toleranzen:
—DMM=h5
—DC=-.0008 / -.0015 *Zoll*
—Fräser (Linksdrall)*



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	FCEDC	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll				
8700250.0	02742798	2	D	■	0.250	0.250	0.750	2.250	2	10	Cylindrical	■
8700500.0	02742800	2	D	■	0.500	0.500	1.500	4.250	2	14	Cylindrical	■

■ **Lagerstandard.**
* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

Schnittdaten – JC870 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	115 (94 — 130) *375 (310 — 420)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	46 (36 — 81) *150 (120 — 260)*

Schnittdaten – JC870 Nutfräsen

SMG		a_p/DC	f_z							v_c
			3	4	5	6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	145 (130 — 170) *475 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	100 (79 — 110) *330 (260 — 360)*
TP2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	100 (74 — 120) *330 (250 — 390)*
TP3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	39 (30 — 68) *130 (99 — 220)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JC870 Eckfräsen/Schruppen – Zoll

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	115 (94 — 130) *375 (310 — 420)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	46 (36 — 81) *150 (120 — 260)*

Schnittdaten – JC870 Nutfräsen – Zoll

SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	145 (130 — 170) *475 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (79 — 110) *330 (260 — 360)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (74 — 120) *330 (250 — 390)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	39 (30 — 68) *130 (99 — 220)*

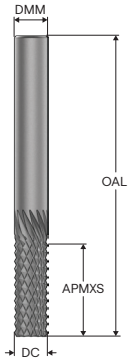
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JC871

Verbundwerkstoff – Fräser – Eckfräser – Zylindrisch – Scharfe Schneide





D

—Toleranzen:
—DMM=h5
—DC=-0,02/-0,08 mm
—Fräser (Linksdrall)*



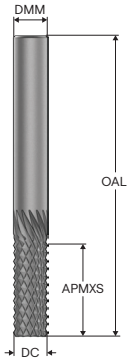
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm			
871030.0-DURA	02720249	2	D	■	3,0	3,0	9,0	50,0	8	Cylindrical	■
871040.0-DURA	02720250	2	D	■	4,0	4,0	12,0	50,0	8	Cylindrical	■
871060.0-DURA	02720252	2	D	■	6,0	6,0	18,0	65,0	10	Cylindrical	■
871080.0-DURA	02720253	2	D	■	8,0	8,0	24,0	75,0	12	Cylindrical	■
871100.0-DURA	02720254	2	D	■	10,0	10,0	30,0	85,0	12	Cylindrical	■
871120.0-DURA	02720257	2	D	■	12,0	12,0	36,0	100,0	14	Cylindrical	■

■ **Lagerstandard.**
* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

JC871

Verbundwerkstoff – Fräser – Eckfräser – Zylindrisch – Scharfe Schneide – Zoll





D

—Toleranzen:
—DMM=h5
—DC=-.0008 / -.0015 *Zoll*
—Fräser (Linksdrall)*



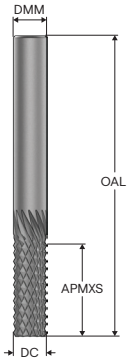
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll			
8710250.0-DURA	02720788	2	D	■	0.250	0.250	0.750	2.250	10	Cylindrical	■
8710375.0-DURA	02720789	2	D	■	0.375	0.375	1.250	3.500	12	Cylindrical	■
8710500.0-DURA	02720790	2	D	■	0.500	0.500	1.500	4.250	14	Cylindrical	■

■ **Lagerstandard.**
* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

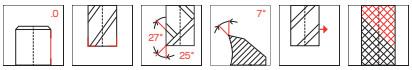
JC871

Verbundwerkstoff – Fräser – Eckfräser – Zylindrisch – Scharfe Schneide





D



—Toleranzen:
—DMM=h5
—DC=-0.02/-0.04
—Fräser (Linksdrall)*

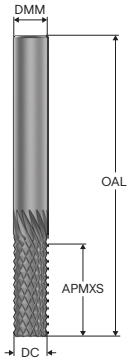
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm			
871030.0	02742801	2	D	■	3,0	3,0	9,0	50,0	8	Cylindrical	■
871040.0	02742803	2	D	■	4,0	4,0	12,0	50,0	8	Cylindrical	■
871060.0	02742806	2	D	■	6,0	6,0	18,0	65,0	10	Cylindrical	■
871080.0	02742807	2	D	■	8,0	8,0	24,0	75,0	12	Cylindrical	■
871100.0	02742808	2	D	■	10,0	10,0	30,0	85,0	12	Cylindrical	■
871120.0	02742809	2	D	■	12,0	12,0	36,0	100,0	14	Cylindrical	■

■ **Lagerstandard.**
* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

JC871

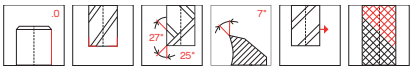
Verbundwerkstoff – Fräser – Eckfräser – Zylindrisch – Scharfe Schneide – Zoll





D

—Toleranzen:
—DMM=h5
—DC=-0,02/-0,08 mm
—Fräser (Linksdrall)*



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll			
8710500.0	02742814	2	D	■	0.500	0.500	1.500	4.250	14	Cylindrical	■

■ **Lagerstandard.**
* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

Schnittdaten – JC871 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	115 (94 — 130) *375 (310 — 420)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	46 (36 — 81) *150 (120 — 260)*

Schnittdaten – JC871 Nutfräsen

SMG		a_p/DC	f_z							v_c
			3	4	5	6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	155 (140 — 180) *510 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	105 (84 — 120) *345 (280 — 390)*
TP2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	105 (79 — 130) *345 (260 — 420)*
TP3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	40 (31 — 70) *130 (110 — 220)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JC871 Eckfräsen/Schruppen – Zoll

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	115 (94 — 130) *375 (310 — 420)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	46 (36 — 81) *150 (120 — 260)*

Schnittdaten – JC871 Nutfräsen – Zoll

SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	145 (130 — 170) *475 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (79 — 110) *330 (260 — 360)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	100 (74 — 120) *330 (250 — 390)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	39 (30 — 68) *130 (99 — 220)*

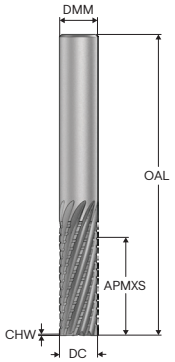
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JC875

Verbundwerkstoff – Eckfräser – 5-10 Schneiden – Zylindrisch – Fase





D

—Toleranzen:
—DMM=h5
—DC=-0,02/-0,08 mm



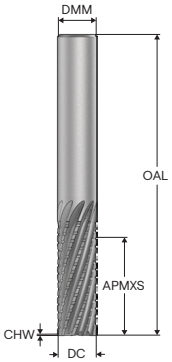
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm			
JC875030D2.0-DURA	02968155	2	D	■	3,0	3,0	9,0	50,0	0,05	5	Cylindrical	■
JC875050D2.0-DURA	02968157	2	D	■	5,0	5,0	15,0	50,0	0,05	6	Cylindrical	■
JC875060D2.0-DURA	02968158	2	D	■	6,0	6,0	18,0	65,0	0,06	6	Cylindrical	■
JC875080D2.0-DURA	02968159	2	D	■	8,0	8,0	24,0	70,0	0,08	10	Cylindrical	■
JC875100D2.0-DURA	02968160	2	D	■	10,0	10,0	30,0	80,0	0,1	10	Cylindrical	■

■ **Lagerstandard.**

JC875

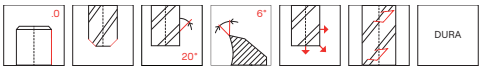
Verbundwerkstoff – Eckfräser – 6-10 Schneiden – Zylindrisch – Fase – Zoll





D

—Toleranzen:
—DMM=h5
—DC= -.0008/-.0030 *Zoll*



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll			
JC875.250D2.0-DURA	02968162	2	D	■	0.250	0.250	0.750	3.000	0.002	6	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JC875 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z					v_c
				3	5	6	8	10	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	190 (160 — 220) *620 (530 — 720)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	130 (110 — 150) *425 (370 — 490)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	130 (96 — 150) *425 (320 — 490)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.0095 *0,00038*	0.016 *0,00065*	0.019 *0,00075*	0.025 *0,0010*	0.032 *0,0013*	50 (39 — 89) *165 (130 — 290)*

Schnittdaten – JC875 Nutfräsen

SMG		a_p/DC	f_z					v_c
			3	5	6	8	10	
TS2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	160 (140 — 180) *520 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	105 (86 — 120) *345 (290 — 390)*
TP2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	105 (81 — 130) *345 (270 — 420)*
TP3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.010 *0,00040*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	42 (33 — 74) *140 (110 — 240)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JC875 Eckfräsen – Zoll

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	190 (160 — 220) *620 (530 — 720)*
TS3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	130 (110 — 150) *425 (370 — 490)*
TP2	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	130 (96 — 150) *425 (320 — 490)*
TP3	E/A/D	0.350 *0,350*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.038 *0,0015*	50 (39 — 89) *165 (130 — 290)*

Schnittdaten – JC875 Nutfräsen – Zoll

SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	160 (140 — 180) *520 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (86 — 120) *345 (290 — 390)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (81 — 130) *345 (270 — 420)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	42 (33 — 74) *140 (110 — 240)*

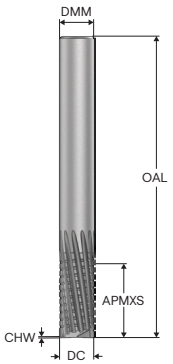
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JC876

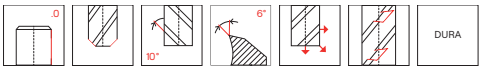
Verbundwerkstoff – Eckfräser – 6-14 Schneiden – Zylindrisch – Fase





D

—Toleranzen:
—DMM=h5
—DC=-0,02 -0,08 mm
—Linksdrall



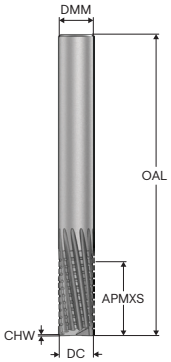
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	L	APMXS	OAL	CHW	FCEDC	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm				
JC876030D2C.0Z6-DURA	03135004	2	D	■	3,0	3,0	7,5	7,5	50,0	0,035	2	6	Cylindrical	■
JC876040D2C.0Z6-DURA	03135005	2	D	■	4,0	4,0	10,0	10,0	54,0	0,045	2	6	Cylindrical	■
JC876060D2C.0Z8-DURA	03135006	2	D	■	6,0	6,0	15,0	15,0	62,0	0,075	2	8	Cylindrical	■
JC876060D2C.0Z10-DURA	03135007	2	D	■	6,0	6,0	15,0	15,0	62,0	0,075	2	10	Cylindrical	■
JC876080D2C.0Z10-DURA	03135009	2	D	■	8,0	8,0	20,0	20,0	70,0	0,1	2	10	Cylindrical	■
JC876100D2C.0Z12-DURA	03135011	2	D	■	10,0	10,0	25,0	25,0	82,0	0,125	2	12	Cylindrical	■
JC876120D2C.0Z14-DURA	03135012	2	D	■	12,0	12,0	30,0	30,0	95,0	0,15	2	14	Cylindrical	■

■ **Lagerstandard.**

JC876

Verbundwerkstoff – Eckfräser – 8-14 Schneiden – Zylindrisch – Fase – Zoll





D

—Toleranzen:
—DMM=h5
—DC= -.0008/-.0030 *Zoll*
—Linksdrall



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	CHW	FCEDC	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll				
JC876.250D2C.0Z8-DURA	03135125	2	D	■	0.250	0.250	0.625	2.500	0.003	2	8	Cylindrical	■
JC876.375D2C.0Z12-DURA	03135127	2	D	■	0.375	0.375	1.000	3.000	0.005	2	12	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JC876 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
TS2	E/A/D	0.334 *0,334*	1.7 *1,7*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	220 (190 — 250) *720 (630 — 820)*
TS3	E/A/D	0.334 *0,334*	1.7 *1,7*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	145 (120 — 170) *475 (400 — 550)*
TP2	E/A/D	0.334 *0,334*	1.7 *1,7*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	145 (110 — 180) *475 (370 — 590)*
TP3	E/A/D	0.334 *0,334*	1.7 *1,7*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	75 (44 — 100) *245 (150 — 320)*

Schnittdaten – JC876 Nutfräsen

SMG		a_p/DC	f_z						v_c
			3	4	6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	115 (94 — 140) *375 (310 — 450)*
TP2	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	1.0 *1,0*	0.0060 *0,00024*	0.0080 *0,00032*	0.012 *0,00048*	0.016 *0,00065*	0.020 *0,00080*	0.025 *0,0010*	60 (36 — 81) *195 (120 — 260)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JC876 Eckfräsen/Schruppen – Zoll

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.334 *0,334*	1.7 *1,7*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	220 (190 — 250) *720 (630 — 820)*
TS3	E/A/D	0.334 *0,334*	1.7 *1,7*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	145 (120 — 170) *475 (400 — 550)*
TP2	E/A/D	0.334 *0,334*	1.7 *1,7*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	145 (110 — 180) *475 (370 — 590)*
TP3	E/A/D	0.334 *0,334*	1.7 *1,7*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	75 (44 — 100) *245 (150 — 320)*

Schnittdaten – JC876 Nutfräsen – Zoll

SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	175 (150 — 200) *570 (500 — 650)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	115 (94 — 140) *375 (310 — 450)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	115 (88 — 140) *375 (290 — 450)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	60 (36 — 81) *195 (120 — 260)*

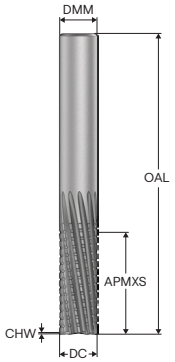
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JC877

Verbundwerkstoff – Eckfräser – 6-14 Schneiden – Zylindrisch – Fase





D

—Toleranzen:
—DMM=h5
—DC=-0,02, -0,08 mm
—Linksdrall



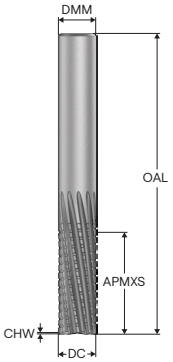
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	L	APMXS	OAL	CHW	FCEDC	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm				
JC877030D2C.0Z6-DURA	03135013	2	D	■	3,0	3,0	9,0	9,0	50,0	0,035	3	6	Cylindrical	■
JC877040D2C.0Z6-DURA	03135014	2	D	■	4,0	4,0	12,0	12,0	54,0	0,045	3	6	Cylindrical	■
JC877060D2C.0Z8-DURA	03135015	2	D	■	6,0	6,0	18,0	18,0	62,0	0,075	4	8	Cylindrical	■
JC877060D2C.0Z10-DURA	03135016	2	D	■	6,0	6,0	18,0	18,0	62,0	0,075	5	10	Cylindrical	■
JC877080D2C.0Z10-DURA	03135018	2	D	■	8,0	8,0	24,0	24,0	70,0	0,1	5	10	Cylindrical	■
JC877100D2C.0Z12-DURA	03135020	2	D	■	10,0	10,0	30,0	30,0	82,0	0,125	6	12	Cylindrical	■
JC877120D2C.0Z14-DURA	03135021	2	D	■	12,0	12,0	36,0	36,0	95,0	0,15	7	14	Cylindrical	■

■ **Lagerstandard.**

JC877

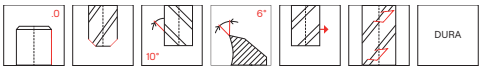
Verbundwerkstoff – Eckfräser – 8-14 Schneiden – Zylindrisch – Fase – Zoll





D

—Toleranzen:
—DMM=h5
—DC= -.0008/-.0030 *Zoll*
—Linksdrall



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	CHW	FCEDC	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll				
JC877.250D2C.0Z8-DURA	03135129	2	D	■	0.250	0.250	0.750	2.500	0.003	4	8	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JC877 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
TS2	E/A/D	0.334 *0,334*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	195 (170 — 220) *640 (560 — 720)*
TS3	E/A/D	0.334 *0,334*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	130 (110 — 150) *425 (370 — 490)*
TP2	E/A/D	0.334 *0,334*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	130 (98 — 160) *425 (330 — 520)*
TP3	E/A/D	0.334 *0,334*	2.0 *2,0*	0.0095 *0,00038*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	0.032 *0,0013*	0.038 *0,0015*	65 (40 — 91) *215 (140 — 290)*

Schnittdaten – JC877 Nutfräsen

SMG		a_p/DC	f_z						v_c
			3	4	6	8	10	12	
TS2	E/A/D	1,0 *1,0*	0,0060 *0,0060*	0,0080 *0,0080*	0,012 *0,012*	0,016 *0,016*	0,020 *0,020*	0,025 *0,025*	170 (150 — 200) *115 (92 — 130)*
TP2	E/A/D	1,0 *1,0*	0,0060 *0,0060*	0,0080 *0,0080*	0,012 *0,012*	0,016 *0,016*	0,020 *0,020*	0,025 *0,025*	115 (86 — 140) *55 (35 — 80)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – JC877 Eckfräsen/Schruppen – Zoll

SMG		a_e/DC	a_p/DC	f_z			v_c
				1/4	3/8	1/2	
TS2	E/A/D	0.334 *0,334*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	195 (170 — 220) *640 (560 — 720)*
TS3	E/A/D	0.334 *0,334*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	130 (110 — 150) *425 (370 — 490)*
TP2	E/A/D	0.334 *0,334*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	130 (98 — 160) *425 (330 — 520)*
TP3	E/A/D	0.334 *0,334*	2.0 *2,0*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	65 (40 — 91) *215 (140 — 290)*

Schnittdaten – JC877 Nutfräsen – Zoll

SMG		a_p/DC	f_z			v_c
			1/4	3/8	1/2	
TS2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	160 (140 — 180) *520 (460 — 590)*
TS3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (85 — 120) *345 (280 — 390)*
TP2	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	105 (80 — 130) *345 (270 — 420)*
TP3	E/A/D	1.0 *1,0*	0.013 *0,00050*	0.019 *0,00075*	0.026 *0,0010*	55 (32 — 74) *180 (110 — 240)*

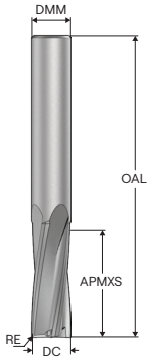
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

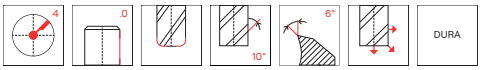
JC880

Verbundwerkstoff – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius





D



—Toleranzen:
—DMM=h5
—DC=-0,02/-0,04 mm
—RE=±0,01 mm

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
880040R020Z4.0-DURA	02843012	2	D	4,0	4,0	12,0	50,0	0,2	4	Cylindrical	■
880050R020Z4.0-DURA	02843013	2	D	5,0	5,0	15,0	50,0	0,2	4	Cylindrical	■
880060R020Z4.0-DURA	02720258	2	D	6,0	6,0	18,0	65,0	0,2	4	Cylindrical	■
880080R020Z4.0-DURA	02720259	2	D	8,0	8,0	24,0	70,0	0,2	4	Cylindrical	■
880100R020Z4.0-DURA	02720260	2	D	10,0	10,0	30,0	80,0	0,2	4	Cylindrical	■
880120R020Z4.0-DURA	02720261	2	D	12,0	12,0	36,0	100,0	0,2	4	Cylindrical	■
880160R020Z4.0-DURA	02720262	2	D	16,0	16,0	48,0	110,0	0,2	4	Cylindrical	■
880200R020Z4.0-DURA	02720263	2	D	20,0	20,0	60,0	130,0	0,2	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JC880 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z							v_c
				4	6	8	10	12	16	20	
TS2	E/A/D	0.400 *0,400*	1.9 *1,9*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	190 (160 — 210) *620 (530 — 680)*
TS3	E/A/D	0.300 *0,300*	2.0 *2,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	130 (93 — 170) *425 (310 — 550)*
TP2	E/A/D	0.400 *0,400*	1.9 *1,9*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	125 (95 — 150) *410 (320 — 490)*
TP3	E/A/D	0.300 *0,300*	2.0 *2,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	0.050 *0,0020*	0.060 *0,0024*	0.070 *0,0028*	50 (40 — 92) *165 (140 — 300)*

Schnittdaten – JC880 Nutfräsen

SMG		a_p/DC	f_z								v_c
			4	5	6	8	10	12	16	20	
TS2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	150 (130 — 170) *490 (430 — 550)*
TS3	E/A/D	1.0 *1,0*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	100 (71 — 130) *330 (240 — 420)*
TP2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.030 *0,0012*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	0.070 *0,0028*	0.090 *0,0036*	0.10 *0,0040*	100 (76 — 120) *330 (250 — 390)*
TP3	E/A/D	1.0 *1,0*	0.015 *0,00060*	0.019 *0,00075*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	0.044 *0,0017*	0.055 *0,0022*	0.065 *0,0026*	40 (31 — 70) *130 (110 — 220)*

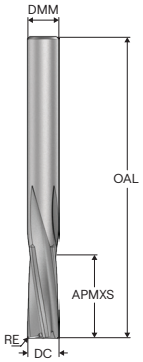
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

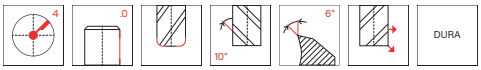
JC885

Verbundwerkstoff – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius





D



—Toleranzen:
—DMM=h5
—DC=-0,02/-0,04 mm
—RE=±0,01 mm
—Linksdrall

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm			
JC885040D2R020.0Z4-DURA	02843014	2	D	4,0	4,0	12,0	50,0	0,2	4	Cylindrical	■
JC885060D2R020.0Z4-DURA	02843016	2	D	6,0	6,0	18,0	70,0	0,2	4	Cylindrical	■
JC885080D2R020.0Z4-DURA	02843017	2	D	8,0	8,0	24,0	80,0	0,2	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JC885 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z				v_c
				4	6	8	10	
TS2	E/A/D	0.400 *0,400*	2.0 *2,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	190 (160 — 210) *620 (530 — 680)*
TS3	E/A/D	0.300 *0,300*	2.0 *2,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	130 (99 — 170) *425 (330 — 550)*
TP2	E/A/D	0.400 *0,400*	2.0 *2,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	125 (94 — 150) *410 (310 — 490)*
TP3	E/A/D	0.300 *0,300*	2.0 *2,0*	0.017 *0,00065*	0.025 *0,0010*	0.034 *0,0013*	0.042 *0,0017*	50 (33 — 92) *165 (110 — 300)*

Schnittdaten – JC885 Nutfräsen

SMG		a_p/DC	f_z				v_c
			4	6	8	10	
TS2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	150 (130 — 170) *490 (430 — 550)*
TS3	E/A/D	0.70 *0,70*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	100 (76 — 130) *330 (250 — 420)*
TP2	E/A/D	1.0 *1,0*	0.024 *0,00095*	0.036 *0,0014*	0.048 *0,0019*	0.060 *0,0024*	100 (75 — 120) *330 (250 — 390)*
TP3	E/A/D	0.70 *0,70*	0.015 *0,00060*	0.022 *0,00085*	0.030 *0,0012*	0.038 *0,0015*	40 (26 — 70) *130 (86 — 220)*

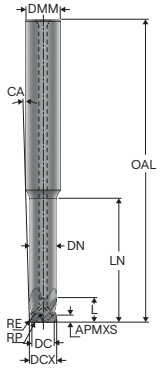
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

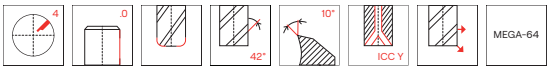
JC898

Hochvorschubfräser – Plattenpakete – Eckenradius – 4 Schneiden – Zylindrisch – Eckenradius





G



– Toleranzen:
– DMM=h5
– DC= e7
– RE= ±0,1 mm

Bezeichnung	Produkt-nummer	Längen-index		CSP	DCX	DC	DMM	L	APMXS	OAL	LN	DN	RE	RP	UTCN	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm	mm	mm	mm	mm				
JC898080G3HZ4A.0-M64	03245308	3	G	■	8,0	4,0	10,0	6,0	0,43	88,0	35,0	7,6	0,5	0,87	0,22	1,5	4	Cylindrical	■
JC898150G3HZ4A.0-M64	03245309	3	G	■	15,0	7,5	16,0	12,0	0,796	125,0	70,0	14,3	0,94	1,63	0,4	0,4	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JC898 Eckfräsen

SMG		a_e/DCX	a_p/DCX	f_z		v_c
				8	15	
S12+TS2/TP2	D	0,30 *0,30*	0,020 *0,020*	0,1 *0,0040*	0,15 *0,0060*	90 (80-120) *300 (270-400)*
TP2+TS2/TP2	D	0,30 *0,30*	0,034 *0,034*	0,12 *0,0048*	0,25 *0,0100*	120 (90-150) *400 (300-490)*

Schnittdaten – JC898 Nutfräsen

SMG		a_p/DCX	f_z		v_c
			8	15	
S12+TP2/TS2	D	0.020 *0.020*	0.08 *0,0032*	0.10 *0,0040*	90 (80-120) *300 (270-400)*
N1+TP2/TS2	D	0.034 *0.034*	0.1 *0,0040*	0.10 *0,0040*	120 (90-150) *400 (300-490)*

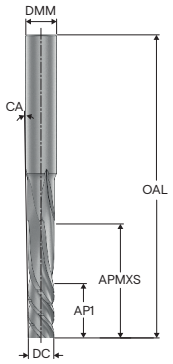
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

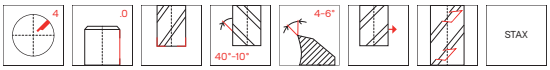
JC899

Hochleistungsfräser – Plattenpakete – Eckfräser – 4 Schneiden – Zylindrisch – Scharfe Schneide





F



—Toleranzen:
—DMM=h5
—DC= ±0,02 mm

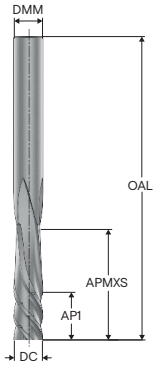
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	OAL	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm				
JC899085F3S.0Z4-STAX	03245482	3	F	■	8,5	10,0	38,0	100,0	0,8	4	Cylindrical	■
JC899148F3S.0Z4-STAX	03245480	3	F	■	14,8	16,0	55,0	150,0	0,53	4	Cylindrical	■
JC899148F4S.0Z4-STAX	03245481	4	F	■	14,8	16,0	62,0	150,0	0,48	4	Cylindrical	■

■ **Lagerstandard.**

JC899

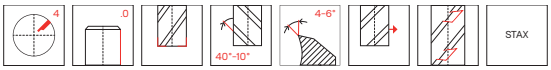
Hochleistungsfräser – Plattenpakete – Eckfräser – 4 Schneiden – Zylindrisch – Scharfe Schneide – Zoll





D

—Toleranzen:
—DMM=h5
—DC= ±0,0008 *Zoll*



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	Spanteiler	DC	DMM	APMXS	AP1	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll	Zoll			
JC8990375D4S.0Z4-STAX	03245483	4	D	■	0.373	0.375	1.500	0.625	4.000	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JC899 Schlichten

SMG		a_e/DC	a_p/DC	f_z		v_c
				8.5	14.8	
S12+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,04 *0,0016*	0,075 *0,0030*	40 (30 — 50) *140 (100 — 170)*
N1+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,06 *0,0032*	0,09 *0,0036*	60 (50 — 75) *200 (170 — 250)*

Schnittdaten – JC899 Schlichten – Zoll

SMG		a_e/DC	a_p/DC	f_z	v_c
				3/8	
S12+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,05 *0,0022*	40 (30 — 50) *140 (100 — 170)*
N1+TP2/TS2	D	0,025 *0,025*	4,0 *4,0*	0,07 *0,0028*	60 (50 — 75) *200 (170 — 250)*

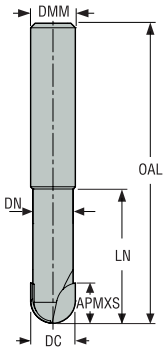
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JPD850

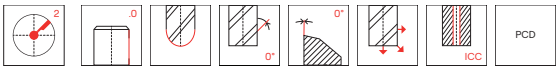
Verbundwerkstoff – Kugelkopf – 2 Schneiden – Zylindrisch





E

—Toleranzen:
—DMM=h5
—DC= h10
—CSP= 2 gerade Kanäle



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JPD850060E2B.0Z2A	02968184	2	E	■	6,0	6,0	7,0	58,0	18,0	5,4	3,0	2	Cylindrical	■
JPD850080E2B.0Z2A	02968185	2	E	■	8,0	8,0	8,0	64,0	24,0	7,2	4,0	2	Cylindrical	■
JPD850100E2B.0Z2A	02968186	2	E	■	10,0	10,0	10,0	73,0	30,0	9,0	5,0	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JPD850 Kopierfräser

SMG		a_e/DC	a_p/DC	f_z					v_c
				4	5	6	8	10	
TS2	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	550 (470 — 820) *1800 (1600 — 2600)*
TS3	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	310 (270 — 460) *1025 (890 — 1500)*
TP2	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	890 (750 — 1300) *2925 (2500 — 4200)*
TP3	E/A/D	0.200 *0,200*	0.50 *0,50*	0.040 *0,0016*	0.048 *0,0019*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	580 (500 — 870) *1900 (1700 — 2800)*

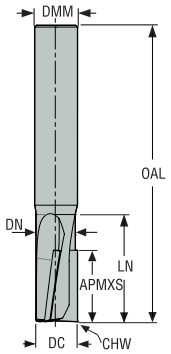
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JPD880

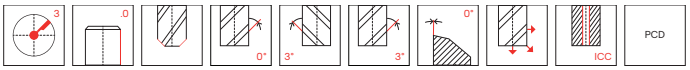
Verbundwerkstoff – Eckfräser – 3 Schneiden – Zylindrisch – Fase





E

—Toleranzen:
—DMM=h5
—DC=h10
—CSP=Y



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JPD880060G2C.0Z3A	02968190	2	G	■	6,0	8,0	13,0	64,0	20,0	5,3	0,1	3	Cylindrical	■
JPD880080E2C.0Z3A	02968191	2	E	■	8,0	8,0	15,0	64,0	20,0	7,3	0,1	3	Cylindrical	■
JPD880100E2C.0Z3A	02968192	2	E	■	10,0	10,0	13,0	73,0	30,0	9,2	0,1	3	Cylindrical	■
JPD880120E2C.0Z3A	02968194	2	E	■	12,0	12,0	13,0	83,0	30,0	11,0	0,1	3	Cylindrical	■
JPD880160E2C.0Z3A	02968196	2	E	■	16,0	16,0	13,0	90,0	35,0	14,8	0,1	3	Cylindrical	■
JPD880100E3C.0Z3A	02968193	3	E	■	10,0	10,0	20,0	73,0	30,0	9,2	0,1	3	Cylindrical	■
JPD880160E3C.0Z3A	02968197	3	E	■	16,0	16,0	20,0	90,0	35,0	14,8	0,1	3	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JPD880 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z					v_c
				6	8	10	12	16	
TS2	E/A/D	0.300 *0,300*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	510 (430 — 750) *1675 (1500 — 2400)*
TS3	E/A/D	0.300 *0,300*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	275 (230 — 410) *900 (760 — 1300)*
TP2	E/A/D	0.300 *0,300*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	810 (680 — 940) *2650 (2300 — 3000)*
TP3	E/A/D	0.300 *0,300*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	520 (440 — 780) *1700 (1500 — 2500)*

Schnittdaten – JPD880 Nutfräsen

SMG		a_p/DC	f_z					v_c
			6	8	10	12	16	
TS2	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	385 (330 — 570) *1275 (1100 — 1800)*
TS3	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	210 (180 — 310) *690 (600 — 1000)*
TP2	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	620 (520 — 710) *2025 (1800 — 2300)*
TP3	E/A/D	1.0 *1,0*	0.055 *0,0022*	0.075 *0,0030*	0.090 *0,0036*	0.11 *0,0044*	0.14 *0,0055*	395 (340 — 590) *1300 (1200 — 1900)*

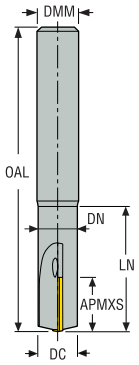
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JPD890

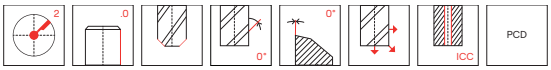
Verbundwerkstoff – Eckfräser – 2 Schneiden – Zylindrisch – Fase





E

—Toleranzen:
—DMM=h5
—DC=h10
—CSP=2 gerade Kanäle



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	DC	DMM	APMXS	OAL	LN	DN	CHW	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm			
JPD890060G2S.0Z2A	02791382	2	G	■	6,0	8,0	13,0	64,0	20,0	5,4	0,1	2	Cylindrical	■
JPD890080E2S.0Z2A	02791383	2	E	■	8,0	8,0	15,0	64,0	20,0	7,4	0,1	2	Cylindrical	■
JPD890100E2S.0Z2A	02791384	2	E	■	10,0	10,0	13,0	73,0	30,0	9,4	0,1	2	Cylindrical	■
JPD890120E2S.0Z2A	02791386	2	E	■	12,0	12,0	13,0	83,0	30,0	11,4	0,1	2	Cylindrical	■
JPD890100E3S.0Z2A	02791385	3	E	■	10,0	10,0	20,0	73,0	30,0	9,4	0,1	2	Cylindrical	■
JPD890120E3S.0Z2A	02791387	3	E	■	12,0	12,0	20,0	83,0	30,0	11,4	0,1	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JPD890 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
TS2	E/A/D	0.300 *0,300*	1.2 *1,2*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	415 (360 — 620) *1350 (1200 — 2000)*
TS3	E/A/D	0.200 *0,200*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	305 (260 — 450) *1000 (860 — 1400)*
TP2	E/A/D	0.300 *0,300*	1.2 *1,2*	0.12 *0,0048*	0.16 *0,0065*	0.20 *0,0080*	0.24 *0,0095*	670 (560 — 770) *2200 (1900 — 2500)*
TP3	E/A/D	0.200 *0,200*	1.2 *1,2*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	580 (490 — 860) *1900 (1700 — 2800)*

Schnittdaten – JPD890 Nutfräsen

SMG		a_p/DC	f_z				v_c
			6	8	10	12	
TS2	E/A/D	1.0 *1,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	375 (320 — 550) *1225 (1100 — 1800)*
TS3	E/A/D	1.0 *1,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	225 (190 — 330) *740 (630 — 1000)*
TP2	E/A/D	1.0 *1,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	600 (500 — 690) *1975 (1700 — 2200)*
TP3	E/A/D	1.0 *1,0*	0.042 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.085 *0,0034*	420 (360 — 630) *1375 (1200 — 2000)*

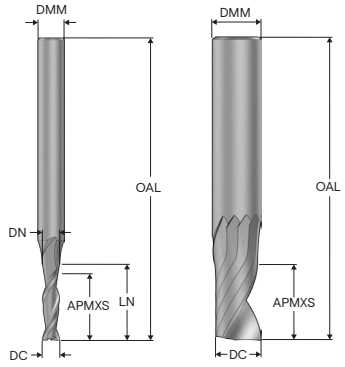
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

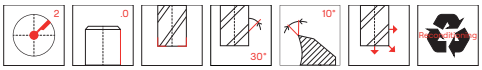
J93F

Allgemeine Anwendung – Kunststoff – Eckfräser – 2 Schneiden – Zylindrisch – Scharfe Schneide





F D



—Toleranzen:
—DMM= h5
—DC= Ø1-Ø6= -0,02/-0,034 mm
—DC= Ø8-Ø20= -0,02/-0,044 mm
—Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm				
93015-F	02605874	2	F	1,5	3,0	6,0	40,0	4,0	2	Cylindrical	■
93020-F	02605888	2	F	2,0	3,0	9,0	40,0	2,5	2	Cylindrical	■
93030-F	02606060	2	D	3,0	3,0	12,0	40,0	–	2	Cylindrical	■
93040-F	02606061	2	D	4,0	4,0	14,0	50,0	–	2	Cylindrical	■
93060-F	02606063	2	D	6,0	6,0	20,0	65,0	–	2	Cylindrical	■
93080-F	02606064	2	D	8,0	8,0	20,0	70,0	–	2	Cylindrical	■
93100-F	02606065	2	D	10,0	10,0	25,0	80,0	–	2	Cylindrical	■
93120-F	02606066	2	D	12,0	12,0	25,0	90,0	–	2	Cylindrical	■
93160-F	02606068	2	D	16,0	16,0	30,0	90,0	–	2	Cylindrical	■
93L060-F	02606071	3	D	6,0	6,0	40,0	100,0	–	2	Cylindrical	■
93L080-F	02606072	3	D	8,0	8,0	40,0	100,0	–	2	Cylindrical	■
93L100-F	02606073	3	D	10,0	10,0	40,0	100,0	–	2	Cylindrical	■
93L120-F	02606074	3	D	12,0	12,0	45,0	100,0	–	2	Cylindrical	■
93L160-F	02606077	3	D	16,0	16,0	45,0	100,0	–	2	Cylindrical	■
93L200-F	02606078	3	D	20,0	20,0	55,0	125,0	–	2	Cylindrical	■
93XL120-F	02606079	4	D	12,0	12,0	30,0	150,0	–	2	Cylindrical	■
93XL160-F	02606080	4	D	16,0	16,0	65,0	150,0	–	2	Cylindrical	■
93XL200-F	02606081	4	D	20,0	20,0	65,0	150,0	–	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – J93F Eckfräsen

SMG		a_e/DC	a_p/DC	f_z										v_c
				1.5	2	3	4	6	8	10	12	16	20	
TS1	A	0.400 *0,400*	1.4 *1,4*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	590 (480 — 710) *1925 (1600 — 2300)*
TP1	A	0.400 *0,400*	1.4 *1,4*	0.015 *0,00060*	0.020 *0,00080*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	0.15 *0,0060*	0.17 *0,0065*	570 (460 — 680) *1875 (1600 — 2200)*

Schnittdaten – J93F Nutfräsen

SMG		a_p/DC	f_z										v_c
			1.5	2	3	4	6	8	10	12	16	20	
TS1	A	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	500 (400 — 590) *1650 (1400 — 1900)*
TP1	A	0.50 *0,50*	0.012 *0,00048*	0.016 *0,00065*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	0.13 *0,0050*	0.16 *0,0065*	485 (390 — 580) *1600 (1300 — 1900)*

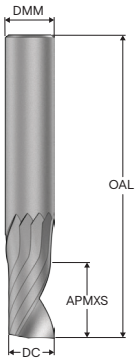
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

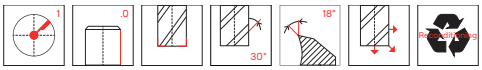
J28

Allgemeine Anwendung – Kunststoff – Eckfräser – 1 Schneide – Zylindrisch – Scharfe Schneide





D



—Toleranzen:
—DMM= h5
—DC= Ø2-Ø6= -0,02/-0,034 mm
—DC= Ø8-Ø12= -0,02/-0,044 mm
—Nachschleifen möglich, wenn DC ≥ Ø6 ist

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm			
28030	00029353	2	D	3,0	3,0	10,0	40,0	1	Cylindrical	■
28040	00029361	2	D	4,0	4,0	14,0	50,0	1	Cylindrical	■
28050	00029363	2	D	5,0	5,0	16,0	60,0	1	Cylindrical	■
28060	00029366	2	D	6,0	6,0	20,0	65,0	1	Cylindrical	■
28080	00029369	2	D	8,0	8,0	25,0	75,0	1	Cylindrical	■
28100	00029370	2	D	10,0	10,0	25,0	75,0	1	Cylindrical	■
28120	00029372	2	D	12,0	12,0	25,0	75,0	1	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – J28 Eckfräsen a_e/DC=0,4

SMG		a_e/DC	a_p/DC	f_z							v_c
				3	4	5	6	8	10	12	
TS1	A/D	0.300 *0,300*	1.5 *1,5*	0.040 *0,0016*	0.050 *0,0020*	0.065 *0,0026*	0.080 *0,0032*	0.10 *0,0040*	0.13 *0,0050*	0.16 *0,0065*	490 (370 — 610) *1600 (1300 — 2000)*

Schnittdaten – J28 Nutfräsen

SMG		a_p/DC	f_z							v_c
			3	4	5	6	8	10	12	
TS1	A/D	1.0 *1,0*	0.026 *0,0010*	0.036 *0,0014*	0.044 *0,0017*	0.055 *0,0022*	0.070 *0,0028*	0.090 *0,0036*	0.11 *0,0044*	400 (310 — 490) *1300 (1100 — 1600)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte



GRAPHIT

Die diamantbeschichteten Vollhartmetallfräser von Seco wurden speziell für die Bearbeitung von Graphit entwickelt. Sie bieten eine bis zu 10-mal höhere Werkzeugstandzeit als Fräser mit konventionellen Beschichtungen. Verfügbar in einer Vielzahl an Geometrien in
einem großen Durchmesserbereich mit bestmöglichem Substrat für perfekte Adhäsion der Diamantbeschichtung bei unterschiedlichen Schnittparametern.

- JD620, JD630, JD640 und JME642 Schaftfräser mit Eckenradius
- JD660, SMB614, SMB616 und JMB642 Kugelkopffräser

Werkzeugauswahl Graphit

					
Werkzeugbezeichnung		JD620	JD630	JD640	JD660
Seite(n)		594	596	598	600
Produktfamilie		DIAMOND	DIAMOND	DIAMOND	DIAMOND
Fräserausführung					
Auf-nahmen	Zylindrisch	■	■	■	■
	Weldon				
Schneidenzahl		2	3	4	2
CSP					
	Metrisch	3-12	3-8	6-12	3-6
	Zoll				
Verfügbare Längen		2,3,4	2,3,4	2,3,4	1,2,3,4,5
Bearbeitung					
					
					
SMG					
GR		●	●	●	●

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl Graphit

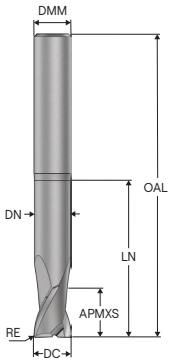
			 	
Werkzeugbezeichnung		SMB614/616	JME642	JMB642/JMB662
Seite(n)		604	604	606
Produktfamilie		MINI DIAMOND	MINI DIAMOND	MINI DIAMOND
Fräserausführung				
Aufnahmen	Zylindrisch	■	■	■
	Weldon			
Schneidenzahl		2	2	2
CSP				
	Metrisch	0,6-3	0,2-2,0	0,2-3,0
	Zoll			
Verfügbare Längen		1,3,5,6,7	1,3,5,6,7	1,3,5,6,7
Bearbeitung				
				
				
SMG				
GR		●	●	●

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

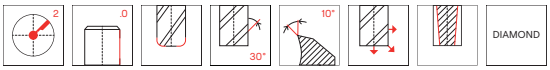
JD620

Diamant – Graphit – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius





E



– Toleranzen:
– Rundlaufabweichung = <0,01 mm
– DMM= h5
– DC= -0,02/-0,04 mm
– RE= ±0,05 mm

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
620V030R050-DIAMOND	00023425	2	E	3,0	3,0	5,0	60,0	30,0	2,85	0,5	2	Cylindrical	■
620V040R050-DIAMOND	00023427	2	E	4,0	4,0	5,0	60,0	30,0	3,85	0,5	2	Cylindrical	■
620V060R050-DIAMOND	00023429	2	E	6,0	6,0	10,0	80,0	40,0	5,8	0,5	2	Cylindrical	■
620V080R050-DIAMOND	00023431	2	E	8,0	8,0	10,0	80,0	40,0	7,7	0,5	2	Cylindrical	■
620V100R050-DIAMOND	00023435	2	E	10,0	10,0	10,0	80,0	40,0	9,7	0,5	2	Cylindrical	■
620V120R050-DIAMOND	00023437	2	E	12,0	12,0	10,0	80,0	40,0	11,7	0,5	2	Cylindrical	■
620VL060R050-DIAMOND	00023444	3	E	6,0	6,0	10,0	100,0	70,0	5,8	0,5	2	Cylindrical	■
620VL080R050-DIAMOND	00023446	3	E	8,0	8,0	10,0	100,0	70,0	7,8	0,5	2	Cylindrical	■
620VL080R100-DIAMOND	00023447	3	E	8,0	8,0	10,0	100,0	70,0	7,8	1,0	2	Cylindrical	■
620VL100R050-DIAMOND	00023448	3	E	10,0	10,0	10,0	100,0	70,0	9,8	0,5	2	Cylindrical	■
620VL100R100-DIAMOND	00023449	3	E	10,0	10,0	10,0	100,0	70,0	9,8	1,0	2	Cylindrical	■
620VL120R050-DIAMOND	00023450	3	E	12,0	12,0	10,0	100,0	70,0	11,8	0,5	2	Cylindrical	■
620VL120R100-DIAMOND	00023451	3	E	12,0	12,0	10,0	100,0	70,0	11,7	1,0	2	Cylindrical	■
620VSL100R100-DIAMOND	00023452	4	E	10,0	10,0	10,0	150,0	100,0	9,8	1,0	2	Cylindrical	■
620VSL120R100-DIAMOND	00023453	4	E	12,0	12,0	10,0	150,0	100,0	11,8	1,0	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JD620 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z						v_c
				3	4	6	8	10	12	
GR1	D	0.500 *0,500*	0.50 *0,50*	0.030 *0,0012*	0.040 *0,0016*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	690 (580 — 800) *2275 (2000 — 2600)*

Schnittdaten – JD620 Nutfräsen

SMG		a_p/DC	f_z						v_c
			3	4	6	8	10	12	
GR1	D	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	610 (520 — 710) *2000 (1800 — 2300)*

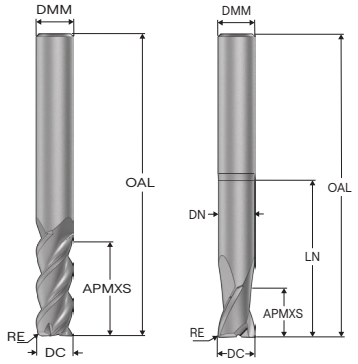
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

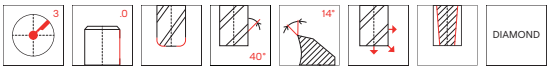
JD630

Diamant – Graphit – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius





D E



– Toleranzen:
– Rundlaufabweichung = <0,01 mm
– DMM= h5
– DC= -0,02/-0,04 mm
– RE= ±0,05 mm

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
630030R015-DIAMOND	00023454	2	D	3,0	3,0	12,0	40,0	–	–	0,15	3	Cylindrical	■
630040R020-DIAMOND	00023456	2	D	4,0	4,0	14,0	50,0	–	–	0,2	3	Cylindrical	■
630050R030-DIAMOND	00023457	2	D	5,0	5,0	16,0	50,0	–	–	0,3	3	Cylindrical	■
630060R030-DIAMOND	00023458	2	D	6,0	6,0	20,0	65,0	–	–	0,3	3	Cylindrical	■
630080R050-DIAMOND	00023459	2	D	8,0	8,0	20,0	65,0	–	–	0,5	3	Cylindrical	■
630V030R030-DIAMOND	00023464	3	E	3,0	3,0	5,0	40,0	15,0	2,9	0,3	3	Cylindrical	■
630V040R030-DIAMOND	00023465	3	E	4,0	4,0	5,0	50,0	20,0	3,9	0,3	3	Cylindrical	■
630VL030R020-DIAMOND	00023467	4	E	3,0	3,0	5,0	60,0	25,0	2,9	0,2	3	Cylindrical	■
630VL040R020-DIAMOND	00023470	4	E	4,0	4,0	5,0	60,0	30,0	3,9	0,2	3	Cylindrical	■
630VL050R020-DIAMOND	00023471	4	E	5,0	5,0	6,0	70,0	40,0	4,9	0,2	3	Cylindrical	■
630VL060R050-DIAMOND	00023472	4	E	6,0	6,0	10,0	100,0	60,0	5,9	0,5	3	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JD630 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z					v_c
				3	4	5	6	8	
GR1	D	0.500 *0,500*	1.0 *1,0*	0.030 *0,0012*	0.040 *0,0016*	0.050 *0,0020*	0.060 *0,0024*	0.080 *0,0032*	680 (580 — 790) *2225 (2000 — 2500)*

Schnittdaten – JD630 Nutfräsen

SMG		a_p/DC	f_z					v_c
			3	4	5	6	8	
GR1	D	0.50 *0,50*	0.024 *0,00095*	0.032 *0,0013*	0.040 *0,0016*	0.048 *0,0019*	0.065 *0,0026*	620 (520 — 720) *2025 (1800 — 2300)*

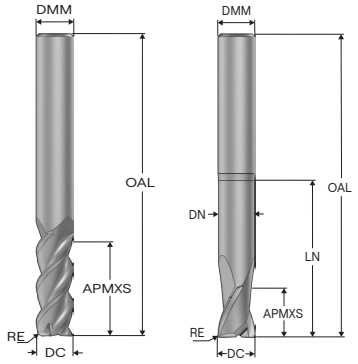
Schnittdaten, siehe Seite 699 - 707

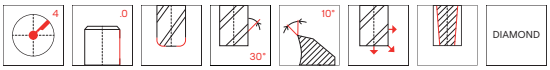
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JD640

Diamant – Graphit – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius







– Toleranzen:
– Rundlaufabweichung = <0,01 mm
– DMM= h5
– DC= -0,02/-0,04 mm
– RE= ±0,05 mm

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
640100R050-DIAMOND	00023474	2	D	10,0	10,0	25,0	75,0	–	–	0,5	4	Cylindrical	■
640120R050-DIAMOND	00023475	2	D	12,0	12,0	25,0	80,0	–	–	0,5	4	Cylindrical	■
640V060R050-DIAMOND	00023479	3	E	6,0	6,0	10,0	80,0	40,0	5,9	0,5	4	Cylindrical	■
640V080R050-DIAMOND	00023480	3	E	8,0	8,0	10,0	80,0	40,0	7,8	0,5	4	Cylindrical	■
640V100R050-DIAMOND	00023481	3	E	10,0	10,0	12,0	80,0	40,0	9,8	0,5	4	Cylindrical	■
640V120R050-DIAMOND	00023483	3	E	12,0	12,0	15,0	80,0	40,0	11,8	0,5	4	Cylindrical	■
640VL100R050-DIAMOND	00023486	4	E	10,0	10,0	12,0	125,0	80,0	9,8	0,5	4	Cylindrical	■
640VL120R050-DIAMOND	02462698	4	E	12,0	12,0	15,0	125,0	80,0	11,7	0,5	4	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JD640 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z				v_c
				6	8	10	12	
GR1	D	0.500 *0,500*	1.0 *1,0*	0.060 *0,0024*	0.080 *0,0032*	0.10 *0,0040*	0.12 *0,0048*	680 (570 — 780) *2225 (1900 — 2500)*

Schnittdaten – JD640 Nutfräsen

SMG		a_p/DC	f_z				v_c
			6	8	10	12	
GR1	D	0.50 *0,50*	0.048 *0,0019*	0.065 *0,0026*	0.080 *0,0032*	0.095 *0,0038*	610 (520 — 710) *2000 (1800 — 2300)*

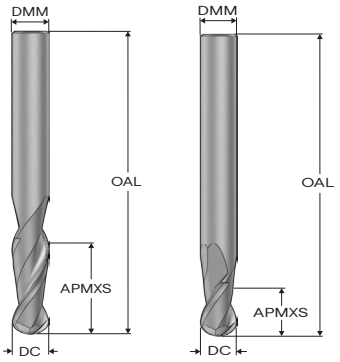
Schnittdaten, siehe Seite 699 - 707

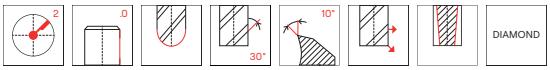
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JD660

Diamant – Graphit – Kugelkopf – 2 Schneiden – Zylindrisch







– Toleranzen:
– Rundlaufabweichung =<0,01 mm
– DMM=h5
– DC= -0,02/-0,04 mm
– RE= ±0,01 mm
– B=0,9°

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm			
660030-DIAMOND	00023488	1	D	3,0	3,0	8,0	40,0	–	–	1,5	2	Cylindrical	■
660040-DIAMOND	00023489	1	D	4,0	4,0	14,0	50,0	–	–	2,0	2	Cylindrical	■
660060-DIAMOND	00023491	1	D	6,0	6,0	20,0	65,0	–	–	3,0	2	Cylindrical	■
660V030-DIAMOND	00023501	2	E	3,0	3,0	6,0	40,0	15,0	2,9	1,5	2	Cylindrical	■
660V040-DIAMOND	00023502	2	E	4,0	4,0	6,0	40,0	15,0	3,9	2,0	2	Cylindrical	■
660V060-DIAMOND	00023505	2	E	6,0	6,0	10,0	65,0	35,0	5,9	3,0	2	Cylindrical	■
660L030-DIAMOND	00023494	3	D	3,0	3,0	20,0	60,0	–	–	1,5	2	Cylindrical	■
660L040-DIAMOND	00023496	3	D	4,0	4,0	30,0	60,0	–	–	2,0	2	Cylindrical	■
660L060-DIAMOND	00023498	3	D	6,0	6,0	40,0	100,0	–	–	3,0	2	Cylindrical	■
660VL030-DIAMOND	00023511	4	E	3,0	3,0	6,0	60,0	30,0	2,9	1,5	2	Cylindrical	■
660VL040-DIAMOND	00023512	4	E	4,0	4,0	6,0	60,0	30,0	3,9	2,0	2	Cylindrical	■
660VL060-DIAMOND	00023516	4	E	6,0	6,0	10,0	100,0	70,0	5,8	3,0	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JD660 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z			v_c
				3	4	6	
GR1	D	0.400 *0,400*	2.4 *2,4*	0.024 *0,00095*	0.032 *0,0013*	0.046 *0,0018*	920 (780 — 1000) *3025 (2600 — 3200)*

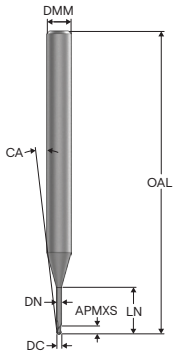
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

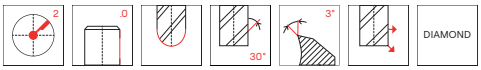
SMB614/616

Mini – Graphit – Kugelkopf – 2 Schneiden – Zylindrisch





G



—Toleranzen:
—Rundlaufabweichung = <0,005 mm
—DMM = h5
—DC Beschichtet = -0,01/-0,025 mm
—DC Beschichtet = 0/-0,015 mm
—RE = ±0,01 mm

Bezeichnung	Beschich-tung	Produkt-nummer	Längen-index		DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm	mm	mm	mm				
SMB614010G4B.0Z2	DIA	10108776	4	G	1,0	4,0	1,0	50,0	7,5	0,95	0,5	6,54	2	Cylindrical	■
SMB614020G4B.0Z2	DIA	10108777	4	G	2,0	4,0	2,0	50,0	12,0	1,9	1,0	3,74	2	Cylindrical	■
SMB614030G4B.0Z2	DIA	10108778	4	G	3,0	4,0	3,0	50,0	20,0	2,85	1,5	1,36	2	Cylindrical	■
SMB614020G5B.0Z2	DIA	10108779	5	G	2,0	4,0	2,0	50,0	16,0	1,9	1,0	3,13	2	Cylindrical	■
SMB614006G6B.0Z2	DIA	10108780	6	G	0,6	4,0	0,6	50,0	6,0	0,55	0,3	7,72	2	Cylindrical	■
SMB614008G6B.0Z2	DIA	10108781	6	G	0,8	4,0	0,8	50,0	10,0	0,75	0,4	5,69	2	Cylindrical	■
SMB614010G6B.0Z2	DIA	10108782	6	G	1,0	4,0	0,5	50,0	12,0	0,95	0,5	4,88	2	Cylindrical	■
SMB614020G6B.0Z2	DIA	10108783	6	G	2,0	4,0	2,0	50,0	20,0	1,9	1,0	2,46	2	Cylindrical	■
SMB614006G7B.0Z2	DIA	10108784	7	G	0,6	4,0	0,6	50,0	10,0	0,55	0,3	5,87	2	Cylindrical	■
SMB614010G7B.0Z2	DIA	10108785	7	G	1,0	4,0	1,0	50,0	18,0	0,95	0,5	3,64	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – SMB614 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z					v_c
				0.6	0.8	1	2	3	
GR1	D	0,0700 *0.0700*	0,10 *0.10*	0,018 *0.00070*	0,024 *0.00095*	0,030 *0.0012*	0,060 *0.0024*	0,090 *0.0036*	95 (54 — 120) *310 (180 — 390)*

Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – SMB616 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z				v_c
				0.6	1	2	3	
GR1	D	0,0700 *0.0700*	0,10 *0.10*	0,018 *0.00070*	0,030 *0.0012*	0,060 *0.0024*	0,090 *0.0036*	95 (54 — 120) *310 (180 — 390)*

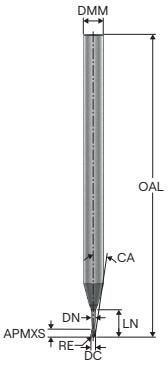
Schnittdaten, siehe Seite 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

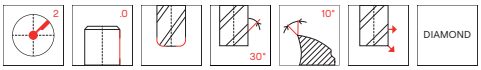
JME642

Mini – Graphit – Eckfräser – Diamant – 2 Schneiden – DMM 4 – Zylindrisch – Eckenradius





G



—Toleranzen:
—Rundlaufabweichung = <0,005 mm
—DMM= h5
—DC= 0/-0,015 mm
—RE= ±0,007 mm

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
JME642002G1R002.0Z2-DIA	03215524	1	G	0,2	4,0	0,3	40,0	0,4	0,18	0,02	14,32	2	Cylindrical	■
JME642003G1R002.0Z2-DIA	03215525	1	G	0,3	4,0	0,5	40,0	0,5	0,28	0,02	14,1	2	Cylindrical	■
JME642004G1R004.0Z2-DIA	03215526	1	G	0,4	4,0	0,6	40,0	2,0	0,37	0,04	11,67	2	Cylindrical	■
JME642005G3R005.0Z2-DIA	03215527	3	G	0,5	4,0	0,7	40,0	2,5	0,45	0,05	10,97	2	Cylindrical	■
JME642006G3R006.0Z2-DIA	03215528	3	G	0,6	4,0	1,0	60,0	3,0	0,55	0,06	10,31	2	Cylindrical	■
JME642008G3R008.0Z2-DIA	03215529	3	G	0,8	4,0	1,2	60,0	4,0	0,75	0,08	9,31	2	Cylindrical	■
JME642010G3R010.0Z2-DIA	03215530	3	G	1,0	4,0	1,6	60,0	5,0	0,95	0,1	8,04	2	Cylindrical	■
JME642012G3R012.0Z2-DIA	03215531	3	G	1,2	4,0	1,6	60,0	6,0	1,15	0,12	7,09	2	Cylindrical	■
JME642015G3R015.0Z2-DIA	03215532	3	G	1,5	4,0	2,4	60,0	7,5	1,4	0,15	5,8	2	Cylindrical	■
JME642020G3R015.0Z2-DIA	03236441	3	G	2,0	4,0	2,2	60,0	10,0	1,9	0,15	4,11	2	Cylindrical	■
JME642020G3R020.0Z2-DIA	03215533	3	G	2,0	4,0	3,0	60,0	10,0	1,9	0,2	4,11	2	Cylindrical	■
JME642005G5R005.0Z2-DIA	03215534	5	G	0,5	4,0	0,7	40,0	4,0	0,45	0,05	9,43	2	Cylindrical	■
JME642006G5R006.0Z2-DIA	03215535	5	G	0,6	4,0	1,0	60,0	5,0	0,55	0,06	8,5	2	Cylindrical	■
JME642008G5R008.0Z2-DIA	03215536	5	G	0,8	4,0	1,2	60,0	7,0	0,75	0,08	7,02	2	Cylindrical	■
JME642010G5R010.0Z2-DIA	03215537	5	G	1,0	4,0	1,6	60,0	8,5	0,95	0,1	6,06	2	Cylindrical	■
JME642012G5R012.0Z2-DIA	03215538	5	G	1,2	4,0	1,6	60,0	10,0	1,15	0,12	5,23	2	Cylindrical	■
JME642015G5R015.0Z2-DIA	03215539	5	G	1,5	4,0	2,4	60,0	12,0	1,4	0,15	4,25	2	Cylindrical	■
JME642020G5R015.0Z2-DIA	03236442	5	G	2,0	4,0	2,2	60,0	16,0	1,9	0,15	2,87	2	Cylindrical	■
JME642020G5R020.0Z2-DIA	03215540	5	G	2,0	4,0	3,0	60,0	16,0	1,9	0,2	2,87	2	Cylindrical	■
JME642010G6R010.0Z2-DIA	03215541	6	G	1,0	4,0	1,6	60,0	12,0	0,95	0,1	4,86	2	Cylindrical	■
JME642015G6R015.0Z2-DIA	03215542	6	G	1,5	4,0	2,4	50,0	18,0	1,4	0,15	3,13	2	Cylindrical	■
JME642020G6R020.0Z2-DIA	03215543	6	G	2,0	4,0	3,0	60,0	25,0	1,9	0,2	1,97	2	Cylindrical	■
JME642020G7R020.0Z2-DIA	03215544	7	G	2,0	4,0	3,0	60,0	30,0	1,9	0,2	1,68	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JME642/JME662 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z										v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.300 *0,300*	0.80 *0,80*	0.024 *0,00095*	0.036 *0,0014*	0.044 *0,0017*	0.048 *0,0019*	0.055 *0,0022*	0.060 *0,0024*	0.065 *0,0026*	0.070 *0,0028*	0.075 *0,0030*	0.085 *0,0034*	175 (130 — 370) *570 (430 — 1200)*

Schnittdaten – JME642 Nutfräsen

SMG		a_p/DC	f_z										v_c
			0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.30 *0,30*	0.022 *0,00085*	0.032 *0,0013*	0.040 *0,0016*	0.046 *0,0018*	0.050 *0,0020*	0.055 *0,0022*	0.065 *0,0026*	0.065 *0,0026*	0.075 *0,0030*	0.080 *0,0032*	140 (110 — 300) *460 (370 — 980)*

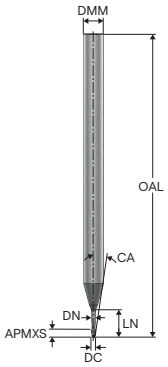
Tabelle basierend auf LV3, auf Basis der gewählten Version neu berechnen. Siehe Seite(n). 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JMB642/JMB662

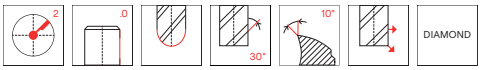
Mini – Graphit – Kugelkopf – Diamant – 2 Schneiden – DMM 4-6 – Zylindrisch





G

—Toleranzen:
—Rundlaufabweichung = <0,005 mm
—DMM= h5
—DC= 0/-0,015 mm
—RE= ±0,007 mm



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	DC	DMM	APMXS	OAL	LN	DN	RE	CA°	PCEDC	Auf-nahmen	Lagerstand-ard
				mm	mm	mm	mm	mm	mm	mm				
JMB642002G1B.0Z2-DIA	03215373	1	G	0,2	4,0	0,3	40,0	0,4	0,18	0,1	14,5	2	Cylindrical	■
JMB642003G1B.0Z2-DIA	03215374	1	G	0,3	4,0	0,5	40,0	0,6	0,28	0,15	14,17	2	Cylindrical	■
JMB642004G1B.0Z2-DIA	03215375	1	G	0,4	4,0	2,0	40,0	0,8	0,37	0,2	13,8	2	Cylindrical	■
JMB642005G3B.0Z2-DIA	03215376	3	G	0,5	4,0	0,7	40,0	2,5	0,45	0,25	11,19	2	Cylindrical	■
JMB642006G3B.0Z2-DIA	03215377	3	G	0,6	4,0	1,0	60,0	3,0	0,55	0,3	10,55	2	Cylindrical	■
JMB642008G3B.0Z2-DIA	03215378	3	G	0,8	4,0	1,2	60,0	4,0	0,75	0,4	9,38	2	Cylindrical	■
JMB642010G3B.0Z2-DIA	03215379	3	G	1,0	4,0	1,6	60,0	5,0	0,95	0,5	8,33	2	Cylindrical	■
JMB642012G3B.0Z2-DIA	03215380	3	G	1,2	4,0	1,6	60,0	6,0	1,15	0,6	7,38	2	Cylindrical	■
JMB642015G3B.0Z2-DIA	03215381	3	G	1,5	4,0	2,4	60,0	7,5	1,4	0,75	6,08	2	Cylindrical	■
JMB642020G3B.0Z2-DIA	03215382	3	G	2,0	4,0	3,0	60,0	10,0	1,9	1,0	4,35	2	Cylindrical	■
JMB662030G3B.0Z2-DIA	03215384	3	G	3,0	6,0	3,0	60,0	15,0	2,8	1,5	4,38	2	Cylindrical	■
JMB642005G5B.0Z2-DIA	03215387	5	G	0,5	4,0	0,7	40,0	4,0	0,45	0,25	9,6	2	Cylindrical	■
JMB642006G5B.0Z2-DIA	03215388	5	G	0,6	4,0	1,0	60,0	5,0	0,55	0,3	8,68	2	Cylindrical	■
JMB642008G5B.0Z2-DIA	03215389	5	G	0,8	4,0	1,2	60,0	7,0	0,75	0,4	7,18	2	Cylindrical	■
JMB642010G5B.0Z2-DIA	03215390	5	G	1,0	4,0	1,6	60,0	8,5	0,95	0,5	6,22	2	Cylindrical	■
JMB642012G5B.0Z2-DIA	03215391	5	G	1,2	4,0	1,6	60,0	10,0	1,15	0,6	5,4	2	Cylindrical	■
JMB642015G5B.0Z2-DIA	03215392	5	G	1,5	4,0	2,4	60,0	12,0	1,4	0,75	4,4	2	Cylindrical	■
JMB642020G5B.0Z2-DIA	03215393	5	G	2,0	4,0	3,0	60,0	16,0	1,9	1,0	2,99	2	Cylindrical	■
JMB662030G5B.0Z2-DIA	03215395	5	G	3,0	6,0	3,0	60,0	24,0	2,8	1,5	3,0	2	Cylindrical	■
JMB642010G6B.0Z2-DIA	03215396	6	G	1,0	4,0	1,6	60,0	12,0	0,95	0,5	4,96	2	Cylindrical	■
JMB642015G6B.0Z2-DIA	03215397	6	G	1,5	4,0	2,4	60,0	18,0	1,4	0,75	3,21	2	Cylindrical	■
JMB642020G6B.0Z2-DIA	03215398	6	G	2,0	4,0	3,0	60,0	25,0	1,9	1,0	2,03	2	Cylindrical	■
JMB642020G7B.0Z2-DIA	03215399	7	G	2,0	4,0	3,0	60,0	30,0	1,9	1,0	1,72	2	Cylindrical	■

■ **Lagerstandard.**

Schnittdaten – JMB642/662 Eckfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z										v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.300 *0,300*	0.50 *0,50*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	250 (200 — 300) *820 (660 — 980)*

Schnittdaten – JMB642/662 Kopierfräsen/Schruppen

SMG		a_e/DC	a_p/DC	f_z										v_c
				0.2	0.3	0.4	0.5	0.6	0.8	1	1.2	1.5	2	
GR1	D	0.300 *0,300*	0.50 *0,50*	0.0024 *0,000095*	0.0036 *0,00014*	0.0048 *0,00019*	0.0060 *0,00024*	0.0070 *0,00028*	0.0095 *0,00038*	0.012 *0,00048*	0.014 *0,00055*	0.017 *0,00065*	0.020 *0,00080*	250 (200 — 300) *820 (660 — 980)*

Tabelle basierend auf LV3, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 699 - 707

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte



SECO X-HEADS

Das neue Programm an austauschbaren Köpfen von Seco ist ein umfassendes Angebot, das den Anforderungen der meisten Kunden entspricht. Mit unseren bewährten Vollhartmetallgeometrien bieten wir verschiedene Typen für die Bearbeitung der meisten Materialien und zur Durchführung verschiedener Bearbeitungsvorgänge an. Der Anschluss ist eine bewährte Konstruktion austauschbarer Köpfe, die eine hohe Prozesssicherheit und Zuverlässigkeit bietet. Es gibt viele Arten von Schäften für Anwendungen mit kurzen bis langen Werkzeugen. Gerade und konische Freilegungen für die beste Kombination von Stabilität je nach Bedarf bei Ihre Bearbeitungsvorgänge.

- XSE550, XSE720, XSE450, XHF5831, XHF580, XHF780 XVE540 und XVE510 mit Fase oder Eckenradius.
- XSB540, XSB720 und XVB510 Kugelkopffräsen.
- XVC506, XVC509, XS5021, XS5061 und XVC512 konisch
- XHT740 Tonnenfräser.

Werkzeugauswahl X-Heads

							
Werkzeugbezeichnung		XSE550	XSB540	XSE720	XSB720	XSE450	XHT740
Seite(n)		620	637	639	645	651	655
Produktfamilie		X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS SOLID²	X-HEADS HSM/TORNADO
Fräserausführung							
Schneidenzahl		3,4,5	4	6	6	3	4,6
CSP			■				
	Metrisch	10-20	10-16	10-25	10-20	10-20	10-16
	Zoll	3/8-1		3/8-1	3/8-1	3/8-1	
Verfügbare Längen		1,2	1	3	3	2	2,3
Bearbeitung							
							
							
							
SMG							
P1-8		●	●	○	○		○
P11-12		●	○	●	●		●
M1-3		●	●	●	●		●
M4-5		●	●	●	●		
K1-7		●	●				
S1-3		●	○	●	●		○
S11-13		●	●	●	●		●
H3 H5 H7 H8 H11 H12 H21 H31		●	○				
N1		●	●			●	
N2-3		●	●			●	
N11		●	●			●	
TS1		●	●			●	
TP1		●	●			●	
GR		○	○				

■ Lagerstandard.
● Erste Wahl, ○ Alternative

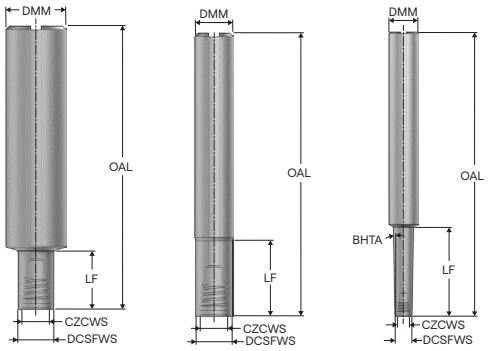
Werkzeugauswahl X-Heads

										
Werkzeugbezeichnung		XHF580	XHF780	XS5021	XS5061	XVE540	XVE510	XVB510	XVC506/509/512	XVK310
Seite(n)		658	663	669	671	680	685	688	692	696
Produktfamilie		X-HEADS HFM	X-HEADS HFM	X-HEADS SOLID[2]	X-HEADS SOLID[2]	X-HEADS VHM	X-HEADS VHM	X-HEADS VHM	X-HEADS VHM	X-HEADS VHM
Fräserausführung										
Schneidenzahl		4	4	2	6	3,4	2	2	2	4
CSP		■				■				
	Metrisch	10-16	10-16	10-16	10-16	10-20	10-12	10-16	10-16	12-20
	Zoll	3/8-5/8	3/8-5/8			3/8-3/4		3/8-5/8		
Verfügbare Längen		1	1	1	1	1	1	1	1	1
Bearbeitung										
										
										
										
SMG										
P1-8		●	○	●	●	●	●	●	●	●
P11-12		●	○	●	●	●	●	●	●	●
M1-3		●	●	●	●	●	●	●	●	●
M4-5		●	●	●	●	●	●	●	●	●
K1-7		●		●	●	●	●	●	●	●
S1-3		○	●	○	○	○	○	○	○	○
S11-13		○	●	○	○	○	○	○	○	○
H3 H5 H7 H8 H11 H12 H21 H31		○	○	●	●	○				○
N1				○	○	●	○	○	○	●
N2-3				○	○	●	○	○	○	●
N11				○	○	●	○	○	○	●
TS1				●	●	●	●	●	●	●
TP1				●	●	●	●	●	●	●
GR				○	○	○	○	○	○	○

■ Lagerstandard ☐ Weldon verfügbar, die Lieferzeit beträgt 3 Tage. ☐ Safe-Lock verfügbar, die Lieferzeit beträgt 6 Tage.
● Erste Wahl ○ Alternative

Stahl - Metrisch







—Toleranzen:
—DMM= h6
—DCSFWS= ±0,05 mm
—BHTA= ±20'

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DCSFWS	DMM	LF	OAL	BHTA°	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm			
XE10160G1-065-00.0S	10138083	1	G	E10	9,6	16,0	5,0	65,0	0,0	Cylindrical	■
XE12160G1-065-00.0S	10138084	1	G	E12	11,6	16,0	5,0	65,0	0,0	Cylindrical	■
XE16200G1-070-00.0S	10138085	1	G	E16	15,4	20,0	5,0	70,0	0,0	Cylindrical	■
XE20250G1-080-00.0S	10138086	1	G	E20	19,2	25,0	5,0	80,0	0,0	Cylindrical	■
XE25320G1-080-00.0S	10138087	1	G	E25	24,1	32,0	5,0	80,0	0,0	Cylindrical	■
XE10100E2-055-00.0S	10138092	2	E	E10	9,6	10,0	10,0	55,0	0,0	Cylindrical	■
XE10100E2-075-00.0S	10138093	2	E	E10	9,6	10,0	20,0	75,0	0,0	Cylindrical	■
XE12120E2-065-00.0S	10138094	2	E	E12	11,6	12,0	12,0	65,0	0,0	Cylindrical	■
XE12120E2-100-00.0S	10138095	2	E	E12	11,6	12,0	22,0	100,0	0,0	Cylindrical	■
XE10160G2-075-00.0S	10138088	2	G	E10	9,6	16,0	15,0	75,0	0,0	Cylindrical	■
XE12160G2-080-00.0S	10138089	2	G	E12	11,6	16,0	18,0	80,0	0,0	Cylindrical	■
XE12160J2-140-05.0S	10138107	2	J	E12	11,6	16,0	25,1	140,0	5,0	Cylindrical	■
XE16160E2-070-00.0S	10138096	2	E	E16	15,4	16,0	16,0	70,0	0,0	Cylindrical	■
XE16200G2-090-00.0S	10138090	2	G	E16	15,4	20,0	24,0	90,0	0,0	Cylindrical	■
XE16200G2-110-00.0S	10138091	2	G	E16	15,4	20,0	25,0	110,0	0,0	Cylindrical	■
XE20200E2-120-00.0S	10138097	2	E	E20	19,2	20,0	30,0	120,0	0,0	Cylindrical	■
XE25250E2-140-00.0S	10138098	2	E	E25	24,1	25,0	40,0	140,0	0,0	Cylindrical	■
XE25320J2-200-05.0S	10138112	2	J	E25	24,1	32,0	45,1	200,0	5,0	Cylindrical	■
XE10160J3-120-01.0S	10138099	3	J	E10	9,6	16,0	35,0	120,0	1,0	Cylindrical	■
XE10160J3-140-05.0S	10138106	3	J	E10	9,6	16,0	36,6	140,0	5,0	Cylindrical	■
XE12160J3-155-01.0S	10138101	3	J	E12	11,6	16,0	42,0	155,0	1,0	Cylindrical	■
XE16200J3-190-01.0S	10138103	3	J	E16	15,4	20,0	56,0	190,0	1,0	Cylindrical	■
XE16250J3-170-05.0S	10138110	3	J	E16	15,4	25,0	54,9	170,0	5,0	Cylindrical	■
XE20320J3-180-05.0S	10138111	3	J	E20	19,2	32,0	73,2	180,0	5,0	Cylindrical	■
XE12200J4-155-05.0S	10138109	4	J	E12	11,6	20,0	48,0	155,0	5,0	Cylindrical	■
XE16200J4-190-01.0S	10138104	4	J	E16	15,4	20,0	75,0	190,0	1,0	Cylindrical	■
XE20250J4-200-01.0S	10138105	4	J	E20	19,2	25,0	80,0	200,0	1,0	Cylindrical	■
XE12320J4-250-10.0S	10138114	4	J	E12	11,6	32,0	57,8	250,0	10,0	Cylindrical	■
XE10160J5-160-01.0S	10138100	5	J	E10	9,6	16,0	50,0	160,0	1,0	Cylindrical	■
XE12160J5-170-01.0S	10138102	5	J	E12	11,6	16,0	60,0	170,0	1,0	Cylindrical	■
XE10200J5-140-05.0S	10138108	5	J	E10	9,6	20,0	59,4	140,0	5,0	Cylindrical	■
XE10320J6-250-10.0S	10138113	6	J	E10	9,6	32,0	63,5	250,0	10,0	Cylindrical	■

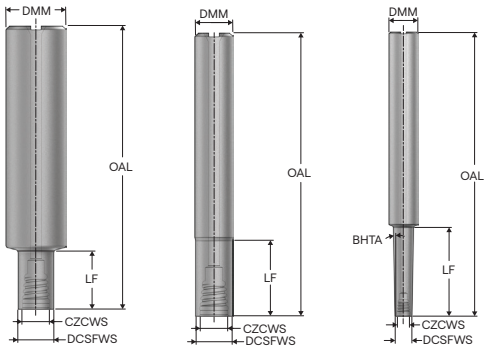
Ersatzteile, im Lieferumfang enthalten Zubehör

Für Fräser	Spannschlüssel	Ersatzklinge	Ersatzklinge 1	Drehmoment-schlüssel
				
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ **Lagerstandard.**

Stahl - Zoll







—Toleranzen:
—DMM= h6
—DCSFWS= ±.002 Zoll
—BHTA= ±20'

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DCSFMS	DMM	LF	OAL	BHTA°	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll			
XE10.500G1-2.50-00.0S	10138050	1	G	E10	0.360	0.500	0.250	2.500	0,0	Cylindrical	■
XE12.500E1-3.00-00.0S	10138054	1	E	E12	0.480	0.500	0.250	3.000	0,0	Cylindrical	■
XE16.625E1-3.00-00.0S	10138057	1	E	E16	0.606	0.625	0.250	3.000	0,0	Cylindrical	■
XE20.750E1-3.00-00.0S	10138060	1	E	E20	0.724	0.750	0.250	3.000	0,0	Cylindrical	■
XE251.00E1-3.50-00.0S	10138062	1	E	E25	0.961	1.000	0.250	3.500	0,0	Cylindrical	■
XE10.375E2-3.00-00.0S	10334248	2	E	E10	0.362	0.375	0.799	3.000	0,0	Cylindrical	■
XE10.375E2-2.50-00.0S	10138053	2	E	E10	0.360	0.375	0.402	2.500	0,0	Cylindrical	■
XE10.500G2-3.00-00.0S	10138051	2	G	E10	0.360	0.500	1.000	3.000	0,0	Cylindrical	■
XE12.500E2-2.50-00.0S	10138055	2	E	E12	0.480	0.500	0.500	2.500	0,0	Cylindrical	■
XE12.500E2-4.50-00.0S	10138056	2	E	E12	0.480	0.500	1.000	4.500	0,0	Cylindrical	■
XE12.625J2-6.50-05.0S	10138075	2	J	E12	0.480	0.625	0.827	6.500	5,0	Cylindrical	■
XE16.625E2-3.00-00.0S	10138058	2	E	E16	0.606	0.625	0.650	3.000	0,0	Cylindrical	■
XE16.625E2-4.50-00.0S	10138059	2	E	E16	0.606	0.625	1.000	4.500	0,0	Cylindrical	■
XE16.750J2-6.50-05.0S	10138076	2	J	E16	0.606	0.750	0.821	6.500	5,0	Cylindrical	■
XE20.750E2-4.50-00.0S	10138061	2	E	E20	0.724	0.750	1.000	4.500	0,0	Cylindrical	■
XE201.00J2-6.00-05.0S	10334251	2	J	E20	0.724	1.000	1.575	6.000	5,0	Cylindrical	■
XE251.00E2-4.50-00.0S	10218129	2	E	E25	0.961	1.000	1.500	4.500	0,0	Cylindrical	■
XE251.25G2-6.50-00.0S	10138052	2	G	E25	0.961	1.250	2.500	6.500	0,0	Cylindrical	■
XE251.25J2-7.50-05.0S	10218130	2	J	E25	0.961	1.250	1.654	7.500	5,0	Cylindrical	■
XE10.625J3-4.50-01.0S	10138063	3	J	E10	0.360	0.625	1.402	4.500	1,0	Cylindrical	■
XE12.625J3-6.00-01.0S	10138065	3	J	E12	0.480	0.625	1.650	6.000	1,0	Cylindrical	■
XE16.750J3-7.50-01.0S	10138068	3	J	E16	0.606	0.750	2.252	7.500	1,0	Cylindrical	■
XE161.00J3-7.00-05.0S	10138077	3	J	E16	0.606	1.000	2.250	7.000	5,0	Cylindrical	■
XE10.625J4-5.50-05.0S	10334250	4	J	E10	0.374	0.625	1.512	5.500	5,0	Cylindrical	■
XE10.625J4-4.00-03.0S	10138071	4	J	E10	0.360	0.625	1.799	4.000	3,0	Cylindrical	■
XE12.625J4-7.50-01.0S	10138066	4	J	E12	0.480	0.625	2.400	7.500	1,0	Cylindrical	■
XE12.750J4-4.50-03.0S	10138073	4	J	E12	0.480	0.750	2.201	4.500	3,0	Cylindrical	■
XE16.750J4-7.50-01.0S	10138070	4	J	E16	0.606	0.750	3.000	7.500	1,0	Cylindrical	■
XE201.00J4-8.00-01.0S	10334249	4	J	E20	0.724	1.000	3.150	8.000	1,0	Cylindrical	■
XE10.625J5-6.50-01.0S	10138064	5	J	E10	0.360	0.625	2.000	6.500	1,0	Cylindrical	■
XE12.750J5-6.00-03.0S	10138074	5	J	E12	0.480	0.750	2.575	6.000	3,0	Cylindrical	■
XE12.750J5-6.50-01.0S	10138067	5	J	E12	0.480	0.750	2.850	6.500	1,0	Cylindrical	■
XE16.750J6-7.50-01.0S	10138069	6	J	E16	0.606	0.750	3.748	7.500	1,0	Cylindrical	■
XE10.750J9-6.00-03.0S	10138072	9	J	E10	0.360	0.750	3.720	6.000	3,0	Cylindrical	■

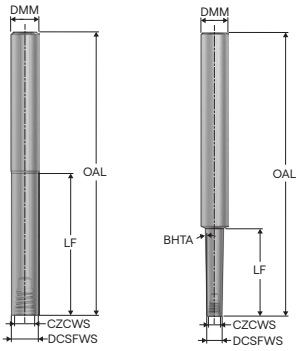
Ersatzteile, im Lieferumfang enthalten Zubehör

Für Fräser	Spannschlüssel	Ersatzklinge	Ersatzklinge 1	Drehmoment-schlüssel
				
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ **Lagerstandard.**

Vollhartmetall - Metrisch





E J



—Toleranzen:
—DMM= h6
—DCSFWS= ±0,05 mm
—BHTA= ±20'

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DCSFWS	DMM	LF	OAL	BHTA°	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm			
XE12160J2-165-05.0E	10334240	2	J	E12	11,6	16,0	25,1	165,0	5,0	Cylindrical	■
XE16200J2-165-05.0E	10334241	2	J	E16	15,4	20,0	26,3	165,0	5,0	Cylindrical	■
XE20200E2-095-00.0E	10138123	2	E	E20	19,2	20,0	38,0	95,0	0,0	Cylindrical	■
XE20250J2-150-05.0E	10334242	2	J	E20	19,2	25,0	33,1	150,0	5,0	Cylindrical	■
XE25320J2-190-05.0E	10218127	2	J	E25	24,1	32,0	45,1	190,0	5,0	Cylindrical	■
XE25320J2-215-05.0E	10218128	2	J	E25	24,1	32,0	45,1	215,0	5,0	Cylindrical	■
XE10120G3-095-00.0E	10334223	3	G	E10	9,6	12,0	30,0	95,0	0,0	Cylindrical	■
XE10160J3-140-05.0E	10334239	3	J	E10	9,6	16,0	36,6	140,0	5,0	Cylindrical	■
XE12160G3-107-00.0E	10334226	3	G	E12	11,6	16,0	36,0	107,0	0,0	Cylindrical	■
XE16160E3-126-00.0E	10334229	3	E	E16	15,4	16,0	48,0	126,0	0,0	Cylindrical	■
XE20320J3-175-05.0E	10334243	3	J	E20	19,2	32,0	73,2	175,0	5,0	Cylindrical	■
XE10120G4-105-00.0E	10334224	4	G	E10	9,6	12,0	40,0	105,0	0,0	Cylindrical	■
XE12120E4-100-00.0E	10138121	4	E	E12	11,6	12,0	48,0	100,0	0,0	Cylindrical	■
XE12160G4-120-00.0E	10334227	4	G	E12	11,6	16,0	48,0	120,0	0,0	Cylindrical	■
XE16160E4-140-00.0E	10334230	4	E	E16	15,4	16,0	64,0	140,0	0,0	Cylindrical	■
XE20250J4-200-02.0E	10138129	4	J	E20	19,2	25,0	83,0	200,0	2,0	Cylindrical	■
XE25250E4-200-00.0E	10138125	4	E	E25	24,1	25,0	120,0	200,0	0,0	Cylindrical	■
XE10100E5-100-00.0E	10138120	5	E	E10	9,6	10,0	50,0	100,0	0,0	Cylindrical	■
XE10120G5-125-00.0E	10334225	5	G	E10	9,6	12,0	50,0	125,0	0,0	Cylindrical	■
XE10160J5-120-01.0E	10334232	5	J	E10	9,6	16,0	50,0	120,0	1,0	Cylindrical	■
XE16160E5-135-00.0E	10138122	5	E	E16	15,4	16,0	80,0	135,0	0,0	Cylindrical	■
XE12160G5-150-00.0E	10334228	5	G	E12	11,6	16,0	60,0	150,0	0,0	Cylindrical	■
XE16200J5-135-01.0E	10334235	5	J	E16	15,4	20,0	80,0	135,0	1,0	Cylindrical	■
XE20200E5-180-00.0E	10138124	5	E	E20	19,2	20,0	110,0	180,0	0,0	Cylindrical	■
XE12160J7-150-01.0E	10138127	7	J	E12	11,6	16,0	90,0	150,0	1,0	Cylindrical	■
XE16200J7-175-01.0E	10138128	7	J	E16	15,4	20,0	118,0	175,0	1,0	Cylindrical	■
XE10160J8-150-01.0E	10334233	8	J	E10	9,6	16,0	80,0	150,0	1,0	Cylindrical	■
XE10160J9-155-01.0E	10138126	9	J	E10	9,6	16,0	100,0	155,0	1,0	Cylindrical	■

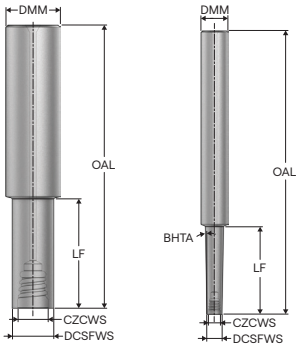
Ersatzteile, im Lieferumfang enthalten Zubehör

Für Fräser	Spannschlüssel	Ersatzklinge	Ersatzklinge 1	Drehmoment-schlüssel
				
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ **Lagerstandard.**

Vollhartmetall - Zoll





G J



—Toleranzen:
—DMM= h6
—DCSFWS= ±.002 Zoll
—BHTA= ±20'

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DCSFMS	DMM	LF	OAL	BHTA°	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll			
XE12.625J2-6.50-05.0E	10334245	2	J	E12	0.480	0.625	0.827	6.500	5,0	Cylindrical	■
XE16.750J2-6.50-05.0E	10334246	2	J	E16	0.606	0.750	0.823	6.500	5,0	Cylindrical	■
XE201.00J2-6.00-05.0E	10334247	2	J	E20	0.724	1.000	1.575	6.000	5,0	Cylindrical	■
XE251.25G2-6.50-00.0E	10138078	2	G	E25	0.961	1.250	2.500	6.500	0,0	Cylindrical	■
XE251.25J2-8.50-05.0E	10218131	2	J	E25	0.961	1.250	1.654	8.500	5,0	Cylindrical	■
XE10.625J4-5.50-05.0E	10334244	4	J	E10	0.360	0.625	1.512	5.500	5,0	Cylindrical	■
XE12.625J4-7.50-01.0E	10138080	4	J	E12	0.480	0.625	2.400	7.500	1,0	Cylindrical	■
XE16.750J4-7.50-01.0E	10138081	4	J	E16	0.606	0.750	3.000	7.500	1,0	Cylindrical	■
XE201.00J4-8.00-01.0E	10138082	4	J	E20	0.724	1.000	3.150	8.000	1,0	Cylindrical	■
XE10.500G5-5.00-00.0E	10334236	5	G	E10	0.360	0.500	2.000	5.000	0,0	Cylindrical	■
XE10.625J5-6.50-01.0E	10138079	5	J	E10	0.360	0.625	2.000	6.500	1,0	Cylindrical	■
XE12.625G5-6.00-00.0E	10334237	5	G	E12	0.480	0.625	2.400	6.000	0,0	Cylindrical	■
XE16.625E5-7.00-00.0E	10334238	5	E	E16	0.606	0.625	3.200	7.000	0,0	Cylindrical	■

Ersatzteile, im Lieferumfang enthalten

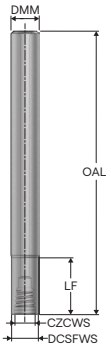
Zubehör

Für Fräser	Spannschlüssel	Ersatzklinge	Ersatzklinge 1	Drehmoment-schlüssel
				
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ **Lagerstandard.**

Densimet - Metrisch





E



—Toleranzen:
—DMM= h6
—DCSFWS= ±0,05 mm
—BHTA= ±20'

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DCSFWS	DMM	LF	OAL	BHTA°	Auf-nahmen	Lagerstand-ard
					mm	mm	mm	mm			
XE10100E2-100-00.0DM	10138115	2	E	E10	9,6	10,0	20,0	100,0	0,0	Cylindrical	■
XE12120E2-110-00.0DM	10138116	2	E	E12	11,6	12,0	25,0	110,0	0,0	Cylindrical	■
XE16160E2-130-00.0DM	10138117	2	E	E16	15,4	16,0	35,0	130,0	0,0	Cylindrical	■
XE20200E2-160-00.0DM	10138118	2	E	E20	19,2	20,0	45,0	160,0	0,0	Cylindrical	■
XE25250E2-185-00.0DM	10138119	2	E	E25	24,1	25,0	65,0	185,0	0,0	Cylindrical	■

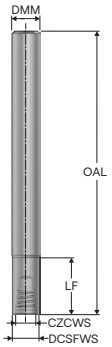
Ersatzteile, im Lieferumfang enthalten Zubehör

Für Fräser	Spannschlüssel	Ersatzklinge	Ersatzklinge 1	Drehmoment-schlüssel
				
E10	XW-E10	XTWH-E10.08	XTWH-E10.06	XTW-E10.E12
E12	XW-E12	XTWH-E12.10	XTWH-E12.08	XTW-E10.E12
E16	XW-E16	XTWH-E16.12	XTWH-E16.10	XTW-E16.E25
E20	XW-E20	XTWH-E20.16	–	XTW-E16.E25
E25	XW-E25	XTWH-E25.20	–	XTW-E16.E25

■ **Lagerstandard.**

Densimet - Zoll





E



—Toleranzen:
—DMM= h6
—DCSFWS= ±.002 Zoll

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DCSFMS	DMM	LF	OAL	BHTA°	Auf-nahmen	Lagerstand-ard
					Zoll	Zoll	Zoll	Zoll			
XE251.00E2-7.28-00.0DM	10218132	2	E	E25	0.961	1.000	2.559	7.283	0,0	Cylindrical	■

Ersatzteile, im Lieferumfang enthalten

Zubehör

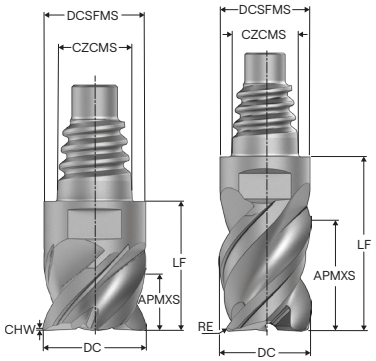
Für Fräser	Spannschlüssel	Ersatzklinge	Drehmoment-schlüssel
			
E25	XW-E25	XTWH-E25.20	XTW-E16.E25

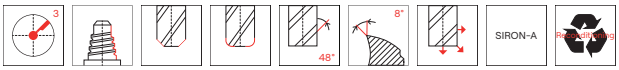
■ **Lagerstandard.**

XSE550

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Eckenradius oder Fase





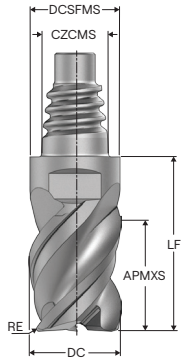


– Toleranzen:
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich, wenn DC ≥ Ø12 ist mm

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCSFMS	APMXS	LF	CHW	RE	PCEDC	SW	Beschichtung
					mm	mm	mm	mm	mm	mm			SIRA
XSE550E10100D1R050Z3	10138138	1	D	E10	10,0	9,7	5,5	12,3	–	0,5	3	8,0	■
XSE550E10100D1R100Z3	10219210	1	D	E10	10,0	9,7	5,5	12,3	–	1,0	3	8,0	■
XSE550E10100D1R200Z3	10219211	1	D	E10	10,0	9,7	5,5	12,3	–	2,0	3	8,0	■
XSE550E10100D2R050Z3	10138142	2	D	E10	10,0	9,7	12,0	18,7	–	0,5	3	8,0	■
XSE550E10100D2R100Z3	10219218	2	D	E10	10,0	9,7	12,0	18,7	–	1,0	3	8,0	■
XSE550E10100D2R200Z3	10219219	2	D	E10	10,0	9,7	12,0	18,7	–	2,0	3	8,0	■
XSE550E12120D1R050Z3	10138139	1	D	E12	12,0	11,7	6,6	14,4	–	0,5	3	10,0	■
XSE550E12120D1R100Z3	10219212	1	D	E12	12,0	11,7	6,6	14,4	–	1,0	3	10,0	■
XSE550E12120D1R200Z3	10219213	1	D	E12	12,0	11,7	6,6	14,4	–	2,0	3	10,0	■
XSE550E12120D2R050Z3	10138143	2	D	E12	12,0	11,7	14,4	22,1	–	0,5	3	10,0	■
XSE550E12120D2R100Z3	10219220	2	D	E12	12,0	11,7	14,4	22,1	–	1,0	3	10,0	■
XSE550E12120D2R200Z3	10219221	2	D	E12	12,0	11,7	14,4	22,1	–	2,0	3	10,0	■
XSE550E16160D1R050Z3	10138140	1	D	E16	16,0	15,5	8,8	18,6	–	0,5	3	12,0	■
XSE550E16160D1R100Z3	10219214	1	D	E16	16,0	15,5	8,8	18,6	–	1,0	3	12,0	■
XSE550E16160D1R200Z3	10219215	1	D	E16	16,0	15,5	8,8	18,6	–	2,0	3	12,0	■
XSE550E16160D2R050Z3	10138144	2	D	E16	16,0	15,5	19,2	29,2	–	0,5	3	12,0	■
XSE550E16160D2R100Z3	10219222	2	D	E16	16,0	15,5	19,2	29,2	–	1,0	3	12,0	■
XSE550E16160D2R200Z3	10219223	2	D	E16	16,0	15,5	19,2	29,2	–	2,0	3	12,0	■
XSE550E20200D1R050Z3	10138141	1	D	E20	20,0	19,3	11,0	21,2	–	0,5	3	16,0	■
XSE550E20200D2R050Z3	10138145	2	D	E20	20,0	19,3	24,0	34,3	–	0,5	3	16,0	■
XSE550E20200D1R100Z3	10219216	1	D	E20	20,0	19,7	11,0	21,2	–	1,0	3	16,0	■
XSE550E20200D1R200Z3	10219217	1	D	E20	20,0	19,7	11,0	21,2	–	2,0	3	16,0	■
XSE550E20200D2R100Z3	10219224	2	D	E20	20,0	19,7	24,0	34,3	–	1,0	3	16,0	■
XSE550E20200D2R200Z3	10219225	2	D	E20	20,0	19,7	24,0	34,3	–	2,0	3	16,0	■
XSE550E25250D1CZ3	10219207	1	D	E25	25,0	24,2	13,75	25,5	0,3125	–	3	20,0	■
XSE550E25250D1R050Z3	10219208	1	D	E25	25,0	24,2	13,75	25,5	–	0,5	3	20,0	■
XSE550E25250D1R100Z3	10219209	1	D	E25	25,0	24,2	13,75	25,5	–	1,0	3	20,0	■

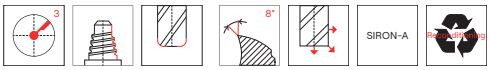
XSE550 – Zoll
Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Eckenradius – Zoll





D

- Toleranzen:
- DC= e7
- RE= ±.0008 Zoll
- Nachschleifen möglich, wenn DC ≥ Ø.500 ist Zoll



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Beschichtung
					Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*			SIRA
XSE550E10.375D1R030Z3	10138146	1	D	E10	0.375	0.364	0.206	0.484	0.030	3	8,0	■
XSE550E10.375D2R030Z3	10138149	2	D	E10	0.375	0.364	0.450	0.720	0.030	3	8,0	■
XSE550E12.500D1R030Z3	10138147	1	D	E12	0.500	0.484	0.275	0.567	0.030	3	10,0	■
XSE550E12.500D2R030Z3	10138150	2	D	E12	0.500	0.484	0.600	0.906	0.030	3	10,0	■
XSE550E20.750D1R030Z3	10138148	1	D	E20	0.750	0.728	0.413	0.835	0.030	3	16,0	■
XSE550E20.750D2R030Z3	10138151	2	D	E20	0.750	0.728	0.900	1.295	0.030	3	16,0	■

Schnittdaten – XSE550 – Eckfräsen PCEDC 3

SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
P1	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	0,19 *0.0075*	185 (140 — 220) *610 (460 — 720)*
P2	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	175 (140 — 210) *570 (460 — 680)*
P3	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	155 (120 — 190) *510 (400 — 620)*
P4	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	135 (110 — 170) *445 (370 — 550)*
P5	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	130 (98 — 160) *425 (330 — 520)*
P6	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	145 (110 — 180) *475 (370 — 590)*
P7	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	140 (110 — 170) *460 (370 — 550)*
P8	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	130 (97 — 160) *425 (320 — 520)*
P11	E/M/A/D	0,30 *0.30*	1,1 *1.1*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	95 (80 — 100) *310 (270 — 320)*
P12	E/M/A/D	0,30 *0.30*	1,1 *1.1*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	60 (51 — 67) *195 (170 — 210)*
M1	E/M/A	0,30 *0.30*	1,1 *1.1*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	105 (92 — 120) *345 (310 — 390)*
M2	E/M/A	0,30 *0.30*	1,1 *1.1*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	90 (76 — 100) *295 (250 — 320)*
M3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	55 (44 — 68) *180 (150 — 220)*
M4	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	43 (34 — 52) *140 (120 — 170)*
M5	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	36 (28 — 43) *120 (92 — 140)*
K1	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	160 (140 — 180) *520 (460 — 590)*
K2	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	140 (130 — 160) *460 (430 — 520)*
K3	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	120 (110 — 130) *395 (370 — 420)*
K4	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	115 (97 — 120) *375 (320 — 390)*
K5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	140 (120 — 150) *460 (400 — 490)*
K6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	200 (170 — 220) *660 (560 — 720)*
K7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	180 (150 — 200) *590 (500 — 650)*
N1	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	600 (560 — 780) *1975 (1900 — 2500)*
N2	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	390 (360 — 500) *1275 (1200 — 1600)*
N3	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	260 (240 — 330) *850 (790 — 1000)*
N11	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	335 (280 — 380) *1100 (920 — 1200)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	32 (26 — 40) *105 (86 — 130)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	28 (21 — 34) *90 (69 — 110)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	24 (19 — 30) *80 (63 — 98)*
S11	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	105 (77 — 130) *345 (260 — 420)*
S12	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	80 (59 — 100) *260 (200 — 320)*
S13	E	0,40 *0.40*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	65 (47 — 83) *215 (160 — 270)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	75 (62 — 92) *245 (210 — 300)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	80 (64 — 95) *260 (210 — 310)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	80 (64 — 95) *260 (210 — 310)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	60 (50 — 74) *195 (170 — 240)*
TS1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	280 (170 — 390) *920 (560 — 1200)*
TP1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	280 (170 — 390) *920 (560 — 1200)*

Schnittdaten – XSE550 – Nutfräsen PCEDC 3

SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
P1	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	165 (130 — 200) *540 (430 — 650)*
P2	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	160 (120 — 190) *520 (400 — 620)*
P3	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	135 (110 — 170) *445 (370 — 550)*
P4	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	120 (90 — 140) *395 (300 — 450)*
P5	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	115 (86 — 140) *375 (290 — 450)*
P6	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	130 (97 — 160) *425 (320 — 520)*
P7	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	120 (92 — 150) *395 (310 — 490)*
P8	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	115 (86 — 140) *375 (290 — 450)*
P11	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	75 (64 — 84) *245 (210 — 270)*
P12	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	45 (39 — 51) *150 (130 — 160)*
M1	E/M/A	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	85 (75 — 99) *280 (250 — 320)*
M2	E/M/A	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	70 (60 — 79) *230 (200 — 250)*
M3	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	45 (35 — 54) *150 (120 — 170)*
M4	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	34 (27 — 41) *110 (89 — 130)*
M5	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	28 (22 — 34) *90 (73 — 110)*
K1	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	140 (120 — 160) *460 (400 — 520)*
K2	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	105 (88 — 110) *345 (290 — 360)*
K4	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	0,15 *0.0060*	100 (84 — 110) *330 (280 — 360)*
K5	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	125 (100 — 130) *410 (330 — 420)*
K6	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	185 (150 — 200) *610 (500 — 650)*
K7	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	160 (130 — 170) *520 (430 — 550)*
N1	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	540 (500 — 690) *1775 (1700 — 2200)*
N2	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	345 (330 — 440) *1125 (1100 — 1400)*
N3	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	230 (220 — 290) *750 (730 — 950)*
N11	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	300 (250 — 340) *980 (830 — 1100)*
S1	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	27 (21 — 33) *90 (69 — 100)*
S2	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	23 (17 — 28) *75 (56 — 91)*
S3	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	20 (15 — 25) *65 (50 — 82)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	90 (66 — 110) *295 (220 — 360)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	70 (50 — 89) *230 (170 — 290)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	55 (39 — 69) *180 (130 — 220)*
H5	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	50 (41 — 60) *165 (140 — 190)*
H8	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	50 (41 — 60) *165 (140 — 190)*
H21	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	50 (41 — 60) *165 (140 — 190)*
H31	M/A	0,30 *0.30*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	39 (32 — 46) *130 (110 — 150)*
TS1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	250 (150 — 340) *820 (500 — 1100)*

Schnittdaten – XSE550 – Eckfräsen PCEDC 3 – Zoll

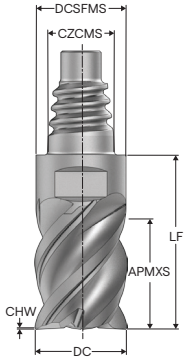
SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	215 (190 — 240) *710 (630 — 780)*
P2	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	205 (180 — 230) *670 (600 — 750)*
P3	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	180 (160 — 200) *590 (530 — 650)*
P4	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	160 (140 — 180) *520 (460 — 590)*
P5	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (140 — 170) *490 (460 — 550)*
P6	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	150 (130 — 170) *490 (430 — 550)*
P11	E/M/A/D	0,30 *0.30*	1,1 *1.1*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	105 (93 — 110) *345 (310 — 360)*
P12	E/M/A/D	0,30 *0.30*	1,1 *1.1*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	65 (60 — 75) *215 (200 — 240)*
M1	E/M/A	0,30 *0.30*	1,1 *1.1*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	120 (110 — 130) *395 (370 — 420)*
M2	E/M/A	0,30 *0.30*	1,1 *1.1*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	100 (88 — 110) *330 (290 — 360)*
M3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	60 (50 — 74) *195 (170 — 240)*
M4	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	48 (39 — 57) *155 (130 — 180)*
M5	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	40 (32 — 47) *130 (110 — 150)*
K1	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	170 (160 — 200) *560 (530 — 650)*
K2	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	150 (150 — 180) *490 (500 — 590)*
K3	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	125 (120 — 150) *410 (400 — 490)*
K4	E/M/A/D	0,40 *0.40*	1,1 *1.1*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	120 (120 — 140) *395 (400 — 450)*
K5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	155 (140 — 170) *510 (460 — 550)*
K6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	225 (200 — 250) *740 (660 — 820)*
K7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	200 (180 — 220) *660 (600 — 720)*
N1	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	670 (560 — 780) *2200 (1900 — 2500)*
N2	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	430 (360 — 500) *1400 (1200 — 1600)*
N3	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	285 (240 — 330) *940 (790 — 1000)*
N11	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	335 (280 — 380) *1100 (920 — 1200)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	43 (26 — 60) *140 (86 — 190)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	35 (21 — 48) *115 (69 — 150)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	30 (19 — 42) *100 (63 — 130)*
S11	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	105 (77 — 130) *345 (260 — 420)*
S12	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (59 — 100) *260 (200 — 320)*
S13	E	0,40 *0.40*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	65 (47 — 83) *215 (160 — 270)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	75 (62 — 92) *245 (210 — 300)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	80 (64 — 95) *260 (210 — 310)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	80 (64 — 95) *260 (210 — 310)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	60 (50 — 74) *195 (170 — 240)*
TS1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	280 (170 — 390) *920 (560 — 1200)*
TP1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	280 (170 — 390) *920 (560 — 1200)*

Schnittdaten – XSE550 – Nutfräsen PCEDC 3 – Zoll

SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	190 (170 — 210) *620 (560 — 680)*
P2	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	185 (160 — 210) *610 (530 — 680)*
P3	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	160 (140 — 180) *520 (460 — 590)*
P4	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	140 (120 — 150) *460 (400 — 490)*
P5	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	135 (120 — 150) *445 (400 — 490)*
P6	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	150 (130 — 170) *490 (430 — 550)*
P7	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	140 (130 — 160) *460 (430 — 520)*
P8	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	135 (120 — 150) *445 (400 — 490)*
P11	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	85 (74 — 94) *280 (250 — 300)*
P12	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	50 (46 — 58) *165 (160 — 190)*
M1	E/M/A	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	100 (87 — 110) *330 (290 — 360)*
M2	E/M/A	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	80 (70 — 89) *260 (230 — 290)*
M3	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	50 (41 — 60) *165 (140 — 190)*
M4	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,075 *0.0030*	37 (30 — 45) *120 (99 — 140)*
M5	E/M/A	0,70 *0.70*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,075 *0.0030*	31 (25 — 37) *100 (83 — 120)*
K1	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	150 (140 — 180) *490 (460 — 590)*
K2	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	130 (130 — 150) *425 (430 — 490)*
K3	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	110 (110 — 130) *360 (370 — 420)*
K4	E/M/A/D	1,0 *1.0*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	0,12 *0.0048*	105 (99 — 120) *345 (330 — 390)*
K5	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	140 (120 — 150) *460 (400 — 490)*
K6	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	205 (180 — 230) *670 (600 — 750)*
K7	E/M/A/D	0,80 *0.80*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	180 (160 — 200) *590 (530 — 650)*
N1	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	600 (510 — 690) *1975 (1700 — 2200)*
N2	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	385 (330 — 440) *1275 (1100 — 1400)*
N3	E/M/A	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	255 (220 — 290) *840 (730 — 950)*
N11	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	300 (250 — 340) *980 (830 — 1100)*
S1	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	36 (22 — 50) *120 (73 — 160)*
S2	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	29 (18 — 40) *95 (60 — 130)*
S3	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	25 (15 — 34) *80 (50 — 110)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	90 (66 — 110) *295 (220 — 360)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	70 (50 — 89) *230 (170 — 290)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	55 (39 — 69) *180 (130 — 220)*
H5	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	50 (41 — 60) *165 (140 — 190)*
H8	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,050 *0.0020*	50 (41 — 60) *165 (140 — 190)*
H21	M/A	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,044 *0.0017*	0,050 *0.0020*	50 (41 — 60) *165 (140 — 190)*
H31	M/A	0,30 *0.30*	0,026 *0.0010*	0,032 *0.0013*	0,038 *0.0015*	0,044 *0.0017*	39 (32 — 46) *130 (110 — 150)*
TS1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,70 *0.70*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*

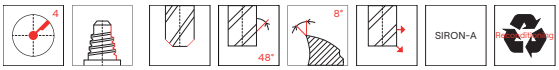
XSE550
Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Fase





D

– Toleranzen:
– DC= e7
– Nachschleifen möglich, wenn DC ≥ Ø12 ist mm

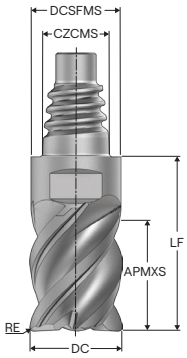


Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCSFMS	APMXS	LF	CHW	PCEDC	SW	Beschichtung
					mm	mm	mm	mm	mm			SIRA
XSE550E10100D1CZ4	10219229	1	D	E10	10,0	9,7	5,5	12,3	0,125	4	8,0	■
XSE550E10100D2CZ4	10138152	2	D	E10	10,0	9,7	12,0	18,7	0,125	4	8,0	■
XSE550E12120D1CZ4	10219230	1	D	E12	12,0	11,7	6,6	14,4	0,15	4	10,0	■
XSE550E12120D2CZ4	10138153	2	D	E12	12,0	11,7	14,4	22,1	0,15	4	10,0	■
XSE550E16160D1CZ4	10219231	1	D	E16	16,0	15,5	8,8	18,6	0,2	4	12,0	■
XSE550E16160D2CZ4	10138154	2	D	E16	16,0	15,5	19,2	29,2	0,2	4	12,0	■
XSE550E20200D2CZ4	10138155	2	D	E20	20,0	19,3	24,0	34,3	0,25	4	16,0	■
XSE550E20200D1CZ4	10219232	1	D	E20	20,0	19,7	11,0	21,2	0,25	4	16,0	■
XSE550E25250D1CZ4	10219226	1	D	E25	25,0	24,2	13,75	25,5	0,3125	4	20,0	■

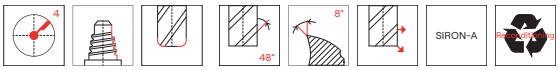
■ **Lagerstandard.**

XSE550
Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Eckenradius





D



– Toleranzen:
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich, wenn DC ≥ Ø12 ist mm

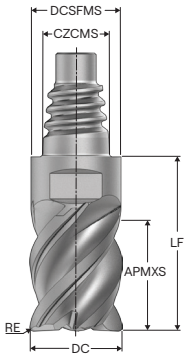
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Beschichtung
					mm	mm	mm	mm	mm			SIRA
XSE550E10100D1R100Z4	10219233	1	D	E10	10,0	9,7	5,5	12,3	1,0	4	8,0	■
XSE550E10100D1R200Z4	10219234	1	D	E10	10,0	9,7	5,5	12,3	2,0	4	8,0	■
XSE550E10100D1R050Z4	10138156	1	D	E10	10,0	9,7	5,5	12,3	0,5	4	8,0	■
XSE550E10100D2R100Z4	10138161	2	D	E10	10,0	9,7	12,0	18,7	1,0	4	8,0	■
XSE550E10100D2R050Z4	10138160	2	D	E10	10,0	9,7	12,0	18,7	0,5	4	8,0	■
XSE550E10100D2R200Z4	10138162	2	D	E10	10,0	9,7	12,0	18,7	2,0	4	8,0	■
XSE550E10100D2R250Z4	10138163	2	D	E10	10,0	9,7	12,0	18,7	2,5	4	8,0	■
XSE550E12120D1R100Z4	10219235	1	D	E12	12,0	11,7	6,6	14,4	1,0	4	10,0	■
XSE550E12120D1R200Z4	10219236	1	D	E12	12,0	11,7	6,6	14,4	2,0	4	10,0	■
XSE550E12120D1R050Z4	10138157	1	D	E12	12,0	11,7	6,6	14,4	0,5	4	10,0	■
XSE550E12120D2R100Z4	10138165	2	D	E12	12,0	11,7	14,4	22,1	1,0	4	10,0	■
XSE550E12120D2R050Z4	10138164	2	D	E12	12,0	11,7	14,4	22,1	0,5	4	10,0	■
XSE550E12120D2R200Z4	10138166	2	D	E12	12,0	11,7	14,4	22,1	2,0	4	10,0	■
XSE550E12120D2R300Z4	10138167	2	D	E12	12,0	11,7	14,4	22,1	3,0	4	10,0	■
XSE550E16160D1R100Z4	10219237	1	D	E16	16,0	15,5	8,8	18,6	1,0	4	12,0	■
XSE550E16160D1R200Z4	10219238	1	D	E16	16,0	15,5	8,8	18,6	2,0	4	12,0	■
XSE550E16160D1R050Z4	10138158	1	D	E16	16,0	15,5	8,8	18,6	0,5	4	12,0	■
XSE550E16160D2R100Z4	10138169	2	D	E16	16,0	15,5	19,2	29,2	1,0	4	12,0	■
XSE550E16160D2R050Z4	10138168	2	D	E16	16,0	15,5	19,2	29,2	0,5	4	12,0	■
XSE550E16160D2R200Z4	10138170	2	D	E16	16,0	15,5	19,2	29,2	2,0	4	12,0	■
XSE550E16160D2R300Z4	10138171	2	D	E16	16,0	15,5	19,2	29,2	3,0	4	12,0	■
XSE550E20200D1R100Z4	10138159	1	D	E20	20,0	19,3	11,0	21,2	1,0	4	16,0	■
XSE550E20200D2R100Z4	10138172	2	D	E20	20,0	19,3	24,0	34,3	1,0	4	16,0	■
XSE550E20200D2R200Z4	10138173	2	D	E20	20,0	19,3	24,0	34,3	2,0	4	16,0	■
XSE550E20200D2R300Z4	10138174	2	D	E20	20,0	19,3	24,0	34,3	3,0	4	16,0	■
XSE550E20200D2R400Z4	10138175	2	D	E20	20,0	19,3	24,0	34,3	4,0	4	16,0	■
XSE550E20200D1R200Z4	10219239	1	D	E20	20,0	19,7	11,0	21,2	2,0	4	16,0	■
XSE550E25250D1R100Z4	10219227	1	D	E25	25,0	24,2	13,75	25,5	1,0	4	20,0	■
XSE550E25250D1R200Z4	10219228	1	D	E25	25,0	24,2	13,75	25,5	2,0	4	20,0	■

■ **Lagerstandard.**

XSE550 – Zoll

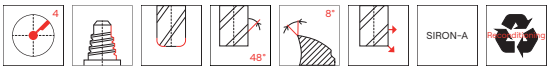
Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Eckenradius – Zoll





D

—Toleranzen:
—DC= e7
—RE= ±.0008 Zoll
—Nachschleifen möglich, wenn DC ≥ Ø.500 ist Zoll



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Beschichtung
					Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*			SIRA
XSE550E10.375D1R030Z4	10138176	1	D	E10	0.375	0.364	0.206	0.484	0.030	4	8,0	■
XSE550E10.375D2R030Z4	10138179	2	D	E10	0.375	0.364	0.450	0.720	0.030	4	8,0	■
XSE550E12.500D1R030Z4	10138177	1	D	E12	0.500	0.484	0.275	0.567	0.030	4	10,0	■
XSE550E12.500D2R030Z4	10138180	2	D	E12	0.500	0.484	0.600	0.906	0.030	4	10,0	■
XSE550E20.750D1R030Z4	10138178	1	D	E20	0.750	0.728	0.413	0.835	0.030	4	16,0	■
XSE550E20.750D2R030Z4	10138181	2	D	E20	0.750	0.728	0.900	1.295	0.030	4	16,0	■

■ **Lagerstandard.**

Schnittdaten – XSE550 – Eckfräsen PCEDC 4

SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
P1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	170 (130 — 210) *560 (430 — 680)*
P2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	165 (130 — 200) *540 (430 — 650)*
P3	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	145 (110 — 180) *475 (370 — 590)*
P4	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	130 (97 — 160) *425 (320 — 520)*
P5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	125 (93 — 150) *410 (310 — 490)*
P6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 170) *460 (370 — 550)*
P7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*	130 (98 — 160) *425 (330 — 520)*
P8	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	120 (91 — 150) *395 (300 — 490)*
P11	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	85 (72 — 100) *280 (240 — 320)*
P12	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	55 (46 — 68) *180 (160 — 220)*
M1	E/M/A	0,30 *0.30*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	95 (83 — 120) *310 (280 — 390)*
M2	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,13 *0.0050*	80 (69 — 100) *260 (230 — 320)*
M3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	47 (36 — 58) *155 (120 — 190)*
M4	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	36 (28 — 45) *120 (92 — 140)*
M5	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	30 (23 — 37) *100 (76 — 120)*
K1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	150 (130 — 170) *490 (430 — 550)*
K2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	130 (120 — 150) *425 (400 — 490)*
K3	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	110 (96 — 120) *360 (320 — 390)*
K4	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	105 (92 — 120) *345 (310 — 390)*
K5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	150 (130 — 170) *490 (430 — 550)*
K6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	215 (190 — 240) *710 (630 — 780)*
K7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	190 (170 — 210) *620 (560 — 680)*
N1	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	550 (450 — 660) *1800 (1500 — 2100)*
N2	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	355 (290 — 420) *1175 (960 — 1300)*
N3	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	240 (200 — 280) *790 (660 — 910)*
N11	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	310 (280 — 380) *1025 (920 — 1200)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	32 (26 — 40) *105 (86 — 130)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	28 (21 — 34) *90 (69 — 110)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	24 (19 — 30) *80 (63 — 98)*
S11	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	90 (77 — 120) *295 (260 — 390)*
S12	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	70 (59 — 93) *230 (200 — 300)*
S13	E	0,40 *0.40*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	55 (47 — 74) *180 (160 — 240)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	75 (59 — 73) *245 (200 — 230)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	75 (62 — 76) *245 (210 — 240)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	75 (62 — 76) *245 (210 — 240)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	60 (48 — 59) *195 (160 — 190)*
TS1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	275 (170 — 380) *900 (560 — 1200)*
TP1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	275 (170 — 380) *900 (560 — 1200)*

Schnittdaten – XSE550 – Nutfräsen PCEDC 4

SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
P1	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	165 (130 — 200) *540 (430 — 650)*
P2	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	160 (120 — 190) *520 (400 — 620)*
P3	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	135 (110 — 170) *445 (370 — 550)*
P4	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	120 (90 — 140) *395 (300 — 450)*
P5	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	115 (86 — 140) *375 (290 — 450)*
P6	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	130 (97 — 160) *425 (320 — 520)*
P7	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	120 (92 — 150) *395 (310 — 490)*
P8	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	115 (86 — 140) *375 (290 — 450)*
P11	E/M/A/D	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	75 (64 — 94) *245 (210 — 300)*
P12	E/M/A/D	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	44 (38 — 55) *145 (130 — 180)*
M1	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	85 (75 — 110) *280 (250 — 360)*
M2	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	70 (60 — 90) *230 (200 — 290)*
M3	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	40 (30 — 50) *130 (99 — 160)*
M4	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	30 (23 — 37) *100 (76 — 120)*
M5	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	25 (19 — 31) *80 (63 — 100)*
K1	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	140 (120 — 160) *460 (400 — 520)*
K2	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	105 (88 — 110) *345 (290 — 360)*
K4	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	100 (84 — 110) *330 (280 — 360)*
K5	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	140 (120 — 160) *460 (400 — 520)*
K6	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	205 (180 — 230) *670 (600 — 750)*
K7	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	0,10 *0.0040*	180 (160 — 200) *590 (530 — 650)*
N1	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	500 (410 — 590) *1650 (1400 — 1900)*
N2	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	320 (260 — 380) *1050 (860 — 1200)*
N3	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	215 (180 — 250) *710 (600 — 820)*
N11	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	280 (250 — 340) *920 (830 — 1100)*
S1	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	27 (21 — 33) *90 (69 — 100)*
S2	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	23 (17 — 28) *75 (56 — 91)*
S3	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	0,075 *0.0030*	20 (15 — 24) *65 (50 — 78)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	80 (65 — 100) *260 (220 — 320)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	60 (50 — 79) *195 (170 — 250)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	46 (39 — 61) *150 (130 — 200)*
H5	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,065 *0.0026*	50 (41 — 50) *165 (140 — 160)*
H8	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (41 — 50) *165 (140 — 160)*
H21	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (41 — 50) *165 (140 — 160)*
H31	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,038 *0.0015*	0,044 *0.0017*	0,050 *0.0020*	38 (31 — 38) *125 (110 — 120)*
TS1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	0,13 *0.0050*	250 (150 — 340) *820 (500 — 1100)*

Schnittdaten – XSE550 – Eckfräsen PCEDC 4 – Zoll

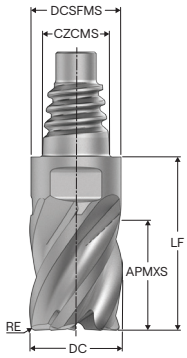
SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	195 (170 — 220) *640 (560 — 720)*
P3	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
P5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	145 (130 — 160) *475 (430 — 520)*
P6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	160 (140 — 180) *520 (460 — 590)*
P7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	150 (140 — 170) *490 (460 — 550)*
P8	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	140 (130 — 160) *460 (430 — 520)*
P11	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	95 (84 — 100) *310 (280 — 320)*
P12	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,044 *0.0017*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	60 (54 — 68) *195 (180 — 220)*
M1	E/M/A	0,30 *0.30*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	110 (97 — 120) *360 (320 — 390)*
M2	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	90 (80 — 100) *295 (270 — 320)*
M3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	60 (47 — 70) *195 (160 — 220)*
M4	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (37 — 54) *150 (130 — 170)*
M5	E/M/A	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	38 (31 — 45) *125 (110 — 140)*
K1	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	160 (160 — 190) *520 (530 — 620)*
K2	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	140 (140 — 170) *460 (460 — 550)*
K3	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	120 (120 — 140) *395 (400 — 450)*
K4	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	115 (110 — 130) *375 (370 — 420)*
K5	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
K6	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	215 (190 — 240) *710 (630 — 780)*
K7	E/M/A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	190 (170 — 210) *620 (560 — 680)*
N1	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	670 (560 — 770) *2200 (1900 — 2500)*
N2	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	430 (360 — 490) *1400 (1200 — 1600)*
N3	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	285 (240 — 330) *940 (790 — 1000)*
N11	E/M/A	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	335 (280 — 380) *1100 (920 — 1200)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	43 (26 — 60) *140 (86 — 190)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	35 (21 — 48) *115 (69 — 150)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	30 (19 — 42) *100 (63 — 130)*
S11	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	105 (77 — 130) *345 (260 — 420)*
S12	E	0,40 *0.40*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (59 — 100) *260 (200 — 320)*
S13	E	0,40 *0.40*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	65 (47 — 83) *215 (160 — 270)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	75 (59 — 73) *245 (200 — 230)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	75 (62 — 76) *245 (210 — 240)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	75 (62 — 76) *245 (210 — 240)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	60 (48 — 59) *195 (160 — 190)*
TS1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	275 (170 — 380) *900 (560 — 1200)*
TP1	A/D	0,40 *0.40*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	275 (170 — 380) *900 (560 — 1200)*

Schnittdaten – XSE550 – Nutfräsen PCEDC 4 – Zoll

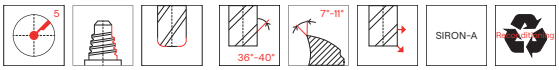
SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	190 (170 — 210) *620 (560 — 680)*
P2	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	185 (160 — 210) *610 (530 — 680)*
P3	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	160 (140 — 180) *520 (460 — 590)*
P4	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	140 (120 — 150) *460 (400 — 490)*
P5	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	135 (120 — 150) *445 (400 — 490)*
P6	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	150 (130 — 170) *490 (430 — 550)*
P7	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	140 (130 — 160) *460 (430 — 520)*
P8	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	135 (120 — 150) *445 (400 — 490)*
P11	E/M/A/D	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	85 (74 — 94) *280 (250 — 300)*
P12	E/M/A/D	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	50 (44 — 55) *165 (150 — 180)*
M1	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	100 (87 — 110) *330 (290 — 360)*
M2	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	80 (70 — 90) *260 (230 — 290)*
M3	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	50 (40 — 60) *165 (140 — 190)*
M4	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	37 (30 — 45) *120 (99 — 140)*
M5	E/M/A	0,60 *0.60*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	31 (25 — 37) *100 (83 — 120)*
K1	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	150 (150 — 180) *490 (500 — 590)*
K2	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	130 (130 — 150) *425 (430 — 490)*
K3	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	110 (110 — 130) *360 (370 — 420)*
K4	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	105 (99 — 120) *345 (330 — 390)*
K5	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	140 (120 — 160) *460 (400 — 520)*
K6	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	205 (180 — 230) *670 (600 — 750)*
K7	E/M/A/D	0,80 *0.80*	0,040 *0.0016*	0,048 *0.0019*	0,065 *0.0026*	0,080 *0.0032*	180 (160 — 200) *590 (530 — 650)*
N1	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	600 (510 — 700) *1975 (1700 — 2200)*
N2	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	385 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	255 (220 — 300) *840 (730 — 980)*
N11	E/M/A	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	300 (250 — 350) *980 (830 — 1100)*
S1	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	36 (22 — 50) *120 (73 — 160)*
S2	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	29 (18 — 40) *95 (60 — 130)*
S3	E	0,30 *0.30*	0,030 *0.0012*	0,036 *0.0014*	0,048 *0.0019*	0,060 *0.0024*	25 (15 — 34) *80 (50 — 110)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	90 (65 — 110) *295 (220 — 360)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	70 (50 — 90) *230 (170 — 290)*
S13	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	55 (39 — 69) *180 (130 — 220)*
H5	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	50 (41 — 50) *165 (140 — 160)*
H8	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	50 (41 — 50) *165 (140 — 160)*
H21	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,040 *0.0016*	0,050 *0.0020*	50 (41 — 50) *165 (140 — 160)*
H31	M/A	0,26 *0.26*	0,025 *0.0010*	0,030 *0.0012*	0,038 *0.0015*	0,044 *0.0017*	38 (31 — 38) *125 (110 — 120)*
TS1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,60 *0.60*	0,050 *0.0020*	0,060 *0.0024*	0,080 *0.0032*	0,10 *0.0040*	250 (150 — 340) *820 (500 — 1100)*

XSE550
Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Eckenradius





D



– Toleranzen:
– DC= 0/-0,0508 mm
– RE= ±0,0254 mm
– Nachschleifen möglich, wenn DC ≥ Ø12 ist mm

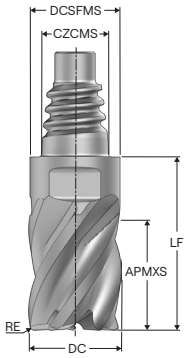
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Beschichtung
					mm	mm	mm	mm	mm			SIRA
XSE550E10100D2R050Z5	10138337	2	D	E10	10,0	9,7	12,0	18,7	0,5	5	8,0	■
XSE550E10100D2R100Z5	10138338	2	D	E10	10,0	9,7	12,0	18,7	1,0	5	8,0	■
XSE550E12120D2R050Z5	10138339	2	D	E12	12,0	11,7	14,4	22,1	0,5	5	10,0	■
XSE550E12120D2R100Z5	10138340	2	D	E12	12,0	11,7	14,4	22,1	1,0	5	10,0	■
XSE550E16160D2R050Z5	10138341	2	D	E16	16,0	15,5	19,2	29,2	0,5	5	12,0	■
XSE550E16160D2R100Z5	10138342	2	D	E16	16,0	15,5	19,2	29,2	1,0	5	12,0	■
XSE550E20200D2R050Z5	10138343	2	D	E20	20,0	19,3	24,0	34,3	0,5	5	16,0	■
XSE550E20200D2R100Z5	10138344	2	D	E20	20,0	19,3	24,0	34,3	1,0	5	16,0	■

■ **Lagerstandard.**

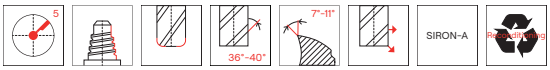
XSE550

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Eckenradius – Zoll





D



– Toleranzen:
– DC= 0/-.002 Zoll
– RE= ±.001 Zoll
– Nachschleifen möglich, wenn DC ≥ Ø.500 ist Zoll

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Beschichtung
					Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*			SIRA
XSE550E10.375D2R015Z5	10138345	2	D	E10	0.375	0.364	0.450	0.720	0.015	5	8,0	■
XSE550E10.375D2R030Z5	10138346	2	D	E10	0.375	0.364	0.450	0.720	0.030	5	8,0	■
XSE550E10.375D2R045Z5	10138347	2	D	E10	0.375	0.364	0.450	0.720	0.044	5	8,0	■
XSE550E12.500D2R030Z5	10138348	2	D	E12	0.500	0.484	0.600	0.906	0.030	5	10,0	■
XSE550E12.500D2R060Z5	10138349	2	D	E12	0.500	0.484	0.600	0.906	0.060	5	10,0	■
XSE550E12.500D2R120Z5	10138350	2	D	E12	0.500	0.484	0.600	0.906	0.120	5	10,0	■
XSE550E16.625D2R030Z5	10138351	2	D	E16	0.625	0.610	0.750	1.150	0.030	5	12,0	■
XSE550E16.625D2R060Z5	10138352	2	D	E16	0.625	0.610	0.750	1.150	0.060	5	12,0	■
XSE550E16.625D2R120Z5	10138353	2	D	E16	0.625	0.610	0.750	1.150	0.120	5	12,0	■
XSE550E20.750D2R030Z5	10138354	2	D	E20	0.750	0.728	0.900	1.295	0.030	5	16,0	■
XSE550E20.750D2R060Z5	10138355	2	D	E20	0.750	0.728	0.900	1.295	0.060	5	16,0	■
XSE550E20.750D2R120Z5	10138356	2	D	E20	0.750	0.728	0.900	1.295	0.120	5	16,0	■
XSE550E251.00D2R030Z5	10138357	2	D	E25	1.000	0.965	1.200	1.673	0.030	5	20,0	■
XSE550E251.00D2R060Z5	10138358	2	D	E25	1.000	0.965	1.200	1.673	0.060	5	20,0	■
XSE550E251.00D2R120Z5	10138359	2	D	E25	1.000	0.965	1.200	1.673	0.120	5	20,0	■

■ **Lagerstandard.**

Schnittdaten – XSE550 – Eckfräsen PCEDC 5

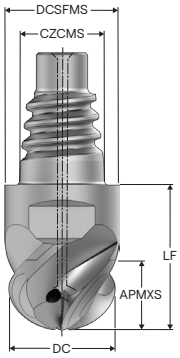
SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
P1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	165 (130 — 190) *540 (430 — 620)*
P2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	160 (130 — 190) *520 (430 — 620)*
P3	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 160) *460 (370 — 520)*
P4	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	125 (97 — 140) *410 (320 — 450)*
P5	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	110 (97 — 130) *360 (320 — 420)*
P6	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	125 (110 — 150) *410 (370 — 490)*
P7	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	120 (110 — 140) *395 (370 — 450)*
P8	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	110 (97 — 130) *360 (320 — 420)*
P11	E/M/A/D	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	100 (89 — 110) *330 (300 — 360)*
P12	E/M/A/D	0,20 *0.20*	0,95 *0.95*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	65 (56 — 71) *215 (190 — 230)*
M1	E/M/A	0,20 *0.20*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	115 (110 — 120) *375 (370 — 390)*
M2	E/M/A	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	95 (84 — 100) *310 (280 — 320)*
M3	E/M/A	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	60 (47 — 69) *195 (160 — 220)*
M4	E/M/A	0,20 *0.20*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	44 (36 — 53) *145 (120 — 170)*
M5	E/M/A	0,20 *0.20*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	37 (30 — 44) *120 (99 — 140)*
K1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	130 (120 — 150) *425 (400 — 490)*
K2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	115 (98 — 130) *375 (330 — 420)*
K3	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	100 (83 — 110) *330 (280 — 360)*
K4	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	95 (79 — 100) *310 (260 — 320)*
K5	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	105 (89 — 130) *345 (300 — 420)*
K6	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	155 (130 — 190) *510 (430 — 620)*
K7	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	135 (120 — 160) *445 (400 — 520)*
N1	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	690 (580 — 800) *2275 (2000 — 2600)*
N2	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	445 (380 — 520) *1450 (1300 — 1700)*
N3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	300 (250 — 340) *980 (830 — 1100)*
N11	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	345 (290 — 400) *1125 (960 — 1300)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	27 (24 — 41) *90 (79 — 130)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	26 (21 — 35) *85 (69 — 110)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	25 (19 — 30) *80 (63 — 98)*
S11	E	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	65 (52 — 88) *215 (180 — 280)*
S12	E	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	50 (40 — 68) *165 (140 — 220)*
S13	E	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	41 (32 — 54) *135 (110 — 170)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	70 (56 — 83) *230 (190 — 270)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	70 (58 — 86) *230 (200 — 280)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	70 (58 — 86) *230 (200 — 280)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	55 (45 — 67) *180 (150 — 210)*
TS1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	290 (180 — 400) *950 (600 — 1300)*
TP1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	290 (180 — 400) *950 (600 — 1300)*

Schnittdaten – XSE550 – Eckfräsen PCEDC 5 – Zoll

SMG		a_e/DC	a_p/DC	f_z					v_c
				3/8	1/2	5/8	3/4	1	
P1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,16 *0.0065*	195 (170 — 220) *640 (560 — 720)*
P3	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
P5	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	145 (130 — 160) *475 (430 — 520)*
P6	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	160 (140 — 180) *520 (460 — 590)*
P7	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	150 (130 — 170) *490 (430 — 550)*
P8	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	145 (130 — 160) *475 (430 — 520)*
P11	E/M/A/D	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	100 (89 — 110) *330 (300 — 360)*
P12	E/M/A/D	0,20 *0.20*	0,95 *0.95*	0,042 *0.0017*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,080 *0.0032*	65 (56 — 71) *215 (190 — 230)*
M1	E/M/A	0,20 *0.20*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	115 (110 — 120) *375 (370 — 390)*
M2	E/M/A	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	95 (84 — 100) *310 (280 — 320)*
M3	E/M/A	0,20 *0.20*	0,95 *0.95*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	60 (47 — 69) *195 (160 — 220)*
M4	E/M/A	0,20 *0.20*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	44 (36 — 53) *145 (120 — 170)*
M5	E/M/A	0,20 *0.20*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	37 (30 — 44) *120 (99 — 140)*
K1	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	165 (160 — 190) *540 (530 — 620)*
K2	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	145 (140 — 170) *475 (460 — 550)*
K3	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	125 (120 — 140) *410 (400 — 450)*
K4	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	120 (110 — 140) *395 (370 — 450)*
K5	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	155 (140 — 170) *510 (460 — 550)*
K6	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	225 (200 — 250) *740 (660 — 820)*
K7	E/M/A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	200 (170 — 220) *660 (560 — 720)*
N1	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	690 (580 — 800) *2275 (2000 — 2600)*
N2	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	445 (380 — 520) *1450 (1300 — 1700)*
N3	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	300 (250 — 340) *980 (830 — 1100)*
N11	E/M/A	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	345 (290 — 400) *1125 (960 — 1300)*
S1	E	0,15 *0.15*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	44 (27 — 61) *145 (89 — 200)*
S2	E	0,15 *0.15*	0,95 *0.95*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	35 (22 — 49) *115 (73 — 160)*
S3	E	0,15 *0.15*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	31 (19 — 43) *100 (63 — 140)*
S11	E	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	105 (75 — 130) *345 (250 — 420)*
S12	E	0,30 *0.30*	0,95 *0.95*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	80 (58 — 100) *260 (200 — 320)*
S13	E	0,30 *0.30*	0,95 *0.95*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	65 (46 — 81) *215 (160 — 260)*
H5	M/A	0,050 *0.050*	0,95 *0.95*	0,090 *0.0036*	0,10 *0.0040*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	70 (56 — 83) *230 (190 — 270)*
H8	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	70 (58 — 86) *230 (200 — 280)*
H21	M/A	0,050 *0.050*	0,95 *0.95*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,11 *0.0044*	0,13 *0.0050*	70 (58 — 86) *230 (200 — 280)*
H31	M/A	0,050 *0.050*	0,95 *0.95*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	55 (45 — 67) *180 (150 — 210)*
TS1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	290 (180 — 400) *950 (600 — 1300)*
TP1	A/D	0,30 *0.30*	0,95 *0.95*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	290 (180 — 400) *950 (600 — 1300)*

XSB540
Hochleistungsfräser – Universell – Kugelkopf – 4 Schneiden





D

- Toleranzen:
- DC= e8
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø12 ist mm



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Beschichtung
						mm	mm	mm	mm	mm			SIRA
XSB540E10100D1BZ4A	10138334	1	D	■	E10	10,0	9,7	5,5	12,3	5,0	4	8,0	■
XSB540E12120D1BZ4A	10138335	1	D	■	E12	12,0	11,7	6,6	14,4	6,0	4	10,0	■
XSB540E16160D1BZ4A	10138336	1	D	■	E16	16,0	15,5	8,8	18,6	8,0	4	12,0	■

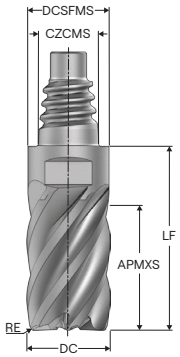
■ **Lagerstandard.**

Schnittdaten – XSB540 Kopierfräsen/Schruppen

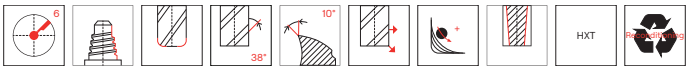
SMG		a_e/DC	a_p/DC	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	210 (190 — 240) *690 (630 — 780)*
P2	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	205 (180 — 230) *670 (600 — 750)*
P3	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	180 (160 — 200) *590 (530 — 650)*
P4	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	155 (140 — 170) *510 (460 — 550)*
P5	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	150 (130 — 170) *490 (430 — 550)*
P6	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	150 (130 — 170) *490 (430 — 550)*
P11	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	190 (160 — 220) *620 (530 — 720)*
P12	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	115 (97 — 130) *375 (320 — 420)*
M1	E/M/A	0,10 *0.10*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	145 (120 — 170) *475 (400 — 550)*
M2	E/M/A	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	115 (97 — 130) *375 (320 — 420)*
M3	E/M/A	0,10 *0.10*	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	95 (75 — 110) *310 (250 — 360)*
M4	E/M/A	0,10 *0.10*	0,50 *0.50*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	75 (57 — 88) *245 (190 — 280)*
M5	E/M/A	0,10 *0.10*	0,50 *0.50*	0,036 *0.0014*	0,042 *0.0017*	0,050 *0.0020*	60 (48 — 74) *195 (160 — 240)*
K1	E/M/A/D	0,15 *0.15*	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	205 (190 — 220) *670 (630 — 720)*
K2	E/M/A/D	0,15 *0.15*	0,50 *0.50*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	180 (160 — 190) *590 (530 — 620)*
K3	E/M/A/D	0,15 *0.15*	0,50 *0.50*	0,036 *0.0014*	0,044 *0.0017*	0,055 *0.0022*	150 (140 — 160) *490 (460 — 520)*
K4	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	170 (150 — 190) *560 (500 — 620)*
K5	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,036 *0.0014*	0,042 *0.0017*	0,055 *0.0022*	105 (90 — 110) *345 (300 — 360)*
K6	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	150 (140 — 160) *490 (460 — 520)*
K7	E/M/A/D	0,10 *0.10*	0,50 *0.50*	0,036 *0.0014*	0,042 *0.0017*	0,055 *0.0022*	130 (120 — 140) *425 (400 — 450)*
N1	E/M/A	0,20 *0.20*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	640 (540 — 740) *2100 (1800 — 2400)*
N2	E/M/A	0,20 *0.20*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	415 (350 — 480) *1350 (1200 — 1500)*
N3	E/M/A	0,20 *0.20*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	275 (230 — 320) *900 (760 — 1000)*
N11	E/M/A	0,15 *0.15*	0,50 *0.50*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	430 (380 — 480) *1400 (1300 — 1500)*
S1	E	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	65 (54 — 74) *215 (180 — 240)*
S2	E	0,10 *0.10*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	65 (59 — 75) *215 (200 — 240)*
S3	E	0,10 *0.10*	0,50 *0.50*	0,020 *0.00080*	0,024 *0.00095*	0,030 *0.0012*	32 (22 — 42) *105 (73 — 130)*
S11	E	0,15 *0.15*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	110 (98 — 120) *360 (330 — 390)*
S12	E	0,15 *0.15*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	85 (75 — 96) *280 (250 — 310)*
S13	E	0,15 *0.15*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	65 (59 — 75) *215 (200 — 240)*
H5	M/A	0,030 *0.030*	0,44 *0.44*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	135 (120 — 150) *445 (400 — 490)*
H8	M/A	0,030 *0.030*	0,44 *0.44*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	135 (120 — 150) *445 (400 — 490)*
H21	M/A	0,030 *0.030*	0,44 *0.44*	0,038 *0.0015*	0,046 *0.0018*	0,055 *0.0022*	135 (120 — 150) *445 (400 — 490)*
H31	M/A	0,030 *0.030*	0,44 *0.44*	0,034 *0.0013*	0,040 *0.0016*	0,048 *0.0019*	100 (86 — 110) *330 (290 — 360)*
TS1	A/D	0,15 *0.15*	0,50 *0.50*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	270 (170 — 370) *890 (560 — 1200)*
TP1	A/D	0,15 *0.15*	0,50 *0.50*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	270 (170 — 370) *890 (560 — 1200)*

XSE720
Hochleistungsfräser – Superlegierung – Eckfräser – 6 Schneiden – Eckenradius





D



– Toleranzen:
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich, wenn DC ≥ Ø12 ist mm

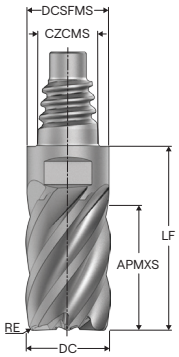
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Beschichtung
					mm	mm	mm	mm	mm			HXT
XSE720E10100D3R050Z6	10138187	3	D	E10	10,0	9,7	15,0	21,8	0,5	6	8,0	■
XSE720E10100D3R100Z6	10138188	3	D	E10	10,0	9,7	15,0	21,8	1,0	6	8,0	■
XSE720E12120D3R050Z6	10138189	3	D	E12	12,0	11,7	18,0	25,9	0,5	6	10,0	■
XSE720E12120D3R100Z6	10138190	3	D	E12	12,0	11,7	18,0	25,9	1,0	6	10,0	■
XSE720E12120D3R200Z6	10138191	3	D	E12	12,0	11,7	18,0	25,9	2,0	6	10,0	■
XSE720E12120D3R300Z6	10138192	3	D	E12	12,0	11,7	18,0	25,9	3,0	6	10,0	■
XSE720E16160D3R050Z6	10138193	3	D	E16	16,0	15,5	24,0	34,1	0,5	6	12,0	■
XSE720E16160D3R100Z6	10138194	3	D	E16	16,0	15,5	24,0	34,1	1,0	6	12,0	■
XSE720E16160D3R200Z6	10138195	3	D	E16	16,0	15,5	24,0	34,1	2,0	6	12,0	■
XSE720E16160D3R300Z6	10138196	3	D	E16	16,0	15,5	24,0	34,1	3,0	6	12,0	■
XSE720E20200D3R050Z6	10138197	3	D	E20	20,0	19,3	30,0	40,2	0,5	6	16,0	■
XSE720E20200D3R100Z6	10138198	3	D	E20	20,0	19,3	30,0	40,2	1,0	6	16,0	■
XSE720E20200D3R200Z6	10138199	3	D	E20	20,0	19,3	30,0	40,2	2,0	6	16,0	■
XSE720E20200D3R300Z6	10138200	3	D	E20	20,0	19,3	30,0	40,2	3,0	6	16,0	■
XSE720E25250D3R200Z6	10138201	3	D	E25	25,0	24,2	37,5	49,5	2,0	6	20,0	■
XSE720E25250D3R300Z6	10138202	3	D	E25	25,0	24,2	37,5	49,5	3,0	6	20,0	■
XSE720E25250D3R400Z6	10138203	3	D	E25	25,0	24,2	37,5	49,5	4,0	6	20,0	■

■ **Lagerstandard.**

XSE720

Hochleistungsfräser – Superlegierung – Eckfräser – 6 Schneiden – Eckenradius oder scharf – Zoll





D



– Toleranzen:
– DC= e7
– RE= ±.0008 Zoll
– Nachschleifen möglich, wenn DC ≥ Ø.500 ist Zoll

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Beschichtung
					Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*			HXT
XSE720E10.375D3SZ6	10138204	3	D	E10	0.375	0.364	0.563	0.827	–	6	8,0	■
XSE720E10.375D3R030Z6	10138209	3	D	E10	0.375	0.364	0.563	0.827	0.030	6	8,0	■
XSE720E12.500D3SZ6	10138205	3	D	E12	0.500	0.484	0.750	1.055	–	6	10,0	■
XSE720E12.500D3R030Z6	10138210	3	D	E12	0.500	0.484	0.750	1.055	0.030	6	10,0	■
XSE720E12.500D3R060Z6	10138211	3	D	E12	0.500	0.484	0.750	1.055	0.060	6	10,0	■
XSE720E12.500D3R120Z6	10138212	3	D	E12	0.500	0.484	0.750	1.055	0.120	6	10,0	■
XSE720E16.625D3SZ6	10138206	3	D	E16	0.625	0.610	0.938	1.343	–	6	12,0	■
XSE720E16.625D3R030Z6	10138213	3	D	E16	0.625	0.610	0.938	1.343	0.030	6	12,0	■
XSE720E16.625D3R060Z6	10138214	3	D	E16	0.625	0.610	0.938	1.343	0.060	6	12,0	■
XSE720E16.625D3R120Z6	10138215	3	D	E16	0.625	0.610	0.938	1.343	0.120	6	12,0	■
XSE720E20.750D3SZ6	10138207	3	D	E20	0.750	0.728	1.125	1.524	–	6	16,0	■
XSE720E20.750D3R030Z6	10138216	3	D	E20	0.750	0.728	1.125	1.524	0.030	6	16,0	■
XSE720E20.750D3R060Z6	10138217	3	D	E20	0.750	0.728	1.125	1.524	0.060	6	16,0	■
XSE720E20.750D3R120Z6	10138218	3	D	E20	0.750	0.728	1.125	1.524	0.120	6	16,0	■
XSE720E251.00D3SZ6	10138208	3	D	E25	1.000	0.965	1.500	1.980	–	6	20,0	■
XSE720E251.00D3R030Z6	10138219	3	D	E25	1.000	0.965	1.500	1.980	0.030	6	20,0	■
XSE720E251.00D3R060Z6	10138220	3	D	E25	1.000	0.965	1.500	1.980	0.060	6	20,0	■
XSE720E251.00D3R120Z6	10138221	3	D	E25	1.000	0.965	1.500	1.980	0.120	6	20,0	■

■ **Lagerstandard.**

Schnittdaten – XSE720 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z					v_c
				10	12	16	20	25	
P1	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*	230 (180 — 280) *750 (600 — 910)*
P2	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	220 (170 — 270) *720 (560 — 880)*
P3	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	195 (150 — 230) *640 (500 — 750)*
P4	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	170 (130 — 200) *560 (430 — 650)*
P5	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	130 (100 — 160) *425 (330 — 520)*
P6	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	145 (120 — 190) *475 (400 — 620)*
P7	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	140 (110 — 180) *460 (370 — 590)*
P8	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	130 (100 — 160) *425 (330 — 520)*
P11	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	130 (110 — 170) *425 (370 — 550)*
P12	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	95 (80 — 100) *310 (270 — 320)*
M1	E/M/A	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
M2	E/M/A	0,12 *0.12*	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	140 (120 — 150) *460 (400 — 490)*
M3	E/M/A	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	120 (100 — 130) *395 (330 — 420)*
M4	E/M/A	0,10 *0.10*	1,4 *1.4*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	90 (77 — 100) *295 (260 — 320)*
M5	E/M/A	0,10 *0.10*	1,4 *1.4*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	75 (64 — 88) *245 (210 — 280)*
S1	E	0,060 *0.060*	1,4 *1.4*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	45 (35 — 54) *150 (120 — 170)*
S2	E	0,060 *0.060*	1,4 *1.4*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,080 *0.0032*	35 (25 — 44) *115 (83 — 140)*
S3	E	0,060 *0.060*	1,4 *1.4*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,080 *0.0032*	30 (20 — 39) *100 (66 — 120)*
S11	E	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	105 (78 — 120) *345 (260 — 390)*
S12	E	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	80 (60 — 99) *260 (200 — 320)*
S13	E	0,10 *0.10*	1,4 *1.4*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	65 (48 — 79) *215 (160 — 250)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – XSE720 dynamisches Fräsen

SMG		a_p/DC	f_z					v_c
			10	12	16	20	25	
P1	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	245 (190 — 300) *800 (630 — 980)*
P2	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	240 (190 — 290) *790 (630 — 950)*
P3	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	205 (160 — 250) *670 (530 — 820)*
P4	E/M/A/D	1,4 *1.4*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	185 (140 — 220) *610 (460 — 720)*
P5	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 180) *460 (370 — 590)*
P6	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	155 (130 — 200) *510 (430 — 650)*
P7	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (120 — 190) *490 (400 — 620)*
P8	E/M/A/D	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	140 (110 — 180) *460 (370 — 590)*
P11	E/M/A/D	1,4 *1.4*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	140 (110 — 180) *460 (370 — 590)*
P12	E/M/A/D	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	100 (86 — 110) *330 (290 — 360)*
M1	E/M/A	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	180 (160 — 200) *590 (530 — 650)*
M2	E/M/A	1,4 *1.4*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	150 (130 — 170) *490 (430 — 550)*
M3	E/M/A	1,4 *1.4*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	125 (110 — 140) *410 (370 — 450)*
M4	E/M/A	1,4 *1.4*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	95 (80 — 110) *310 (270 — 360)*
M5	E/M/A	1,4 *1.4*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	80 (67 — 92) *260 (220 — 300)*
S1	E	1,4 *1.4*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	44 (35 — 53) *145 (120 — 170)*
S2	E	1,4 *1.4*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	34 (25 — 43) *110 (83 — 140)*
S3	E	1,4 *1.4*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	29 (20 — 39) *95 (66 — 120)*
S11	E	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	110 (82 — 130) *360 (270 — 420)*
S12	E	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	85 (63 — 100) *280 (210 — 320)*
S13	E	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	65 (50 — 83) *215 (170 — 270)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – XSE720 Eckfräsen – Zoll

SMG		a_e/DC	a_p/DC	f_z					v_c
				3/8	1/2	5/8	3/4	1	
P1	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,13 *0.0050*	0,15 *0.0060*	265 (200 — 320) *870 (660 — 1000)*
P2	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	255 (200 — 320) *840 (660 — 1000)*
P3	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	225 (170 — 270) *740 (560 — 880)*
P4	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,14 *0.0055*	195 (150 — 240) *640 (500 — 780)*
P5	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	160 (120 — 190) *520 (400 — 620)*
P6	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	180 (140 — 220) *590 (460 — 720)*
P7	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,11 *0.0044*	170 (130 — 210) *560 (430 — 680)*
P8	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,12 *0.0048*	160 (120 — 190) *520 (400 — 620)*
P11	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	160 (130 — 200) *520 (430 — 650)*
P12	E/M/A/D	0,12 *0.12*	1,4 *1.4*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	95 (80 — 100) *310 (270 — 320)*
M1	E/M/A	0,12 *0.12*	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	170 (150 — 190) *560 (500 — 620)*
M2	E/M/A	0,12 *0.12*	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,13 *0.0050*	140 (120 — 150) *460 (400 — 490)*
M3	E/M/A	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	120 (100 — 110) *395 (330 — 360)*
M4	E/M/A	0,10 *0.10*	1,4 *1.4*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	90 (77 — 91) *295 (260 — 290)*
M5	E/M/A	0,10 *0.10*	1,4 *1.4*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	0,10 *0.0040*	75 (64 — 76) *245 (210 — 240)*
S1	E	0,060 *0.060*	1,4 *1.4*	0,046 *0.0018*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	0,090 *0.0036*	45 (35 — 54) *150 (120 — 170)*
S2	E	0,060 *0.060*	1,4 *1.4*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,080 *0.0032*	35 (25 — 44) *115 (83 — 140)*
S3	E	0,060 *0.060*	1,4 *1.4*	0,042 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,080 *0.0032*	30 (20 — 39) *100 (66 — 120)*
S11	E	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	105 (78 — 120) *345 (260 — 390)*
S12	E	0,10 *0.10*	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,11 *0.0044*	80 (60 — 99) *260 (200 — 320)*
S13	E	0,10 *0.10*	1,4 *1.4*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	65 (48 — 79) *215 (160 — 250)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

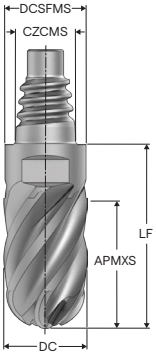
Schnittdaten – XSE720 dynamisches Fräsen – Zoll

SMG		a_p/DC	f_z					v_c
			3/8	1/2	5/8	3/4	1	
P1	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	285 (220 — 350) *940 (730 — 1100)*
P2	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,18 *0.0070*	0,20 *0.0080*	275 (210 — 340) *900 (690 — 1100)*
P3	E/M/A/D	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	240 (180 — 290) *790 (600 — 950)*
P4	E/M/A/D	1,4 *1.4*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	0,18 *0.0070*	210 (160 — 260) *690 (530 — 850)*
P5	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	175 (130 — 210) *570 (430 — 680)*
P6	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	195 (150 — 240) *640 (500 — 780)*
P7	E/M/A/D	1,4 *1.4*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	185 (140 — 220) *610 (460 — 720)*
P8	E/M/A/D	1,4 *1.4*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	0,15 *0.0060*	170 (130 — 210) *560 (430 — 680)*
P11	E/M/A/D	1,4 *1.4*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	170 (130 — 210) *560 (430 — 680)*
P12	E/M/A/D	1,4 *1.4*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	100 (86 — 110) *330 (290 — 360)*
M1	E/M/A	1,4 *1.4*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	0,19 *0.0075*	180 (160 — 200) *590 (530 — 650)*
M2	E/M/A	1,4 *1.4*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	0,17 *0.0065*	150 (130 — 170) *490 (430 — 550)*
M3	E/M/A	1,4 *1.4*	0,075 *0.0030*	0,085 *0.0034*	0,11 *0.0044*	0,12 *0.0048*	0,14 *0.0055*	125 (110 — 120) *410 (370 — 390)*
M4	E/M/A	1,4 *1.4*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	95 (80 — 95) *310 (270 — 310)*
M5	E/M/A	1,4 *1.4*	0,065 *0.0026*	0,075 *0.0030*	0,095 *0.0038*	0,11 *0.0044*	0,12 *0.0048*	80 (67 — 79) *260 (220 — 250)*
S1	E	1,4 *1.4*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	0,085 *0.0034*	44 (35 — 53) *145 (120 — 170)*
S2	E	1,4 *1.4*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	34 (25 — 43) *110 (83 — 140)*
S3	E	1,4 *1.4*	0,040 *0.0016*	0,048 *0.0019*	0,060 *0.0024*	0,070 *0.0028*	0,075 *0.0030*	29 (20 — 39) *95 (66 — 120)*
S11	E	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	110 (82 — 130) *360 (270 — 420)*
S12	E	1,4 *1.4*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	0,14 *0.0055*	85 (63 — 100) *280 (210 — 320)*
S13	E	1,4 *1.4*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	0,12 *0.0048*	65 (50 — 83) *215 (170 — 270)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

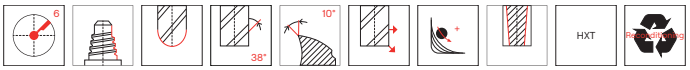
XSB720
Hochleistungsfräser – Superlegierung – Kugelkopf – 6 Schneiden





D

– Toleranzen:
– DC= e7
– RE= ±0,02 mm
– Nachschleifen möglich, wenn DC ≥ Ø12 ist mm

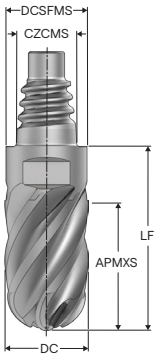


Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Beschichtung
					mm	mm	mm	mm	mm			HXT
XSB720E10100D3BZ6	10138222	3	D	E10	10,0	9,7	15,0	21,8	5,0	6	8,0	■
XSB720E12120D3BZ6	10138223	3	D	E12	12,0	11,7	18,0	25,9	6,0	6	10,0	■
XSB720E16160D3BZ6	10138224	3	D	E16	16,0	15,5	24,0	34,1	8,0	6	12,0	■
XSB720E20200D3BZ6	10138225	3	D	E20	20,0	19,3	30,0	40,2	10,0	6	16,0	■

■ **Lagerstandard.**

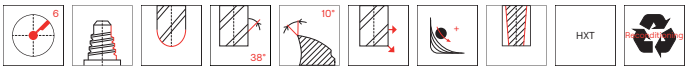
XSB720
Hochleistungsfräser – Superlegierung – Kugelkopf – 6 Schneiden – Zoll





D

—Toleranzen:
—DC= e7
—RE= ±.0008 Zoll
—Nachschleifen möglich, wenn DC ≥ Ø.500 ist Zoll



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Beschichtung
					Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*			HXT
XSB720E10.375D3BZ6	10138226	3	D	E10	0.375	0.364	0.563	0.827	0.188	6	8,0	■
XSB720E12.500D3BZ6	10138227	3	D	E12	0.500	0.484	0.750	1.055	0.250	6	10,0	■
XSB720E16.625D3BZ6	10138228	3	D	E16	0.625	0.610	0.938	1.343	0.313	6	12,0	■
XSB720E20.750D3BZ6	10138229	3	D	E20	0.750	0.728	1.125	1.524	0.375	6	16,0	■
XSB720E251.00D3BZ6	10138230	3	D	E25	1.000	0.965	1.500	1.980	0.500	6	20,0	■

■ **Lagerstandard.**

Schnittdaten – XSB720 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P1	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	185 (150 — 140) *610 (500 — 450)*
P2	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	175 (140 — 130) *570 (460 — 420)*
P3	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	155 (120 — 110) *510 (400 — 360)*
P4	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	135 (110 — 100) *445 (370 — 320)*
P5	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	130 (110 — 100) *425 (370 — 320)*
P6	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	145 (120 — 110) *475 (400 — 360)*
P7	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (110 — 100) *460 (370 — 320)*
P8	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	130 (99 — 98) *425 (330 — 320)*
P11	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	140 (110 — 100) *460 (370 — 320)*
P12	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	85 (68 — 67) *280 (230 — 210)*
M1	E/M/A	0,12 *0.12*	1,2 *1.2*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	170 (150 — 190) *560 (500 — 620)*
M2	E/M/A	0,12 *0.12*	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	140 (120 — 160) *460 (400 — 520)*
M3	E/M/A	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	120 (110 — 140) *395 (370 — 450)*
M4	E/M/A	0,10 *0.10*	1,2 *1.2*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	90 (77 — 100) *295 (260 — 320)*
M5	E/M/A	0,10 *0.10*	1,2 *1.2*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	75 (65 — 89) *245 (220 — 290)*
S1	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (35 — 54) *150 (120 — 170)*
S2	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	35 (5 — 45) *115 (17 — 140)*
S3	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	30 (20 — 40) *100 (66 — 130)*
S11	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	105 (79 — 130) *345 (260 — 420)*
S12	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*
S13	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	60 (47 — 77) *195 (160 — 250)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – XSB720 Eckfräsen dynamisches Fräsen a_e/DC=0,07

SMG		a_p/DC	f_z				v_c
			10	12	16	20	
P1	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	195 (160 — 150) *640 (530 — 490)*
P2	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*	0,22 *0.0085*	190 (150 — 140) *620 (500 — 450)*
P3	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	165 (130 — 120) *540 (430 — 390)*
P4	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	145 (120 — 110) *475 (400 — 360)*
P5	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	140 (110 — 100) *460 (370 — 320)*
P6	E/M/A/D	1,2 *1.2*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	160 (130 — 120) *520 (430 — 390)*
P7	E/M/A/D	1,2 *1.2*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	150 (120 — 110) *490 (400 — 360)*
P8	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	140 (110 — 100) *460 (370 — 320)*
P11	E/M/A/D	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (120 — 110) *490 (400 — 360)*
P12	E/M/A/D	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	95 (73 — 72) *310 (240 — 230)*
M1	E/M/A	1,2 *1.2*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	185 (160 — 200) *610 (530 — 650)*
M2	E/M/A	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (130 — 170) *490 (430 — 550)*
M3	E/M/A	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	125 (110 — 140) *410 (370 — 450)*
M4	E/M/A	1,2 *1.2*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	95 (81 — 110) *310 (270 — 360)*
M5	E/M/A	1,2 *1.2*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	80 (68 — 93) *260 (230 — 300)*
S1	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (35 — 54) *150 (120 — 170)*
S2	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	35 (5 — 45) *115 (17 — 140)*
S3	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	30 (20 — 40) *100 (66 — 130)*
S11	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	110 (82 — 130) *360 (270 — 420)*
S12	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*
S13	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	65 (49 — 81) *215 (170 — 260)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – XSB720 Eckfräsen – Zoll

SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	195 (170 — 220) *640 (560 — 720)*
P2	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	190 (170 — 210) *620 (560 — 680)*
P3	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	165 (150 — 180) *540 (500 — 590)*
P4	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,16 *0.0065*	145 (130 — 160) *475 (430 — 520)*
P5	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	140 (130 — 160) *460 (430 — 520)*
P6	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	155 (140 — 170) *510 (460 — 550)*
P7	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	150 (130 — 160) *490 (430 — 520)*
P8	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,095 *0.0038*	0,11 *0.0044*	0,14 *0.0055*	0,16 *0.0065*	140 (120 — 150) *460 (400 — 490)*
P11	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,070 *0.0028*	0,080 *0.0032*	0,10 *0.0040*	0,12 *0.0048*	150 (130 — 170) *490 (430 — 550)*
P12	E/M/A/D	0,12 *0.12*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	95 (81 — 100) *310 (270 — 320)*
M1	E/M/A	0,12 *0.12*	1,2 *1.2*	0,075 *0.0030*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	220 (180 — 260) *720 (600 — 850)*
M2	E/M/A	0,12 *0.12*	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	180 (140 — 220) *590 (460 — 720)*
M3	E/M/A	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	160 (120 — 200) *520 (400 — 650)*
M4	E/M/A	0,10 *0.10*	1,2 *1.2*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	125 (93 — 150) *410 (310 — 490)*
M5	E/M/A	0,10 *0.10*	1,2 *1.2*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	105 (77 — 120) *345 (260 — 390)*
S1	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (35 — 54) *150 (120 — 170)*
S2	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	37 (27 — 47) *120 (89 — 150)*
S3	E	0,070 *0.070*	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	30 (20 — 40) *100 (66 — 130)*
S11	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*
S12	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*
S13	E	0,10 *0.10*	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	80 (61 — 100) *260 (210 — 320)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

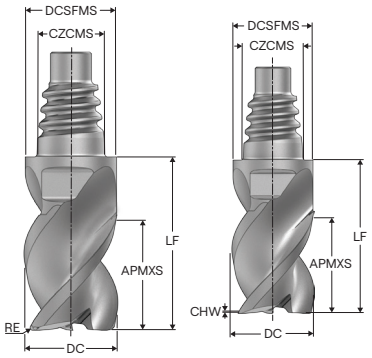
Schnittdaten – XSB720 Eckfräsen dynamisches Fräsen a_e/DC=0,07 – Zoll

SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,22 *0.0085*	210 (190 — 240) *690 (630 — 780)*
P2	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,19 *0.0075*	0,22 *0.0085*	205 (180 — 230) *670 (600 — 750)*
P3	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	180 (160 — 200) *590 (530 — 650)*
P4	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	155 (140 — 170) *510 (460 — 550)*
P5	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,17 *0.0065*	0,20 *0.0080*	150 (130 — 170) *490 (430 — 550)*
P6	E/M/A/D	1,2 *1.2*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	1,2 *1.2*	0,11 *0.0044*	0,14 *0.0055*	0,17 *0.0065*	0,19 *0.0075*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	1,2 *1.2*	0,12 *0.0048*	0,14 *0.0055*	0,18 *0.0070*	0,20 *0.0080*	150 (130 — 170) *490 (430 — 550)*
P11	E/M/A/D	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	160 (140 — 180) *520 (460 — 590)*
P12	E/M/A/D	1,2 *1.2*	0,060 *0.0024*	0,070 *0.0028*	0,090 *0.0036*	0,10 *0.0040*	100 (87 — 110) *330 (290 — 360)*
M1	E/M/A	1,2 *1.2*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	0,17 *0.0065*	235 (190 — 280) *770 (630 — 910)*
M2	E/M/A	1,2 *1.2*	0,090 *0.0036*	0,11 *0.0044*	0,13 *0.0050*	0,15 *0.0060*	195 (160 — 230) *640 (530 — 750)*
M3	E/M/A	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	170 (130 — 200) *560 (430 — 650)*
M4	E/M/A	1,2 *1.2*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	130 (97 — 160) *425 (320 — 520)*
M5	E/M/A	1,2 *1.2*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	0,10 *0.0040*	105 (81 — 130) *345 (270 — 420)*
S1	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	45 (35 — 54) *150 (120 — 170)*
S2	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	37 (27 — 47) *120 (89 — 150)*
S3	E	1,2 *1.2*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	30 (20 — 40) *100 (66 — 130)*
S11	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*
S12	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*
S13	E	1,2 *1.2*	0,070 *0.0028*	0,085 *0.0034*	0,10 *0.0040*	0,12 *0.0048*	85 (63 — 100) *280 (210 — 320)*

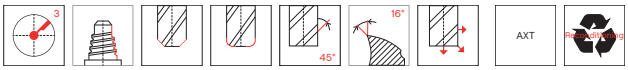
SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

XSE450
Hochleistungsfräser – Aluminium – Eckfräser – 3 Schneiden – Eckenradius oder Fase





– Toleranzen:
– DC= 0/-0,0508 mm
– RE= ±0,0254 mm
– Nachschleifen möglich, wenn DC ≥ Ø12 ist mm



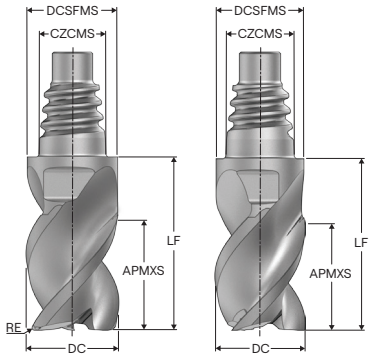
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCSFMS	APMXS	LF	CHW	RE	PCEDC	SW	Beschichtung
					mm	mm	mm	mm	mm	mm			AXT
XSE450E10100D2CZ3	10271542	2	D	E10	10,0	9,7	12,0	18,7	0,1	–	3	8,0	■
XSE450E10100D2R100Z3	10271547	2	D	E10	10,0	9,7	12,0	18,7	–	1,0	3	8,0	■
XSE450E10100D2R050Z3	10138362	2	D	E10	10,0	9,7	12,0	18,7	–	0,5	3	8,0	■
XSE450E12120D2CZ3	10271543	2	D	E12	12,0	11,7	14,4	22,1	0,1	–	3	10,0	■
XSE450E12120D2R300Z3	10271551	2	D	E12	12,0	11,7	14,4	22,1	–	3,0	3	10,0	■
XSE450E12120D2R050Z3	10138363	2	D	E12	12,0	11,7	14,4	22,1	–	0,5	3	10,0	■
XSE450E12120D2R100Z3	10138364	2	D	E12	12,0	11,7	14,4	22,1	–	1,0	3	10,0	■
XSE450E16160D2CZ3	10271544	2	D	E16	16,0	15,5	19,2	29,2	0,1	–	3	12,0	■
XSE450E16160D2R300Z3	10271553	2	D	E16	16,0	15,5	19,2	29,2	–	3,0	3	12,0	■
XSE450E16160D2R050Z3	10138365	2	D	E16	16,0	15,5	19,2	29,2	–	0,5	3	12,0	■
XSE450E16160D2R100Z3	10138366	2	D	E16	16,0	15,5	19,2	29,2	–	1,0	3	12,0	■
XSE450E20200D2CZ3	10271545	2	D	E20	20,0	19,3	24,0	34,3	0,1	–	3	16,0	■
XSE450E20200D2R300Z3	10271555	2	D	E20	20,0	19,3	24,0	34,3	–	3,0	3	16,0	■
XSE450E20200D2R050Z3	10138367	2	D	E20	20,0	19,3	24,0	34,3	–	0,5	3	16,0	■
XSE450E20200D2R100Z3	10138369	2	D	E20	20,0	19,3	24,0	34,3	–	1,0	3	16,0	■

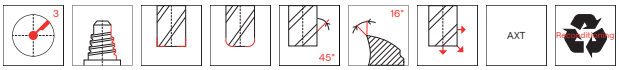
■ **Lagerstandard.**

XSE450

Hochleistungsfräser – Aluminium – Eckfräser – 3 Schneiden – scharf oder Eckenradius – Zoll







– Toleranzen:
– DC= 0/-.002 Zoll
– RE= ±.001 Zoll
– Nachschleifen möglich, wenn DC ≥ Ø.500 ist Zoll

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Beschichtung
					Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*			AXT
XSE450E10.375D2R010Z3	10271561	2	D	E10	0.375	0.364	0.450	0.720	0.010	3	8,0	■
XSE450E10.375D2SZ3	10138370	2	D	E10	0.375	0.364	0.450	0.720	–	3	8,0	■
XSE450E10.375D2R030Z3	10138375	2	D	E10	0.375	0.364	0.450	0.720	0.030	3	8,0	■
XSE450E12.500D2R010Z3	10271562	2	D	E12	0.500	0.484	0.600	0.906	0.010	3	10,0	■
XSE450E12.500D2SZ3	10138371	2	D	E12	0.500	0.484	0.600	0.906	–	3	10,0	■
XSE450E12.500D2R030Z3	10138376	2	D	E12	0.500	0.484	0.600	0.906	0.030	3	10,0	■
XSE450E12.500D2R060Z3	10138377	2	D	E12	0.500	0.484	0.600	0.906	0.060	3	10,0	■
XSE450E16.625D2SZ3	10138372	2	D	E16	0.625	0.610	0.750	1.150	–	3	12,0	■
XSE450E16.625D2R030Z3	10138378	2	D	E16	0.625	0.610	0.750	1.150	0.030	3	12,0	■
XSE450E16.625D2R060Z3	10138379	2	D	E16	0.625	0.610	0.750	1.150	0.060	3	12,0	■
XSE450E16.625D2R120Z3	10138380	2	D	E16	0.625	0.610	0.750	1.150	0.120	3	12,0	■
XSE450E20.750D2SZ3	10138373	2	D	E20	0.750	0.728	0.900	1.295	–	3	16,0	■
XSE450E20.750D2R030Z3	10138381	2	D	E20	0.750	0.728	0.900	1.295	0.030	3	16,0	■
XSE450E20.750D2R060Z3	10138382	2	D	E20	0.750	0.728	0.900	1.295	0.060	3	16,0	■
XSE450E20.750D2R120Z3	10138383	2	D	E20	0.750	0.728	0.900	1.295	0.120	3	16,0	■
XSE450E251.00D2SZ3	10138374	2	D	E25	1.000	0.965	1.200	1.673	–	3	20,0	■
XSE450E251.00D2R030Z3	10138384	2	D	E25	1.000	0.965	1.200	1.673	0.030	3	20,0	■
XSE450E251.00D2R060Z3	10138385	2	D	E25	1.000	0.965	1.200	1.673	0.060	3	20,0	■
XSE450E251.00D2R120Z3	10138386	2	D	E25	1.000	0.965	1.200	1.673	0.120	3	20,0	■

■ **Lagerstandard.**

Schnittdaten – XSE450 Eckfräsen

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
N1	E/M/A	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	405 (340 — 450) *1325 (1200 — 1400)*
N2	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	275 (230 — 330) *900 (760 — 1000)*
N3	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	185 (150 — 220) *610 (500 — 720)*
N11	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	245 (200 — 290) *800 (660 — 950)*
TS1	A/D	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	280 (170 — 390) *920 (560 — 1200)*
TP1	A/D	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	280 (170 — 390) *920 (560 — 1200)*

Schnittdaten – XSE450 Nutfräsen

SMG		a_p/DC	f_z				v_c
			10	12	16	20	
N1	E/M/A	0,48 *0.48*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	370 (310 — 410) *1225 (1100 — 1300)*
N2	E/M/A	0,48 *0.48*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	255 (210 — 300) *840 (690 — 980)*
N3	E/M/A	0,48 *0.48*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	170 (140 — 200) *560 (460 — 650)*
N11	E/M/A	0,48 *0.48*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	225 (190 — 270) *740 (630 — 880)*
TS1	A/D	0,48 *0.48*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	255 (160 — 350) *840 (530 — 1100)*
TP1	A/D	0,48 *0.48*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	255 (160 — 350) *840 (530 — 1100)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – XSE450 Eckfräsen – Zoll

SMG		a_e/DC	a_p/DC	f_z					v_c
				3/8	1/2	5/8	3/4	1	
N1	E/M/A	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	560 (450 — 670) *1825 (1500 — 2100)*
N2	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	445 (340 — 550) *1450 (1200 — 1800)*
N3	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	295 (230 — 360) *970 (760 — 1100)*
N11	E/M/A	0,40 *0.40*	1,1 *1.1*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	0,22 *0.0085*	0,25 *0.010*	395 (300 — 490) *1300 (990 — 1600)*
TS1	A/D	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	280 (170 — 390) *920 (560 — 1200)*
TP1	A/D	0,40 *0.40*	1,1 *1.1*	0,15 *0.0060*	0,18 *0.0070*	0,22 *0.0085*	0,26 *0.010*	0,30 *0.012*	280 (170 — 390) *920 (560 — 1200)*

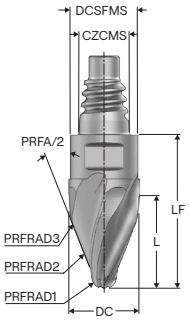
Schnittdaten – XSE450 Nutfräsen – Zoll

SMG		a_p/DC	f_z					v_c
			3/8	1/2	5/8	3/4	1	
N1	E/M/A	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	500 (400 — 590) *1650 (1400 — 1900)*
N2	E/M/A	1,1 *1.1*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	400 (300 — 490) *1300 (990 — 1600)*
N3	E/M/A	1,1 *1.1*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	265 (200 — 330) *870 (660 — 1000)*
N11	E/M/A	1,1 *1.1*	0,080 *0.0032*	0,095 *0.0038*	0,13 *0.0050*	0,16 *0.0065*	0,20 *0.0080*	355 (270 — 440) *1175 (890 — 1400)*
TS1	A/D	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	1,1 *1.1*	0,10 *0.0040*	0,12 *0.0048*	0,16 *0.0065*	0,20 *0.0080*	0,25 *0.010*	250 (150 — 340) *820 (500 — 1100)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

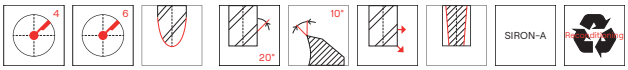
XHT740
Hochgeschwindigkeitsfräsen – ISO– M und ISO– S – Konische Form – 4-6 Schneiden





T

—Toleranzen:
—PRFRAD1= ±0,03 mm
—Formtoleranz PRFRAD2= 0,02 mm
—Nachschleifen möglich, wenn DC ≥ Ø12 mm und PRFRAD1 ≥ 1,5 mm ist



Bezeichnung	Produkt-nummer	Längen-index		CZCMS	DC	DCSFMS	APMXS	LF	L	PRFRAD1	PRFRAD2	PRFRAD3	PRFA/2°	PCEDC	SW	Beschich-tung
					mm	mm	mm	mm	mm	mm	mm	mm				SIRA
XHT740E10100T2R1.5R250Z4	10138388	2	T	E10	10,0	9,7	1,62	18,7	5,4	1,5	250,0	2,0	65,0	4	8,0	■
XHT740E10100T3R2R250Z4	10138391	3	T	E10	10,0	9,7	9,04	21,8	12,7	2,0	250,0	5,0	20,0	4	8,0	■
XHT740E10100T3R2R250Z6	10138395	3	T	E10	10,0	9,7	9,04	21,8	12,7	2,0	250,0	5,0	20,0	6	8,0	■
XHT740E12120T2R3R250Z4	10138389	2	T	E12	12,0	11,7	5,33	22,1	10,5	3,0	250,0	6,0	32,5	4	10,0	■
XHT740E12120T3R3R250Z4	10138392	3	T	E12	12,0	11,7	9,71	25,9	13,7	3,0	250,0	6,0	20,0	4	10,0	■
XHT740E12120T3R3R250Z6	10138396	3	T	E12	12,0	11,7	9,71	25,9	13,7	3,0	250,0	6,0	20,0	6	10,0	■
XHT740E16160T2R4R500Z4	10138390	2	T	E16	16,0	15,5	8,95	29,2	14,6	4,0	500,0	8,0	27,5	4	12,0	■
XHT740E16160T3R4R1000Z4	10138394	3	T	E16	16,0	15,5	21,02	34,1	24,0	4,0	1000,0	5,0	20,0	4	12,0	■
XHT740E16160T3R4R500Z4	10138393	3	T	E16	16,0	15,5	12,94	34,1	17,6	4,0	500,0	8,0	20,0	4	12,0	■
XHT740E16160T3R4R500Z6	10138397	3	T	E16	16,0	15,5	12,94	34,1	17,6	4,0	500,0	8,0	20,0	6	12,0	■

■ **Lagerstandard.**

Schnittdaten – XHT740 – Kopierfräser PCEDC 4

SMG		a_e/DC	f_z			v_c
			10	12	16	
P8	E/M/A/D	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E/M/A/D	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

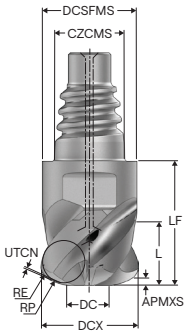
Schnittdaten – XHT740 – Kopierfräser PCEDC 6

SMG		a_e/DC	f_z			v_c
			10	12	16	
P8	E/M/A/D	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	170 (150 - 195) *560 (490 - 640)*
P12	E/M/A/D	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	120 (95 - 135) *400 (310 - 445)*
M1	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	150 (125 - 155) *490 (410 - 510)*
M2	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	145 (120 - 150) *475 (400 - 490)*
M3	E/M/A	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	130 (90 - 140) *425 (295 - 460)*
S2	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	60 (50 - 70) *195 (165 - 230)*
S11	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	100 (85 - 105) *320 (280 - 345)*
S12	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	95 (80 - 100) *310 (260 - 320)*
S13	E	0,010 *0.010*	0,05 *0.0022*	0,06 *0.0024*	0,08 *0.0032*	90 (75 - 95) *295 (245 - 310)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

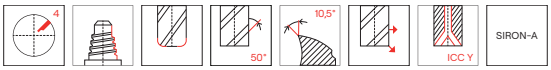
XHF580
Hochvorschubfräser – Universell – 4 Schneiden – Eckenradius





D

– Toleranzen:
– DCX= h9
– RE= ±0,03 mm

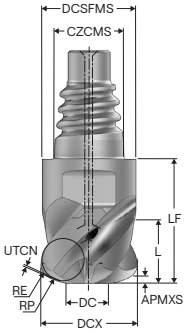


Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	CZCMS	DCX	DC	DCSFMS	APMXS	L	LF	RE	RP	UTCN	PCEDC	SW	Be-schich-tung
						mm	mm	mm	mm	mm	mm	mm	mm	mm			SIRA
XHF580E10100D1HZ4A	10137971	1	D	■	E10	10,0	3,4	9,7	0,7	6,0	12,4	1,5	1,99	0,27	4	8,0	■
XHF580E12120D1HZ4A	10137972	1	D	■	E12	12,0	4,5	11,7	0,8	7,5	14,5	1,5	2,1	0,323	4	10,0	■
XHF580E16160D1HZ4A	10137973	1	D	■	E16	16,0	6,2	15,5	1,0	10,0	18,7	2,0	2,747	0,426	4	12,0	■

■ **Lagerstandard.**

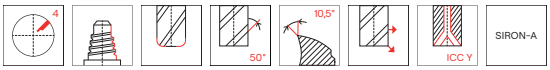
XHF580
Hochvorschubfräser – Universell – 3-4 Schneiden – Eckenradius – Zoll





D

—Toleranzen:
—DCX= h9
—RE= ±.0012 Zoll



Bezeichnung	Produkt-nummer	Längen-index		CSP	CZCMS	DCX	DC	DCSFMS	APMXS	L	LF	RE	RP	UTCN	PCEDC	SW	Beschich-tung
						Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*			SIRA
XHF580E10.375D1HZ4A	10137974	1	D	■	E10	0.375	0.134	0.364	0.024	0.236	0.488	0.060	0.076	0.008	4	8,0	■
XHF580E12.500D1HZ4A	10137975	1	D	■	E12	0.500	0.197	0.484	0.033	0.315	0.571	0.060	0.086	0.014	4	10,0	■
XHF580E16.625D1HZ4A	10137976	1	D	■	E16	0.625	0.236	0.610	0.039	0.394	0.736	0.080	0.110	0.016	4	12,0	■

■ **Lagerstandard.**

Schnittdaten – XHF580 Eckfräsen

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	350 (330 — 400) *1150 (1100 — 1300)*
P2	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	340 (320 — 390) *1125 (1100 — 1200)*
P3	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	295 (280 — 340) *970 (920 — 1100)*
P4	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (250 — 300) *850 (830 — 980)*
P5	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (250 — 300) *850 (830 — 980)*
P6	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	190 (180 — 230) *620 (600 — 750)*
P7	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	180 (170 — 220) *590 (560 — 720)*
P8	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	170 (160 — 200) *560 (530 — 650)*
P11	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	145 (150 — 170) *475 (500 — 550)*
P12	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	85 (83 — 100) *280 (280 — 320)*
M1	E/M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	170 (170 — 200) *560 (560 — 650)*
M2	E/M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	140 (140 — 160) *460 (460 — 520)*
M3	E/M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (97 — 130) *345 (320 — 420)*
M4	E/M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	75 (73 — 99) *245 (240 — 320)*
M5	E/M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	65 (61 — 83) *215 (210 — 270)*
K1	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	345 (330 — 400) *1125 (1100 — 1300)*
K2	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	300 (280 — 340) *980 (920 — 1100)*
K3	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	250 (240 — 290) *820 (790 — 950)*
K4	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	240 (230 — 280) *790 (760 — 910)*
K5	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	145 (140 — 160) *475 (460 — 520)*
K6	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	210 (200 — 240) *690 (660 — 780)*
K7	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	185 (180 — 210) *610 (600 — 680)*
S1	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	45 (36 — 71) *150 (120 — 230)*
S2	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	36 (29 — 57) *120 (96 — 180)*
S3	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	31 (25 — 49) *100 (83 — 160)*
S11	E	0,30 *0.30*	0,060 *0.060*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	160 (160 — 190) *520 (530 — 620)*
S12	E	0,30 *0.30*	0,060 *0.060*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	125 (120 — 150) *410 (400 — 490)*
S13	E	0,30 *0.30*	0,060 *0.060*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	95 (91 — 110) *310 (300 — 360)*
H5	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (98 — 130) *345 (330 — 420)*
H8	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (98 — 130) *345 (330 — 420)*
H21	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (98 — 130) *345 (330 — 420)*
H31	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	80 (74 — 100) *260 (250 — 320)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – XHF580 Nutfräsen

SMG		a_p/DCX	f_z			v_c
			10	12	16	
P1	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	320 (300 — 360) *1050 (990 — 1100)*
P2	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	310 (290 — 350) *1025 (960 — 1100)*
P3	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	265 (250 — 300) *870 (830 — 980)*
P4	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	235 (220 — 270) *770 (730 — 880)*
P5	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	235 (220 — 270) *770 (730 — 880)*
P6	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	175 (160 — 210) *570 (530 — 680)*
P7	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	165 (150 — 200) *540 (500 — 650)*
P8	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	155 (150 — 180) *510 (500 — 590)*
P11	E/M/A/D	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	130 (130 — 160) *425 (430 — 520)*
P12	E/M/A/D	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (75 — 94) *260 (250 — 300)*
M1	E/M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	155 (150 — 180) *510 (500 — 590)*
M2	E/M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	125 (120 — 150) *410 (400 — 490)*
M3	E/M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	95 (88 — 110) *310 (290 — 360)*
M4	E/M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	70 (66 — 89) *230 (220 — 290)*
M5	E/M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	60 (55 — 74) *195 (190 — 240)*
K1	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	310 (300 — 360) *1025 (990 — 1100)*
K2	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	270 (260 — 310) *890 (860 — 1000)*
K3	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	230 (220 — 260) *750 (730 — 850)*
K4	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	220 (210 — 250) *720 (690 — 820)*
K5	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	130 (130 — 150) *425 (430 — 490)*
K6	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	190 (180 — 220) *620 (600 — 720)*
K7	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	165 (160 — 190) *540 (530 — 620)*
S1	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	39 (32 — 62) *130 (110 — 200)*
S2	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	31 (26 — 50) *100 (86 — 160)*
S3	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	27 (22 — 43) *90 (73 — 140)*
S11	E	0,060 *0.060*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	150 (150 — 180) *490 (500 — 590)*
S12	E	0,060 *0.060*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	115 (110 — 140) *375 (370 — 450)*
S13	E	0,060 *0.060*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	90 (85 — 100) *295 (280 — 320)*
H5	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	95 (88 — 120) *310 (290 — 390)*
H8	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	95 (88 — 120) *310 (290 — 390)*
H21	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	95 (88 — 120) *310 (290 — 390)*
H31	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	70 (67 — 91) *230 (220 — 290)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – XHF580 Eckfräsen – Zoll

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				3/8	1/2	5/8	
P1	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	485 (440 — 530) *1600 (1500 — 1700)*
P2	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	475 (430 — 520) *1550 (1500 — 1700)*
P3	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	405 (370 — 450) *1325 (1300 — 1400)*
P4	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	360 (320 — 390) *1175 (1100 — 1200)*
P5	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (240 — 290) *850 (790 — 950)*
P6	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	295 (270 — 320) *970 (890 — 1000)*
P7	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	280 (250 — 300) *920 (830 — 980)*
P8	E/M/A/D	0,34 *0.34*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (240 — 290) *850 (790 — 950)*
P11	E/M/A/D	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	160 (140 — 170) *520 (460 — 550)*
P12	E/M/A/D	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	95 (83 — 100) *310 (280 — 320)*
M1	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	185 (170 — 200) *610 (560 — 650)*
M2	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	150 (140 — 160) *490 (460 — 520)*
M3	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (97 — 130) *375 (320 — 420)*
M4	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	85 (73 — 99) *280 (240 — 320)*
M5	E/M/A	0,30 *0.30*	0,055 *0.055*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	70 (61 — 82) *230 (210 — 260)*
K1	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	475 (430 — 520) *1550 (1500 — 1700)*
K2	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	415 (370 — 450) *1350 (1300 — 1400)*
K3	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	350 (320 — 380) *1150 (1100 — 1200)*
K4	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	335 (300 — 370) *1100 (990 — 1200)*
K5	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	200 (180 — 220) *660 (600 — 720)*
K6	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	295 (270 — 320) *970 (890 — 1000)*
K7	E/M/A/D	0,30 *0.30*	0,060 *0.060*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	255 (230 — 280) *840 (760 — 910)*
S1	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	55 (36 — 71) *180 (120 — 230)*
S2	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	43 (29 — 57) *140 (96 — 180)*
S3	E	0,30 *0.30*	0,034 *0.034*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	37 (25 — 49) *120 (83 — 160)*
S11	E	0,30 *0.30*	0,034 *0.034*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	170 (150 — 190) *560 (500 — 620)*
S12	E	0,30 *0.30*	0,034 *0.034*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	130 (120 — 140) *425 (400 — 450)*
S13	E	0,30 *0.30*	0,034 *0.034*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	100 (89 — 110) *330 (300 — 360)*
H5	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (98 — 130) *375 (330 — 420)*
H8	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (98 — 130) *375 (330 — 420)*
H21	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (98 — 130) *375 (330 — 420)*
H31	M/A	0,30 *0.30*	0,060 *0.060*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	90 (74 — 100) *295 (250 — 320)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

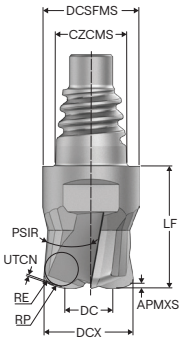
Schnittdaten – XHF580 Nutfräsen – Zoll

SMG		a_p/DCX	f_z			v_c
			3/8	1/2	5/8	
P1	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	440 (400 — 480) *1450 (1400 — 1500)*
P2	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	430 (390 — 470) *1400 (1300 — 1500)*
P3	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	370 (330 — 400) *1225 (1100 — 1300)*
P4	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	325 (290 — 360) *1075 (960 — 1100)*
P5	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	245 (220 — 270) *800 (730 — 880)*
P6	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	275 (250 — 300) *900 (830 — 980)*
P7	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	260 (240 — 280) *850 (790 — 910)*
P8	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	245 (220 — 270) *800 (730 — 880)*
P11	E/M/A/D	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	145 (130 — 160) *475 (430 — 520)*
P12	E/M/A/D	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	85 (75 — 94) *280 (250 — 300)*
M1	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	170 (150 — 180) *560 (500 — 590)*
M2	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	135 (120 — 150) *445 (400 — 490)*
M3	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 110) *345 (290 — 360)*
M4	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (66 — 89) *260 (220 — 290)*
M5	E/M/A	0,055 *0.055*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	65 (55 — 74) *215 (190 — 240)*
K1	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	430 (390 — 480) *1400 (1300 — 1500)*
K2	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	375 (340 — 410) *1225 (1200 — 1300)*
K3	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	315 (290 — 350) *1025 (960 — 1100)*
K4	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	305 (270 — 330) *1000 (890 — 1000)*
K5	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	180 (170 — 200) *590 (560 — 650)*
K6	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	265 (240 — 290) *870 (790 — 950)*
K7	E/M/A/D	0,060 *0.060*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	230 (210 — 250) *750 (690 — 820)*
S1	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	47 (32 — 62) *155 (110 — 200)*
S2	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	38 (26 — 50) *125 (86 — 160)*
S3	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	32 (22 — 43) *105 (73 — 140)*
S11	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	160 (150 — 180) *520 (500 — 590)*
S12	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	125 (110 — 140) *410 (370 — 450)*
S13	E	0,034 *0.034*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	95 (84 — 100) *310 (280 — 320)*
H5	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 120) *345 (290 — 390)*
H8	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 120) *345 (290 — 390)*
H21	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	105 (88 — 120) *345 (290 — 390)*
H31	M/A	0,060 *0.060*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (67 — 91) *260 (220 — 290)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

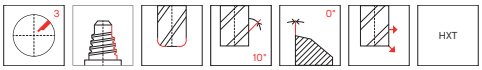
XHF780
Hochvorschubfräser – ISO– M und ISO– S – 3 Schneiden – Eckenradius





D

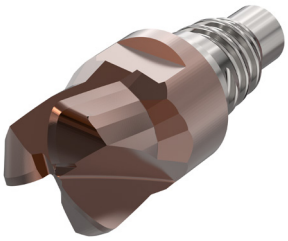
—Toleranzen:
—DCX= -0,02/-0,04 mm
—RE= ±0,05 mm

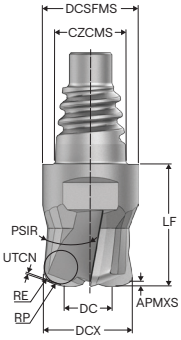


Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DCX	DC	DCSFMS	APMXS	L	LF	RE	RP	UTCN	PCEDC	SW	Beschich-tung
					mm	mm	mm	mm	mm	mm	mm	mm	mm			HXT
XHF780E10100D1HZ3	10137957	1	D	E10	10,0	5,0	9,7	0,45	5,5	12,3	0,8	1,175	0,232	3	8,0	■
XHF780E12120D1HZ3	10137958	1	D	E12	12,0	6,0	11,7	0,5	6,6	14,4	1,0	1,416	0,262	3	10,0	■
XHF780E16160D1HZ3	10137959	1	D	E16	16,0	8,0	15,5	0,6	8,8	18,6	1,5	1,989	0,32	3	12,0	■

■ **Lagerstandard.**

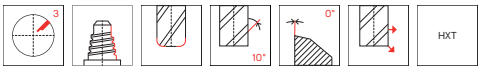
XHF780
Hochvorschubfräser – ISO– M und ISO– S – 3 Schneiden – Eckenradius – Zoll





D

– Toleranzen:
– DCX= -.0008/-0.0016 Zoll
– RE= ±.002 Zoll



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DCX	DC	DCSFMS	APMXS	L	LF	RE	RP	UTCN	PCEDC	SW	Beschichtung
					Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*	*Zoll*			HXT
XHF780E10.375D1HZ3	10137960	1	D	E10	0.375	0.188	0.364	0.018	0.206	0.484	0.028	0.043	0.009	3	8,0	■
XHF780E12.500D1HZ3	10137961	1	D	E12	0.500	0.250	0.484	0.020	0.276	0.567	0.045	0.061	0.010	3	10,0	■
XHF780E16.625D1HZ3	10137962	1	D	E16	0.625	0.313	0.610	0.024	0.343	0.732	0.061	0.080	0.012	3	12,0	■

■ **Lagerstandard.**

Schnittdaten – XHF780 Eckfräsen

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	355 (330 — 410) *1175 (1100 — 1300)*
P2	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	345 (320 — 390) *1125 (1100 — 1200)*
P3	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	295 (280 — 340) *970 (920 — 1100)*
P4	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (250 — 300) *850 (830 — 980)*
P5	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	260 (250 — 300) *850 (830 — 980)*
P6	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	195 (180 — 230) *640 (600 — 750)*
P7	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	185 (170 — 220) *610 (560 — 720)*
P8	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	175 (160 — 210) *570 (530 — 680)*
P11	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	180 (170 — 210) *590 (560 — 680)*
P12	E/M/A/D	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	85 (83 — 100) *280 (280 — 320)*
M1	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	175 (170 — 210) *570 (560 — 680)*
M2	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	140 (140 — 160) *460 (460 — 520)*
M3	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (97 — 130) *345 (320 — 420)*
M4	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	75 (73 — 100) *245 (240 — 320)*
M5	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	65 (61 — 83) *215 (210 — 270)*
S1	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	45 (36 — 71) *150 (120 — 230)*
S2	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	36 (29 — 57) *120 (96 — 180)*
S3	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	31 (25 — 49) *100 (83 — 160)*
S11	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	160 (160 — 190) *520 (530 — 620)*
S12	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	120 (120 — 150) *395 (400 — 490)*
S13	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	95 (90 — 110) *310 (300 — 360)*
H5	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (99 — 130) *345 (330 — 420)*
H8	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (99 — 130) *345 (330 — 420)*
H11	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	135 (130 — 170) *445 (430 — 550)*
H21	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	105 (99 — 130) *345 (330 — 420)*
H31	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	80 (75 — 100) *260 (250 — 320)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – XHF780 Nutfräsen

SMG		a_p/DCX	f_z			v_c
			10	12	16	
P1	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	310 (290 — 350) *1025 (960 — 1100)*
P2	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	300 (290 — 350) *980 (960 — 1100)*
P3	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	260 (250 — 300) *850 (830 — 980)*
P4	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	230 (220 — 260) *750 (730 — 850)*
P5	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	230 (220 — 260) *750 (730 — 850)*
P6	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	170 (160 — 200) *560 (530 — 650)*
P7	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	160 (150 — 190) *520 (500 — 620)*
P8	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	150 (140 — 180) *490 (460 — 590)*
P11	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	155 (150 — 180) *510 (500 — 590)*
P12	E/M/A/D	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	75 (73 — 92) *245 (240 — 300)*
M1	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	150 (150 — 180) *490 (500 — 590)*
M2	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	120 (120 — 140) *395 (400 — 450)*
M3	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	90 (85 — 110) *295 (280 — 360)*
M4	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	65 (64 — 87) *215 (210 — 280)*
M5	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	55 (53 — 72) *180 (180 — 230)*
S1	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	38 (31 — 60) *125 (110 — 190)*
S2	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	30 (25 — 48) *100 (83 — 150)*
S3	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	26 (21 — 41) *85 (69 — 130)*
S11	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	145 (140 — 170) *475 (460 — 550)*
S12	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	110 (110 — 130) *360 (370 — 420)*
S13	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	85 (82 — 100) *280 (270 — 320)*
H5	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	90 (86 — 110) *295 (290 — 360)*
H8	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	90 (86 — 110) *295 (290 — 360)*
H11	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	115 (110 — 140) *375 (370 — 450)*
H21	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	90 (86 — 110) *295 (290 — 360)*
H31	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	70 (65 — 88) *230 (220 — 280)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – XHF780 Eckfräsen – Zoll

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				3/8	1/2	5/8	
P1	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	370 (330 — 410) *1225 (1100 — 1300)*
P2	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	360 (320 — 390) *1175 (1100 — 1200)*
P3	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	310 (280 — 340) *1025 (920 — 1100)*
P4	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	270 (250 — 300) *890 (830 — 980)*
P5	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	270 (250 — 300) *890 (830 — 980)*
P6	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	305 (280 — 330) *1000 (920 — 1000)*
P7	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	290 (260 — 320) *950 (860 — 1000)*
P8	E/M/A/D	0,30 *0.30*	0,040 *0.040*	0,50 *0.020*	0,60 *0.024*	0,80 *0.032*	270 (250 — 300) *890 (830 — 980)*
P11	E/M/A/D	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	160 (150 — 170) *520 (500 — 550)*
P12	E/M/A/D	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	95 (83 — 100) *310 (280 — 320)*
M1	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	190 (170 — 210) *620 (560 — 680)*
M2	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	150 (140 — 160) *490 (460 — 520)*
M3	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (97 — 130) *375 (320 — 420)*
M4	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	85 (73 — 100) *280 (240 — 320)*
M5	E/M/A	0,30 *0.30*	0,036 *0.036*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	70 (61 — 83) *230 (210 — 270)*
S1	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	55 (36 — 71) *180 (120 — 230)*
S2	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	43 (29 — 57) *140 (96 — 180)*
S3	E	0,30 *0.30*	0,022 *0.022*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	37 (25 — 49) *120 (83 — 160)*
S11	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	175 (160 — 190) *570 (530 — 620)*
S12	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	135 (120 — 150) *445 (400 — 490)*
S13	E	0,30 *0.30*	0,022 *0.022*	0,36 *0.014*	0,42 *0.017*	0,55 *0.022*	105 (90 — 110) *345 (300 — 360)*
H5	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (99 — 130) *375 (330 — 420)*
H8	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (99 — 130) *375 (330 — 420)*
H11	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	150 (130 — 170) *490 (430 — 550)*
H21	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	115 (99 — 130) *375 (330 — 420)*
H31	M/A	0,30 *0.30*	0,040 *0.040*	0,40 *0.016*	0,48 *0.019*	0,65 *0.026*	90 (75 — 100) *295 (250 — 320)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

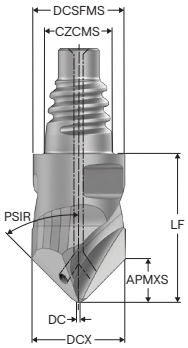
Schnittdaten – XHF780 Nutfräsen – Zoll

SMG		a_p/DCX	f_z			v_c
			3/8	1/2	5/8	
P1	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	325 (290 — 350) *1075 (960 — 1100)*
P2	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	315 (290 — 350) *1025 (960 — 1100)*
P3	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	270 (250 — 300) *890 (830 — 980)*
P4	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	240 (220 — 260) *790 (730 — 850)*
P5	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	240 (220 — 260) *790 (730 — 850)*
P6	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	270 (240 — 290) *890 (790 — 950)*
P7	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	255 (230 — 280) *840 (760 — 910)*
P8	E/M/A/D	0,040 *0.040*	0,30 *0.012*	0,36 *0.014*	0,48 *0.019*	240 (220 — 260) *790 (730 — 850)*
P11	E/M/A/D	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	140 (130 — 150) *460 (430 — 490)*
P12	E/M/A/D	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	80 (73 — 92) *260 (240 — 300)*
M1	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	165 (150 — 180) *540 (500 — 590)*
M2	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	130 (120 — 140) *425 (400 — 450)*
M3	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (85 — 110) *330 (280 — 360)*
M4	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	75 (64 — 87) *245 (210 — 280)*
M5	E/M/A	0,036 *0.036*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	65 (53 — 72) *215 (180 — 230)*
S1	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	45 (31 — 60) *150 (110 — 190)*
S2	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	36 (25 — 48) *120 (83 — 150)*
S3	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	31 (21 — 41) *100 (69 — 130)*
S11	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	155 (140 — 170) *510 (460 — 550)*
S12	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	120 (110 — 130) *395 (370 — 420)*
S13	E	0,022 *0.022*	0,18 *0.0070*	0,22 *0.0085*	0,28 *0.011*	95 (82 — 100) *310 (270 — 320)*
H5	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (86 — 110) *330 (290 — 360)*
H8	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (86 — 110) *330 (290 — 360)*
H11	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	130 (110 — 140) *425 (370 — 450)*
H21	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	100 (86 — 110) *330 (290 — 360)*
H31	M/A	0,040 *0.040*	0,24 *0.0095*	0,28 *0.011*	0,38 *0.015*	75 (65 — 88) *245 (220 — 280)*

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

XS5021
Hochleistungsfräser – Universell – Fase –2 Schneiden





N

– Toleranzen:
– DCX= 0,02/-0,04 mm
– PSIR= ±0,5°
– Nachschleifen möglich, wenn DC ≥ Ø12 ist mm



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCX	DCSFMS	APMXS	LF	PSIR°	PCEDC	SW	Beschichtung
					mm	mm	mm	mm	mm				SIRA
XS5021-E10100N1SZ2T45A	10343896	1	N	E10	0,5	10,0	9,7	7,1	16,0	45,0	2	8,0	■
XS5021-E12120N1SZ2T45A	10343897	1	N	E12	0,6	12,0	11,7	8,6	19,0	45,0	2	10,0	■
XS5021-E16160N1SZ2T45A	10343898	1	N	E16	0,8	16,0	15,5	12,0	26,4	45,0	2	12,0	■

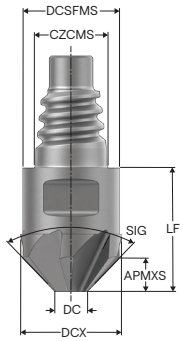
■ **Lagerstandard.**

Schnittdaten – XS5021 Anfasen

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,075 *0.0030*	0,095 *0.0037*	275 (135 — 310) *900 (440 — 1010)*
P2	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,075 *0.0030*	0,095 *0.0037*	270 (130 — 300) *890 (425 — 975)*
P3	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,075 *0.0030*	0,095 *0.0037*	235 (110 — 260) *770 (370 — 850)*
P4	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	220 (105 — 250) *720 (350 — 810)*
P5	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	200 (95 — 220) *660 (310 — 715)*
P6	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,045 *0.0018*	0,07 *0.0028*	0,085 *0.0033*	200 (95 — 220) *660 (310 — 715)*
P7	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,045 *0.0018*	0,07 *0.0028*	0,085 *0.0033*	200 (95 — 220) *660 (310 — 715)*
P8	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,045 *0.0018*	0,07 *0.0028*	0,085 *0.0033*	200 (95 — 220) *660 (310 — 715)*
P11	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,045 *0.0018*	0,07 *0.0028*	0,085 *0.0033*	180 (80 — 200) *590 (270 — 650)*
P12	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,07 *0.0028*	0,06 *0.0024*	130 (60 — 140) *425 (200 — 460)*
M1	E/M/A	0,20 *0.20*	0,20 *0.20*	0,055 *0.0022*	0,075 *0.0030*	0,095 *0.0037*	220 (100 — 240) *720 (330 — 790)*
M2	E/M/A	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	180 (80 — 200) *590 (270 — 650)*
M3	E/M/A	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,06 *0.0024*	0,07 *0.0028*	145 (65 — 155) *475 (210 — 510)*
M4	E/M/A	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,05 *0.0020*	0,06 *0.0024*	110 (50 — 120) *360 (160 — 390)*
M5	E/M/A	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,05 *0.0020*	0,06 *0.0024*	90 (40 — 100) *295 (140 — 330)*
K1	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	215 (100 — 235) *710 (340 — 770)*
K2	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	190 (90 — 205) *620 (300 — 675)*
K3	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	160 (75 — 175) *520 (250 — 570)*
K4	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	150 (70 — 165) *490 (240 — 540)*
K5	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,065 *0.0026*	0,075 *0.0030*	80 (45 — 100) *260 (145 — 330)*
K6	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,05 *0.0020*	0,07 *0.0028*	0,085 *0.0033*	115 (65 — 145) *375 (210 —480)*
K7	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,065 *0.0026*	0,075 *0.0030*	100 (60 — 130) *330 (190 — 425)*
N1	E/M/A	0,20 *0.20*	0,20 *0.20*	0,07 *0.0028*	0,095 *0.0037*	0,12 *0.0047*	1250 (775— 1800) *4100 (2540 — 5900)*
N2	E/M/A	0,20 *0.20*	0,20 *0.20*	0,07 *0.0028*	0,095 *0.0037*	0,12 *0.0047*	570 (310 — 720) *1870 (1020 — 2370)*
N3	E/M/A	0,20 *0.20*	0,20 *0.20*	0,07 *0.0028*	0,095 *0.0037*	0,12 *0.0047*	380 (210 — 480) *1240 (680 — 1580)*
N11	E/M/A	0,20 *0.20*	0,20 *0.20*	0,07 *0.0028*	0,095 *0.0037*	0,12 *0.0047*	610 (240 — 555) *2000 (780 — 1820)*
S1	E	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,06 *0.0024*	30 (17 — 40) *100 (55 — 125)*
S2	E	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,06 *0.0024*	24 (15 — 31) *80 (44 — 102)*
S3	E	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,06 *0.0024*	21 (12 — 27) *70 (38 — 88)*
S11	E	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	43 (25 — 55) *140 (80 — 180)*
S12	E	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	33 (20 — 42) *108 (60 — 138)*
S13	E	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,06 *0.0024*	26 (15 — 33) *85 (50 — 110)*
H5	M/A	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,06 *0.0024*	60 (30 — 70) *195 (105— 240)*
H8	M/A	0,20 *0.20*	0,20 *0.20*	0,025 *0.0010*	0,035 *0.0014*	0,05 *0.0020*	60 (30 — 70) *195 (105— 240)*
H21	M/A	0,20 *0.20*	0,20 *0.20*	0,025 *0.0010*	0,035 *0.0014*	0,05 *0.0020*	60 (30 — 70) *195 (105— 240)*
H31	M/A	0,20 *0.20*	0,20 *0.20*	0,025 *0.0010*	0,035 *0.0014*	0,05 *0.0020*	45 (25 — 55) *145 (80 — 185)*

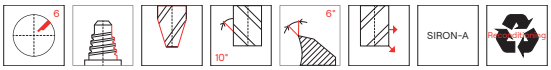
XS5061
Hochleistungsfräser – Universell – Fase –6 Schneiden





N

– Toleranzen:
– PSIR= ±0,5°
– Nachschleifen möglich, wenn DC ≥ Ø12 ist mm



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCX	DCSFMS	APMXS	LF	PSIR°	PCEDC	SW	Beschichtung
					mm	mm	mm	mm	mm				SIRA
XS5061-E10100N1SZ6T45	10219277	1	N	E10	1,95	10,1	9,7	4,075	12,3	45,0	6	8,0	■
XS5061-E12120N1SZ6T45	10219278	1	N	E12	2,95	12,1	11,7	4,575	14,4	45,0	6	10,0	■
XS5061-E16160N1SZ6T45	10219279	1	N	E16	3,95	16,1	15,5	6,075	18,6	45,0	6	12,0	■

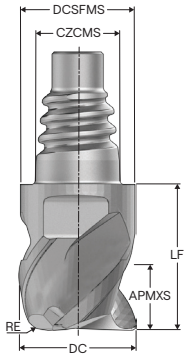
■ **Lagerstandard.**

Schnittdaten – XS5061 Anfasen

SMG		a_e/DCX	a_p/DCX	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,065 *0.0026*	0,075 *0.0030*	275 (135 — 310) *900 (440 — 1010)*
P2	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,065 *0.0026*	0,075 *0.0030*	270 (130 — 300) *890 (425 — 975)*
P3	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,065 *0.0026*	0,075 *0.0030*	235 (110 — 260) *770 (370 — 850)*
P4	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,06 *0.0024*	0,07 *0.0028*	220 (105 — 250) *720 (350 — 810)*
P5	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,06 *0.0024*	0,07 *0.0028*	200 (95 — 220) *660 (310 — 715)*
P6	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	200 (95 — 220) *660 (310 — 715)*
P7	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	200 (95 — 220) *660 (310 — 715)*
P8	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	200 (95 — 220) *660 (310 — 715)*
P11	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	180 (80 — 200) *590 (270 — 650)*
P12	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,055 *0.0022*	0,05 *0.0020*	130 (60 — 140) *425 (200 — 460)*
M1	E/M/A	0,20 *0.20*	0,20 *0.20*	0,045 *0.0018*	0,065 *0.0026*	0,075 *0.0030*	220 (100 — 240) *720 (330 — 790)*
M2	E/M/A	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	180 (80 — 200) *590 (270 — 650)*
M3	E/M/A	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,05 *0.0020*	0,055 *0.0022*	145 (65 — 155) *475 (210 — 510)*
M4	E/M/A	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	110 (50 — 120) *360 (160 — 390)*
M5	E/M/A	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	90 (40 — 100) *295 (140 — 330)*
K1	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	215 (100 — 235) *710 (340 — 770)*
K2	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	190 (90 — 205) *620 (300 — 675)*
K3	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	160 (75 — 175) *520 (250 — 570)*
K4	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	150 (70 — 165) *490 (240 — 540)*
K5	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,05 *0.0020*	0,065 *0.0026*	80 (45 — 100) *260 (145 — 330)*
K6	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,04 *0.0016*	0,055 *0.0022*	0,07 *0.0028*	115 (65 — 145) *375 (210 —480)*
K7	E/M/A/D	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,05 *0.0020*	0,065 *0.0026*	100 (60 — 130) *330 (190 — 425)*
N1	E/M/A	0,20 *0.20*	0,20 *0.20*	0,055 *0.0022*	0,075 *0.0030*	0,1 *0.0039*	1250 (775— 1800) *4100 (2540 — 5900)*
N2	E/M/A	0,20 *0.20*	0,20 *0.20*	0,055 *0.0022*	0,075 *0.0030*	0,1 *0.0039*	570 (310 — 720) *1870 (1020 — 2370)*
N3	E/M/A	0,20 *0.20*	0,20 *0.20*	0,055 *0.0022*	0,075 *0.0030*	0,1 *0.0039*	380 (210 — 480) *1240 (680 — 1580)*
N11	E/M/A	0,20 *0.20*	0,20 *0.20*	0,055 *0.0022*	0,075 *0.0030*	0,1 *0.0039*	610 (240 — 555) *2000 (780 — 1820)*
S1	E	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	30 (17 — 40) *100 (55 — 125)*
S2	E	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	24 (15 — 31) *80 (44 — 102)*
S3	E	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	21 (12 — 27) *70 (38 — 88)*
S11	E	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,055 *0.0022*	43 (25 — 55) *140 (80 — 180)*
S12	E	0,20 *0.20*	0,20 *0.20*	0,035 *0.0014*	0,045 *0.0018*	0,055 *0.0022*	33 (20 — 42) *108 (60 — 138)*
S13	E	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	26 (15 — 33) *85 (50 — 110)*
H5	M/A	0,20 *0.20*	0,20 *0.20*	0,03 *0.0012*	0,04 *0.0016*	0,05 *0.0020*	60 (30 — 70) *195 (105— 240)*
H8	M/A	0,20 *0.20*	0,20 *0.20*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	60 (30 — 70) *195 (105— 240)*
H21	M/A	0,20 *0.20*	0,20 *0.20*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	60 (30 — 70) *195 (105— 240)*
H31	M/A	0,20 *0.20*	0,20 *0.20*	0,02 *0.0008*	0,03 *0.0012*	0,04 *0.0016*	45 (25 — 55) *145 (80 — 185)*

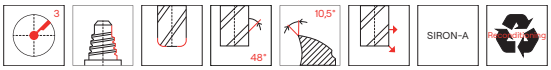
XVE540
Allgemeine Anwendung – Universell – Eckfräser – 3 Schneiden – Eckenradius





D

– Toleranzen:
– DC= h9
– RE= ±0,015 mm
– Nachschleifen möglich, wenn DC ≥ Ø12 ist mm

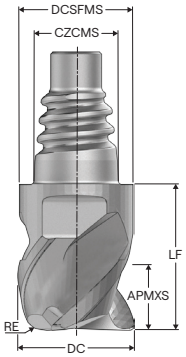


Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Beschichtung
					mm	mm	mm	mm	mm			SIRA
XVE540E10100D1R050Z3	10137981	1	D	E10	10,0	9,7	5,5	12,4	0,5	3	8,0	■
XVE540E12120D1R050Z3	10137982	1	D	E12	12,0	11,7	6,5	14,5	0,5	3	10,0	■
XVE540E16160D1R050Z3	10137983	1	D	E16	16,0	15,5	8,5	18,7	0,5	3	12,0	■
XVE540E20200D1R050Z3	10137984	1	D	E20	20,0	19,3	11,0	21,3	0,5	3	16,0	■

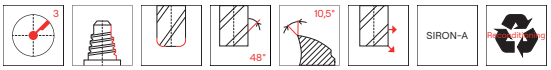
■ **Lagerstandard.**

XVE540
Allgemeine Anwendung – Universell – Eckfräser – 3 Schneiden – Eckenradius





D



– Toleranzen:
– DC= h9
– RE= .015 Zoll= ±.0006 Zoll
– RE= .031 Zoll= ±.0012 Zoll
– Nachschleifen möglich, wenn DC ≥ Ø.500 ist Zoll

Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Beschichtung
					Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*			SIRA
XVE540E10.375D1R015Z3	10137985	1	D	E10	0.375	0.364	0.209	0.488	0.015	3	8,0	■
XVE540E12.500D1R015Z3	10137986	1	D	E12	0.500	0.484	0.276	0.575	0.015	3	10,0	■
XVE540E16.625D1R015Z3	10137987	1	D	E16	0.625	0.610	0.335	0.736	0.015	3	12,0	■
XVE540E20.750D1R031Z3	10137988	1	D	E20	0.750	0.728	0.413	0.839	0.031	3	16,0	■

■ **Lagerstandard.**

Schnittdaten – XVE540 – Eckfräsen PCEDC 3

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P1	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	175 (140 — 220) *570 (460 — 720)*
P2	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	170 (130 — 210) *560 (430 — 680)*
P3	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	150 (120 — 180) *490 (400 — 590)*
P4	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	135 (100 — 160) *445 (330 — 520)*
P5	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	125 (96 — 150) *410 (320 — 490)*
P6	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	145 (110 — 170) *475 (370 — 550)*
P7	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	135 (110 — 160) *445 (370 — 520)*
P8	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	125 (96 — 150) *410 (320 — 490)*
P11	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	80 (70 — 93) *260 (230 — 300)*
P12	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (45 — 59) *165 (150 — 190)*
M1	E/M/A	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	95 (81 — 100) *310 (270 — 320)*
M2	E/M/A	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (67 — 88) *245 (220 — 280)*
M3	E/M/A	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	50 (39 — 60) *165 (130 — 190)*
M4	E/M/A	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	38 (30 — 46) *125 (99 — 150)*
M5	E/M/A	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	32 (25 — 39) *105 (83 — 120)*
K1	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	155 (140 — 170) *510 (460 — 550)*
K2	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	135 (120 — 150) *445 (400 — 490)*
K3	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	115 (99 — 130) *375 (330 — 420)*
K4	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	110 (95 — 120) *360 (320 — 390)*
K5	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	140 (120 — 150) *460 (400 — 490)*
K6	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	200 (170 — 220) *660 (560 — 720)*
K7	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	175 (150 — 190) *570 (500 — 620)*
N1	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	550 (510 — 710) *1800 (1700 — 2300)*
N2	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	355 (330 — 450) *1175 (1100 — 1400)*
N3	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	235 (220 — 300) *770 (730 — 980)*
N11	E/M/A	0,50 *0.50*	0,50 *0.50*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*	0,13 *0.0050*	300 (250 — 340) *980 (830 — 1100)*
S1	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	30 (24 — 37) *100 (79 — 120)*
S2	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	25 (19 — 32) *80 (63 — 100)*
S3	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	22 (17 — 27) *70 (56 — 88)*
S11	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	100 (72 — 120) *330 (240 — 390)*
S12	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (56 — 99) *245 (190 — 320)*
S13	E	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	60 (44 — 79) *195 (150 — 250)*
TS1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	255 (160 — 350) *840 (530 — 1100)*
TP1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	255 (160 — 350) *840 (530 — 1100)*
GR1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 710) *2000 (1700 — 2300)*

Schnittdaten – XVE540 – Nutfräsen PCEDC 3

SMG		a_p/DC	f_z				v_c
			10	12	16	20	
P1	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	165 (130 — 200) *540 (430 — 650)*
P2	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	160 (120 — 190) *520 (400 — 620)*
P3	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	135 (110 — 170) *445 (370 — 550)*
P4	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (90 — 140) *395 (300 — 450)*
P5	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	115 (86 — 140) *375 (290 — 450)*
P6	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	130 (97 — 160) *425 (320 — 520)*
P7	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (92 — 150) *395 (310 — 490)*
P8	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	115 (86 — 140) *375 (290 — 450)*
P11	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	75 (64 — 84) *245 (210 — 270)*
P12	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	44 (38 — 49) *145 (130 — 160)*
M1	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (75 — 99) *280 (250 — 320)*
M2	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (60 — 79) *230 (200 — 250)*
M3	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	45 (35 — 55) *150 (120 — 180)*
M4	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	34 (27 — 41) *110 (89 — 130)*
M5	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	28 (22 — 34) *90 (73 — 110)*
K1	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	140 (120 — 150) *460 (400 — 490)*
K2	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (89 — 110) *345 (300 — 360)*
K4	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (85 — 110) *330 (280 — 360)*
K5	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (110 — 140) *410 (370 — 450)*
K6	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	185 (150 — 200) *610 (500 — 650)*
K7	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	160 (130 — 170) *520 (430 — 550)*
N1	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	540 (510 — 700) *1775 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	345 (330 — 450) *1125 (1100 — 1400)*
N3	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	230 (220 — 300) *750 (730 — 980)*
N11	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	300 (260 — 350) *980 (860 — 1100)*
S1	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	27 (22 — 34) *90 (73 — 110)*
S2	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	23 (18 — 29) *75 (60 — 95)*
S3	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	20 (15 — 24) *65 (50 — 78)*
S11	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (66 — 110) *295 (220 — 360)*
S12	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (51 — 90) *230 (170 — 290)*
S13	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	55 (39 — 69) *180 (130 — 220)*
TS1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 350) *820 (500 — 1100)*
TP1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 350) *820 (500 — 1100)*
GR1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	600 (500 — 700) *1975 (1700 — 2200)*

Schnittdaten – XVE540 – Eckfräsen PCEDC 3 – Zoll

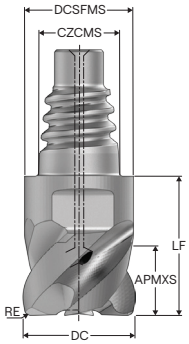
SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	185 (150 — 210) *610 (500 — 680)*
P2	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	180 (150 — 200) *590 (500 — 650)*
P3	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	155 (130 — 180) *510 (430 — 590)*
P4	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	140 (120 — 160) *460 (400 — 520)*
P5	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (89 — 130) *360 (300 — 420)*
P6	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	125 (100 — 140) *410 (330 — 450)*
P7	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (94 — 140) *375 (310 — 450)*
P8	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	110 (89 — 130) *360 (300 — 420)*
P11	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	95 (70 — 110) *310 (230 — 360)*
P12	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	60 (45 — 73) *195 (150 — 230)*
M1	E/M/A	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	105 (81 — 130) *345 (270 — 420)*
M2	E/M/A	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (67 — 110) *295 (220 — 360)*
M3	E/M/A	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (56 — 99) *245 (190 — 320)*
M4	E/M/A	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	60 (43 — 76) *195 (150 — 240)*
M5	E/M/A	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	50 (36 — 63) *165 (120 — 200)*
K1	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	140 (120 — 160) *460 (400 — 520)*
K2	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	120 (110 — 140) *395 (370 — 450)*
K3	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	105 (87 — 110) *345 (290 — 360)*
K4	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (89 — 130) *360 (300 — 420)*
K5	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	65 (54 — 80) *215 (180 — 260)*
K6	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	95 (78 — 110) *310 (260 — 360)*
K7	E/M/A/D	0,50 *0.50*	0,50 *0.50*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	85 (69 — 100) *280 (230 — 320)*
N1	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 710) *2000 (1700 — 2300)*
N2	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	395 (330 — 450) *1300 (1100 — 1400)*
N3	E/M/A	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	260 (220 — 300) *850 (730 — 980)*
N11	E/M/A	0,50 *0.50*	0,50 *0.30*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*	0,13 *0.0055*	300 (250 — 340) *1025 (860 — 1100)*
S1	E	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	39 (32 — 46) *130 (110 — 150)*
S2	E	0,50 *0.50*	0,50 *0.50*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	31 (26 — 37) *100 (86 — 120)*
S3	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	28 (23 — 33) *90 (76 — 100)*
S11	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (87 — 140) *375 (290 — 450)*
S12	E	0,50 *0.50*	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (67 — 110) *295 (220 — 360)*
S13	E	0,50 *0.50*	0,50 *0.50*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	70 (53 — 87) *230 (180 — 280)*
TS1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	255 (160 — 350) *840 (530 — 1100)*
TP1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	255 (160 — 350) *840 (530 — 1100)*
GR1	A/D	0,40 *0.40*	0,50 *0.50*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 710) *2000 (1700 — 2300)*

Schnittdaten – XVE540 – Nutfräsen PCEDC 3 – Zoll

SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	170 (140 — 190) *560 (460 — 620)*
P2	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	165 (140 — 190) *540 (460 — 620)*
P3	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	140 (120 — 160) *460 (400 — 520)*
P4	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (100 — 140) *410 (330 — 450)*
P5	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (81 — 120) *330 (270 — 390)*
P6	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	110 (90 — 130) *360 (300 — 420)*
P7	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (85 — 120) *345 (280 — 390)*
P8	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (81 — 120) *330 (270 — 390)*
P11	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (64 — 100) *280 (210 — 320)*
P12	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (38 — 62) *165 (130 — 200)*
M1	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (75 — 120) *330 (250 — 390)*
M2	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (61 — 100) *260 (210 — 320)*
M3	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (50 — 89) *230 (170 — 290)*
M4	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	50 (38 — 67) *165 (130 — 210)*
M5	E/M/A	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	44 (32 — 56) *145 (110 — 180)*
K1	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (110 — 140) *410 (370 — 450)*
K2	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	110 (92 — 120) *360 (310 — 390)*
K3	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (78 — 100) *295 (260 — 320)*
K4	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (81 — 120) *330 (270 — 390)*
K5	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (48 — 71) *195 (160 — 230)*
K6	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (71 — 100) *295 (240 — 320)*
K7	E/M/A/D	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	75 (61 — 91) *245 (210 — 290)*
N1	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	600 (500 — 700) *1975 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	385 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	255 (220 — 300) *840 (730 — 980)*
N11	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	300 (260 — 340) *980 (860 — 1100)*
S1	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	36 (29 — 43) *120 (96 — 140)*
S2	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	29 (24 — 34) *95 (79 — 110)*
S3	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	25 (20 — 30) *80 (66 — 98)*
S11	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (79 — 130) *345 (260 — 420)*
S12	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (61 — 100) *260 (210 — 320)*
S13	E	0,50 *0.50*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (47 — 77) *195 (160 — 250)*
TS1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 350) *820 (500 — 1100)*
TP1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 350) *820 (500 — 1100)*
GR1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	600 (500 — 700) *1975 (1700 — 2200)*

XVE540
Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Eckenradius





D

– Toleranzen:
– DC= h9
– RE= ±0,015 mm
– Nachschleifen möglich, wenn DC ≥ Ø12 ist mm



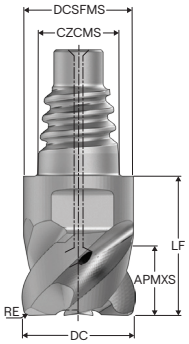
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Beschichtung
						mm	mm	mm	mm	mm			SIRA
XVE540E10100D1R050Z4A	10137989	1	D	■	E10	10,0	9,7	6,0	12,4	0,5	4	8,0	■
XVE540E12120D1R050Z4A	10137990	1	D	■	E12	12,0	11,7	7,5	14,5	0,5	4	10,0	■
XVE540E16160D1R050Z4A	10137991	1	D	■	E16	16,0	15,5	10,0	18,7	0,5	4	12,0	■
XVE540E20200D1R050Z4A	10137992	1	D	■	E20	20,0	19,3	12,0	21,3	0,5	4	16,0	■

■ **Lagerstandard.**

XVE540

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Eckenradius – Zoll





D

—Toleranzen:
—DC= h9
—RE= .015 Zoll= ±.0006 Zoll
—RE= .031 Zoll= ±.0012 Zoll
—Nachschleifen möglich, wenn DC ≥ Ø.500 ist Zoll



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CSP	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Beschichtung
						Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*			SIRA
XVE540E10.375D1R015Z4A	10137993	1	D	■	E10	0.375	0.364	0.236	0.488	0.015	4	8,0	■
XVE540E12.500D1R031Z4A	10137994	1	D	■	E12	0.500	0.484	0.315	0.571	0.031	4	12,0	■
XVE540E16.625D1R031Z4A	10137995	1	D	■	E16	0.625	0.610	0.394	0.736	0.031	4	16,0	■
XVE540E20.750D1R031Z4A	10137996	1	D	■	E20	0.750	0.728	0.453	0.839	0.031	4	18,0	■

■ **Lagerstandard.**

Schnittdaten – XVE540 – Eckfräsen PCEDC 4

SMG		a_e/DC	a_p/DC	f_z				v_c
				10	12	16	20	
P1	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	175 (140 — 210) *570 (460 — 680)*
P2	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	170 (130 — 210) *560 (430 — 680)*
P3	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	150 (120 — 180) *490 (400 — 590)*
P4	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	130 (99 — 160) *425 (330 — 520)*
P5	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,070 *0.0028*	0,085 *0.0034*	125 (95 — 150) *410 (320 — 490)*
P6	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	140 (110 — 170) *460 (370 — 550)*
P7	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,048 *0.0019*	0,055 *0.0022*	0,070 *0.0028*	0,080 *0.0032*	135 (110 — 160) *445 (370 — 520)*
P8	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	125 (95 — 150) *410 (320 — 490)*
P11	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	80 (70 — 92) *260 (230 — 300)*
P12	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	50 (44 — 58) *165 (150 — 190)*
M1	E/M/A	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	95 (80 — 100) *310 (270 — 320)*
M2	E/M/A	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (66 — 87) *245 (220 — 280)*
M3	E/M/A	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	49 (39 — 60) *160 (130 — 190)*
M4	E/M/A	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	38 (30 — 46) *125 (99 — 150)*
M5	E/M/A	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	32 (25 — 38) *105 (83 — 120)*
K1	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	155 (140 — 170) *510 (460 — 550)*
K2	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	135 (120 — 150) *445 (400 — 490)*
K3	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	115 (99 — 130) *375 (330 — 420)*
K4	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	110 (94 — 120) *360 (310 — 390)*
K5	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	135 (110 — 150) *445 (370 — 490)*
K6	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	200 (160 — 220) *660 (530 — 720)*
K7	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	175 (150 — 190) *570 (500 — 620)*
N1	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	540 (510 — 700) *1775 (1700 — 2200)*
N2	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	350 (330 — 450) *1150 (1100 — 1400)*
N3	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	235 (220 — 300) *770 (730 — 980)*
N11	E/M/A	0,50 *0.50*	0,55 *0.55*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*	0,13 *0.0050*	295 (250 — 340) *970 (830 — 1100)*
S1	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	30 (24 — 37) *100 (79 — 120)*
S2	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	25 (19 — 31) *80 (63 — 100)*
S3	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	22 (17 — 27) *70 (56 — 88)*
S11	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	100 (72 — 120) *330 (240 — 390)*
S12	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (55 — 98) *245 (190 — 320)*
S13	E	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	60 (44 — 78) *195 (150 — 250)*
TS1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	250 (160 — 350) *820 (530 — 1100)*
TP1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	250 (160 — 350) *820 (530 — 1100)*
GR1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 700) *2000 (1700 — 2200)*

Schnittdaten – XVE540 – Nutfräsen PCEDC 4

SMG		a_p/DC	f_z				v_c
			10	12	16	20	
P1	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	160 (130 — 200) *520 (430 — 650)*
P2	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	155 (120 — 190) *510 (400 — 620)*
P3	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	135 (110 — 160) *445 (370 — 520)*
P4	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (90 — 140) *395 (300 — 450)*
P5	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	115 (86 — 140) *375 (290 — 450)*
P6	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (96 — 150) *410 (320 — 490)*
P7	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (91 — 150) *395 (300 — 490)*
P8	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	115 (86 — 140) *375 (290 — 450)*
P11	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	75 (63 — 83) *245 (210 — 270)*
P12	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	43 (37 — 49) *140 (130 — 160)*
M1	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (74 — 98) *280 (250 — 320)*
M2	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (60 — 79) *230 (200 — 250)*
M3	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	45 (35 — 54) *150 (120 — 170)*
M4	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	33 (26 — 40) *110 (86 — 130)*
M5	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	28 (22 — 34) *90 (73 — 110)*
K1	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	140 (120 — 150) *460 (400 — 490)*
K2	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (88 — 110) *330 (290 — 360)*
K4	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	95 (84 — 110) *310 (280 — 360)*
K5	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (100 — 130) *410 (330 — 420)*
K6	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	185 (150 — 200) *610 (500 — 650)*
K7	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	160 (130 — 170) *520 (430 — 550)*
N1	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	530 (500 — 690) *1750 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	345 (320 — 440) *1125 (1100 — 1400)*
N3	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	230 (220 — 290) *750 (730 — 950)*
N11	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	295 (250 — 340) *970 (830 — 1100)*
S1	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	27 (21 — 33) *90 (69 — 100)*
S2	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	23 (17 — 28) *75 (56 — 91)*
S3	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	20 (15 — 24) *65 (50 — 78)*
S11	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (65 — 110) *295 (220 — 360)*
S12	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (50 — 89) *230 (170 — 290)*
S13	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	55 (39 — 69) *180 (130 — 220)*
TS1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	590 (500 — 690) *1925 (1700 — 2200)*

Schnittdaten – XVE540 – Eckfräsen PCEDC 4 – Zoll

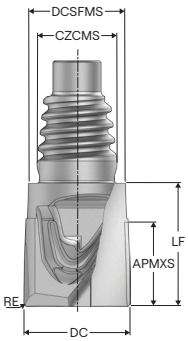
SMG		a_e/DC	a_p/DC	f_z				v_c
				3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	180 (150 — 210) *590 (500 — 680)*
P2	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	175 (150 — 200) *570 (500 — 650)*
P3	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	155 (130 — 180) *510 (430 — 590)*
P4	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	135 (110 — 150) *445 (370 — 490)*
P5	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (88 — 130) *360 (290 — 420)*
P6	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	125 (99 — 140) *410 (330 — 450)*
P7	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (93 — 130) *375 (310 — 420)*
P8	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	110 (88 — 130) *360 (290 — 420)*
P11	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (70 — 110) *295 (230 — 360)*
P12	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	60 (44 — 73) *195 (150 — 230)*
M1	E/M/A	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,095 *0.0038*	105 (80 — 130) *345 (270 — 420)*
M2	E/M/A	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (66 — 100) *295 (220 — 320)*
M3	E/M/A	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	75 (55 — 98) *245 (190 — 320)*
M4	E/M/A	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	60 (43 — 75) *195 (150 — 240)*
M5	E/M/A	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	49 (36 — 63) *160 (120 — 200)*
K1	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	135 (120 — 150) *445 (400 — 490)*
K2	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	120 (110 — 130) *395 (370 — 420)*
K3	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	100 (86 — 110) *330 (290 — 360)*
K4	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	110 (88 — 130) *360 (290 — 420)*
K5	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	65 (54 — 79) *215 (180 — 250)*
K6	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	95 (78 — 110) *310 (260 — 360)*
K7	E/M/A/D	0,50 *0.50*	0,55 *0.55*	0,046 *0.0018*	0,055 *0.0022*	0,065 *0.0026*	0,075 *0.0030*	85 (68 — 100) *280 (230 — 320)*
N1	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 700) *2000 (1700 — 2200)*
N2	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	390 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	260 (220 — 300) *850 (730 — 980)*
N11	E/M/A	0,50 *0.50*	0,55 *0.30*	0,070 *0.0028*	0,080 *0.0032*	0,11 *0.0044*	0,13 *0.0055*	295 (250 — 340) *1000 (860 — 1100)*
S1	E	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	39 (31 — 46) *130 (110 — 150)*
S2	E	0,50 *0.50*	0,55 *0.55*	0,055 *0.0022*	0,065 *0.0026*	0,080 *0.0032*	0,090 *0.0036*	31 (25 — 37) *100 (83 — 120)*
S3	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	27 (22 — 32) *90 (73 — 100)*
S11	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	115 (86 — 140) *375 (290 — 450)*
S12	E	0,50 *0.50*	0,55 *0.55*	0,050 *0.0020*	0,060 *0.0024*	0,075 *0.0030*	0,085 *0.0034*	90 (66 — 100) *295 (220 — 320)*
S13	E	0,50 *0.50*	0,55 *0.55*	0,044 *0.0017*	0,050 *0.0020*	0,065 *0.0026*	0,075 *0.0030*	70 (53 — 87) *230 (180 — 280)*
TS1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	250 (160 — 350) *820 (530 — 1100)*
TP1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	250 (160 — 350) *820 (530 — 1100)*
GR1	A/D	0,40 *0.40*	0,55 *0.55*	0,080 *0.0032*	0,095 *0.0038*	0,12 *0.0048*	0,14 *0.0055*	610 (510 — 700) *2000 (1700 — 2200)*

Schnittdaten – XVE540 – Nutfräsen PCEDC 4 Zoll

SMG		a_p/DC	f_z				v_c
			3/8	1/2	5/8	3/4	
P1	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	170 (140 — 190) *560 (460 — 620)*
P2	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	165 (140 — 180) *540 (460 — 590)*
P3	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	140 (120 — 160) *460 (400 — 520)*
P4	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (100 — 140) *410 (330 — 450)*
P5	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (80 — 110) *330 (270 — 360)*
P6	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	110 (89 — 130) *360 (300 — 420)*
P7	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (84 — 120) *345 (280 — 390)*
P8	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (80 — 110) *330 (270 — 360)*
P11	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (63 — 100) *280 (210 — 320)*
P12	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,040 *0.0016*	0,050 *0.0020*	0,060 *0.0024*	49 (37 — 61) *160 (130 — 200)*
M1	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (74 — 120) *330 (250 — 390)*
M2	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (60 — 99) *260 (200 — 320)*
M3	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	70 (50 — 89) *230 (170 — 290)*
M4	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	50 (38 — 66) *165 (130 — 210)*
M5	E/M/A	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	43 (31 — 55) *140 (110 — 180)*
K1	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	125 (110 — 140) *410 (370 — 450)*
K2	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (91 — 120) *345 (300 — 390)*
K3	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	90 (77 — 100) *295 (260 — 320)*
K4	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	100 (80 — 110) *330 (270 — 360)*
K5	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (48 — 70) *195 (160 — 220)*
K6	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	85 (70 — 100) *280 (230 — 320)*
K7	E/M/A/D	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	75 (61 — 90) *245 (210 — 290)*
N1	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	590 (500 — 690) *1925 (1700 — 2200)*
N2	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	380 (320 — 440) *1250 (1100 — 1400)*
N3	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	255 (220 — 290) *840 (730 — 950)*
N11	E/M/A	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	295 (250 — 340) *970 (830 — 1100)*
S1	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	36 (29 — 42) *120 (96 — 130)*
S2	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	29 (23 — 34) *95 (76 — 110)*
S3	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	25 (20 — 29) *80 (66 — 95)*
S11	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	105 (78 — 120) *345 (260 — 390)*
S12	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	80 (60 — 99) *260 (200 — 320)*
S13	E	0,55 *0.55*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	60 (47 — 76) *195 (160 — 240)*
TS1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 340) *820 (500 — 1100)*
TP1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	250 (150 — 340) *820 (500 — 1100)*
GR1	A/D	0,30 *0.30*	0,034 *0.0013*	0,042 *0.0017*	0,055 *0.0022*	0,070 *0.0028*	590 (500 — 690) *1925 (1700 — 2200)*

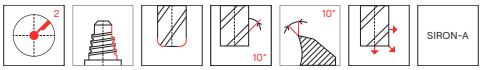
XVE510
Allgemeine Anwendung – Universell – Eckfräser – 2 Schneiden – Eckenradius





D

– Toleranzen:
– DC= h10
– RE= ±0,015 mm



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Beschichtung
					mm	mm	mm	mm	mm			SIRA
XVE510E10100D1R050Z2	10138003	1	D	E10	10,0	9,7	8,0	11,8	0,5	2	6,0	■
XVE510E12120D1R050Z2	10138004	1	D	E12	12,0	11,7	10,0	14,0	0,5	2	8,0	■

■ **Lagerstandard.**

Schnittdaten – XVE510 Eckfräsen

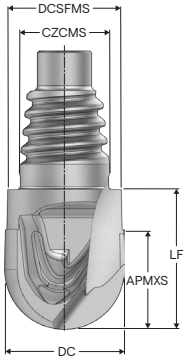
SMG		a_e/DC	a_p/DC	f_z		v_c
				10	12	
P1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	210 (170 — 250) *690 (560 — 820)*
P2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	205 (170 — 240) *670 (560 — 780)*
P3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	175 (150 — 210) *570 (500 — 680)*
P4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	155 (130 — 180) *510 (430 — 590)*
P5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	155 (130 — 180) *510 (430 — 590)*
P6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	175 (140 — 200) *570 (460 — 650)*
P7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	165 (140 — 190) *540 (460 — 620)*
P8	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	155 (130 — 180) *510 (430 — 590)*
P11	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	115 (82 — 140) *375 (270 — 450)*
P12	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,080 *0.0032*	70 (50 — 89) *230 (170 — 290)*
M1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	135 (97 — 170) *445 (320 — 550)*
M2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	110 (78 — 130) *360 (260 — 420)*
M3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	70 (55 — 85) *230 (190 — 270)*
M4	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	50 (41 — 64) *165 (140 — 200)*
M5	E/M/A	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	44 (35 — 53) *145 (120 — 170)*
K1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	185 (160 — 210) *610 (530 — 680)*
K2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	160 (140 — 180) *520 (460 — 590)*
K3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	135 (120 — 150) *445 (400 — 490)*
K4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	130 (110 — 150) *425 (370 — 490)*
K5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	155 (130 — 180) *510 (430 — 590)*
K6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	230 (190 — 270) *750 (630 — 880)*
K7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	100 (83 — 110) *330 (280 — 360)*
N1	E/M/A	0,20 *0.20*	0,65 *0.65*	0,075 *0.0030*	0,090 *0.0036*	470 (410 — 530) *1550 (1400 — 1700)*
N2	E/M/A	0,20 *0.20*	0,65 *0.65*	0,075 *0.0030*	0,090 *0.0036*	305 (270 — 340) *1000 (890 — 1100)*
N3	E/M/A	0,20 *0.20*	0,65 *0.65*	0,075 *0.0030*	0,090 *0.0036*	200 (180 — 230) *660 (600 — 750)*
N11	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	370 (300 — 440) *1225 (990 — 1400)*
S1	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	60 (39 — 85) *195 (130 — 270)*
S2	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	55 (32 — 77) *180 (110 — 250)*
S3	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	39 (24 — 54) *130 (79 — 170)*
S11	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	120 (110 — 140) *395 (370 — 450)*
S12	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	95 (78 — 100) *310 (260 — 320)*
S13	E	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	70 (61 — 84) *230 (210 — 270)*
TS1	A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	540 (470 — 620) *1775 (1600 — 2000)*
TP1	A/D	0,10 *0.10*	0,65 *0.65*	0,080 *0.0032*	0,095 *0.0038*	540 (470 — 620) *1775 (1600 — 2000)*
GR1	A/D	0,20 *0.20*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	570 (510 — 630) *1875 (1700 — 2000)*

Schnittdaten – XVE510 Nutfräsen

SMG		a_p/DC	f_z		v_c
			10	12	
P1	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	135 (110 — 160) *445 (370 — 520)*
P2	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	130 (110 — 150) *425 (370 — 490)*
P3	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	115 (91 — 130) *375 (300 — 420)*
P4	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	100 (80 — 110) *330 (270 — 360)*
P5	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	100 (81 — 120) *330 (270 — 390)*
P6	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	110 (90 — 130) *360 (300 — 420)*
P7	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	105 (85 — 120) *345 (280 — 390)*
P8	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	100 (81 — 120) *330 (270 — 390)*
P11	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	75 (53 — 94) *245 (180 — 300)*
P12	E/M/A/D	0,40 *0.40*	0,040 *0.0016*	0,048 *0.0019*	46 (33 — 58) *150 (110 — 190)*
M1	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	85 (62 — 110) *280 (210 — 360)*
M2	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	70 (50 — 89) *230 (170 — 290)*
M3	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	45 (35 — 54) *150 (120 — 170)*
M4	E/M/A	0,38 *0.38*	0,050 *0.0020*	0,060 *0.0024*	34 (27 — 41) *110 (89 — 130)*
M5	E/M/A	0,38 *0.38*	0,050 *0.0020*	0,060 *0.0024*	28 (23 — 34) *90 (76 — 110)*
K1	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	120 (100 — 130) *395 (330 — 420)*
K2	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	105 (87 — 120) *345 (290 — 390)*
K3	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	90 (74 — 100) *295 (250 — 320)*
K4	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	85 (70 — 97) *280 (230 — 310)*
K5	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	100 (80 — 120) *330 (270 — 390)*
K6	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	150 (120 — 170) *490 (400 — 550)*
K7	E/M/A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	65 (54 — 74) *215 (180 — 240)*
N1	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	350 (300 — 390) *1150 (990 — 1200)*
N2	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	225 (200 — 250) *740 (660 — 820)*
N3	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	150 (130 — 170) *490 (430 — 550)*
N11	E/M/A	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	250 (200 — 290) *820 (660 — 950)*
S1	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	40 (25 — 54) *130 (83 — 170)*
S2	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	35 (20 — 49) *115 (66 — 160)*
S3	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	25 (15 — 34) *80 (50 — 110)*
S11	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	80 (65 — 90) *260 (220 — 290)*
S12	E	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	60 (50 — 69) *195 (170 — 220)*
S13	E	0,42 *0.42*	0,050 *0.0020*	0,060 *0.0024*	47 (39 — 54) *155 (130 — 170)*
TS1	A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	350 (300 — 390) *1150 (990 — 1200)*
TP1	A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	350 (300 — 390) *1150 (990 — 1200)*
GR1	A/D	0,50 *0.50*	0,050 *0.0020*	0,060 *0.0024*	450 (400 — 490) *1475 (1400 — 1600)*

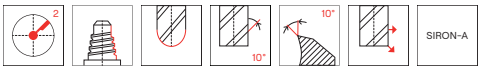
XVB510
Allgemeine Anwendung – Universell – Kugelkopf – 2 Schneiden





D

– Toleranzen:
– DC= h9
– RE= ±0,01 mm

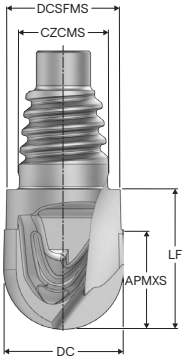


Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Beschichtung
					mm	mm	mm	mm	mm			SIRA
XVB510E10100D1BZ2	10138005	1	D	E10	10,0	9,7	8,0	11,8	5,0	2	6,0	■
XVB510E12120D1BZ2	10138006	1	D	E12	12,0	11,7	10,0	14,0	6,0	2	8,0	■
XVB510E16160D1BZ2	10138007	1	D	E16	16,0	15,5	13,0	18,1	8,0	2	10,0	■

■ **Lagerstandard.**

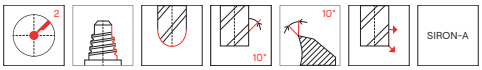
XVB510
Allgemeine Anwendung – Universell – Kugelkopf – 2 Schneiden – Zoll





D

– Toleranzen:
– DC= h9
– RE= ±.0004 Zoll



Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Beschichtung
					Zoll	*Zoll*	*Zoll*	*Zoll*	*Zoll*			SIRA
XVB510E10.375D1BZ2	10138008	1	D	E10	0.375	0.364	0.315	0.465	0.187	2	6,0	■
XVB510E12.500D1BZ2	10138009	1	D	E12	0.500	0.484	0.413	0.551	0.250	2	8,0	■
XVB510E16.625D1BZ2	10138010	1	D	E16	0.625	0.610	0.512	0.713	0.313	2	10,0	■

■ **Lagerstandard.**

Schnittdaten – XVB510 Kopierfräsen/Schruppen

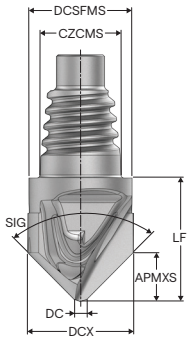
SMG		a_e/DC	a_p/DC	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	185 (150 — 210) *610 (500 — 680)*
P2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	180 (150 — 210) *590 (500 — 680)*
P3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	155 (130 — 180) *510 (430 — 590)*
P4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	135 (110 — 160) *445 (370 — 520)*
P5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	135 (110 — 160) *445 (370 — 520)*
P6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	150 (130 — 180) *490 (430 — 590)*
P7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	145 (120 — 170) *475 (400 — 550)*
P8	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	135 (110 — 160) *445 (370 — 520)*
P11	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	65 (50 — 78) *215 (170 — 250)*
P12	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	39 (30 — 47) *130 (99 — 150)*
M1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	75 (59 — 91) *245 (200 — 290)*
M2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	60 (48 — 74) *195 (160 — 240)*
M3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	60 (48 — 74) *195 (160 — 240)*
M4	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	46 (36 — 55) *150 (120 — 180)*
M5	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	38 (30 — 46) *125 (99 — 150)*
K1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	180 (150 — 210) *590 (500 — 680)*
K2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	155 (130 — 180) *510 (430 — 590)*
K3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	130 (110 — 150) *425 (370 — 490)*
K4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	125 (110 — 150) *410 (370 — 490)*
K5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	80 (63 — 94) *260 (210 — 300)*
K6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	115 (93 — 130) *375 (310 — 420)*
K7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	100 (81 — 120) *330 (270 — 390)*
N1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	445 (390 — 500) *1450 (1300 — 1600)*
N2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	285 (250 — 320) *940 (830 — 1000)*
N3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	190 (170 — 210) *620 (560 — 680)*
N11	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	335 (270 — 400) *1100 (890 — 1300)*
S1	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	55 (33 — 76) *180 (110 — 240)*
S2	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	44 (27 — 61) *145 (89 — 200)*
S3	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	38 (23 — 52) *125 (76 — 170)*
S11	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	105 (88 — 120) *345 (290 — 390)*
S12	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	80 (68 — 94) *260 (230 — 300)*
S13	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	65 (53 — 73) *215 (180 — 230)*
TS1	A/D	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	445 (390 — 500) *1450 (1300 — 1600)*
TP1	A/D	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	445 (390 — 500) *1450 (1300 — 1600)*
GR1	A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	630 (570 — 700) *2075 (1900 — 2200)*

Schnittdaten – XVB510 Kopierfräsen/Schruppen – Zoll

SMG		a_e/DC	a_p/DC	f_z			v_c
				3/8	1/2	5/8	
P1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	365 (320 — 420) *1200 (1100 — 1300)*
P2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	355 (310 — 400) *1175 (1100 — 1300)*
P3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	305 (270 — 350) *1000 (890 — 1100)*
P4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	270 (230 — 310) *890 (760 — 1000)*
P5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	175 (140 — 210) *570 (460 — 680)*
P6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	195 (160 — 240) *640 (530 — 780)*
P7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	185 (150 — 220) *610 (500 — 720)*
P8	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	175 (140 — 210) *570 (460 — 680)*
P11	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	155 (130 — 180) *510 (430 — 590)*
P12	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,060 *0.0024*	0,075 *0.0030*	0,090 *0.0036*	95 (78 — 110) *310 (260 — 360)*
M1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	185 (160 — 210) *610 (530 — 680)*
M2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	150 (130 — 170) *490 (430 — 550)*
M3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	120 (95 — 140) *395 (320 — 450)*
M4	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	90 (71 — 110) *295 (240 — 360)*
M5	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	75 (59 — 92) *245 (200 — 300)*
K1	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	360 (310 — 410) *1175 (1100 — 1300)*
K2	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	310 (270 — 350) *1025 (890 — 1100)*
K3	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	265 (230 — 300) *870 (760 — 980)*
K4	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	250 (220 — 280) *820 (730 — 910)*
K5	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	100 (79 — 120) *330 (260 — 390)*
K6	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	150 (120 — 180) *490 (400 — 590)*
K7	E/M/A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	130 (110 — 160) *425 (370 — 520)*
N1	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	510 (390 — 630) *1675 (1300 — 2000)*
N2	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	330 (250 — 400) *1075 (830 — 1300)*
N3	E/M/A	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	220 (170 — 270) *720 (560 — 880)*
N11	E/M/A	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	405 (270 — 530) *1325 (890 — 1700)*
S1	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	110 (66 — 150) *360 (220 — 490)*
S2	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	90 (53 — 120) *295 (180 — 390)*
S3	E	0,050 *0.050*	0,65 *0.65*	0,060 *0.0024*	0,070 *0.0028*	0,095 *0.0038*	75 (46 — 100) *245 (160 — 320)*
S11	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	175 (130 — 220) *570 (430 — 720)*
S12	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	135 (95 — 170) *445 (320 — 550)*
S13	E	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	105 (74 — 130) *345 (250 — 420)*
TS1	A/D	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	320 (200 — 440) *1050 (660 — 1400)*
TP1	A/D	0,10 *0.10*	0,65 *0.65*	0,10 *0.0040*	0,12 *0.0048*	0,15 *0.0060*	320 (200 — 440) *1050 (660 — 1400)*
GR1	A/D	0,10 *0.10*	0,65 *0.65*	0,070 *0.0028*	0,085 *0.0034*	0,11 *0.0044*	850 (710 — 980) *2800 (2400 — 3200)*

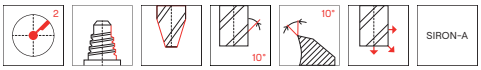
XVC506/509/512
Allgemeine Anwendung – Universell – Fase – 2 Schneiden





N

—Toleranzen:
—SIG= ±1°



Bezeichnung	Produktnummer	Längenindex	Werkzeugform	CZCMS	DC	DCSFMS	APMXS	LF	PCEDC	SW	Beschichtung
					mm	mm	mm	mm			SIRA
XVC506E10100N1SZ2	10138012	1	N	E10	1,5	9,7	7,23	11,8	2	6,0	■
XVC509E10100N1SZ2	10138014	1	N	E10	1,5	9,7	4,23	11,8	2	6,0	■
XVC506E12120N1SZ2	10138013	1	N	E12	1,5	11,7	7,73	14,0	2	8,0	■
XVC509E12120N1SZ2	10138015	1	N	E12	1,5	11,7	5,23	14,0	2	8,0	■
XVC512E12120N1SZ2	10138017	1	N	E12	1,5	11,7	3,03	14,0	2	8,0	■
XVC509E16160N1SZ2	10138016	1	N	E16	1,5	15,5	7,23	18,1	2	10,0	■

■ **Lagerstandard.**

Schnittdaten – XVC506 Anfasen

SMG		a_e/DC	a_p/DC	f_z		v_c
				10	12	
P1	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,25 *0.010*	0,26 *0.010*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,25 *0.010*	0,26 *0.010*	195 (180 — 220) *640 (600 — 720)*
P3	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	150 (130 — 160) *490 (430 — 520)*
P5	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	150 (140 — 170) *490 (460 — 550)*
P6	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,24 *0.0095*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,24 *0.0095*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,26 *0.010*	150 (140 — 170) *490 (460 — 550)*
P11	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,24 *0.0095*	105 (86 — 120) *345 (290 — 390)*
P12	E/M/A/D	0,10 *0.10*	1,6 *1.6*	0,15 *0.0060*	0,16 *0.0065*	65 (52 — 76) *215 (180 — 240)*
M1	E/M/A	0,10 *0.10*	2,0 *2.0*	0,26 *0.010*	0,28 *0.011*	125 (99 — 140) *410 (330 — 450)*
M2	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	100 (80 — 120) *330 (270 — 390)*
M3	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	65 (45 — 84) *215 (150 — 270)*
M4	E/M/A	0,10 *0.10*	1,5 *1.5*	0,19 *0.0075*	0,20 *0.0080*	47 (33 — 60) *155 (110 — 190)*
M5	E/M/A	0,10 *0.10*	1,5 *1.5*	0,19 *0.0075*	0,20 *0.0080*	39 (27 — 50) *130 (89 — 160)*
K1	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,25 *0.010*	0,26 *0.010*	200 (180 — 220) *660 (600 — 720)*
K2	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	175 (160 — 190) *570 (530 — 620)*
K3	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	150 (130 — 160) *490 (430 — 520)*
K4	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	140 (130 — 150) *460 (430 — 490)*
K5	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	85 (74 — 95) *280 (250 — 310)*
K6	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	125 (110 — 140) *410 (370 — 450)*
K7	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	110 (94 — 120) *360 (310 — 390)*
N1	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	600 (500 — 690) *1975 (1700 — 2200)*
N2	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	385 (330 — 440) *1275 (1100 — 1400)*
N3	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	255 (220 — 290) *840 (730 — 950)*
N11	E/M/A	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	400 (350 — 450) *1300 (1200 — 1400)*
S1	E	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,13 *0.0050*	43 (15 — 71) *140 (50 — 230)*
S2	E	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,13 *0.0050*	35 (12 — 57) *115 (40 — 180)*
S3	E	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,12 *0.0048*	30 (10 — 49) *100 (33 — 160)*
S11	E	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	95 (72 — 120) *310 (240 — 390)*
S12	E	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	75 (55 — 94) *245 (190 — 300)*
S13	E	0,10 *0.10*	1,7 *1.7*	0,19 *0.0075*	0,20 *0.0080*	55 (43 — 72) *180 (150 — 230)*
H5	M/A	0,050 *0.050*	2,0 *2.0*	0,11 *0.0044*	0,12 *0.0048*	120 (110 — 140) *395 (370 — 450)*
H8	M/A	0,050 *0.050*	1,8 *1.8*	0,080 *0.0032*	0,085 *0.0034*	120 (99 — 130) *395 (330 — 420)*
H21	M/A	0,050 *0.050*	1,8 *1.8*	0,080 *0.0032*	0,085 *0.0034*	120 (99 — 130) *395 (330 — 420)*
H31	M/A	0,050 *0.050*	1,8 *1.8*	0,070 *0.0028*	0,075 *0.0030*	90 (75 — 100) *295 (250 — 320)*
TS1	A/D	0,10 *0.10*	2,0 *2.0*	0,17 *0.0065*	0,18 *0.0070*	260 (160 — 360) *850 (530 — 1100)*
TP1	A/D	0,10 *0.10*	2,0 *2.0*	0,17 *0.0065*	0,18 *0.0070*	260 (160 — 360) *850 (530 — 1100)*

Schnittdaten – XVC509 Anfasen

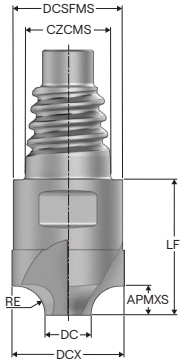
SMG		a_e/DC	a_p/DC	f_z			v_c
				10	12	16	
P1	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	0,28 *0.011*	200 (180 — 220) *660 (600 — 720)*
P2	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	195 (180 — 220) *640 (600 — 720)*
P3	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,24 *0.0095*	0,26 *0.010*	170 (150 — 190) *560 (500 — 620)*
P4	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	150 (130 — 160) *490 (430 — 520)*
P5	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	150 (140 — 170) *490 (460 — 550)*
P6	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	170 (150 — 190) *560 (500 — 620)*
P7	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	160 (140 — 180) *520 (460 — 590)*
P8	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,25 *0.010*	0,28 *0.011*	150 (130 — 160) *490 (430 — 520)*
P11	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	105 (85 — 120) *345 (280 — 390)*
P12	E/M/A/D	0,10 *0.10*	1,6 *1.6*	0,14 *0.0055*	0,15 *0.0060*	0,17 *0.0065*	60 (50 — 74) *195 (170 — 240)*
M1	E/M/A	0,10 *0.10*	2,0 *2.0*	0,25 *0.010*	0,26 *0.010*	0,28 *0.011*	120 (98 — 140) *395 (330 — 450)*
M2	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	100 (80 — 120) *330 (270 — 390)*
M3	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	65 (45 — 84) *215 (150 — 270)*
M4	E/M/A	0,10 *0.10*	1,5 *1.5*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	46 (33 — 60) *150 (110 — 190)*
M5	E/M/A	0,10 *0.10*	1,5 *1.5*	0,18 *0.0070*	0,19 *0.0075*	0,20 *0.0080*	39 (27 — 50) *130 (89 — 160)*
K1	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,24 *0.0095*	0,26 *0.010*	0,28 *0.011*	200 (180 — 220) *660 (600 — 720)*
K2	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	175 (160 — 190) *570 (530 — 620)*
K3	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	145 (130 — 160) *475 (430 — 520)*
K4	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	140 (130 — 150) *460 (430 — 490)*
K5	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	85 (74 — 95) *280 (250 — 310)*
K6	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	125 (110 — 130) *410 (370 — 420)*
K7	E/M/A/D	0,10 *0.10*	2,0 *2.0*	0,20 *0.0080*	0,22 *0.0085*	0,24 *0.0095*	110 (94 — 120) *360 (310 — 390)*
N1	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	600 (500 — 700) *1975 (1700 — 2200)*
N2	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	385 (330 — 450) *1275 (1100 — 1400)*
N3	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	255 (220 — 300) *840 (730 — 980)*
N11	E/M/A	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	400 (350 — 450) *1300 (1200 — 1400)*
S1	E	0,10 *0.10*	2,0 *2.0*	0,13 *0.0050*	0,13 *0.0050*	0,15 *0.0060*	43 (15 — 71) *140 (50 — 230)*
S2	E	0,10 *0.10*	2,0 *2.0*	0,13 *0.0050*	0,13 *0.0050*	0,15 *0.0060*	35 (12 — 57) *115 (40 — 180)*
S3	E	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,12 *0.0048*	0,14 *0.0055*	30 (10 — 50) *100 (33 — 160)*
S11	E	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	100 (72 — 120) *330 (240 — 390)*
S12	E	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	75 (55 — 94) *245 (190 — 300)*
S13	E	0,10 *0.10*	1,7 *1.7*	0,19 *0.0075*	0,20 *0.0080*	0,22 *0.0085*	55 (42 — 72) *180 (140 — 230)*
H5	M/A	0,10 *0.10*	2,0 *2.0*	0,12 *0.0048*	0,12 *0.0048*	0,14 *0.0055*	120 (110 — 140) *395 (370 — 450)*
H8	M/A	0,10 *0.10*	1,8 *1.8*	0,085 *0.0034*	0,090 *0.0036*	0,10 *0.0040*	120 (99 — 130) *395 (330 — 420)*
H21	M/A	0,10 *0.10*	1,8 *1.8*	0,085 *0.0034*	0,090 *0.0036*	0,10 *0.0040*	120 (99 — 130) *395 (330 — 420)*
H31	M/A	0,10 *0.10*	1,8 *1.8*	0,075 *0.0030*	0,080 *0.0032*	0,085 *0.0034*	90 (75 — 100) *295 (250 — 320)*
TS1	A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	250 (150 — 350) *820 (500 — 1100)*
TP1	A/D	0,10 *0.10*	2,0 *2.0*	0,22 *0.0085*	0,24 *0.0095*	0,26 *0.010*	250 (150 — 350) *820 (500 — 1100)*

Schnittdaten – XVC512 Anfasen

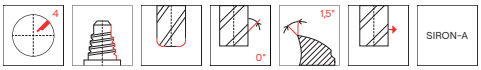
SMG		a_e/DC	a_p/DC	f_z	v_c
				12	
P1	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,36 *0.014*	165 (150 — 180) *540 (500 — 590)*
P2	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,36 *0.014*	160 (140 — 170) *520 (460 — 550)*
P3	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	135 (120 — 150) *445 (400 — 490)*
P4	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	120 (110 — 130) *395 (370 — 420)*
P5	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	120 (110 — 130) *395 (370 — 420)*
P6	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	135 (120 — 150) *445 (400 — 490)*
P7	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	125 (120 — 140) *410 (400 — 450)*
P8	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	120 (110 — 130) *395 (370 — 420)*
P11	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	85 (68 — 100) *280 (230 — 320)*
P12	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,22 *0.0085*	50 (41 — 61) *165 (140 — 200)*
M1	E/M/A	0,10 *0.10*	1,3 *1.3*	0,36 *0.014*	100 (80 — 110) *330 (270 — 360)*
M2	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	80 (65 — 96) *260 (220 — 310)*
M3	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	50 (37 — 68) *165 (130 — 220)*
M4	E/M/A	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	39 (28 — 51) *130 (92 — 160)*
M5	E/M/A	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	33 (23 — 42) *110 (76 — 130)*
K1	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,36 *0.014*	160 (140 — 180) *520 (460 — 590)*
K2	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	140 (130 — 150) *460 (430 — 490)*
K3	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	115 (110 — 130) *375 (370 — 420)*
K4	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	110 (98 — 120) *360 (330 — 390)*
K5	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	65 (58 — 75) *215 (200 — 240)*
K6	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,32 *0.013*	100 (86 — 110) *330 (290 — 360)*
K7	E/M/A/D	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	85 (74 — 96) *280 (250 — 310)*
N1	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	480 (410 — 560) *1575 (1400 — 1800)*
N2	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	310 (260 — 360) *1025 (860 — 1100)*
N3	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	205 (180 — 240) *670 (600 — 780)*
N11	E/M/A	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	320 (290 — 360) *1050 (960 — 1100)*
S1	E	0,10 *0.10*	1,3 *1.3*	0,19 *0.0075*	35 (12 — 58) *115 (40 — 190)*
S2	E	0,10 *0.10*	1,3 *1.3*	0,19 *0.0075*	29 (9,6 — 47) *95 (32 — 150)*
S3	E	0,10 *0.10*	1,3 *1.3*	0,17 *0.0065*	25 (8,3 — 41) *80 (28 — 130)*
S11	E	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	80 (58 — 98) *260 (200 — 320)*
S12	E	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	60 (45 — 76) *195 (150 — 240)*
S13	E	0,10 *0.10*	1,3 *1.3*	0,30 *0.012*	47 (35 — 59) *155 (120 — 190)*
H5	M/A	0,10 *0.10*	1,3 *1.3*	0,17 *0.0065*	100 (83 — 110) *330 (280 — 360)*
H8	M/A	0,10 *0.10*	1,3 *1.3*	0,13 *0.0050*	100 (84 — 110) *330 (280 — 360)*
H21	M/A	0,10 *0.10*	1,3 *1.3*	0,13 *0.0050*	100 (84 — 110) *330 (280 — 360)*
H31	M/A	0,10 *0.10*	1,3 *1.3*	0,11 *0.0044*	75 (64 — 88) *245 (210 — 280)*
TS1	A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	200 (130 — 280) *660 (430 — 910)*
TP1	A/D	0,10 *0.10*	1,3 *1.3*	0,34 *0.013*	200 (130 — 280) *660 (430 — 910)*

XVK310
Allgemeine Anwendung – Universell – Konkav – 4 Schneiden





– Toleranzen:
– RE= ≤5= ±0,05 mm
– RE= >5= ±0,1 mm



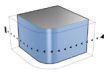
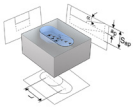
Bezeichnung	Produkt-nummer	Längen-index	Werkzeug-form	CZCMS	DC	DCSFMS	APMXS	LF	RE	PCEDC	SW	Beschichtung
					mm	mm	mm	mm	mm			SIRA
XVK310E12120D1K400Z4	10137999	1	D	E12	4,0	11,7	4,0	14,5	4,0	4	10,0	■
XVK310E12120D1K300Z4	10137998	1	D	E12	5,0	11,7	3,0	14,5	3,0	4	10,0	■
XVK310E16160D1K500Z4	10138000	1	D	E16	6,0	15,5	5,0	18,7	5,0	4	12,0	■
XVK310E20200D1K600Z4	10138001	1	D	E20	8,0	19,3	6,0	21,3	6,0	4	16,0	■

■ **Lagerstandard.**

Schnittdaten – XVK310 Eckfräsen/Schruppen

SMG		a_p/D_c	f_z			v_c
			12	16	20	
P1	E/M/A/D	0,24 *0,24*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	290 (195 — 310) *950 (640 — 1100)*
P2	E/M/A/D	0,24 *0,24*	0,050 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	280 (190 — 305) *910 (620 — 1000)*
P3	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	240 (165 — 260) *790 (540 — 850)*
P4	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	210 (145 — 230) *680 (475 — 760)*
P5	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
P6	E/M/A/D	0,24 *0,24*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	230 (155 — 245) *760 (510 — 800)*
P7	E/M/A/D	0,24 *0,24*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	215 (145 — 230) *710 (475 — 760)*
P8	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (140 — 220) *670 (460 — 730)*
P11	E/M/A/D	0,24 *0,24*	0,044 *0,0017*	0,060 *0,0024*	0,075 *0,003*	210 (140 — 225) *680 (460 — 740)*
M1	E/M/A	0,24 *0,24*	0,050 *0,0022*	0,065 *0,0026*	0,080 *0,0032*	255 (170 — 270) *840 (560 — 890)*
M2	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
M3	E/M/A	0,24 *0,24*	0,036 *0,0014*	0,048 *0,0019*	0,060 *0,0024*	150 (105 — 165) *490 (345 — 540)*
M4	E/M/A	0,24 *0,24*	0,032 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	110 (75 — 120) *360 (250 — 400)*
M5	E/M/A	0,24 *0,24*	0,032 *0,0013*	0,042 *0,0017*	0,050 *0,0022*	95 (65 — 100) *310 (220 — 320)*
K1	E/M/A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
K2	E/M/A/D	0,24 *0,24*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	175 (120 — 190) *570 (400 — 620)*
K3	E/M/A/D	0,24 *0,24*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	150 (100 — 160) *490 (320 — 530)*
K4	E/M/A/D	0,24 *0,24*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	140 (95 — 150) *460 (310 — 490)*
K5	E/M/A/D	0,24 *0,24*	0,036 *0,0014*	0,050 *0,0022*	0,060 *0,0024*	85 (55 — 90) *280 (180 — 300)*
K6	E/M/A/D	0,24 *0,24*	0,040 *0,0016*	0,055 *0,0022*	0,065 *0,0026*	125 (85 — 135) *410 (280 — 445)*
K7	E/M/A/D	0,24 *0,24*	0,036 *0,0014*	0,050 *0,0022*	0,060 *0,0024*	105 (70 — 115) *345 (220 — 375)*
N1	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	315 (215 — 340) *1025 (710 — 1125)*
N2	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
N3	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	135 (90 — 145) *445 (300 — 475)*
N11	E/M/A	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
S1	E	0,24 *0,24*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	205 (140 — 220) *670 (460 — 730)*
S2	E	0,24 *0,24*	0,048 *0,0019*	0,065 *0,0026*	0,080 *0,0032*	205 (140 — 220) *670 (460 — 730)*
S3	E	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
S11	E	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	265 (180 — 285) *870 (590 — 940)*
S12	E	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
S13	E	0,24 *0,24*	0,040 *0,0016*	0,050 *0,0022*	0,065 *0,0026*	155 (105 — 165) *510 (345 — 540)*
TS1	A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
TP1	A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*
GR1	A/D	0,24 *0,24*	0,046 *0,0018*	0,060 *0,0024*	0,075 *0,003*	205 (135 — 220) *670 (445 — 730)*

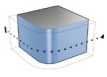
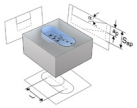
Berechnungen

Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen.										Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen.				
	Nutfräsen		Eckfräsen/Schruppen			Eckfräsen/Schlichten				Einwärtskopieren		Walzenstirnfräsen		
Gerade														
	a_p	f_z	a_e	f_z	a_p	v_c	a_e	f_z	a_p	a_p	f_z	f_z	a_p/360° (% DC)	Bohrung Ø (≥ % DC)
										≤ 30° *				
C5121														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	70%	80%	100%	80%	100%	80%	100%	80%	100%	100%	100%	100%	100%	170%
LV3	60%	64%	100%	64%	100%	64%	100%	64%	100%	100%	85%	85%	100%	170%
LV4	x	x	100%	52%	100%	52%	100%	52%	100%	100%	75%	75%	100%	170%
LV5	x	x	100%	40%	100%	40%	100%	40%	100%	100%	65%	65%	100%	170%
LV6	x	x	100%	33%	100%	33%	100%	33%	100%	100%	55%	55%	100%	170%
LV7	x	x	100%	26%	100%	26%	100%	26%	100%	100%	45%	45%	100%	170%
LV8	x	x	100%	21%	100%	21%	100%	21%	100%	100%	35%	35%	100%	170%
										≤ 10° *				
C5131														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	70%	80%	100%	80%	100%	80%	100%	80%	100%	100%	100%	100%	100%	170%
LV3	60%	64%	100%	64%	100%	64%	100%	64%	100%	100%	85%	85%	100%	170%
LV4	x	x	100%	52%	100%	52%	100%	52%	100%	100%	75%	75%	100%	170%
										≤ 30° *				
C5141														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	70%	80%	100%	80%	100%	80%	100%	80%	100%	100%	100%	100%	100%	170%
LV3	60%	64%	100%	64%	100%	64%	100%	64%	100%	100%	85%	85%	100%	170%
LV4	x	x	100%	52%	100%	52%	100%	52%	100%	100%	75%	75%	100%	170%
LV5	x	x	100%	40%	100%	40%	100%	40%	100%	100%	65%	65%	100%	170%
LV6	x	x	100%	33%	100%	33%	100%	33%	100%	100%	55%	55%	100%	170%
LV7	x	x	100%	26%	100%	26%	100%	26%	100%	100%	45%	45%	100%	170%
LV8	x	x	100%	21%	100%	21%	100%	21%	100%	100%	35%	35%	100%	170%
LV9	x	x	100%	17%	100%	17%	100%	17%	100%	100%	25%	25%	100%	170%
										≤ 10° *				
C5231														
LV2	100%	100%	100%	100%	100%	100%	80%	100%	80%	100%	100%	100%	100%	100%
LV3	70%	80%	100%	80%	100%	80%	64%	100%	64%	100%	100%	85%	85%	100%
										≤ 10° *				
ST5541														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	70%	90%	100%	85%	70%	90%	100%	85%	100%	100%	85%	85%	100%	170%
LV3	50%	70%	100%	75%	50%	80%	100%	75%	100%	100%	75%	75%	100%	170%
LV4	x	x	100%	65%	40%	70%	100%	65%	100%	100%	65%	65%	100%	170%
										≤ 10° *				
ST5551														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	75%	80%	100%	85%	75%	90%	100%	85%	100%	100%	85%	85%	100%	170%
LV3	x	x	100%	70%	55%	85%	100%	70%	100%	100%	70%	70%	100%	170%
LV4	x	x	100%	55%	25%	75%	100%	55%	100%	100%	55%	55%	100%	170%
LV5	x	x	100%	40%	20%	70%	100%	40%	100%	100%	40%	40%	100%	170%
LV6	x	x	100%	30%	15%	65%	100%	35%	100%	100%	35%	35%	100%	170%
LV8	x	x	100%	15%	10%	60%	100%	25%	100%	100%	25%	25%	100%	170%

* Max. Einwärtskopierwinkel

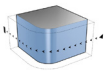
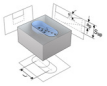
Prozentuale Werte, bezogen auf die Original-Schnittdaten.

Berechnungen

Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen.										Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen.						
	Nutfräsen		Eckfräsen/Schruppen			Eckfräsen/Schlichten				Einwärtskopieren		Walzenstirnfräsen			Bohren	
Gerade																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% DC)	Bohrung Ø (≥ % DC)	f_z	a_p (% DC)
										≤ 30° *						
JS412																
LV2	100	100	100	100	100	140	3	40	120	80	100	50	10	130	50	100
										≤ 10° *						
JS413																
LV2	100	100	100	100	100	150	3	40	120	70	50	50	10	130	X	X
LV3	X	X	25	60	240	120	3	40	230	70	50	50	10	130	X	X
										≤ 30° *						
JS452																
LV2	100	100	100	100	100	140	3	35	120	70	100	50	10	130	50	100
LV3	50	60	75	60	50	120	3	40	100	70	70	50	10	130	20	10
										≤ 10° *						
JS453																
LV2	100	100	100	100	100	140	3	35	120	70	50	50	10	130	20	10
LV3	X	X	25	60	240	120	3	40	230	70	70	50	10	130	20	10
										≤ 30° *						
S4521																
LV2	100	100	100	100	100	140	3	35	120	70	100	50	10	130	50	100
LV3	50	60	75	60	50	120	3	40	100	70	70	50	10	130	20	10
										≤ 30° *						
S4531																
LV2	100	100	100	100	100	140	3	35	120	70	100	50	10	130	50	100
LV3	X	X	25	60	240	120	3	40	100	70	70	50	10	130	20	10
										≤ 30° *						
S4651																
LV2	X	X	100	100	100	140	3	35	100	X	X	100	2	130	X	X
LV4	X	X	100	85	200	120	3	40	200	X	X	60	1,5	130	X	X
										≤ 30° *						
JSE512																
LV2	100	100	100	100	100	110	3	65	125	40	40	100	5	130	40	40
										≤ 5° *						
JSE513																
LV2	100	100	100	100	100	110	3	85	150	100	100	100	5	130	50	40
LV3	30	100	30	50	200	110	3	85	250	X	X	X	X	X	X	X
LV4	X	X	X	X	X	60	3	80	350	X	X	X	X	X	X	X
										≤ 5° *						
JSE514																
LV1	100	100	100	100	100	110	3	60	150	100	100	100	5	130	X	X
LV2	100	100	100	100	100	110	3	60	150	100	100	100	5	130	X	X
LV3	X	X	25	50	200	110	3	60	250	X	X	X	X	X	X	X
LV4	X	X	X	X	X	60	3	80	350	X	X	X	X	X	X	X
										≤ 45° *						
JS553																
LV1	100	100	100	100	100	110	3	55	150	50	55	35	3	130	35	50
LV2	100	100	100	100	100	110	3	55	150	50	55	35	3	130	35	50
LV3	40	60	40	105	200	110	3	55	250	50	15	35	3	130	35	50
										≤ 5° *						
JS554																
LV1	100	100	100	100	100	110	3	53	150	100	100	100	3	130	X	X
LV2	100	100	100	100	100	110	3	53	150	100	100	100	3	130	X	X
LV3	40	60	38	105	200	110	3	53	250	50	50	60	3	130	X	X
JS564																
LV2	X	X	100	100	100	110	3	55	100	X	X	100	2	130	X	X
LV3	X	X	38	105	140	110	3	55	140	X	X	60	1,5	130	X	X
LV4	X	X	38	100	200	110	3	55	200	X	X	X	X	X	X	X
JS565																
LV2	X	X	100	100	100	110	3	55	100	X	X	100	2	130	X	X
LV3	X	X	38	100	140	110	3	55	140	X	X	60	1,5	130	X	X
LV4	X	X	38	100	200	110	3	55	200	X	X	X	X	X	X	X

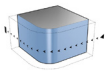
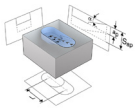
* Max. Einwärtskopierwinkel
Prozentuale Werte, bezogen auf die Original-Schnittdaten.

Berechnungen

Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen.										Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen.						
	Nutfräsen		Eckfräsen/Schruppen			Eckfräsen/Schlichten				Einwärtskopieren		Walzenstirnfräsen			Bohren	
Gerade																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% DC)	Bohrung Ø (≥ % DC)	f_z	a_p (% DC)
										≤ 45° *						
J28																
LV2	100	100	100	100	100	140	3	100	135	40	25	100	10	130	25	60
										≤ X° *						
J36																
LV2	X	X	100	100	100	120	3	85	150	X	X	X	X	X	X	X
										≤ 20° *						
J93F																
LV2	100	100	100	100	100	133	3	40	100	100	100	100	3	130	25	30
										≤ 1°						
JH120																
LV2	100	100	100	100	100	120	3	120	80	17	100	100	2	130	X	X
										≤ X° *						
JH130																
LV2	X	X	100	100	100	120	3	120	80	X	X	X	X	X	X	X
										≤ X° *						
JH142																
LV2	X	X	100	100	100	110	3	80	70	X	X	30	2	130	X	X
LV3	X	X	100	100	100	110	3	80	70	X	X	20	1	130	X	X
LV6	X	X	100	100	100	110	3	80	70	X	X	10	1	130	X	X
										≤ 45° *						
JH830																
LV2	100	100	100	100	100	110	3	110	80	9	135	135	3	130	X	X
										≤ X° *						
JH910																
LV2	100	100	100	100	100	125	4	100	80	15	140	140	3	130	X	X
LV3	80	80	100	80	80	125	4	80	65	10	110	110	3	130	X	X
										≤ X° *						
JH930																
LV2	X	X	100	100	100	125	2	30	100	X	X	X	X	X	X	X

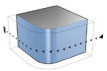
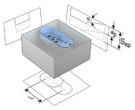
* Max. Einwärtskopierwinkel
Prozentuale Werte, bezogen auf die Original-Schnittdaten.

Berechnungen

Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen.										Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen.						
	Nutfräsen		Eckfräsen/Schruppen			Eckfräsen/Schlichten				Einwärtskopieren		Walzenstirnfräsen			Bohren	
Gerade																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% DC)	Bohrung Ø (≥ % DC)	f_z	a_p (% DC)
										≤ 5° *						
JH40																
LV2	100	100	100	100	100	100	3	35	100	83	55	55	25	130	55	80
LV3	100	100	100	100	100	100	3	35	100	83	55	55	25	130	55	80
										≤ 45° *						
JH410																
LV2	100	100	100	100	100	125	2	25	100	100	67	67	40	130	67	80
LV2 (ML)	75	60	80	60	100	125	2	25	100	60	40	40	40	130	40	50
LV2 (TL)	125	100	100	100	100	100	2	100	100	100	50	100	40	130	150	80
LV2 (RS)	125	100	100	100	100	100	2	100	100	100	50	100	40	130	150	80
LV3 (RS)	95	95	80	100	100	100	2	100	100	50	50	50	40	130	75	40
										≤ 45° *						
JH421																
LV2	100	100	100	100	100	100	4	35	100	100	100	100	25	130	45	80
										≤ 30° *						
JH440																
LV2	100	100	100	100	100	125	3	40	100	100	100	100	5	130	X	X
										≤ 5° *						
JHP750																
LV1	115	120	115	115	100	100	2	145	100	100	120	120	3	130	10	70
LV2	100	100	100	100	100	100	2	145	100	100	100	100	3	130	10	60
										≤ 5° *						
JHP951																
LV2	100	100	100	100	100	158	2	50	113	20	100	125	3	130	6	20
										≤ 10° *						
JHP993																
LV2	100	100	100	100	100	X	X	X	X	30	100	100	3	130	4	40
LV3	80	80	80	80	80	X	X	X	X	20	80	80	3	130	3	30
										≤ X° *						
JS520																
LV2	X	X	100	100	100	133	2	65	100	X	X	X	X	X	X	X
LV3	X	X	X	X	X	133	2	65	175	X	X	X	X	X	X	X
										≤ X° *						
JS522																
LV4	X	X	100	100	100	129	2	140	100	X	X	X	X	X	X	X
JS720																
LV2	X	X	100	100	100	110	2	65	100	X	X	100	2	130	X	X
LV3	X	X	100	100	100	110	2	65	100	X	X	100	2	130	X	X
JS754																
LV1	100	100	100	100	100	110	3	55	150	100	100	100	3	130		
LV2	100	100	100	100	100	110	3	55	150	100	100	100	3	130	X	X
LV3	40	60	38	105	200	110	3	55	250	50	50	60	3	130		
JS755																
LV2	100	100	100	100	100	110	3	55	150	100	100	100	3	130	X	X
LV3	40	60	38	105	100	110	3	55	250	50	50	60	3	130		

* Max. Einwärtskopierwinkel
Prozentuale Werte, bezogen auf die Original-Schnittdaten.

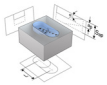
Berechnungen

Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen.										Original-Schnittdaten zum Eckfräsen einsetzen, danach Parameter neu berechnen.						
	Nutfräsen		Eckfräsen/Schruppen			Eckfräsen/Schlichten				Einwärtskopieren		Walzenstirnfräsen			Bohren	
Gerade																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% DC)	Bohrung Ø (≥ % DC)	f_z	a_p (% DC)
										≤ X°						
JME542-JME562-JME564																
LV1	100	100	100	100	100	125	2	150	5	X	X	X	X	X	X	X
LV2	63	100	100	100	65	125	2	150	3	X	X	X	X	X	X	X
LV3	25	100	100	100	25	125	2	150	1	X	X	X	X	X	X	X
LV4 (TL)	18	100	100	100	20	125	2	150	1	X	X	X	X	X	X	X
LV4 (XL)	12	100	100	100	10	125	2	150	1	X	X	X	X	X	X	X
LV5	10	100	100	100	10	125	2	150	1	X	X	X	X	X	X	X
LV6	4	100	100	100	5	125	2	150	1	X	X	X	X	X	X	X
LV7	2	100	100	100	2	125	2	150	1	X	X	X	X	X	X	X
										≤ X°						
JME142-JME144																
LV1	100	100	100	100	100	100	2	150	5	X	X	X	X	X	X	X
LV2	85	85	100	100	63	100	2	150	3	X	X	X	X	X	X	X
LV3	75	75	100	100	25	100	2	150	1	X	X	X	X	X	X	X
LV4	60	60	100	100	20	100	2	150	1	X	X	X	X	X	X	X
LV5	50	50	100	100	10	100	2	150	1	X	X	X	X	X	X	X
LV6	40	40	100	100	5	100	2	150	1	X	X	X	X	X	X	X
										≤ X° *						
JM403-JM404-JM406																
LV1	100	100	100	100	100	X	X	X	X	X	X	X	X	X	X	X
LV2	100	75	100	75	100	X	X	X	X	X	X	X	X	X	X	X
LV3 (L)	100	75	100	75	90	X	X	X	X	X	X	X	X	X	X	X
LV3 (TL)	90	75	100	75	70	X	X	X	X	X	X	X	X	X	X	X
LV4 (XL)	75	75	100	75	70	X	X	X	X	X	X	X	X	X	X	X
LV4 (SL)	75	75	100	75	45	X	X	X	X	X	X	X	X	X	X	X
LV5	50	50	100	50	30	X	X	X	X	X	X	X	X	X	X	X
JME642																
LV1	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X
LV5	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X
LV6	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X
LV7	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X
										≤2						
JC898																
LV3	X	X	100	100	100	X	X	X	X	X	50	80	3	130-160	X	X
										≤5°						
JC899																
LV3	X	X	100	100	100	100	3	50	100	X	X	X	X	X	X	X

* Max. Einwärtskopierwinkel

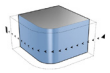
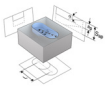
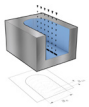
Prozentuale Werte, bezogen auf die Original-Schnittdaten.

Berechnungen

Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen.										Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen.						
	Nutfräsen		Eckfräsen/Schruppen			Eckfräsen/Schlichten				Einwärtskopieren		Walzenstirnfräsen			Bohren	
Gerade																
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% DC)	Bohrung Ø (≥ % DC)	f_z	a_p (% DC)
										≤ 1°						
JHP170																
LV2	100	100	100	100	100	130	3	175	80	100	100	100	2	130	X	X
										≤ 30°						
										≤ 30°						
HP4931																
LV2	100	100	100	100	100	X	X	X	X	50	50	50	5	130	30	50
LV3	100	100	100	100	100	X	X	X	X	50	50	50	5	130	30	50
LV4	100	75	100	75	100	X	X	X	X	50	50	50	5	130	30	50
										≤ 5°						
S4931																
LV3	100	100	100	100	100	X	X	X	X	50	50	50	5	130	X	X
LV4	100	75	100	75	100	X	X	X	X	50	50	50	5	130	X	X
LV5	100	75	100	75	100	X	X	X	X	50	50	50	5	130	X	X
										≤ 5°						
JHP760																
LV2	100	100	100	100	100	140	2	125	15	30	100	100	3	130	10	50
LV3	50	50	100	50	50	140	2	125	15	15	50	50	3	130	5	25
										≤ 15°						
JHP770																
LV2	100	100	100	100	100	170	3	125	100	100	40	40	3	130	X	X
										≤ 5°						
JHP780																
LV1	100	100	100	100	100	160	2	135	140	100	100	35	3	130	35	50
LV2	100	100	100	100	100	160	2	135	140	100	100	35	3	130	35	50
JD620																
LV2	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV4	20	100	60	100	60	100	2	110	4	X	X	X	X	X	X	X
										≤ X°						
JD630																
LV2	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV4	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
										≤ X°						
JD640																
LV2	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X
LV4	100	100	100	100	100	100	2	110	4	X	X	X	X	X	X	X

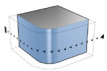
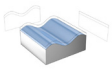
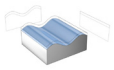
* Max. Einwärtskopierwinkel
Prozentuale Werte, bezogen auf die Original-Schnittdaten.

Berechnungen

Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen.										Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen.								
	Nutfräsen		Eckfräsen/Schruppen			Eckfräsen/Schlichten				Einwärtskopieren		Walzenstirnfräsen			Tauchfräsen			
Gerade																		
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% DC)	f_z	a_p	a_p	f_z	f_z	a_p/360° (% DC)	Bohrung Ø (≥ % DC)	v_c	a_e (% DC)	f_z	a_e-sd (% DC)
JHF181																		
LV1	100	100	100	100	100	X	X	X	X	X	X	100	3,4	130	X	X	X	X
LV2	80	85	100	85	80	X	X	X	X	X	X	85	3,0	130	X	X	X	X
LV3	60	70	100	70	60	X	X	X	X	X	X	70	2,5	130	X	X	X	X
										≤ 1,5° *								
JHF980																		
LV1	100	100	100	100	100	X	X	X	X	100	100	100	3	130	70	30	33	200
LV2	100	100	100	100	100	X	X	X	X	100	100	100	3	130	70	30	33	200
LV3	80	85	80	85	80	X	X	X	X	80	85	85	3	130	70	30	33	200
LV4	50	70	50	70	60	X	X	X	X	60	70	70	3	130	70	30	33	200

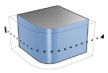
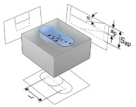
* Max. Einwärtskopierwinkel
Prozentuale Werte, bezogen auf die Original-Schnittdaten.

Berechnungen

KUGELKOPF	Original-Schnittdaten einsetzen, danach Parameter neu berechnen.									Original-Schnittdaten zum Nutzfräsen einsetzen, danach Parameter neu berechnen.									
	Nutfräsen		Eckfräsen/Schruppen			Eckfräsen/Schlichten				Kopierfräsen/Schruppen			Kopierfräsen/ Feinbearbeitung				Walzenstirnfräsen		
																			
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% DC)	f_z	a_p	a_e	f_z	a_p	v_c	a_e (% DC)	f_z	a_p	f_z	a_p/360° (% DC)	
JSB512																			
LV2	X	X	100	100	100	125	3	125	10	X	X	X	X	X	X	X	100	5	130
JS532																			
LV1	X	X	100	100	100	125	3	125	10	X	X	X	X	X	X	X	75	5	130
LV2	X	X	70	100	70	125	3	125	10	X	X	X	X	X	X	X	75	5	130
LV3	X	X	X	X	X	125	3	125	10	X	X	X	X	X	X	X	X	X	X
JS533																			
LV1	X	X	100	100	100	125	3	125	15	X	X	X	X	X	X	X	75	5	130
LV2	X	X	75	75	75	125	3	125	15	X	X	X	X	X	X	X	75	5	130
JS534																			
LV1	X	X	100	100	100	125	3	170	20	X	X	X	X	X	X	X	100	3	130
LV2	X	X	70	100	70	125	3	170	20	X	X	X	X	X	X	X	100	3	130
LV3	X	X	70	100	70	125	3	170	20	X	X	X	X	X	X	X	100	3	130
JHB970																			
LV1	X	X	100	100	100	155	2	30	15	X	X	X	X	X	X	X	40	3	130
LV2	X	X	100	100	100	155	2	30	15	X	X	X	X	X	X	X	40	3	130
LV3	X	X	100	100	100	155	2	30	15	X	X	X	X	X	X	X	40	3	130
JHB720																			
LV2	X	X	100	100	100	125	2	90	75	X	X	X	X	X	X	X	40	3	130
JH112																			
LV1	X	X	100	100	100	110	2	70	100	X	X	X	X	X	X	X	20	2	130
LV2	X	X	100	100	100	110	2	70	100	X	X	X	X	X	X	X	20	2	130
LV3	X	X	100	100	100	110	1,6	55	100	X	X	X	X	X	X	X	X	X	X
LV4	X	X	100	100	100	130	1,4	55	100	X	X	X	X	X	X	X	X	X	X
LV5	X	X	100	100	100	130	1,4	50	100	X	X	X	X	X	X	X	X	X	X
LV6	X	X	100	100	100	130	1	35	100	X	X	X	X	X	X	X	X	X	X
JH150																			
LV2	X	X	100	100	100	165	1	90	35	X	X	X	X	X	X	X	30	2	130

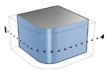
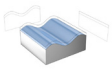
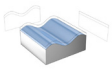
* Max. Einwärtskopierwinkel
Prozentuale Werte, bezogen auf die Original-Schnittdaten.

Berechnungen

Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen.										Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen.				
	Nutfräsen		Eckfräsen/Schruppen			Eckfräsen/Schlichten				Einwärtskopieren		Walzenstirnfräsen		
KUGELKOPF														
	a_p	f_z	a_e	f_z	a_p	v_c	a_e	f_z	a_p	a_p	f_z	f_z	a_p/360° (% DC)	Bohrung Ø (≥ % DC)
C5321														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	100%	80%	100%	80%	100%	80%	100%	80%	100%	70%	100%	85%	90%	170%
LV3	100%	64%	100%	64%	100%	64%	100%	64%	100%	65%	100%	85%	75%	160%
LV4	x	x	100%	52%	100%	52%	100%	52%	100%	65%	65%	70%	75%	160%
LV5	x	x	100%	40%	100%	40%	100%	40%	100%	x	x	65%	75%	160%
LV6	x	x	100%	33%	100%	33%	100%	33%	100%	x	x	60%	75%	160%
LV7	x	x	100%	26%	100%	26%	100%	26%	100%	x	x	55%	75%	160%
C5341														
LV1	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	100%	170%
LV2	100%	80%	100%	80%	100%	80%	100%	80%	100%	70%	100%	85%	90%	170%
LV3	100%	64%	100%	64%	100%	64%	100%	64%	100%	65%	100%	85%	75%	160%
LV4	x	x	100%	52%	100%	52%	100%	52%	100%	65%	65%	70%	75%	160%
LV5	x	x	100%	40%	100%	40%	100%	40%	100%	x	x	65%	75%	160%
LV6	x	x	100%	33%	100%	33%	100%	33%	100%	x	x	60%	75%	160%
LV7	x	x	100%	26%	100%	26%	100%	26%	100%	x	x	55%	75%	160%
LV8	x	x	100%	21%	100%	21%	100%	21%	100%	x	x	50%	75%	160%
ST5341														
LV2	x	x	100%	100%	100%	100%	100%	100%	100%	x	x	x	x	x
LV3	x	x	100%	85%	100%	85%	100%	85%	100%	x	x	x	x	x

* Max. Einwärtskopierwinkel
Prozentuale Werte, bezogen auf die Original-Schnittdaten.

Berechnungen

Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen.										Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen.									
	Nutfräsen		Eckfräsen/Schruppen			Eckfräsen/Schlichten				Kopierfräsen/Schruppen			Kopierfräsen/ Feinbearbeitung				Walzenstirnfräsen		
KUGELKOPF																			
	a_p	f_z	a_e	f_z	a_p	v_c	a_e (% DC)	f_z	a_p	a_e	f_z	a_p	v_c	a_e (% DC)	f_z	a_p	f_z	a_p/360° (% DC)	
JH160																			
Standard (2)	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X
JH450																			
Standard (2)	X	X	100	100	100	120	5	90	25	X	X	X	X	X	X	X	45	5	130
JH460																			
Standard (2)	X	X	100	100	100	120	5	90	25	X	X	X	X	X	X	X	X	X	X
JMB542-JMB562-JMB563																			
LV1	100	100	X	X	X	X	X	X	X	100	100	100	125	2	150	5	X	X	X
LV2	65	100	X	X	X	X	X	X	X	100	100	63	125	2	150	3	X	X	X
LV3	26	100	X	X	X	X	X	X	X	100	100	25	125	2	150	1	X	X	X
LV4 (TL)	20	100	X	X	X	X	X	X	X	100	100	19	125	2	150	1	X	X	X
LV4 (XL)	12	100	X	X	X	X	X	X	X	100	100	12	125	2	150	1	X	X	X
LV5	10	100	X	X	X	X	X	X	X	100	100	10	125	2	150	1	X	X	X
LV6	4	100	X	X	X	X	X	X	X	100	100	4	125	2	150	1	X	X	X
LV7	2	100	X	X	X	X	X	X	X	100	100	2	125	2	150	1	X	X	X
JMB112																			
LV1	100	100	X	X	X	X	X	X	X	100	100	100	118	2	120	5	X	X	X
LV2	65	100	X	X	X	X	X	X	X	64	85	85	118	2	120	3	X	X	X
LV3	26	100	X	X	X	X	X	X	X	56	75	75	118	2	120	1	X	X	X
LV4	20	100	X	X	X	X	X	X	X	45	60	60	118	2	120	1	X	X	X
LV5	10	100	X	X	X	X	X	X	X	38	50	50	118	2	120	1	X	X	X
LV6	4	100	X	X	X	X	X	X	X	30	40	40	118	2	120	1	X	X	X
JM413-JM416																			
LV1	X	X	100	100	100	100	5	40	35	X	X	X	X	X	X	X	X	X	X
LV2	X	X	100	60	100	100	5	40	15	X	X	X	X	X	X	X	X	X	X
LV3	X	X	100	80	100	100	5	40	15	X	X	X	X	X	X	X	X	X	X
LV4	X	X	100	60	75	100	5	40	10	X	X	X	X	X	X	X	X	X	X
JMB642																			
LV1	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV3	100	100	100	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV5	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV6	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
LV7	30	100	60	100	100	100	2	85	200	X	X	X	X	X	X	X	X	X	X
										≤2									
JD660																			
LV1	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV2	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV3	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV4	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X
LV5	X	X	100	100	100	100	2	100	100	X	X	X	X	X	X	X	X	X	X

* Max. Einwärtskopierwinkel
Prozentuale Werte, bezogen auf die Original-Schnittdaten.

Nomenklatur und Formeln

Drehzahl

$$n = \frac{v_c \cdot 1000}{\pi \cdot D_c} \quad \text{(U/min)}$$

Schnittgeschwindigkeit

$$v_c = \frac{n \cdot \pi \cdot D_c}{1000} \quad \text{(m/min)}$$

Vorschubgeschwindigkeit

$$v_f = n \cdot z_n \cdot f_z \quad \text{(mm/min)}$$

Vorschub pro Umdrehung

$$f = z_n \cdot f_z \quad \text{(mm/U)}$$

Zeitspanvolumen

$$Q = \frac{a_e \cdot a_p \cdot v_f}{1000} \quad \text{(cm}^3\text{/min)}$$

Schnittgeschwindigkeit und Drehzahl zum Kopierfräsen

$$v_c = \frac{n \cdot \pi \cdot D_w}{1000} \quad \text{(m/min)}$$

$$n = \frac{v_c \cdot 1000}{\pi \cdot D_w} \quad \text{(Drehzahl)}$$

$$D_w = 2 \cdot \sqrt{a_p\,(D_c - a_p)} \quad \text{(mm)}$$

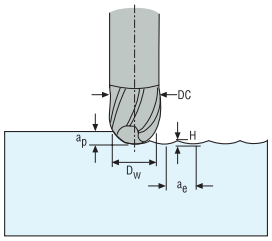
Berechnung von a_p abhängig von Auskraglänge:
Bei Auskraglänge länger als 4 x DC und Einsatz zylindrischer Schäfte muss die Schnitttiefe (a_p) neu berechnet werden.
Die neue Schnitttiefe ist nach folgender Formel zu berechnen: a_p (neu)

$$a_p\text{neu} = a_p \times (4 \times DC/XS)^2$$

Profilhöhe

$$H = \frac{D_C}{2} - \frac{\sqrt{D_C^2 - a_e^2}}{2}$$

$$D_W = 2 \cdot \sqrt{a_p\,(D_C - a_p)} \quad \text{(mm)}$$



Profilhöhe H (um)

DC	Teilung a_e (µm)						
	0,06	0,08	0,11	0,15	0,20	0,3	0,45
1	0,90	1,60	3,00	5,70	10,0	23,0	53,0
2	0,45	0,80	1,50	2,80	5,0	11,0	26,0
4	0,23	0,40	0,76	1,40	2,5	5,60	13,0
6	0,15	0,27	0,50	0,94	1,7	3,80	8,40
8	0,11	0,20	0,38	0,70	1,3	2,80	6,30
10	0,09	0,16	0,30	0,56	1,0	2,30	5,10
12	0,08	0,13	0,25	0,47	0,83	1,90	4,20

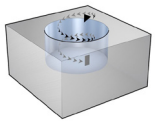
a_p = Axiale Schnitttiefe (mm)
a_e = Radiale Schnitttiefe (Eingriffsbreite) (mm)
DC = Fräserdurchmesser
f = Vorschub/U (mm/U)
f_z = Vorschub/Zahn (mm/Zahn)
z_n = Zähnezahl
n = Drehzahl (U/min)
Q = Zeitspanvolumen (cm^3/min)
v_c = Schnittgeschwindigkeit (m/min)
v_f = Vorschubgeschwindigkeit (mm/min)
D_w = Wirkdurchmesser

Zerspanungsempfehlungen

Bohrzirkularfräsen
Die folgende Tabelle zeigt die Durchmesserempfehlungen für das Bohrzirkularfräsen

Empfohlene Bohrungsdurchmesser zum Bohrzirkularfräsen

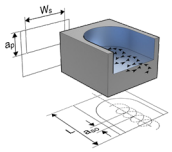
Werkzeugdurchmesser DC	min. Bohrungsdurchmesser
1-2,5	1,4 x DC
3-6	1,3 x DC
8-12	1,2 x DC
16-32	1,15 x DC



Trochoides Verfahren
Nachstehende Abbildung zeigt das sogenannte Trochoide Verfahren

Empfohlene Mindestnutbreite

Werkzeugdurchmesser DC	Nutbreite
1-2,5	1,8 x DC
3-6	1,6 x DC
8-12	1,4 x DC
16-32	1,2 x DC





MINIMASTER™

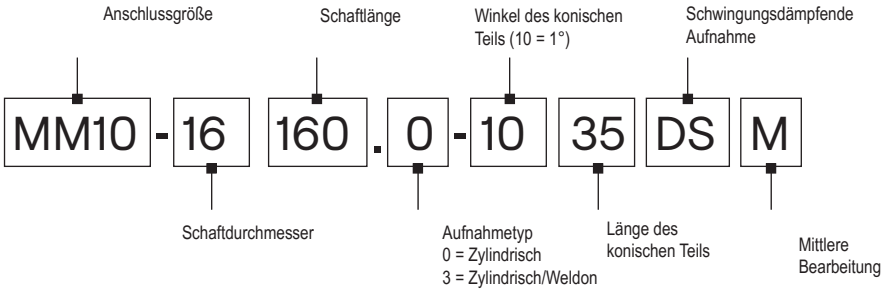
Minimaster™ ist ein einzigartig vielseitiges Schaftfräsersystem, das verschiedene Lösungen kombiniert. Es bietet optimale Zugänglichkeit sowie maximale Stabilität und Sicherheit.

Die flexible, zweiteilige Kombination aus Schäften und Wendeplatten spart Zeit und Geld. Ein vielseitiges Werkzeug, das dem Anwender in nahezu jedem Prozess eine Lösung bietet – egal, ob die Auskragung verringert werden soll, maximale Stabilität gefragt ist oder andere Anforderungen erfüllt werden müssen.

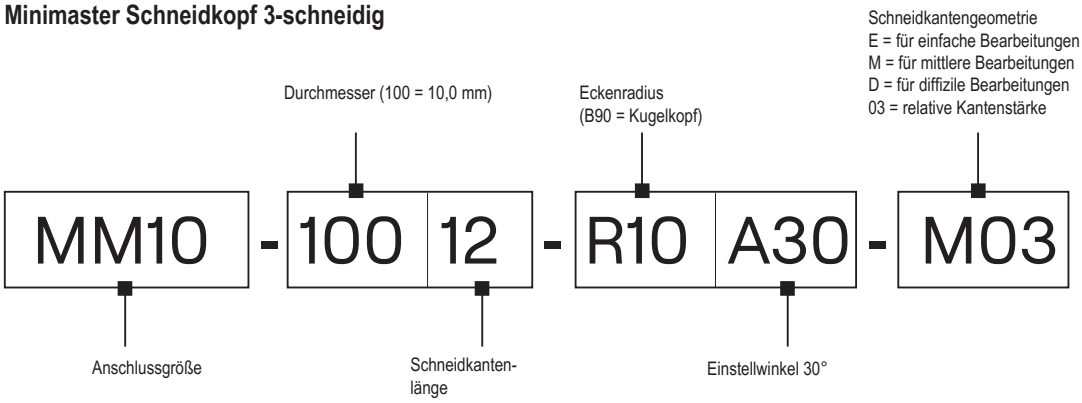
- Schaftfräser: 6 bis 20 mm (.250 - .750”)
- Kugelkopffräser: 6 bis 20 mm (.250 - .750”)
- Zentrier-/Anfasfräser: 6 bis 19,05 mm (.250 - .750”)
- Hochvorschubfräser: 8 bis 12 mm (.375 - .625”)
- Tauchfräser: 6 bis 16 mm (.250 - .625”)
- Konvexradienfräser: 12 mm (.472”)

Code-Schlüssel

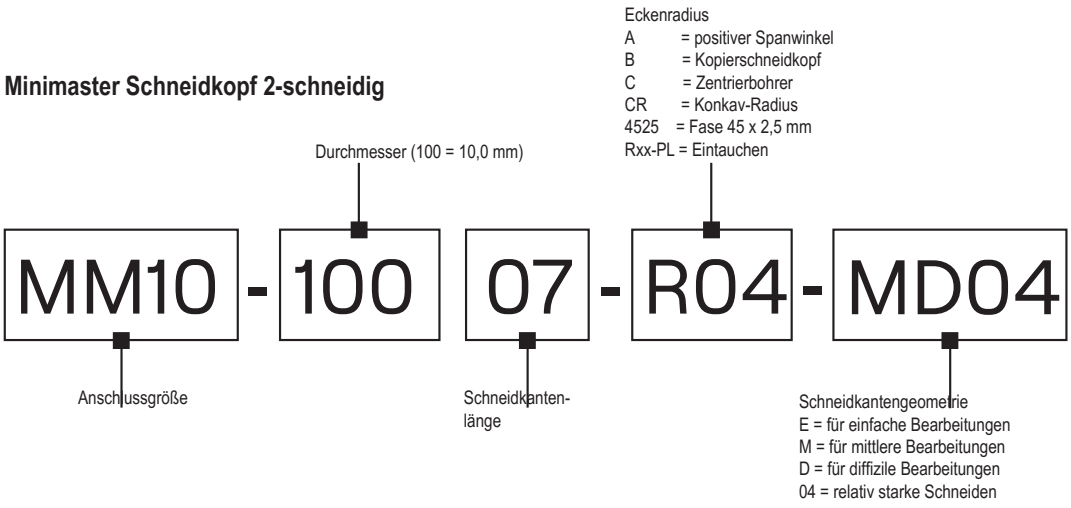
Schäfte



Minimaster Schneidkopf 3-schneidig



Minimaster Schneidkopf 2-schneidig

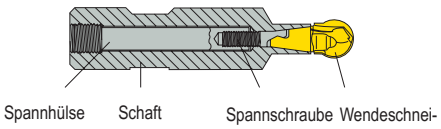
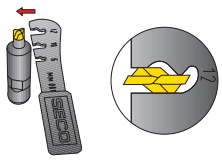
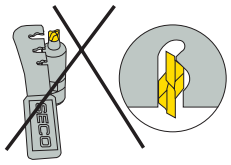
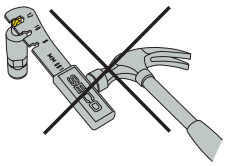
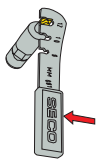


Teile des Codes können bei unterschiedlichen Fräsern variieren.

Innenkühlung



Montagehinweise - MM-Schlüssel nur für 2-schneidige Schneidköpfe

Drehmomentschlüssel	
	Die Spannhülse muss bei erneuter Montage zuerst befestigt werden. Danach Spannschraube und Schneidkopf montieren. Bei abgebrochenem Schneidkopf die Spannhülse lösen. Den Innensechskant-Schlüssel gegen den Uhrzeigersinn drehen. Danach Spannschraube und Schneidkopf entnehmen. Für Minimaster 3-schneidig ist der Schlüssel (MM0416) erforderlich (Schlüsselansatz an sechseckigem Teil des Schneidkopfs).
	Den korrekten Schlüsselansatz beachten.
	Bei nicht korrektem Ansatz können die Schneidkanten beschädigt werden.
	Den Schneidkopf nicht mit einem Hammer oder ähnlichem Gegenstand festklopfen.
	Den Schneidkopf handfest anziehen.

Auswahl

1. Anschlussgröße wählen
Die Ausführung des Werkstückes und die Bearbeitung entscheiden über die Anschlussgröße. Je größer der Anschlussdurchmesser, desto höher ist die Stabilität.

2. Schneidkopf wählen
a. Werkstoff anhand der Seco Werkstoff-Gruppen ab Seite 802 klassifizieren
b. Die gewählte Anschlussgröße den Katalogseiten entnehmen und den geeigneten Schneidkopf in der Auswahltabelle wählen.

3. Aufnahme wählen
a. Auf den Katalogseiten die geeignete Aufnahme auswählen.
b. Schneidkopf und Aufnahme müssen die gleiche Anschlussgröße haben. Je kürzer die Aufnahme, desto größer ist die Stabilität.

4. Schnittdaten wählen
a. Die maximale axiale Schnitttiefe ist in der Tabelle Abmessungen angegeben. Die Schnittdatenempfehlungen basieren auf stabilen Arbeitsbedingungen und müssen daher je nach Stabilität der Bearbeitung (Werkzeugsystem, Maschine und Aufspannung) angepasst werden. Eine allgemeine Regel für die max. Schnitttiefe beim Nutfräsen ist DC*0.3= Max APMXS. (Siehe Abb. 1).
b. Empfehlungen zu Vorschub und Schnittgeschwindigkeit finden Sie ebenfalls in der Tabelle Abmessungen.
c. Die empfohlene Maximaldrehzahl, die aus Sicherheitsgründen nie überschritten werden darf, ist auf Seite N/A angegeben
d. Wenn die radiale Schnitttiefe (Eingriffsbreite) geringer ist als der volle Schneiddurchmesser, müssen Vorschub/Zahn und Schnittgeschwindigkeit erhöht werden, um die Mittenspandicke und die Arbeitstemperatur konstant zu halten.
e. Den Prozentsatz für das Eingriffsverhältnis ermitteln: radiale Schnitttiefe durch den Durchmesser dividieren (bei Kopierfräsern a_e/DC%), bei Kugelkopffräsern den effektiven Wirkdurchmesser D_w anstatt DC (siehe Abb. 2 & 6) verwenden
f. Die Tabelle Schnittdaten enthält Richtwerte für Vorschub/Zahn sowie den Korrekturfaktor für die Schnittgeschwindigkeit.

5. Allgemein
- Beim Fräsen an Ecken und Taschenboden vergrößert sich die Eingriffsbreite dramatisch. Der Vorschub muss reduziert werden, weil sonst die Mittenspandicke enorm zunimmt. Setzen Sie deshalb die Vorschubwerte für volle Eingriffsbreite ein.
- Beim Bohrfräsen mit einem Kopierwinkel von 40° oder beim Ziehfräsen mit einem Kopierwinkel von 30° in Kombination mit einer geringen Schnitttiefe wird der Wirkdurchmesser Dw immer größer sein als die genannten Werte in der Tabelle. In diesem Falle für die Vorschubberechnung den Fräserdurchmesser DC als Wirkdurchmesser Dw einsetzen.
- Nutzen Sie zur Berechnung von Vorschub/U stets den ZEFP-Faktor. Der ZEFP-Faktor ist die effektive Zähnezahl zur Berechnung von Vorschub und Vorschubgeschwindigkeit. Den ZEFP-Faktor finden Sie in der Tabelle Abmessungen.

Hinweis! Bei höheren Vorschubwerten nimmt die Qualität der Werkstück-Oberfläche ab (siehe Abb. 3& 5)

Minimaster

Abb. 1

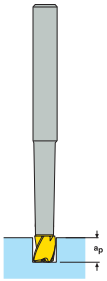


Abb. 2

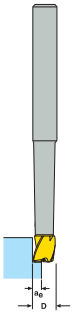


Abb. 3

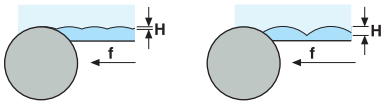


Abb. 4

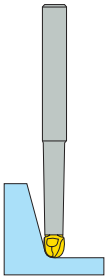


Abb. 5

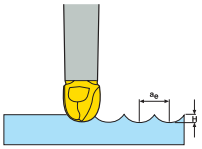
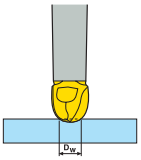
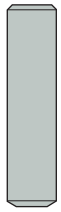
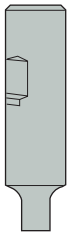
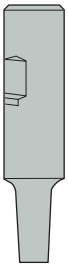
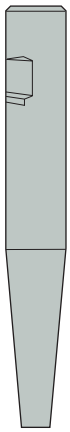
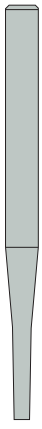


Abb. 6

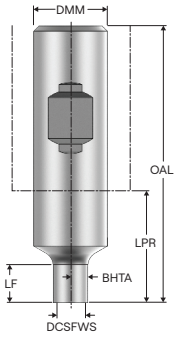


Schaftkonstruktion

Ausführung 1, Keilnut-Schaft	Ausführung 2, Zylindrische/Weldon Schnittstelle und 90° Stirnseite
	
Ausführung 3, Zylindrische/Weldon Schnittstelle und 87°/89° Stirnseite	**Ausführung 4, Zylindrische/Weldon Schnittstelle und 80°/85°/87° Stirnseite**
	
Ausführung 5, Zylindrische Schnittstelle und doppelt konische Stirnseite 89°/85°	
	

MM06 Schaft – Metrisch

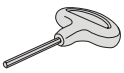




Bezeichnung	Produkt-nummer	DCSFWS	DMM	LF	LPR	OAL	BHTA°	Abb.	CSP	RPMX	Auf-nahmen	Gewicht	Ersatzteil Bezeich-nung
		mm	mm	mm	mm	mm						kg	
MM06-10040.0-0007	00094747	5,75	10,0	7,0	7,0	40,0	0,0	2	■	80000	Cylindrical	0,1	2
MM06-10050.0-0007DS	02580666	5,75	10,0	7,0	7,0	50,0	0,0	2	■	80000	Cylindrical Densimet	0,1	3
MM06-10075.0-3041DS	02580701	5,75	10,0	40,5	35,0	75,0	3,0	4	■	80000	Cylindrical Densimet	0,1	3
MM06-10100.0-1035DS	02580713	5,75	10,0	35,0	60,0	100,0	1,0	3	■	80000	Cylindrical Densimet	0,1	3
MM06-12070.3-0005	75080695	5,75	12,0	5,0	25,0	70,0	0,0	2	■	80000	Weldon	0,1	1
MM06-12065.0-0000	75080694	5,7	12,0	0,0	15,0	65,0	60,0	1	■	80000	Cylindrical	0,1	1
MM06-12120.0-1050DS	02580714	5,75	12,0	50,0	75,0	120,0	1,0	3	■	80000	Cylindrical Densimet	0,2	3
MM06-16075.3-3009	75080696	5,75	16,0	9,0	27,0	75,0	3,0	3	■	80000	Weldon	0,1	1
MM06-16110.3-5058	75080697	5,75	16,0	58,6	62,0	110,0	5,0	4	■	80000	Weldon	0,2	4
MM06-16140.0-1020M	00027102	5,75	16,0	20,0	92,0	140,0	1,0	3	■	80000	Cylindrical	0,2	5
MM06-16140.0-1035M	00027103	5,75	16,0	35,0	92,0	140,0	1,0	3	■	80000	Cylindrical	0,2	6
MM06-16140.0-1050M	00094748	5,75	16,0	50,0	92,0	140,0	1,0	3	■	80000	Cylindrical	0,2	6
MM06-16090.0-0012DS	02580670	5,75	16,0	12,0	42,0	90,0	0,0	2	■	80000	Cylindrical Densimet	0,3	3
MM06-16095.0-0024DS	02580673	5,75	16,0	24,0	47,0	95,0	0,0	2	■	80000	Cylindrical Densimet	0,3	3
MM06-16140.0-1050DS	02580717	5,75	16,0	50,0	92,0	140,0	1,0	3	■	80000	Cylindrical Densimet	0,3	3
MM06-16140.0-1035DS	02580716	5,75	16,0	35,0	92,0	140,0	1,0	3	■	80000	Cylindrical Densimet	0,4	3
MM06-20250.0-1035DS	02580718	5,75	20,0	35,0	190,0	250,0	1,0	5	■	80000	Cylindrical Densimet	0,9	3

Ersatzteile, im Lieferumfang enthalten

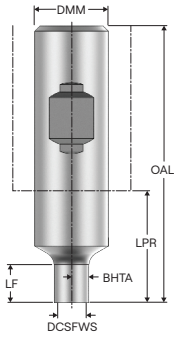
Zubehör

Für Fräser	Hülse	Spannschraube	Schlüssel
			
1	MM-035046	MM06-03518	H05-4
2	MM-035023	MM06-03518	H05-4
3	–	MM06-03518	–
4	MM-035091	MM06-03518	H05-4
5	MM-035046	MM06-03544	H05-4
6	MM-035046	MM06-03564	H05-4

Innensechskant-Schlüssel H05-4 für die Hülse kann separat bestellt werden.
Steckschlüssel, siehe Wendeschneidplatten-Programm:

MM06 Schaft – Zoll

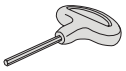




Bezeichnung	Produkt-nummer	DCSFMS	DMM	LF	LPR	OAL	BHTA°	Abb.	CSP	RPMX	Auf-nahmen	Gewicht	Ersatzteil Bezeich-nung
		Zoll	Zoll	Zoll	Zoll	Zoll						lbs	
MM06-0.38-1.6-0-0002	00096107	0.224	0.375	0.276	0.276	1.575	0,0	2	■	80000	Cylindrical	0.220	2
MM06-0.50-2.8-3-0002	00096108	0.224	0.500	0.197	0.984	2.756	0,0	2	■	80000	Weldon	0.220	1
MM06-0.50-2.6-0-0000	00096106	0.224	0.500	0	0.787	2.559	60,0	1	■	80000	Cylindrical	0.220	1
MM06-0.62-3.0-3-3003	00096116	0.224	0.625	0.354	1.063	2.953	3,0	1	■	80000	Weldon	0.220	1
MM06-0.62-4.3-3-5022	00096117	0.224	0.625	2.291	2.441	4.331	5,0	2	■	80000	Weldon	0.440	4
MM06-0.62-5.5-0-1007	00096111	0.224	0.625	0.787	3.622	5.512	1,0	3	■	80000	Cylindrical	0.440	5
MM06-0.62-5.5-0-1013	00096112	0.224	0.625	1.378	3.622	5.512	1,0	3	■	80000	Cylindrical	0.440	6
MM06-0.62-5.5-0-1019	00096114	0.224	0.625	1.969	3.622	5.512	1,0	3	■	80000	Cylindrical	0.440	6
MM06-0.62-3.5-0-0004DS	02593394	0.224	0.625	0.472	1.654	3.543	0,0	2	■	80000	Cylindrical Densimet	0.660	3
MM06-0.62-3.7-0-0009DS	02593395	0.224	0.625	0.945	1.850	3.740	0,0	2	■	80000	Cylindrical Densimet	0.660	3
MM06-0.62-5.5-0-1013DS	02593396	0.224	0.625	1.378	3.622	5.512	1,0	3	■	80000	Cylindrical Densimet	0.880	3
MM06-0.62-5.5-0-1019DS	02593397	0.224	0.625	1.969	3.622	5.512	1,0	3	■	80000	Cylindrical Densimet	0.660	3
MM06-0.75-10.0-0-1013DS	02593399	0.224	0.750	1.378	7.874	9.843	1,0	5	■	80000	Cylindrical Densimet	1.760	3

Ersatzteile, im Lieferumfang enthalten

Zubehör

Für Fräser	Hülse	Spannschraube	Schlüssel
			
1	MM-035046	MM06-03518	H05-4
2	MM-035023	MM06-03518	H05-4
3	–	MM06-03518	–
4	MM-035091	MM06-03518	H05-4
5	MM-035046	MM06-03544	H05-4
6	MM-035046	MM06-03564	H05-4

Innensechskant-Schlüssel H05-4 für die Hülse kann separat bestellt werden.
Steckschlüssel, siehe Wendeschneidplatten-Programm:

Nutfräsen/Eckfräsen

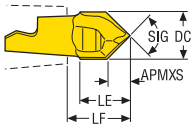


—Drehmomentschlüssel und Drehmomente, siehe Seite 799

												Beschichtung			
Bezeichnung	**DC**	**APMXS**	**RE**	**LF**	**RMPX°**	**C min**	**C max**	**FHA**	**ZEFP**	**Schlüssel**		Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*								T60M	F15M	F30M	F40M
MM06-05804T-R02-D02	5,8 *0.228*	4,1 *0.161*	0,2 *0.008*	5,1 *0.201*	15,0	7,2	11,0	0	2	MM0612		■			
MM06-05807-R02A30-M02	5,8 *0.228*	7,5 *0.295*	0,2 *0.008*	9,9 *0.390*	15,0	7,2	11,0	30	3	MM0612	✓				■
MM06-06004-M02	6,0 *0.236*	4,1 *0.161*	–	5,1 *0.201*	15,0	7,4	11,8	0	2	MM0612		■			
MM06-06004-R04-MD02	6,0 *0.236*	4,1 *0.161*	0,4 *0.016*	5,1 *0.201*	15,0	7,4	11,0	0	2	MM0612		■		■	
MM06-06004-R10-MD02	6,0 *0.236*	4,1 *0.161*	1,0 *0.039*	5,1 *0.201*	15,0	7,4	9,8	0	2	MM0612				■	
MM06-06007-A30-E02	6,0 *0.236*	7,5 *0.295*	–	9,9 *0.390*	15,0	7,4	11,8	30	3	MM0416	✓			■	
MM06-06007-R05A30-M02	6,0 *0.236*	7,5 *0.295*	0,5 *0.020*	9,9 *0.390*	15,0	7,4	10,8	30	3	MM0416	✓				■
MM06-06007-R10A30-D02	6,0 *0.236*	7,5 *0.295*	1,0 *0.039*	9,9 *0.390*	15,0	7,4	9,8	30	3	MM0416	✓			■	
MM06-06007-R10A30-E02	6,0 *0.236*	7,5 *0.295*	1,0 *0.039*	9,9 *0.390*	15,0	7,4	9,8	30	3	MM0416	✓			■	
MM06-06007-R10A30-M02	6,0 *0.236*	7,5 *0.295*	1,0 *0.039*	9,9 *0.390*	15,0	7,4	9,8	30	3	MM0416	✓				■
MM06-06007-R20A30-M02	6,0 *0.236*	7,5 *0.295*	2,0 *0.079*	9,9 *0.390*	15,0	7,4	7,8	30	3	MM0416	✓				■
MM06-06407-A30-E02	6,35 *0.250*	7,5 *0.295*	–	9,9 *0.390*	15,0	7,8	12,5	30	3	MM0416	✓			■	
MM06-06407-R04A30-M02	6,35 *0.250*	7,5 *0.295*	0,4 *0.016*	9,9 *0.390*	15,0	7,8	11,7	30	3	MM0416	✓				■
MM06-06407-R08A30-M02	6,35 *0.250*	7,5 *0.295*	0,8 *0.031*	9,9 *0.390*	15,0	7,8	10,9	30	3	MM0416	✓				■

Zentrierbohren



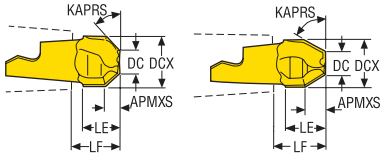


—Drehmomentschlüssel und Drehmomente, siehe Seite 799

								Beschichtung			
								Beschichtet			
Bezeichnung	**DC**	**APMXS**	**LE**	**LF**	**SIG°**	**ZEFP**	**Schlüssel**				
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM06-06003-C120-M02	6,0 *0.236*	1,6 *0.063*	6,27 *0.247*	7,19 *0.283*	120,0	2	MM0612	■			
MM06-06003-C90-M02	6,0 *0.236*	2,86 *0.113*	6,0 *0.236*	7,12 *0.280*	90,0	2	MM0612	■			

Anfasen





—Drehmomentschlüssel und Drehmomente, siehe Seite 799

										Beschichtung			
										Beschichtet			
Bezeichnung	**DCX**	**DC**	**APMXS**	**RE**	**LE**	**LF**	**KAPRS°**	**ZEFP**	**Schlüssel**				
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM06-06004-4515-E02	6,0 *0.236*	1,8 *0.071*	2,1 *0.083*	0,2 *0.008*	4,0 *0.157*	5,1 *0.201*	45,0	2	MM0612	■			
MM06-06004-6015-E02	6,0 *0.236*	3,14 *0.124*	2,4 *0.094*	0,2 *0.008*	4,6 *0.181*	5,75 *0.226*	60,0	2	MM0612	■			

Doppeltes Anfasen

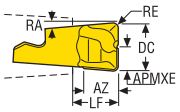


—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DCX	DC	APMXS	DN	LF	BEC°	KAPRS°	ZEFP	Schlüssel	Beschichtung			
										Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*					T60M	F15M	F30M	F40M
MM06-08008-D4510P-M02	8,0 *0.315*	0,6 *0.024*	3,7 *0.146*	6,0 *0.236*	8,5 *0.335*	90,0	45,0	2	MM0612		■		

Tauchfräser

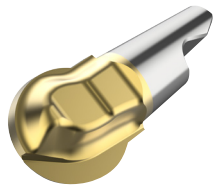




—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DC	APMXE	RE	AZ	LF	RA°	ZEFP	Schlüssel	Beschichtung			
									Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM06-06004-R10-PL-MD02	6,0 *0.236*	3,0 *0.118*	1,0 *0.039*	4,3 *0.169*	5,08 *0.200*	5,0	2	MM0612			■	

Präzisionswendeschneidplatten zum Vorschlichten in allen Werkstoffen



—Drehmomentschlüssel und Drehmomente, siehe Seite 799

										Beschichtung			
Bezeichnung	**DC**	**APMXS**	**RE**	**LE**	**DN**	**LF**	**SA**	**ZEFP**	**Schlüssel**	**Beschichtet**			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM06-08008-B120PF-M01	8,0 *0.315*	4,0 *0.157*	4,0 *0.157*	8,0 *0.315*	6,0 *0.236*	8,73 *0.344*	263,0	2	MM0612		■		
MM06-08008-B120P-M03	8,0 *0.315*	4,0 *0.157*	4,0 *0.157*	8,0 *0.315*	6,0 *0.236*	8,73 *0.344*	263,0	2	MM0612			■	

Kopierfräser



—Drehmomentschlüssel und Drehmomente, siehe Seite 799

								Beschichtung			
Bezeichnung	**DC**	**APMXS**	**RE**	**LF**	**FHA**	**ZEFP**	**Schlüssel**	**Beschichtet**			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM06-06006-B90-MD02	6,0 *0.236*	6,1 *0.240*	3,0 *0.118*	7,06 *0.278*		2	MM0612	■		■	
MM06-06006-B90PF-M01	6,0 *0.236*	5,2 *0.205*	3,0 *0.118*	7,04 *0.277*		2	MM0612		■		
MM06-06006-B90P-M02	6,0 *0.236*	5,2 *0.205*	3,0 *0.118*	7,04 *0.277*		2	MM0612			■	
MM06-06006-B90S-E02	6,0 *0.236*	6,1 *0.240*	3,0 *0.118*	7,06 *0.278*		2	MM0612			■	
MM06-06007-B90A30-E02	6,0 *0.236*	7,4 *0.291*	3,0 *0.118*	9,85 *0.388*	30,0	3	MM0416	✓		■	
MM06-06007-B90A30-M02	6,0 *0.236*	7,4 *0.291*	3,0 *0.118*	9,85 *0.388*	30,0	3	MM0416	✓			■
MM06-06406-B90P-M02	6,35 *0.250*	5,4 *0.213*	3,175 *0.125*	7,22 *0.284*		2	MM0612			■	
MM06-06406-B90S-E02	6,35 *0.250*	6,3 *0.248*	3,175 *0.125*	7,24 *0.285*		2	MM0612			■	

MM06 - Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,030 0.0012	0,030 0.0012	0,036 0.0014	0,048 0.0019
P2	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,030 0.0012	0,030 0.0012	0,036 0.0014	0,048 0.0019
P3	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,046 0.0018
P4	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,044 0.0017
P5	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 0.0011	0,028 0.0011	0,032 0.0013	0,044 0.0017
P6	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 0.0011	0,028 0.0011	0,032 0.0013	0,044 0.0017
P7	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 0.0011	0,028 0.0011	0,032 0.0013	0,044 0.0017
P8	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,046 0.0018
P11	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 0.0011	0,028 0.0011	0,032 0.0013	0,044 0.0017
P12	MM06-06007-R05A30-M02 F40M	1,0 *0.040*	0,020 0.00080	0,020 0.00080	0,022 0.00085	0,030 0.0012
M1	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,030 0.0012	0,030 0.0012	0,036 0.0014	0,048 0.0019
M2	MM06-06007-R05A30-M02 F40M	1,3 *0.050*	0,028 0.0011	0,028 0.0011	0,032 0.0013	0,044 0.0017
M3	MM06-06007-R05A30-M02 F40M	1,0 *0.040*	0,024 0.00095	0,024 0.00095	0,026 0.0010	0,036 0.0014
M4	MM06-06007-R05A30-M02 F40M	0,80 *0.032*	0,022 0.00085	0,020 0.00080	0,024 0.00095	0,030 0.0012
M5	MM06-06007-R05A30-M02 F40M	0,80 *0.032*	0,022 0.00085	0,020 0.00080	0,024 0.00095	0,030 0.0012
K1	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,036 0.0014	0,034 0.0013	0,038 0.0015	0,050 0.0020
K2	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
K3	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
K4	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
K5	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,030 0.0012	0,028 0.0011	0,030 0.0012	0,040 0.0016
K6	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
K7	MM06-06007-R10A30-D02 F30M	1,3 *0.050*	0,030 0.0012	0,028 0.0011	0,030 0.0012	0,040 0.0016
N1	MM06-06007-R10A30-E02 F30M	1,3 *0.050*	0,046 0.0018	0,044 0.0017	0,048 0.0019	0,065 0.0026
N2	MM06-06007-R10A30-E02 F30M	1,3 *0.050*	0,046 0.0018	0,044 0.0017	0,048 0.0019	0,065 0.0026
N3	MM06-06007-R10A30-E02 F30M	1,3 *0.050*	0,046 0.0018	0,044 0.0017	0,048 0.0019	0,065 0.0026
N11	MM06-06007-R10A30-E02 F30M	1,3 *0.050*	0,046 0.0018	0,044 0.0017	0,048 0.0019	0,065 0.0026
S1	MM06-06007-R10A30-D02 F30M	0,80 *0.032*	0,028 0.0011	0,026 0.0010	0,025 0.0010	0,032 0.0013
S2	MM06-06007-R10A30-D02 F30M	0,80 *0.032*	0,028 0.0011	0,026 0.0010	0,025 0.0010	0,032 0.0013
S3	MM06-06007-R10A30-D02 F30M	0,80 *0.032*	0,026 0.0010	0,025 0.0010	0,024 0.00095	0,028 0.0012
S11	MM06-06007-R05A30-M02 F40M	0,90 *0.036*	0,024 0.00095	0,024 0.00095	0,026 0.0010	0,036 0.0014
S12	MM06-06007-R05A30-M02 F40M	0,90 *0.036*	0,024 0.00095	0,024 0.00095	0,026 0.0010	0,036 0.0014
S13	MM06-06007-R05A30-M02 F40M	0,80 *0.032*	0,022 0.00085	0,020 0.00080	0,024 0.00095	0,030 0.0012
H5	MM06-06007-R10A30-D02 F30M	1,0 *0.040*	0,025 0.0010	0,024 0.00095	0,024 0.00095	0,030 0.0012
H8	MM06-06007-R10A30-D02 F30M	0,90 *0.036*	0,020 0.00080	0,019 0.00075	0,018 0.00070	0,024 0.00095
H11	MM06-06007-R10A30-D02 F30M	1,0 *0.040*	0,025 0.0010	0,024 0.00095	0,024 0.00095	0,030 0.0012
H12	MM06-06007-R10A30-D02 F30M	0,90 *0.036*	0,020 0.00080	0,019 0.00075	0,018 0.00070	0,024 0.00095
H21	MM06-06007-R10A30-D02 F30M	0,90 *0.036*	0,020 0.00080	0,019 0.00075	0,018 0.00070	0,024 0.00095

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM06 - Nut- und Eckfräsen – Schnittdaten v_c = (m/min)/(sf/min)

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	280 *920*	350 *1150*	395 *1300*	435 *1425*	270 *890*	335 *1100*	375 *1225*	415 *1350*	220 *720*	270 *890*	300 *980*	330 *1075*
P2	275 *900*	340 *1125*	380 *1250*	420 *1375*	260 *850*	325 *1075*	365 *1200*	400 *1300*	210 *690*	260 *850*	295 *970*	320 *1050*
P3	240 *790*	295 *970*	330 *1075*	365 *1200*	225 *740*	285 *940*	315 *1025*	350 *1150*	185 *610*	230 *750*	255 *840*	280 *920*
P4	210 *690*	260 *850*	295 *970*	320 *1050*	200 *660*	250 *820*	280 *920*	305 *1000*	160 *520*	200 *660*	225 *740*	245 *800*
P5	200 *660*	250 *820*	280 *920*	310 *1025*	190 *620*	240 *790*	265 *870*	295 *970*	155 *510*	190 *620*	215 *710*	235 *770*
P6	225 *740*	285 *940*	315 *1025*	345 *1125*	215 *710*	270 *890*	300 *980*	330 *1075*	175 *570*	215 *710*	240 *790*	265 *870*
P7	215 *710*	265 *870*	295 *970*	325 *1075*	205 *670*	255 *840*	285 *940*	310 *1025*	165 *540*	205 *670*	230 *750*	250 *820*
P8	200 *660*	250 *820*	280 *920*	305 *1000*	190 *620*	240 *790*	265 *870*	290 *950*	155 *510*	190 *620*	215 *710*	235 *770*
P11	210 *690*	260 *850*	290 *950*	320 *1050*	200 *660*	245 *800*	275 *900*	305 *1000*	160 *520*	200 *660*	220 *720*	245 *800*
P12	130 *425*	160 *520*	175 *570*	195 *640*	125 *410*	150 *490*	170 *560*	185 *610*	100 *330*	125 *410*	135 *445*	150 *490*
M1	— —	— —	— —	— —	210 *690*	265 *870*	295 *970*	320 *1050*	170 *560*	210 *690*	235 *770*	260 *850*
M2	— —	— —	— —	— —	175 *570*	215 *710*	240 *790*	265 *870*	140 *460*	170 *560*	195 *640*	210 *690*
M3	— —	— —	— —	— —	135 *445*	165 *540*	190 *620*	205 *670*	110 *360*	135 *445*	150 *490*	165 *540*
M4	— —	— —	— —	— —	105 *345*	130 *425*	145 *475*	155 *510*	85 *280*	105 *345*	115 *375*	125 *410*
M5	— —	— —	— —	— —	85 *280*	105 *345*	120 *395*	130 *425*	70 *230*	85 *280*	95 *310*	105 *345*
K1	215 *710*	270 *890*	305 *1000*	335 *1100*	205 *670*	260 *850*	290 *950*	315 *1025*	165 *540*	210 *690*	230 *750*	255 *840*
K2	190 *620*	235 *770*	265 *870*	295 *970*	180 *590*	225 *740*	255 *840*	280 *920*	150 *490*	180 *590*	205 *670*	225 *740*
K3	160 *520*	200 *660*	225 *740*	250 *820*	155 *510*	190 *620*	215 *710*	235 *770*	125 *410*	155 *510*	175 *570*	190 *620*
K4	155 *510*	190 *620*	215 *710*	235 *770*	145 *475*	180 *590*	205 *670*	225 *740*	120 *395*	145 *475*	165 *540*	180 *590*
K5	95 *310*	115 *375*	130 *425*	145 *475*	90 *295*	110 *360*	125 *410*	135 *445*	70 *230*	90 *295*	100 *330*	110 *360*
K6	135 *445*	170 *560*	190 *620*	210 *690*	130 *425*	160 *520*	180 *590*	200 *660*	105 *345*	130 *425*	145 *475*	160 *520*
K7	120 *395*	150 *490*	165 *540*	180 *590*	115 *375*	140 *460*	160 *520*	175 *570*	90 *295*	115 *375*	125 *410*	140 *460*
N1	1650 *5425*	2050 *6725*	2325 *7625*	2525 *8275*	1575 *5175*	1975 *6475*	2200 *7225*	2400 *7875*	1275 *4175*	1575 *5175*	1775 *5825*	1950 *6400*
N2	670 *2200*	830 *2725*	930 *3050*	1025 *3375*	640 *2100*	790 *2600*	890 *2925*	970 *3175*	510 *1675*	640 *2100*	710 *2325*	790 *2600*
N3	445 *1450*	560 *1825*	620 *2025*	680 *2225*	425 *1400*	530 *1750*	590 *1925*	650 *2125*	340 *1125*	425 *1400*	475 *1550*	530 *1750*
N11	510 *1675*	630 *2075*	710 *2325*	780 *2550*	485 *1600*	600 *1975*	680 *2225*	740 *2425*	390 *1275*	485 *1600*	540 *1775*	600 *1975*
S1	50 *165*	65 *215*	70 *230*	75 *245*	49 *160*	60 *195*	65 *215*	75 *245*	39 *130*	49 *160*	55 *180*	60 *195*
S2	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	32 *105*	39 *130*	44 *145*	48 *155*
S3	36 *120*	44 *145*	49 *160*	55 *180*	34 *110*	42 *140*	47 *155*	50 *165*	27 *90*	34 *110*	38 *125*	41 *135*
S11	— —	— —	— —	— —	70 *230*	85 *280*	95 *310*	105 *345*	55 *180*	70 *230*	75 *245*	85 *280*
S12	— —	— —	— —	— —	48 *155*	60 *195*	65 *215*	70 *245*	38 *125*	48 *155*	55 *180*	60 *195*
S13	— —	— —	— —	— —	27 *90*	34 *110*	38 *125*	41 *135*	22 *70*	27 *90*	30 *100*	33 *110*
H5	43 *140*	55 *180*	60 *195*	65 *215*	41 *135*	50 *165*	55 *180*	60 *195*	33 *110*	41 *135*	45 *150*	50 *165*
H8	44 *145*	55 *180*	60 *195*	65 *215*	42 *140*	50 *165*	60 *195*	65 *215*	34 *110*	42 *140*	47 *155*	50 *165*
H11	55 *180*	65 *215*	75 *245*	85 *280*	50 *165*	65 *215*	70 *230*	80 *260*	42 *140*	50 *165*	60 *195*	65 *215*
H12	80 *260*	95 *310*	110 *360*	120 *395*	75 *245*	90 *295*	105 *345*	115 *375*	60 *195*	75 *245*	85 *280*	90 *295*
H21	44 *145*	55 *180*	60 *195*	65 *215*	42 *140*	50 *165*	60 *195*	65 *215*	34 *110*	42 *140*	47 *155*	50 *165*

MM06 Z3-Kopierfräser – Auswahl der Wendeschneidplatten – Schruppen – Metrisch/ Zoll

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,036 0.0014	0,034 0.0013	0,036 0.0014	0,048 0.0019
P2	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,036 0.0014	0,034 0.0013	0,036 0.0014	0,048 0.0019
P3	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,034 0.0013	0,034 0.0013	0,034 0.0013	0,046 0.0018
P4	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,034 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
P5	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
P6	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
P7	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
P8	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,034 0.0013	0,034 0.0013	0,034 0.0013	0,046 0.0018
P11	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
P12	MM06-06007-B90A30-M02 F40M	1,0 *0.040*	0,024 0.00095	0,022 0.00085	0,024 0.00095	0,030 0.0012
M1	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,036 0.0014	0,034 0.0013	0,036 0.0014	0,048 0.0019
M2	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
M3	MM06-06007-B90A30-M02 F40M	1,0 *0.040*	0,028 0.0011	0,026 0.0010	0,028 0.0011	0,036 0.0014
M4	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 0.0010	0,025 0.0010	0,025 0.0010	0,030 0.0013
M5	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 0.0010	0,025 0.0010	0,025 0.0010	0,030 0.0013
K1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 0.0014	0,034 0.0013	0,036 0.0014	0,048 0.0019
K2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
K3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
K4	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
K5	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,030 0.0012	0,028 0.0011	0,030 0.0012	0,040 0.0016
K6	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0017
K7	MM06-06007-B90A30-M02 F40M	1,3 *0.050*	0,030 0.0012	0,028 0.0011	0,030 0.0012	0,040 0.0016
N1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,046 0.0018	0,044 0.0017	0,046 0.0018	0,060 0.0024
N2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,046 0.0018	0,044 0.0017	0,046 0.0018	0,060 0.0024
N3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,046 0.0018	0,044 0.0017	0,046 0.0018	0,060 0.0024
N11	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,046 0.0018	0,044 0.0017	0,046 0.0018	0,060 0.0024
S1	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 0.0010	0,025 0.0010	0,025 0.0010	0,030 0.0013
S2	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 0.0010	0,025 0.0010	0,025 0.0010	0,030 0.0013
S3	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,024 0.00095	0,022 0.00085	0,022 0.00085	0,028 0.0012
S11	MM06-06007-B90A30-M02 F40M	0,90 *0.036*	0,028 0.0011	0,028 0.0011	0,028 0.0011	0,036 0.0014
S12	MM06-06007-B90A30-M02 F40M	0,90 *0.036*	0,028 0.0011	0,028 0.0011	0,028 0.0011	0,036 0.0014
S13	MM06-06007-B90A30-M02 F40M	0,80 *0.032*	0,025 0.0010	0,025 0.0010	0,025 0.0010	0,030 0.0013
H5	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,024 0.00095	0,022 0.00085	0,024 0.00095	0,030 0.0012
H8	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,018 0.00070	0,018 0.00070	0,018 0.00070	0,022 0.00095
H11	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,024 0.00095	0,022 0.00085	0,024 0.00095	0,030 0.0012
H12	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,018 0.00070	0,018 0.00070	0,018 0.00070	0,022 0.00095
H21	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,018 0.00070	0,018 0.00070	0,018 0.00070	0,022 0.00095

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM06 Z3-Kopierfräser – Auswahl der Wendeschneidplatten – Schlichten – Metrisch/ Zoll

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,040 0.0016	0,048 0.0019	0,065 0.0026	0,11 0.0044
P2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,040 0.0016	0,048 0.0019	0,065 0.0026	0,11 0.0044
P3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,038 0.0015	0,046 0.0018	0,065 0.0026	0,10 0.0040
P4	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,10 0.0040
P5	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 0.0014	0,044 0.0017	0,060 0.0024	0,10 0.0040
P6	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 0.0014	0,044 0.0017	0,060 0.0024	0,10 0.0040
P7	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 0.0014	0,044 0.0017	0,060 0.0024	0,10 0.0040
P8	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,038 0.0015	0,046 0.0018	0,065 0.0026	0,10 0.0040
P11	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 0.0014	0,044 0.0017	0,060 0.0024	0,10 0.0040
P12	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,065 0.0026
M1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,040 0.0016	0,048 0.0019	0,065 0.0026	0,11 0.0044
M2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 0.0014	0,044 0.0017	0,060 0.0024	0,10 0.0040
M3	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,030 0.0012	0,036 0.0014	0,048 0.0019	0,080 0.0032
M4	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 0.0010	0,030 0.0013	0,042 0.0017	0,070 0.0028
M5	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 0.0010	0,030 0.0013	0,042 0.0017	0,070 0.0028
K1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,040 0.0016	0,048 0.0019	0,065 0.0026	0,11 0.0044
K2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 0.0014	0,044 0.0017	0,060 0.0024	0,10 0.0040
K3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 0.0014	0,044 0.0017	0,060 0.0024	0,10 0.0040
K4	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 0.0014	0,044 0.0017	0,060 0.0024	0,10 0.0040
K5	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,034 0.0013	0,040 0.0016	0,055 0.0022	0,090 0.0036
K6	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,036 0.0014	0,044 0.0017	0,060 0.0024	0,10 0.0040
K7	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,034 0.0013	0,040 0.0016	0,055 0.0022	0,090 0.0036
N1	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,050 0.0020	0,060 0.0024	0,085 0.0034	0,14 0.0055
N2	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,050 0.0020	0,060 0.0024	0,085 0.0034	0,14 0.0055
N3	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,050 0.0020	0,060 0.0024	0,085 0.0034	0,14 0.0055
N11	MM06-06007-B90A30-E02 F30M	1,3 *0.050*	0,050 0.0020	0,060 0.0024	0,085 0.0034	0,14 0.0055
S1	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 0.0010	0,030 0.0013	0,042 0.0017	0,070 0.0028
S2	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 0.0010	0,030 0.0013	0,042 0.0017	0,070 0.0028
S3	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,025 0.0010	0,028 0.0012	0,040 0.0016	0,065 0.0026
S11	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,030 0.0012	0,036 0.0014	0,048 0.0019	0,080 0.0032
S12	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,030 0.0012	0,036 0.0014	0,048 0.0019	0,080 0.0032
S13	MM06-06007-B90A30-E02 F30M	0,80 *0.032*	0,026 0.0010	0,030 0.0013	0,042 0.0017	0,070 0.0028
H5	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,065 0.0026
H8	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,020 0.00080	0,022 0.00095	0,032 0.0013	0,050 0.0020
H11	MM06-06007-B90A30-E02 F30M	1,0 *0.040*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,065 0.0026
H12	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,020 0.00080	0,022 0.00095	0,032 0.0013	0,050 0.0020
H21	MM06-06007-B90A30-E02 F30M	0,90 *0.036*	0,020 0.00080	0,022 0.00095	0,032 0.0013	0,050 0.0020

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM06 Z3-Kopierfräser – Schnittdaten v_c = (m/min)/(sf/min)

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	295 *970*	350 *1150*	370 *1225*	405 *1325*	400 *1300*	280 *920*	330 *1075*	355 *1175*	385 *1275*	380 *1250*
P2	285 *940*	340 *1125*	360 *1175*	395 *1300*	390 *1275*	275 *900*	325 *1075*	345 *1125*	375 *1225*	370 *1225*
P3	250 *820*	295 *970*	315 *1025*	340 *1125*	340 *1125*	235 *770*	280 *920*	300 *980*	320 *1050*	325 *1075*
P4	220 *720*	260 *850*	275 *900*	300 *980*	300 *980*	210 *690*	245 *800*	265 *870*	285 *940*	285 *940*
P5	210 *690*	245 *800*	265 *870*	285 *940*	285 *940*	200 *660*	235 *770*	250 *820*	275 *900*	270 *890*
P6	235 *770*	275 *900*	295 *970*	320 *1050*	320 *1050*	225 *740*	265 *870*	285 *940*	305 *1000*	305 *1000*
P7	225 *740*	260 *850*	280 *920*	305 *1000*	300 *980*	210 *690*	250 *820*	265 *870*	290 *950*	285 *940*
P8	210 *690*	245 *800*	265 *870*	285 *940*	285 *940*	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*
P11	215 *710*	255 *840*	270 *890*	295 *970*	295 *970*	205 *670*	240 *790*	260 *850*	280 *920*	280 *920*
P12	135 *445*	160 *520*	165 *560*	180 *590*	180 *590*	125 *410*	150 *490*	160 *520*	170 *560*	170 *560*
M1	230 *750*	275 *900*	290 *950*	315 *1025*	315 *1025*	220 *720*	260 *850*	280 *920*	300 *980*	300 *980*
M2	190 *620*	220 *720*	240 *790*	260 *850*	255 *840*	180 *590*	210 *690*	225 *740*	245 *800*	245 *800*
M3	150 *490*	180 *590*	185 *610*	200 *660*	200 *660*	140 *460*	170 *560*	175 *590*	190 *620*	190 *620*
M4	105 *345*	145 *475*	140 *490*	150 *490*	150 *490*	100 *330*	135 *445*	135 *460*	145 *475*	145 *475*
M5	85 *280*	120 *395*	115 *410*	125 *410*	125 *410*	85 *280*	115 *375*	110 *395*	120 *395*	120 *395*
K1	230 *750*	270 *890*	285 *940*	310 *1025*	310 *1025*	215 *710*	255 *840*	275 *900*	295 *970*	295 *970*
K2	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	240 *790*	260 *850*	255 *840*
K3	170 *560*	200 *660*	210 *690*	230 *750*	230 *750*	160 *520*	190 *620*	200 *660*	220 *720*	220 *720*
K4	160 *520*	190 *620*	205 *670*	220 *720*	220 *720*	155 *510*	180 *590*	195 *640*	210 *690*	210 *690*
K5	95 *310*	115 *375*	120 *395*	130 *425*	130 *425*	90 *295*	110 *360*	115 *375*	125 *410*	125 *410*
K6	140 *460*	165 *540*	180 *590*	195 *640*	190 *620*	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*
K7	125 *410*	145 *475*	155 *510*	170 *560*	170 *560*	120 *395*	140 *460*	150 *490*	160 *520*	160 *520*
N1	1750 *5750*	2075 *6800*	2200 *7225*	2375 *7800*	2375 *7800*	1675 *5500*	1975 *6475*	2100 *6900*	2275 *7475*	2250 *7375*
N2	710 *2325*	830 *2725*	890 *2925*	960 *3150*	950 *3125*	670 *2200*	790 *2600*	850 *2800*	920 *3025*	910 *2975*
N3	470 *1550*	560 *1825*	590 *1925*	640 *2100*	640 *2100*	450 *1475*	530 *1750*	570 *1875*	610 *2000*	610 *2000*
N11	540 *1775*	630 *2075*	680 *2225*	730 *2400*	730 *2400*	510 *1675*	600 *1975*	650 *2125*	700 *2300*	690 *2275*
S1	49 *160*	65 *215*	65 *230*	70 *230*	70 *230*	46 *150*	65 *215*	65 *215*	70 *230*	65 *215*
S2	39 *130*	55 *180*	55 *180*	55 *180*	55 *180*	37 *120*	50 *165*	50 *180*	55 *180*	55 *180*
S3	34 *110*	47 *155*	46 *155*	50 *165*	49 *160*	32 *105*	44 *145*	44 *150*	47 *155*	47 *155*
S11	75 *245*	95 *310*	95 *310*	100 *330*	100 *330*	70 *230*	90 *295*	90 *295*	95 *310*	95 *310*
S12	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*
S13	27 *90*	38 *125*	37 *130*	40 *130*	40 *130*	26 *85*	36 *120*	35 *120*	38 *125*	38 *125*
H5	44 *145*	55 *180*	55 *180*	60 *195*	60 *195*	42 *140*	50 *165*	55 *180*	55 *180*	55 *180*
H8	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*
H11	55 *180*	70 *230*	70 *230*	75 *245*	75 *245*	55 *180*	65 *215*	65 *230*	70 *230*	75 *245*
H12	80 *260*	100 *330*	100 *345*	110 *360*	110 *360*	75 *245*	95 *310*	95 *330*	105 *345*	105 *345*
H21	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*

MM06 Z2-Kopierfräser – Auswahl der Wendeschneidplatten – Schruppen – Metrisch/ Zoll

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,030 0.0012	0,032 0.0013	0,036 0.0014	0,048 0.0019
P2	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,032 0.0013	0,032 0.0013	0,036 0.0014	0,048 0.0019
P3	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,046 0.0018
P4	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,044 0.0017
P5	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,044 0.0017
P6	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 0.0011	0,028 0.0011	0,032 0.0013	0,044 0.0017
P7	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 0.0011	0,028 0.0011	0,032 0.0013	0,044 0.0017
P8	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,046 0.0018
P11	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 0.0011	0,028 0.0011	0,032 0.0013	0,044 0.0017
P12	MM06-06006-B90-MD02 F30M	2,0 *0.080*	0,020 0.00080	0,020 0.00080	0,024 0.00095	0,030 0.0012
M1	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,032 0.0013	0,032 0.0013	0,036 0.0014	0,048 0.0019
M2	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,044 0.0017
M3	MM06-06006-B90S-E02 F30M	2,0 *0.080*	0,024 0.00095	0,024 0.00095	0,028 0.0011	0,036 0.0014
M4	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 0.00085	0,022 0.00085	0,024 0.00095	0,030 0.0013
M5	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 0.00085	0,022 0.00085	0,024 0.00095	0,030 0.0013
K1	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,032 0.0013	0,032 0.0013	0,036 0.0014	0,048 0.0019
K2	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,044 0.0017
K3	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,044 0.0017
K4	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,044 0.0017
K5	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,026 0.0010	0,026 0.0010	0,030 0.0012	0,040 0.0016
K6	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,044 0.0017
K7	MM06-06006-B90-MD02 F30M	2,5 *0.10*	0,026 0.0010	0,026 0.0010	0,030 0.0012	0,040 0.0016
N1	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,040 0.0016	0,040 0.0016	0,046 0.0018	0,060 0.0024
N2	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,040 0.0016	0,040 0.0016	0,046 0.0018	0,060 0.0024
N3	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,040 0.0016	0,040 0.0016	0,046 0.0018	0,060 0.0024
N11	MM06-06006-B90S-E02 F30M	2,5 *0.10*	0,040 0.0016	0,040 0.0016	0,046 0.0018	0,060 0.0024
S1	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 0.00085	0,022 0.00085	0,024 0.00095	0,030 0.0013
S2	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 0.00085	0,022 0.00085	0,024 0.00095	0,030 0.0013
S3	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,020 0.00080	0,020 0.00080	0,022 0.00085	0,028 0.0012
S11	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,025 0.0010	0,024 0.00095	0,028 0.0011	0,036 0.0014
S12	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,025 0.0010	0,024 0.00095	0,028 0.0011	0,036 0.0014
S13	MM06-06006-B90-MD02 F30M	1,5 *0.060*	0,022 0.00085	0,022 0.00085	0,024 0.00095	0,030 0.0013
H5	MM06-06006-B90-MD02 F30M	2,0 *0.080*	0,020 0.00080	0,020 0.00080	0,024 0.00095	0,030 0.0012
H8	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,016 0.00065	0,016 0.00065	0,018 0.00070	0,022 0.00095
H11	MM06-06006-B90-MD02 F30M	2,0 *0.080*	0,020 0.00080	0,020 0.00080	0,024 0.00095	0,030 0.0012
H12	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,016 0.00065	0,016 0.00065	0,018 0.00070	0,022 0.00095
H21	MM06-06006-B90-MD02 F30M	1,7 *0.065*	0,016 0.00065	0,016 0.00065	0,018 0.00070	0,022 0.00095

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM06 Z2-Kopierfräser – Auswahl der Wendeschneidplatten – Schlichten – Metrisch/ Zoll

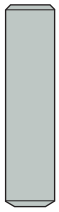
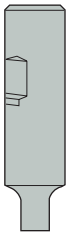
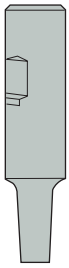
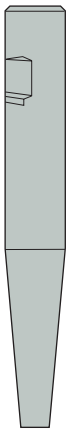
SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 0.00080	0,024 0.00095	0,034 0.0013	0,055 0.0022
P2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 0.00080	0,024 0.00095	0,034 0.0013	0,055 0.0022
P3	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 0.00080	0,024 0.00095	0,032 0.0013	0,050 0.0020
P4	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 0.00075	0,022 0.00085	0,032 0.0013	0,050 0.0020
P5	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
P6	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
P7	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
P8	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 0.00080	0,024 0.00095	0,032 0.0013	0,050 0.0020
P11	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
P12	MM06-06006-B90PF-M01 F15M	1,7 *0.065*	0,013 0.00050	0,015 0.00060	0,020 0.00080	0,032 0.0013
M1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 0.00080	0,024 0.00095	0,034 0.0013	0,055 0.0022
M2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
M3	MM06-06006-B90PF-M01 F15M	1,7 *0.065*	0,015 0.00060	0,018 0.00070	0,025 0.0010	0,038 0.0015
M4	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 0.00055	0,016 0.00065	0,022 0.00085	0,034 0.0013
M5	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 0.00055	0,016 0.00065	0,022 0.00085	0,034 0.0013
K1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,020 0.00080	0,024 0.00095	0,034 0.0013	0,055 0.0022
K2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
K3	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
K4	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
K5	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,017 0.00065	0,020 0.00080	0,028 0.0011	0,044 0.0017
K6	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
K7	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,017 0.00065	0,020 0.00080	0,028 0.0011	0,044 0.0017
N1	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,026 0.0010	0,032 0.0013	0,044 0.0017	0,070 0.0028
N2	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,026 0.0010	0,032 0.0013	0,044 0.0017	0,070 0.0028
N3	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,026 0.0010	0,032 0.0013	0,044 0.0017	0,070 0.0028
N11	MM06-06006-B90PF-M01 F15M	2,0 *0.080*	0,026 0.0010	0,032 0.0013	0,044 0.0017	0,070 0.0028
S1	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 0.00055	0,016 0.00065	0,022 0.00085	0,034 0.0013
S2	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 0.00055	0,016 0.00065	0,022 0.00085	0,034 0.0013
S3	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,013 0.00050	0,014 0.00060	0,020 0.00080	0,032 0.0013
S11	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,015 0.00060	0,018 0.00070	0,025 0.0010	0,038 0.0015
S12	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,015 0.00060	0,018 0.00070	0,025 0.0010	0,038 0.0015
S13	MM06-06006-B90PF-M01 F15M	1,2 *0.048*	0,014 0.00055	0,016 0.00065	0,022 0.00085	0,034 0.0013
H5	MM06-06006-B90PF-M01 F15M	1,7 *0.065*	0,013 0.00050	0,015 0.00060	0,020 0.00080	0,032 0.0013
H8	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,010 0.00040	0,012 0.00048	0,016 0.00065	0,025 0.0010
H11	MM06-06006-B90PF-M01 F15M	1,7 *0.065*	0,013 0.00050	0,015 0.00060	0,020 0.00080	0,032 0.0013
H12	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,010 0.00040	0,012 0.00048	0,016 0.00065	0,025 0.0010
H21	MM06-06006-B90PF-M01 F15M	1,5 *0.060*	0,010 0.00040	0,012 0.00048	0,016 0.00065	0,025 0.0010

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM06 Z2-Kopierfräser – Schnittdaten v_c = (m/min)/(sf/min)

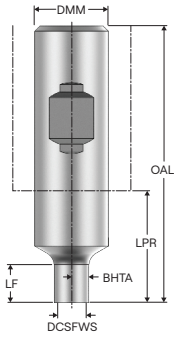
SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	325 *1075*	415 *1350*	430 *1400*	470 *1550*	465 *1525*	275 *900*	345 *1125*	375 *1225*	405 *1325*	405 *1325*	225 *740*	280 *920*	305 *1000*	330 *1075*	325 *1075*
P2	320 *1050*	400 *1300*	420 *1375*	455 *1500*	455 *1500*	265 *870*	335 *1100*	365 *1200*	395 *1300*	395 *1300*	215 *710*	270 *890*	295 *970*	320 *1050*	320 *1050*
P3	275 *900*	345 *1125*	360 *1175*	395 *1300*	395 *1300*	230 *750*	290 *950*	315 *1025*	340 *1125*	340 *1125*	190 *620*	235 *770*	255 *840*	275 *900*	275 *900*
P4	240 *790*	305 *1000*	320 *1050*	345 *1125*	345 *1125*	205 *670*	255 *840*	280 *920*	305 *1000*	300 *980*	165 *540*	205 *670*	225 *740*	245 *800*	245 *800*
P5	230 *750*	290 *950*	305 *1000*	330 *1075*	330 *1075*	195 *640*	245 *800*	265 *870*	290 *950*	290 *950*	160 *520*	200 *660*	215 *710*	235 *770*	235 *770*
P6	260 *850*	330 *1075*	345 *1125*	370 *1225*	370 *1225*	220 *720*	275 *900*	300 *980*	325 *1075*	325 *1075*	180 *590*	225 *740*	245 *800*	265 *870*	260 *850*
P7	245 *800*	310 *1025*	325 *1075*	350 *1150*	350 *1150*	210 *690*	260 *850*	285 *940*	305 *1000*	305 *1000*	170 *560*	210 *690*	230 *750*	250 *820*	245 *800*
P8	230 *750*	290 *950*	305 *1000*	330 *1075*	330 *1075*	195 *640*	245 *800*	265 *870*	285 *940*	290 *950*	160 *520*	200 *660*	215 *710*	230 *750*	235 *770*
P11	240 *790*	300 *980*	315 *1025*	340 *1125*	340 *1125*	200 *660*	255 *840*	275 *900*	300 *980*	295 *970*	165 *540*	205 *670*	220 *720*	240 *790*	240 *790*
P12	145 *475*	185 *610*	190 *620*	205 *670*	205 *670*	130 *425*	160 *520*	170 *560*	180 *590*	180 *590*	105 *345*	130 *425*	135 *445*	145 *475*	145 *475*
M1	255 *840*	325 *1075*	340 *1125*	365 *1200*	365 *1200*	215 *710*	270 *890*	295 *970*	320 *1050*	315 *1025*	175 *570*	220 *720*	240 *790*	260 *850*	255 *840*
M2	210 *690*	265 *870*	275 *900*	300 *980*	300 *980*	175 *570*	220 *720*	240 *790*	260 *850*	260 *850*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*
M3	165 *540*	210 *690*	210 *710*	230 *750*	230 *750*	140 *460*	180 *590*	185 *620*	205 *670*	200 *660*	115 *375*	145 *475*	150 *510*	165 *540*	165 *540*
M4	125 *410*	160 *520*	160 *560*	170 *560*	170 *560*	110 *360*	140 *460*	140 *490*	155 *510*	155 *510*	90 *295*	115 *375*	115 *395*	125 *410*	125 *410*
M5	105 *345*	135 *445*	130 *475*	145 *475*	145 *475*	95 *310*	120 *395*	120 *410*	130 *425*	130 *425*	75 *245*	95 *310*	95 *330*	105 *345*	105 *345*
K1	250 *820*	320 *1050*	335 *1100*	360 *1175*	360 *1175*	210 *690*	265 *870*	290 *950*	315 *1025*	310 *1025*	170 *560*	215 *710*	235 *770*	255 *840*	250 *820*
K2	220 *720*	275 *900*	290 *950*	315 *1025*	315 *1025*	185 *610*	230 *750*	255 *840*	275 *900*	275 *900*	150 *490*	190 *620*	205 *670*	220 *720*	220 *720*
K3	185 *610*	235 *770*	245 *800*	265 *870*	265 *870*	160 *520*	195 *640*	215 *710*	230 *750*	230 *750*	130 *425*	160 *520*	175 *570*	190 *620*	185 *610*
K4	175 *570*	225 *740*	235 *770*	255 *840*	255 *840*	150 *490*	185 *610*	205 *670*	220 *720*	220 *720*	120 *395*	150 *490*	165 *540*	180 *590*	180 *590*
K5	105 *345*	135 *445*	140 *460*	150 *490*	150 *490*	90 *295*	115 *375*	125 *410*	135 *445*	135 *445*	75 *245*	90 *295*	100 *330*	110 *360*	105 *345*
K6	155 *510*	195 *640*	205 *670*	225 *740*	225 *740*	135 *445*	165 *540*	180 *590*	195 *640*	195 *640*	105 *345*	135 *445*	145 *475*	160 *520*	155 *510*
K7	135 *445*	170 *560*	180 *590*	195 *640*	195 *640*	115 *375*	145 *475*	155 *510*	170 *560*	170 *560*	95 *310*	115 *375*	125 *410*	140 *460*	140 *460*
N1	1975 *6475*	2475 *8125*	2600 *8525*	2800 *9175*	2800 *9175*	1625 *5325*	2050 *6725*	2225 *7300*	2400 *7875*	2375 *7800*	1325 *4350*	1650 *5425*	1800 *5900*	1950 *6400*	1925 *6325*
N2	790 *2600*	1000 *3275*	1050 *3450*	1125 *3700*	1125 *3700*	660 *2175*	820 *2700*	900 *2950*	970 *3175*	960 *3150*	530 *1750*	670 *2200*	730 *2400*	790 *2600*	780 *2550*
N3	530 *1750*	670 *2200*	700 *2300*	760 *2500*	750 *2450*	440 *1450*	550 *1800*	600 *1975*	650 *2125*	640 *2100*	355 *1175*	445 *1450*	485 *1600*	520 *1700*	520 *1700*
N11	600 *1975*	760 *2500*	800 *2625*	860 *2825*	860 *2825*	500 *1650*	630 *2075*	680 *2225*	740 *2425*	730 *2400*	405 *1325*	510 *1675*	550 *1800*	600 *1975*	590 *1925*
S1	60 *195*	75 *245*	75 *260*	80 *260*	80 *260*	50 *165*	65 *215*	65 *230*	70 *230*	70 *230*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*
S2	47 *155*	60 *195*	60 *215*	65 *215*	65 *215*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*	34 *110*	43 *140*	43 *150*	47 *155*	47 *155*
S3	41 *135*	50 *165*	50 *180*	55 *180*	55 *180*	36 *120*	46 *150*	46 *160*	50 *165*	50 *165*	29 *95*	37 *120*	38 *130*	40 *130*	40 *130*
S11	85 *280*	105 *345*	105 *360*	115 *375*	115 *375*	75 *245*	95 *310*	95 *310*	105 *345*	100 *330*	60 *195*	75 *245*	75 *260*	85 *280*	85 *280*
S12	55 *180*	75 *245*	75 *245*	80 *260*	80 *260*	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*	41 *135*	55 *180*	55 *180*	55 *180*	55 *180*
S13	33 *110*	42 *140*	42 *150*	45 *150*	45 *150*	29 *95*	37 *120*	37 *130*	40 *130*	40 *130*	24 *80*	30 *100*	30 *105*	33 *110*	33 *110*
H5	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*	34 *110*	43 *140*	45 *150*	49 *160*	49 *160*
H8	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	36 *120*	46 *150*	46 *155*	50 *165*	50 *165*
H11	60 *195*	80 *260*	80 *260*	85 *280*	85 *280*	55 *180*	70 *230*	70 *230*	75 *245*	75 *245*	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*
H12	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	80 *260*	100 *330*	100 *345*	110 *360*	110 *360*	65 *215*	80 *260*	85 *280*	90 *295*	90 *295*
H21	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	36 *120*	46 *150*	46 *155*	50 *165*	50 *165*

Schaftkonstruktion

Ausführung 1, Keilnut-Schaft	Ausführung 2, Zylindrische/Weldon Schnittstelle und 90° Stirnseite
	
Ausführung 3, Zylindrische/Weldon Schnittstelle und 87°/89° Stirnseite	**Konstruktion 4, Zylindrische/Weldon Schnittstelle und 80°/85°/87° Stirnseite**
	
Ausführung 5, Zylindrische Schnittstelle und doppelt konische Stirnseite 89°/85°	
	

MM08 Schaft





Bezeichnung	Produkt-nummer	DCSFWS	DMM	LF	LPR	OAL	BHTA°	Abb.	CSP	RPMX	Auf-nahmen	Gewicht	Ersatzteil Bezeich-nung
		mm	mm	mm	mm	mm						kg	
MM08-10040.0-0007	00083980	7,6	10,0	7,0	7,0	40,0	0,0	2	■	80000	Cylindrical	0,1	2
MM08-10050.0-0007DS	02580665	7,6	10,0	7,0	10,0	50,0	0,0	2	■	80000	Cylindrical Densimet	0,1	3
MM08-10080.0-3023DS	02580702	7,6	10,0	22,9	40,0	80,0	3,0	4	■	80000	Cylindrical Densimet	0,1	3
MM08-12065.0-0000	75034240	7,6	12,0	0,0	20,0	65,0	60,0	1	■	80000	Cylindrical	0,1	1
MM08-12100.0-1035DS	02580719	7,6	12,0	35,0	55,0	100,0	1,0	3	■	80000	Cylindrical Densimet	0,2	3
MM08-12120.0-1050DS	02580720	7,6	12,0	50,0	75,0	120,0	1,0	3	■	80000	Cylindrical Densimet	0,2	3
MM08-16070.3-0007	75034241	7,6	16,0	7,6	22,0	70,0	0,0	2	■	80000	Weldon	0,1	1
MM08-16075.3-3012	75034242	7,6	16,0	12,0	27,0	75,0	3,0	3	■	80000	Weldon	0,1	1
MM08-16120.3-5048M	00042863	7,6	16,0	48,0	72,0	120,0	5,0	4	■	80000	Weldon	0,2	5
MM08-16150.0-1030M	00094751	7,6	16,0	30,0	102,0	150,0	1,0	3	■	80000	Cylindrical	0,2	5
MM08-16150.0-1050M	00094752	7,6	16,0	50,0	102,0	150,0	1,0	3	■	80000	Cylindrical	0,2	4
MM08-16150.0-1070M	00094754	7,6	16,0	70,0	102,0	150,0	1,0	3	■	80000	Cylindrical	0,2	4
MM08-16085.0-0016DS	02580675	7,6	16,0	16,0	37,0	85,0	0,0	2	■	80000	Cylindrical Densimet	0,3	3
MM08-16100.0-0032DS	02580687	7,6	16,0	32,0	52,0	100,0	0,0	2	■	80000	Cylindrical Densimet	0,3	3
MM08-16150.0-1050DS	02580722	7,6	16,0	50,0	102,0	150,0	1,0	3	■	80000	Cylindrical Densimet	0,4	3
MM08-16150.0-1070DS	02580727	7,6	16,0	70,0	102,0	150,0	1,0	3	■	80000	Cylindrical Densimet	0,3	3

Ersatzteile, im Lieferumfang enthalten

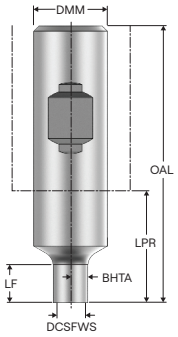
Zubehör

Für Fräser	Hülse	Spannschraube	Schlüssel
			
1	MM-05044	MM08-0524	H05-4
2	MM-05019	MM08-0524	H05-4
3	–	MM08-0524	–
4	MM-05044	MM08-0582	H05-4
5	MM-05044	MM08-0543	H05-4

Innensechskant-Schlüssel H05-4 für die Hülse kann separat bestellt werden.
Steckschlüssel, siehe Wendeschneidplatten-Programm:

MM08 Schaft – Zoll





Bezeichnung	Produkt-nummer	DCSFMS	DMM	LF	LPR	OAL	BHTA°	Abb.	CSP	RPMX	Auf-nahmen	Gewicht	Ersatzteil Bezeich-nung
		Zoll	Zoll	Zoll	Zoll	Zoll						lbs	
MM08-0.38-1.6-0-0002	00096119	0.299	0.375	0.276	0.276	1.575	0,0	2	■	80000	Cylindrical	0.220	3
MM08-0.50-2.6-0-0000	75054599	0.299	0.500	0	0.787	2.559	60,0	1	■	80000	Cylindrical	0.220	1
MM08-0.62-2.8-3-0003	75054600	0.299	0.625	0.299	0.866	2.756	0,0	2	■	80000	Weldon	0.220	1
MM08-0.62-3.0-3-3004	75054601	0.299	0.625	0.472	1.063	2.953	3,0	3	■	80000	Weldon	0.220	1
MM08-0.62-4.7-3-5018	75054602	0.299	0.625	1.850	2.835	4.724	5,0	4	■	80000	Weldon	0.440	2
MM08-0.62-5.9-0-1011	75054604	0.299	0.625	1.181	4.016	5.906	1,0	3	■	80000	Cylindrical	0.440	2
MM08-0.62-3.3-0-0006DS	02593402	0.299	0.625	0.630	1.457	3.346	0,0	2	■	80000	Cylindrical Densimet	0.660	4
MM08-0.62-4.0-0-0012DS	02593403	0.299	0.625	1.260	2.047	3.937	0,0	2	■	80000	Cylindrical Densimet	0.660	4
MM08-0.62-5.9-0-1019DS	02593407	0.299	0.625	1.969	4.016	5.906	1,0	3	■	80000	Cylindrical Densimet	0.880	4
MM08-0.62-5.9-0-1027DS	02593410	0.299	0.625	2.756	4.016	5.906	1,0	3	■	80000	Cylindrical Densimet	0.660	4
MM08-0.75-10.0-0-1019DS	02593413	0.299	0.750	1.969	7.874	9.843	1,0	5	■	80000	Cylindrical Densimet	1.980	4

Ersatzteile, im Lieferumfang enthalten

Zubehör

Für Fräser	Hülse	Spannschraube	Schlüssel
			
1	MM-05044	MM08-0524	H05-4
2	MM-05044	MM08-0543	H05-4
3	MM-05019	MM08-0524	H05-4
4	–	MM08-0524	–

Innensechskant-Schlüssel H05-4 für die Hülse kann separat bestellt werden.
Steckschlüssel, siehe Wendeschneidplatten-Programm:

Nutfräsen/Eckfräsen

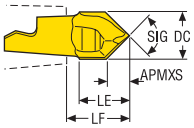


—Drehmomentschlüssel und Drehmomente, siehe Seite 799

											Beschichtung			
Bezeichnung	**DC**	**APMXS**	**RE**	**LF**	**RMPX°**	**C min**	**C max**	**FHA**	**ZEFP**	**Schlüssel**		Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*								T60M	F15M	F30M	F40M
MM08-07805T-R02-D03	7,8 *0.307*	5,4 *0.213*	0,2 *0.008*	6,8 *0.268*	15,0	9,6	15,0	0	2	MM0612		■			
MM08-07809-R02A30-M03	7,8 *0.307*	10,0 *0.394*	0,2 *0.008*	13,0 *0.512*	15,0	9,6	15,0	30	3	MM0416	✓				■
MM08-08005-M03	8,0 *0.315*	5,5 *0.217*	–	6,8 *0.268*	15,0	9,8	15,8	0	2	MM0612		■			
MM08-08005-R04A8-E03	8,0 *0.315*	5,4 *0.213*	0,4 *0.016*	6,7 *0.264*	15,0	9,8	15,0	8	2	MM0612		■		■	
MM08-08005-R04-MD03	8,0 *0.315*	5,5 *0.217*	0,4 *0.016*	6,8 *0.268*	15,0	9,8	15,0	0	2	MM0612		■		■	
MM08-08005-R04P-M02	8,0 *0.315*	5,4 *0.213*	0,4 *0.016*	6,7 *0.264*	15,0	9,8	15,0	0	2	MM0612				■	
MM08-08005-R10-MD03	8,0 *0.315*	5,4 *0.213*	1,0 *0.039*	6,8 *0.268*	15,0	9,8	13,8	0	2	MM0612				■	
MM08-08009-A30-E03	8,0 *0.315*	10,0 *0.394*	–	13,0 *0.512*	15,0	9,8	15,0	30	3	MM0416	✓			■	
MM08-08009-R05A30-M03	8,0 *0.315*	10,0 *0.394*	0,5 *0.020*	13,0 *0.512*	15,0	9,8	14,8	30	3	MM0416	✓				■
MM08-08009-R10A30-D03	8,0 *0.315*	10,0 *0.394*	1,0 *0.039*	13,0 *0.512*	15,0	9,8	13,8	30	3	MM0416	✓			■	
MM08-08009-R10A30-E03	8,0 *0.315*	10,0 *0.394*	1,0 *0.039*	13,0 *0.512*	15,0	9,8	13,8	30	3	MM0416	✓			■	
MM08-08009-R10A30-M03	8,0 *0.315*	10,0 *0.394*	1,0 *0.039*	13,0 *0.512*	15,0	9,8	13,8	30	3	MM0416	✓				■
MM08-08009-R20A30-M03	8,0 *0.315*	10,0 *0.394*	2,0 *0.079*	13,0 *0.512*	15,0	9,8	11,8	30	3	MM0416	✓				■
MM08-08009-R30A30-M03	8,0 *0.315*	10,0 *0.394*	3,0 *0.118*	13,0 *0.512*	15,0	9,8	9,8	30	3	MM0416	✓				■

Zentrierbohren



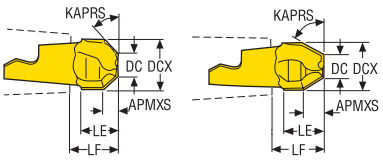


—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DC	APMXS	LE	LF	SIG°	ZEFP	Schlüssel	Beschichtung			
								Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM08-08004-C90-M03	8,0 *0.315*	3,79 *0.149*	8,0 *0.315*	9,5 *0.374*	90,0	2	MM0612	■			
MM08-08006-C120-M03	8,0 *0.315*	2,15 *0.085*	8,32 *0.328*	9,46 *0.372*	120,0	2	MM0612	■			

Anfasen



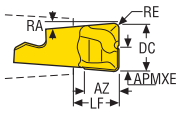


—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DCX	DC	APMXS	RE	LE	LF	KAPRS°	ZEFP	Schlüssel	Beschichtung			
										Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM08-08005-4520-E03	8,0 *0.315*	3,87 *0.152*	2,1 *0.083*	0,2 *0.008*	5,5 *0.217*	6,7 *0.264*	45,0	2	MM0612	■			
MM08-08006-6030-E03	8,0 *0.315*	4,19 *0.165*	3,3 *0.130*	0,24 *0.009*	6,45 *0.254*	7,66 *0.302*	60,0	2	MM0612	■			

Tauchfräser

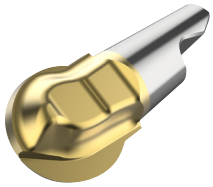




—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DC	APMXE	RE	AZ	LF	RA°	ZEFP	Schlüssel	Beschichtung			
									Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM08-08005-R10-PL-MD03	8,0 *0.315*	4,0 *0.157*	1,0 *0.039*	5,7 *0.224*	6,78 *0.267*	5,0	2	MM0612			■	

Präzisionswendeschneidplatten zum Vorschlichten in allen Werkstoffen



—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DC	APMXS	RE	LE	DN	LF	SA	ZEFP	Schlüssel	Beschichtung			
										Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM08-10010-B120PF-M02	10,0 *0.394*	5,0 *0.197*	5,0 *0.197*	10,0 *0.394*	8,0 *0.315*	10,97 *0.432*	254,0	2	MM0612		■		
MM08-10010-B120P-M04	10,0 *0.394*	5,0 *0.197*	5,0 *0.197*	10,0 *0.394*	8,0 *0.315*	10,97 *0.432*	254,0	2	MM0612			■	

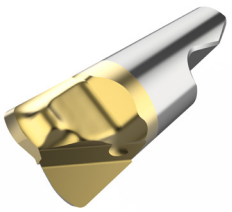
Kopierfräser

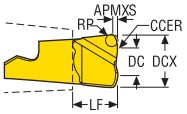


—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DC	APMXS	RE	LF	FHA	ZEFP	Schlüssel		Beschichtung: Beschichtet T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*								
MM08-08008-B90-MD03	8,0 *0.315*	8,1 *0.319*	4,0 *0.157*	9,42 *0.371*		2	MM0612		■		■	
MM08-08008-B90PF-M01	8,0 *0.315*	6,9 *0.272*	4,0 *0.157*	9,39 *0.370*		2	MM0612			■		
MM08-08008-B90P-M03	8,0 *0.315*	6,9 *0.272*	4,0 *0.157*	9,39 *0.370*		2	MM0612				■	
MM08-08008-B90S-E03	8,0 *0.315*	8,1 *0.319*	4,0 *0.157*	9,42 *0.371*		2	MM0612				■	
MM08-08009-B90A30-E03	8,0 *0.315*	10,0 *0.394*	4,0 *0.157*	13,0 *0.512*	30,0	3	MM0416	✓			■	
MM08-08009-B90A30-M03	8,0 *0.315*	10,0 *0.394*	4,0 *0.157*	13,0 *0.512*	30,0	3	MM0416	✓				■

Hochvorschubfräser





—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DCX	DC	APMXS	RP	CCER	LF	RMPX°	C min	C max	ZEFP	Schlüssel	Beschichtung: Beschichtet T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*									
MM08-08.40-HF-MD06	8,0 *0.315*	4,0 *0.157*	0,37 *0.015*	0,88 *0.035*	4,0 *0.157*	6,84 *0.269*	5,0	9,8	14,6	2	MM0612			■	

MM08 - Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,044 0.0017	0,044 0.0017	0,055 0.0022	0,070 0.0028
P2	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,044 0.0017	0,046 0.0018	0,055 0.0022	0,070 0.0028
P3	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,042 0.0017	0,042 0.0017	0,050 0.0020	0,070 0.0028
P4	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,042 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
P5	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 0.0016	0,042 0.0017	0,050 0.0020	0,065 0.0026
P6	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 0.0016	0,040 0.0016	0,048 0.0019	0,065 0.0026
P7	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 0.0016	0,040 0.0016	0,048 0.0019	0,065 0.0026
P8	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,042 0.0017	0,042 0.0017	0,050 0.0020	0,070 0.0028
P11	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 0.0016	0,040 0.0016	0,048 0.0019	0,065 0.0026
P12	MM08-08009-R05A30-M03 F40M	1,4 *0.055*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,044 0.0017
M1	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,044 0.0017	0,046 0.0018	0,055 0.0022	0,070 0.0028
M2	MM08-08009-R05A30-M03 F40M	1,8 *0.070*	0,040 0.0016	0,042 0.0017	0,050 0.0020	0,065 0.0026
M3	MM08-08009-R05A30-M03 F40M	1,4 *0.055*	0,034 0.0013	0,034 0.0013	0,040 0.0016	0,055 0.0022
M4	MM08-08009-R05A30-M03 F40M	1,0 *0.040*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,046 0.0018
M5	MM08-08009-R05A30-M03 F40M	1,0 *0.040*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,046 0.0018
K1	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,050 0.0020	0,048 0.0019	0,055 0.0022	0,075 0.0030
K2	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,044 0.0017	0,044 0.0017	0,050 0.0020	0,065 0.0026
K3	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,044 0.0017	0,044 0.0017	0,050 0.0020	0,065 0.0026
K4	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,044 0.0017	0,044 0.0017	0,050 0.0020	0,065 0.0026
K5	MM08-08009-R10A30-D03 F30M	1,8 *0.070*	0,040 0.0016	0,040 0.0016	0,046 0.0018	0,060 0.0024
K6	MM08-08009-R10A30-D03 F30M	1,8 *0.070*	0,044 0.0017	0,044 0.0017	0,050 0.0020	0,065 0.0026
K7	MM08-08009-R10A30-D03 F30M	1,8 *0.070*	0,040 0.0016	0,040 0.0016	0,046 0.0018	0,060 0.0024
N1	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N2	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N3	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N11	MM08-08009-R10A30-E03 F30M	1,8 *0.070*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
S1	MM08-08009-R10A30-D03 F30M	1,0 *0.040*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
S2	MM08-08009-R10A30-D03 F30M	1,0 *0.040*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
S3	MM08-08009-R10A30-D03 F30M	1,0 *0.040*	0,036 0.0014	0,034 0.0013	0,034 0.0013	0,042 0.0017
S11	MM08-08009-R05A30-M03 F40M	1,2 *0.048*	0,034 0.0013	0,034 0.0013	0,040 0.0016	0,055 0.0022
S12	MM08-08009-R05A30-M03 F40M	1,2 *0.048*	0,034 0.0013	0,034 0.0013	0,040 0.0016	0,055 0.0022
S13	MM08-08009-R05A30-M03 F40M	1,0 *0.040*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,046 0.0018
H5	MM08-08009-R10A30-E03 F30M	1,4 *0.055*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0018
H8	MM08-08009-R10A30-E03 F30M	1,2 *0.048*	0,026 0.0010	0,025 0.0010	0,026 0.0010	0,034 0.0013
H11	MM08-08009-R10A30-E03 F30M	1,4 *0.055*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,044 0.0018
H12	MM08-08009-R10A30-E03 F30M	1,2 *0.048*	0,026 0.0010	0,025 0.0010	0,026 0.0010	0,034 0.0013
H21	MM08-08009-R10A30-E03 F30M	1,2 *0.048*	0,026 0.0010	0,025 0.0010	0,026 0.0010	0,034 0.0013

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM08 - Nut- und Eckfräsen – Schnittdaten v_c = (m/min)/(sf/min)

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	265 *870*	330 *1075*	370 *1225*	410 *1350*	255 *840*	315 *1025*	350 *1150*	385 *1275*	205 *670*	250 *820*	280 *920*	310 *1025*
P2	255 *840*	320 *1050*	360 *1175*	390 *1275*	245 *800*	305 *1000*	340 *1125*	375 *1225*	195 *640*	245 *800*	275 *900*	300 *980*
P3	225 *740*	280 *920*	315 *1025*	340 *1125*	215 *710*	265 *870*	295 *970*	325 *1075*	170 *560*	210 *690*	240 *790*	260 *850*
P4	195 *640*	245 *800*	275 *900*	300 *980*	190 *620*	235 *770*	260 *850*	290 *950*	150 *490*	185 *610*	210 *690*	230 *750*
P5	190 *620*	235 *770*	265 *870*	290 *950*	180 *590*	225 *740*	250 *820*	275 *900*	145 *475*	180 *590*	200 *660*	220 *720*
P6	215 *710*	265 *870*	295 *970*	325 *1075*	205 *670*	255 *840*	280 *920*	310 *1025*	160 *520*	200 *660*	225 *740*	250 *820*
P7	200 *660*	250 *820*	280 *920*	310 *1025*	190 *620*	240 *790*	265 *870*	290 *950*	155 *510*	190 *620*	215 *710*	235 *770*
P8	190 *620*	235 *770*	265 *870*	285 *940*	180 *590*	225 *740*	250 *820*	270 *890*	145 *475*	180 *590*	200 *660*	220 *720*
P11	195 *640*	245 *800*	270 *890*	300 *980*	185 *610*	230 *750*	260 *850*	285 *940*	150 *490*	185 *610*	210 *690*	230 *750*
P12	120 *395*	150 *490*	170 *560*	185 *610*	115 *375*	145 *475*	160 *520*	175 *570*	95 *310*	115 *375*	130 *425*	145 *475*
M1	— —	— —	— —	— —	200 *660*	245 *800*	275 *900*	305 *1000*	160 *520*	195 *640*	220 *720*	240 *790*
M2	— —	— —	— —	— —	165 *540*	200 *660*	225 *740*	250 *820*	130 *425*	160 *520*	180 *590*	200 *660*
M3	— —	— —	— —	— —	130 *425*	160 *520*	175 *570*	195 *640*	105 *345*	130 *425*	145 *475*	155 *510*
M4	— —	— —	— —	— —	100 *330*	120 *395*	135 *445*	150 *490*	80 *260*	100 *330*	110 *360*	120 *395*
M5	— —	— —	— —	— —	80 *260*	100 *330*	115 *375*	125 *410*	65 *215*	85 *280*	90 *295*	100 *330*
K1	205 *670*	255 *840*	285 *940*	310 *1025*	195 *640*	240 *790*	270 *890*	300 *980*	155 *510*	195 *640*	215 *710*	235 *770*
K2	180 *590*	225 *740*	250 *820*	275 *900*	170 *560*	210 *690*	235 *770*	260 *850*	135 *445*	170 *560*	190 *620*	210 *690*
K3	155 *510*	190 *620*	210 *690*	235 *770*	145 *475*	180 *590*	200 *660*	220 *720*	115 *375*	145 *475*	160 *520*	180 *590*
K4	145 *475*	180 *590*	200 *660*	225 *740*	140 *460*	170 *560*	190 *620*	210 *690*	110 *360*	140 *460*	155 *510*	170 *560*
K5	90 *295*	110 *360*	120 *395*	135 *445*	85 *280*	105 *345*	115 *375*	125 *410*	65 *215*	85 *280*	95 *310*	100 *330*
K6	130 *425*	160 *520*	180 *590*	195 *640*	120 *395*	150 *490*	170 *560*	185 *610*	95 *310*	120 *395*	135 *445*	150 *490*
K7	115 *375*	140 *460*	155 *510*	170 *560*	110 *360*	135 *445*	150 *490*	165 *540*	85 *280*	105 *345*	120 *395*	130 *425*
N1	1550 *5075*	1950 *6400*	2150 *7050*	2350 *7700*	1475 *4850*	1850 *6075*	2025 *6650*	2250 *7375*	1175 *3850*	1475 *4850*	1625 *5325*	1800 *5900*
N2	630 *2075*	780 *2550*	870 *2850*	950 *3125*	600 *1975*	750 *2450*	820 *2700*	910 *2975*	475 *1550*	590 *1925*	660 *2175*	720 *2350*
N3	420 *1375*	520 *1700*	580 *1900*	630 *2075*	400 *1300*	495 *1625*	550 *1800*	610 *2000*	315 *1025*	395 *1300*	440 *1450*	485 *1600*
N11	480 *1575*	600 *1975*	660 *2175*	720 *2350*	455 *1500*	570 *1875*	630 *2075*	690 *2275*	360 *1175*	455 *1500*	500 *1650*	550 *1800*
S1	48 *155*	60 *195*	65 *215*	75 *245*	46 *150*	55 *180*	65 *215*	70 *230*	37 *120*	46 *150*	50 *165*	55 *180*
S2	39 *130*	48 *155*	55 *180*	60 *195*	37 *120*	46 *150*	50 *165*	55 *180*	30 *100*	37 *120*	41 *135*	45 *150*
S3	34 *110*	42 *140*	47 *155*	50 *165*	32 *105*	40 *130*	45 *150*	49 *160*	26 *85*	32 *105*	36 *120*	39 *130*
S11	— —	— —	— —	— —	65 *215*	80 *260*	90 *295*	100 *330*	50 *165*	65 *215*	75 *245*	80 *260*
S12	— —	— —	— —	— —	45 *150*	55 *180*	60 *195*	70 *230*	36 *120*	45 *150*	50 *165*	55 *180*
S13	— —	— —	— —	— —	26 *85*	32 *105*	36 *120*	39 *130*	21 *70*	26 *85*	29 *95*	31 *100*
H5	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	31 *100*	39 *130*	43 *140*	47 *155*
H8	42 *140*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*	33 *110*	40 *130*	45 *150*	49 *160*
H11	50 *165*	65 *215*	70 *230*	80 *260*	49 *160*	60 *195*	70 *230*	75 *245*	39 *130*	49 *160*	55 *180*	60 *195*
H12	75 *245*	95 *310*	105 *345*	115 *375*	70 *230*	90 *295*	100 *330*	110 *360*	60 *195*	70 *230*	80 *260*	90 *295*
H21	42 *140*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*	33 *110*	40 *130*	45 *150*	49 *160*

MM08 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Schruppen – Metrisch/ Zoll

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,070 0.0028
P2	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,070 0.0028
P3	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,050 0.0020	0,050 0.0020	0,050 0.0020	0,070 0.0028
P4	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
P5	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 0.0019	0,048 0.0019	0,050 0.0020	0,065 0.0026
P6	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 0.0019	0,048 0.0019	0,050 0.0020	0,065 0.0026
P7	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 0.0019	0,048 0.0019	0,050 0.0020	0,065 0.0026
P8	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,050 0.0020	0,050 0.0020	0,050 0.0020	0,070 0.0028
P11	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 0.0019	0,048 0.0019	0,050 0.0020	0,065 0.0026
P12	MM08-08009-B90A30-M03 F40M	1,4 *0.055*	0,034 0.0013	0,034 0.0013	0,034 0.0013	0,044 0.0017
M1	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,070 0.0028
M2	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 0.0019	0,048 0.0019	0,050 0.0020	0,065 0.0026
M3	MM08-08009-B90A30-M03 F40M	1,4 *0.055*	0,040 0.0016	0,040 0.0016	0,040 0.0016	0,055 0.0022
M4	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
M5	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
K1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,070 0.0028
K2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,048 0.0019	0,048 0.0019	0,050 0.0020	0,065 0.0026
K3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,048 0.0019	0,048 0.0019	0,050 0.0020	0,065 0.0026
K4	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,048 0.0019	0,048 0.0019	0,050 0.0020	0,065 0.0026
K5	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,044 0.0017	0,042 0.0017	0,046 0.0018	0,060 0.0024
K6	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,048 0.0019	0,048 0.0019	0,050 0.0020	0,065 0.0026
K7	MM08-08009-B90A30-M03 F40M	1,8 *0.070*	0,044 0.0017	0,042 0.0017	0,046 0.0018	0,060 0.0024
N1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,070 0.0028	0,065 0.0026	0,070 0.0028	0,090 0.0036
N2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,070 0.0028	0,065 0.0026	0,070 0.0028	0,090 0.0036
N3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,070 0.0028	0,065 0.0026	0,070 0.0028	0,090 0.0036
N11	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,070 0.0028	0,065 0.0026	0,070 0.0028	0,090 0.0036
S1	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
S2	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
S3	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,036 0.0014	0,034 0.0013	0,034 0.0013	0,042 0.0017
S11	MM08-08009-B90A30-M03 F40M	1,2 *0.048*	0,042 0.0017	0,040 0.0016	0,042 0.0017	0,055 0.0022
S12	MM08-08009-B90A30-M03 F40M	1,2 *0.048*	0,042 0.0017	0,040 0.0016	0,042 0.0017	0,055 0.0022
S13	MM08-08009-B90A30-M03 F40M	1,0 *0.040*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
H5	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,034 0.0013	0,034 0.0013	0,034 0.0013	0,044 0.0017
H8	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,028 0.0011	0,026 0.0010	0,026 0.0010	0,034 0.0013
H11	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,034 0.0013	0,034 0.0013	0,034 0.0013	0,044 0.0017
H12	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,028 0.0011	0,026 0.0010	0,026 0.0010	0,034 0.0013
H21	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,028 0.0011	0,026 0.0010	0,026 0.0010	0,034 0.0013

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM08 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Schlichten – Metrisch/ Zoll

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 0.0024	0,070 0.0028	0,10 0.0040	0,16 0.0065
P2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 0.0024	0,070 0.0028	0,10 0.0040	0,17 0.0065
P3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,16 0.0065
P4	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,065 0.0026	0,095 0.0038	0,15 0.0060
P5	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
P6	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
P7	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
P8	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,16 0.0065
P11	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
P12	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,10 0.0040
M1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 0.0024	0,070 0.0028	0,10 0.0040	0,17 0.0065
M2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
M3	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,046 0.0018	0,055 0.0022	0,075 0.0030	0,12 0.0048
M4	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
M5	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
K1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,060 0.0024	0,070 0.0028	0,10 0.0040	0,17 0.0065
K2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K4	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K5	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,050 0.0020	0,060 0.0024	0,080 0.0032	0,13 0.0050
K6	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K7	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,050 0.0020	0,060 0.0024	0,080 0.0032	0,13 0.0050
N1	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,080 0.0032	0,090 0.0036	0,13 0.0050	0,22 0.0085
N2	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,080 0.0032	0,090 0.0036	0,13 0.0050	0,22 0.0085
N3	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,080 0.0032	0,090 0.0036	0,13 0.0050	0,22 0.0085
N11	MM08-08009-B90A30-E03 F30M	1,8 *0.070*	0,080 0.0032	0,090 0.0036	0,13 0.0050	0,22 0.0085
S1	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
S2	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
S3	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,038 0.0015	0,042 0.0017	0,060 0.0024	0,095 0.0038
S11	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,046 0.0018	0,055 0.0022	0,075 0.0030	0,12 0.0048
S12	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,046 0.0018	0,055 0.0022	0,075 0.0030	0,12 0.0048
S13	MM08-08009-B90A30-E03 F30M	1,0 *0.040*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
H5	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,10 0.0040
H8	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,030 0.0012	0,034 0.0013	0,048 0.0019	0,075 0.0030
H11	MM08-08009-B90A30-E03 F30M	1,4 *0.055*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,10 0.0040
H12	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,030 0.0012	0,034 0.0013	0,048 0.0019	0,075 0.0030
H21	MM08-08009-B90A30-E03 F30M	1,2 *0.048*	0,030 0.0012	0,034 0.0013	0,048 0.0019	0,075 0.0030

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM08 Z3 – Kopierfräser – Schnittdaten v_c = (m/min)/(sf/min)

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	280 *920*	330 *1075*	355 *1175*	380 *1250*	380 *1250*	265 *870*	315 *1025*	335 *1100*	360 *1175*	360 *1175*
P2	270 *890*	325 *1075*	345 *1125*	370 *1225*	365 *1200*	260 *850*	310 *1025*	325 *1075*	350 *1150*	350 *1150*
P3	235 *770*	280 *920*	295 *970*	320 *1050*	320 *1050*	225 *740*	270 *890*	280 *920*	305 *1000*	300 *980*
P4	210 *690*	250 *820*	265 *870*	280 *920*	280 *920*	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*
P5	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	240 *790*	260 *850*	255 *840*
P6	225 *740*	265 *870*	280 *920*	305 *1000*	305 *1000*	215 *710*	255 *840*	270 *890*	290 *950*	290 *950*
P7	210 *690*	250 *820*	265 *870*	290 *950*	285 *940*	200 *660*	240 *790*	255 *840*	275 *900*	270 *890*
P8	200 *660*	235 *770*	250 *820*	270 *890*	265 *870*	190 *620*	225 *740*	235 *770*	255 *840*	255 *840*
P11	205 *670*	245 *800*	260 *850*	280 *920*	275 *900*	195 *640*	230 *750*	245 *800*	265 *870*	265 *870*
P12	130 *425*	155 *510*	160 *520*	175 *570*	175 *570*	125 *410*	150 *490*	155 *510*	165 *540*	165 *540*
M1	220 *720*	260 *850*	275 *900*	300 *980*	295 *970*	210 *690*	250 *820*	265 *870*	285 *940*	280 *920*
M2	180 *590*	215 *710*	225 *740*	245 *800*	245 *800*	170 *560*	205 *670*	215 *710*	235 *770*	230 *750*
M3	145 *475*	170 *560*	175 *570*	190 *620*	190 *620*	135 *445*	165 *540*	170 *560*	180 *590*	180 *590*
M4	100 *330*	135 *445*	135 *475*	145 *475*	145 *475*	95 *310*	130 *425*	130 *445*	140 *460*	140 *460*
M5	80 *260*	115 *375*	115 *395*	120 *395*	120 *395*	80 *260*	110 *360*	105 *375*	115 *375*	115 *375*
K1	215 *710*	255 *840*	270 *890*	295 *970*	290 *950*	205 *670*	245 *800*	260 *850*	280 *920*	275 *900*
K2	190 *620*	225 *740*	240 *790*	260 *850*	255 *840*	180 *590*	215 *710*	225 *740*	245 *800*	245 *800*
K3	160 *520*	190 *620*	200 *660*	220 *720*	215 *710*	155 *510*	180 *590*	190 *620*	210 *690*	205 *670*
K4	155 *510*	180 *590*	190 *620*	210 *690*	205 *670*	145 *475*	175 *570*	185 *610*	200 *660*	195 *640*
K5	90 *295*	110 *360*	115 *375*	125 *410*	125 *410*	90 *295*	105 *345*	110 *360*	120 *395*	120 *395*
K6	135 *445*	160 *520*	170 *560*	185 *610*	180 *590*	130 *425*	150 *490*	160 *520*	175 *570*	175 *570*
K7	120 *395*	140 *460*	150 *490*	160 *520*	160 *520*	110 *360*	135 *445*	140 *460*	155 *510*	155 *510*
N1	1625 *5325*	1950 *6400*	2075 *6800*	2225 *7300*	2200 *7225*	1550 *5075*	1850 *6075*	1975 *6475*	2125 *6975*	2100 *6900*
N2	660 *2175*	790 *2600*	830 *2725*	900 *2950*	890 *2925*	630 *2075*	750 *2450*	790 *2600*	850 *2800*	840 *2750*
N3	440 *1450*	520 *1700*	560 *1825*	600 *1975*	590 *1925*	420 *1375*	500 *1650*	530 *1750*	570 *1875*	560 *1825*
N11	500 *1650*	600 *1975*	640 *2100*	680 *2225*	670 *2200*	480 *1575*	570 *1875*	610 *2000*	650 *2125*	640 *2100*
S1	46 *150*	65 *215*	65 *215*	70 *230*	70 *230*	44 *145*	60 *195*	60 *215*	65 *215*	65 *215*
S2	37 *120*	50 *165*	50 *180*	55 *180*	55 *180*	35 *115*	49 *160*	48 *165*	50 *165*	50 *165*
S3	32 *105*	45 *150*	44 *155*	48 *155*	48 *155*	31 *100*	43 *140*	42 *150*	45 *150*	45 *150*
S11	70 *230*	90 *295*	90 *295*	95 *310*	95 *310*	65 *215*	85 *280*	85 *280*	90 *295*	90 *295*
S12	49 *160*	60 *195*	60 *215*	65 *215*	65 *215*	47 *155*	60 *195*	60 *195*	65 *215*	65 *215*
S13	26 *85*	36 *120*	35 *125*	38 *125*	38 *125*	25 *80*	34 *110*	34 *120*	36 *120*	37 *120*
H5	43 *140*	50 *165*	55 *180*	60 *195*	55 *180*	41 *135*	49 *160*	50 *165*	55 *180*	55 *180*
H8	43 *140*	55 *180*	55 *180*	60 *195*	60 *195*	41 *135*	50 *165*	50 *180*	55 *180*	55 *180*
H11	55 *180*	65 *215*	70 *230*	75 *245*	75 *245*	50 *165*	60 *195*	65 *215*	70 *230*	70 *230*
H12	75 *245*	95 *310*	100 *330*	105 *345*	105 *345*	75 *245*	95 *310*	95 *310*	100 *330*	100 *330*
H21	43 *140*	55 *180*	55 *180*	60 *195*	60 *195*	41 *135*	50 *165*	50 *180*	55 *180*	55 *180*

MM08 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Schruppen – Metrisch/ Zoll

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,048 0.0019	0,046 0.0018	0,055 0.0022	0,070 0.0028
P2	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,048 0.0019	0,048 0.0019	0,055 0.0022	0,075 0.0030
P3	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,046 0.0018	0,044 0.0017	0,050 0.0020	0,070 0.0028
P4	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 0.0017	0,044 0.0017	0,050 0.0020	0,070 0.0028
P5	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
P6	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
P7	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
P8	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,046 0.0018	0,044 0.0017	0,050 0.0020	0,070 0.0028
P11	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
P12	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,044 0.0018
M1	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,048 0.0019	0,048 0.0019	0,055 0.0022	0,075 0.0030
M2	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
M3	MM08-08008-B90S-E03 F30M	2,5 *0.10*	0,036 0.0014	0,036 0.0014	0,040 0.0016	0,055 0.0022
M4	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 0.0013	0,034 0.0013	0,036 0.0014	0,046 0.0019
M5	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 0.0013	0,034 0.0013	0,036 0.0014	0,046 0.0019
K1	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,048 0.0019	0,048 0.0019	0,055 0.0022	0,075 0.0030
K2	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
K3	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
K4	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
K5	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,040 0.0016	0,038 0.0015	0,046 0.0018	0,060 0.0024
K6	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
K7	MM08-08008-B90-MD03 F30M	3,0 *0.12*	0,040 0.0016	0,038 0.0015	0,046 0.0018	0,060 0.0024
N1	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N2	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N3	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N11	MM08-08008-B90S-E03 F30M	3,0 *0.12*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
S1	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 0.0013	0,034 0.0013	0,036 0.0014	0,046 0.0019
S2	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 0.0013	0,034 0.0013	0,036 0.0014	0,046 0.0019
S3	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,032 0.0013	0,030 0.0012	0,034 0.0013	0,042 0.0017
S11	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,036 0.0014	0,036 0.0014	0,042 0.0017	0,055 0.0022
S12	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,036 0.0014	0,036 0.0014	0,042 0.0017	0,055 0.0022
S13	MM08-08008-B90-MD03 F30M	1,9 *0.075*	0,034 0.0013	0,034 0.0013	0,036 0.0014	0,046 0.0019
H5	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,044 0.0018
H8	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,024 0.00095	0,024 0.00095	0,026 0.0010	0,034 0.0013
H11	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,044 0.0018
H12	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,024 0.00095	0,024 0.00095	0,026 0.0010	0,034 0.0013
H21	MM08-08008-B90-MD03 F30M	2,5 *0.10*	0,024 0.00095	0,024 0.00095	0,026 0.0010	0,034 0.0013

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM08 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Schlichten – Metrisch/ Zoll

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,020 0.00080	0,024 0.00095	0,032 0.0013	0,050 0.0020
P2	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,020 0.00080	0,024 0.00095	0,034 0.0013	0,055 0.0022
P3	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 0.00075	0,022 0.00085	0,032 0.0013	0,050 0.0020
P4	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
P5	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
P6	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,018 0.00070	0,022 0.00085	0,030 0.0012	0,048 0.0019
P7	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,018 0.00070	0,022 0.00085	0,030 0.0012	0,048 0.0019
P8	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 0.00075	0,022 0.00085	0,032 0.0013	0,050 0.0020
P11	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,018 0.00070	0,022 0.00085	0,030 0.0012	0,048 0.0019
P12	MM08-08008-B90PF-M01 F15M	2,0 *0.080*	0,013 0.00050	0,015 0.00060	0,020 0.00080	0,032 0.0013
M1	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,020 0.00080	0,024 0.00095	0,034 0.0013	0,055 0.0022
M2	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
M3	MM08-08008-B90PF-M01 F15M	2,0 *0.080*	0,015 0.00060	0,018 0.00070	0,024 0.00095	0,038 0.0015
M4	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 0.00055	0,015 0.00065	0,022 0.00085	0,034 0.0013
M5	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 0.00055	0,015 0.00065	0,022 0.00085	0,034 0.0013
K1	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,020 0.00080	0,024 0.00095	0,034 0.0013	0,055 0.0022
K2	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
K3	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
K4	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
K5	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,017 0.00065	0,020 0.00080	0,028 0.0011	0,044 0.0017
K6	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,019 0.00075	0,022 0.00085	0,030 0.0012	0,048 0.0019
K7	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,017 0.00065	0,020 0.00080	0,028 0.0011	0,044 0.0017
N1	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,070 0.0028
N2	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,070 0.0028
N3	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,070 0.0028
N11	MM08-08008-B90PF-M01 F15M	3,0 *0.12*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,070 0.0028
S1	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 0.00055	0,015 0.00065	0,022 0.00085	0,034 0.0013
S2	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 0.00055	0,015 0.00065	0,022 0.00085	0,034 0.0013
S3	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,013 0.00050	0,014 0.00060	0,020 0.00080	0,030 0.0012
S11	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,015 0.00060	0,018 0.00070	0,024 0.00095	0,038 0.0015
S12	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,015 0.00060	0,018 0.00070	0,024 0.00095	0,038 0.0015
S13	MM08-08008-B90PF-M01 F15M	1,7 *0.065*	0,014 0.00055	0,015 0.00065	0,022 0.00085	0,034 0.0013
H5	MM08-08008-B90PF-M01 F15M	2,0 *0.080*	0,013 0.00050	0,015 0.00060	0,020 0.00080	0,032 0.0013
H8	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,010 0.00040	0,011 0.00048	0,016 0.00065	0,025 0.0010
H11	MM08-08008-B90PF-M01 F15M	2,0 *0.080*	0,013 0.00050	0,015 0.00060	0,020 0.00080	0,032 0.0013
H12	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,010 0.00040	0,011 0.00048	0,016 0.00065	0,025 0.0010
H21	MM08-08008-B90PF-M01 F15M	1,9 *0.075*	0,010 0.00040	0,011 0.00048	0,016 0.00065	0,025 0.0010

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM08 Z2 – Kopierfräser – Schnittdaten v_c = (m/min)/(sf/min)

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	320 *1050*	405 *1325*	430 *1400*	465 *1525*	465 *1525*	265 *870*	330 *1075*	360 *1175*	385 *1275*	385 *1275*	215 *710*	265 *870*	290 *950*	315 *1025*	310 *1025*
P2	315 *1025*	395 *1300*	420 *1375*	450 *1475*	450 *1475*	260 *850*	320 *1050*	345 *1125*	375 *1225*	370 *1225*	210 *690*	260 *850*	280 *920*	305 *1000*	300 *980*
P3	270 *890*	340 *1125*	360 *1175*	390 *1275*	390 *1275*	225 *740*	280 *920*	300 *980*	325 *1075*	325 *1075*	180 *590*	225 *740*	245 *800*	265 *870*	260 *850*
P4	240 *790*	300 *980*	320 *1050*	345 *1125*	345 *1125*	200 *660*	245 *800*	265 *870*	285 *940*	285 *940*	160 *520*	200 *660*	215 *710*	230 *750*	230 *750*
P5	225 *740*	285 *940*	305 *1000*	330 *1075*	330 *1075*	190 *620*	235 *770*	255 *840*	275 *900*	275 *900*	155 *510*	190 *620*	205 *670*	220 *720*	220 *720*
P6	255 *840*	320 *1050*	340 *1125*	370 *1225*	370 *1225*	210 *690*	265 *870*	285 *940*	310 *1025*	305 *1000*	170 *560*	215 *710*	230 *750*	250 *820*	250 *820*
P7	240 *790*	300 *980*	320 *1050*	350 *1150*	350 *1150*	200 *660*	250 *820*	270 *890*	295 *970*	290 *950*	160 *520*	200 *660*	220 *720*	235 *770*	235 *770*
P8	225 *740*	285 *940*	305 *1000*	330 *1075*	330 *1075*	190 *620*	235 *770*	250 *820*	275 *900*	270 *890*	150 *490*	190 *620*	205 *670*	220 *720*	220 *720*
P11	235 *770*	295 *970*	315 *1025*	340 *1125*	340 *1125*	195 *640*	240 *790*	260 *850*	285 *940*	280 *920*	160 *520*	195 *640*	210 *690*	230 *750*	230 *750*
P12	145 *475*	185 *610*	185 *620*	200 *660*	200 *660*	125 *410*	155 *510*	165 *540*	175 *570*	175 *570*	100 *330*	125 *410*	130 *445*	145 *475*	140 *460*
M1	250 *820*	315 *1025*	335 *1100*	365 *1200*	365 *1200*	210 *690*	260 *850*	280 *920*	305 *1000*	300 *980*	170 *560*	210 *690*	225 *740*	245 *800*	240 *790*
M2	205 *670*	255 *840*	275 *900*	295 *970*	295 *970*	170 *560*	210 *690*	230 *750*	245 *800*	245 *800*	140 *460*	170 *560*	185 *610*	200 *660*	200 *660*
M3	165 *540*	205 *670*	210 *710*	225 *740*	225 *740*	135 *445*	175 *570*	180 *590*	195 *640*	195 *640*	110 *360*	140 *460*	145 *475*	155 *510*	155 *510*
M4	125 *410*	160 *520*	160 *560*	170 *560*	170 *560*	110 *360*	140 *460*	135 *475*	150 *490*	150 *490*	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*
M5	105 *345*	135 *445*	130 *460*	140 *460*	140 *460*	90 *295*	115 *375*	115 *395*	125 *410*	125 *410*	75 *245*	95 *310*	90 *330*	100 *330*	100 *330*
K1	250 *820*	310 *1025*	330 *1075*	360 *1175*	355 *1175*	205 *670*	255 *840*	275 *900*	300 *980*	295 *970*	165 *540*	205 *670*	220 *720*	240 *790*	240 *790*
K2	215 *710*	270 *890*	290 *950*	310 *1025*	310 *1025*	180 *590*	225 *740*	240 *790*	260 *850*	260 *850*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*
K3	180 *590*	230 *750*	245 *800*	265 *870*	265 *870*	150 *490*	190 *620*	205 *670*	220 *720*	220 *720*	125 *410*	155 *510*	165 *540*	180 *590*	180 *590*
K4	175 *570*	220 *720*	235 *770*	250 *820*	250 *820*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*	115 *375*	145 *475*	160 *520*	170 *560*	170 *560*
K5	105 *345*	130 *425*	140 *460*	150 *490*	150 *490*	90 *295*	110 *360*	120 *395*	125 *410*	125 *410*	70 *230*	90 *295*	95 *310*	105 *345*	105 *345*
K6	155 *510*	190 *620*	205 *670*	220 *720*	220 *720*	130 *425*	160 *520*	170 *560*	185 *610*	185 *610*	105 *345*	130 *425*	140 *460*	150 *490*	150 *490*
K7	135 *445*	165 *540*	180 *590*	195 *640*	195 *640*	110 *360*	140 *460*	150 *490*	165 *540*	165 *540*	90 *295*	110 *360*	120 *395*	130 *425*	130 *425*
N1	1925 *6325*	2425 *7950*	2575 *8450*	2800 *9175*	2775 *9100*	1550 *5075*	1925 *6325*	2075 *6800*	2250 *7375*	2225 *7300*	1250 *4100*	1550 *5075*	1675 *5500*	1825 *6000*	1800 *5900*
N2	780 *2550*	980 *3225*	1050 *3450*	1125 *3700*	1125 *3700*	630 *2075*	780 *2550*	840 *2750*	910 *2975*	900 *2950*	510 *1675*	630 *2075*	680 *2225*	740 *2425*	730 *2400*
N3	520 *1700*	650 *2125*	700 *2300*	750 *2450*	750 *2450*	420 *1375*	520 *1700*	560 *1825*	610 *2000*	600 *1975*	340 *1125*	420 *1375*	455 *1500*	490 *1600*	485 *1600*
N11	590 *1925*	740 *2425*	800 *2625*	860 *2825*	860 *2825*	480 *1575*	590 *1925*	640 *2100*	700 *2300*	690 *2275*	390 *1275*	480 *1575*	520 *1700*	560 *1825*	560 *1825*
S1	60 *195*	75 *245*	75 *260*	80 *260*	80 *260*	50 *165*	65 *215*	65 *230*	70 *230*	70 *230*	41 *135*	50 *165*	50 *180*	55 *180*	55 *180*
S2	47 *155*	60 *195*	60 *215*	65 *215*	65 *215*	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	33 *110*	42 *140*	42 *145*	45 *150*	45 *150*
S3	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	35 *115*	45 *150*	45 *155*	48 *155*	48 *155*	28 *90*	36 *120*	36 *125*	39 *130*	39 *130*
S11	85 *280*	105 *345*	105 *360*	115 *375*	115 *375*	70 *230*	90 *295*	90 *310*	100 *330*	100 *330*	55 *180*	75 *245*	75 *245*	80 *260*	80 *260*
S12	60 *195*	75 *245*	75 *245*	80 *260*	80 *260*	48 *155*	60 *195*	65 *215*	70 *230*	70 *230*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*
S13	33 *110*	42 *140*	42 *150*	45 *150*	45 *150*	28 *90*	36 *120*	36 *125*	39 *130*	39 *130*	23 *75*	29 *95*	29 *100*	31 *100*	32 *105*
H5	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	41 *135*	50 *165*	55 *180*	60 *195*	60 *195*	33 *110*	42 *140*	44 *145*	47 *155*	47 *155*
H8	49 *160*	60 *195*	60 *215*	65 *215*	65 *215*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*	34 *110*	44 *145*	45 *150*	48 *155*	48 *155*
H11	60 *195*	80 *260*	80 *260*	85 *280*	85 *280*	55 *180*	65 *215*	70 *230*	75 *245*	75 *245*	43 *140*	55 *180*	55 *180*	60 *195*	60 *195*
H12	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	75 *245*	100 *330*	100 *345*	105 *345*	105 *345*	60 *195*	80 *260*	80 *280*	85 *280*	85 *280*
H21	49 *160*	60 *195*	60 *215*	65 *215*	65 *215*	42 *140*	55 *180*	55 *180*	60 *195*	60 *195*	34 *110*	44 *145*	45 *150*	48 *155*	48 *155*

MM08 Hohe Vorschübe – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

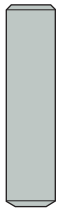
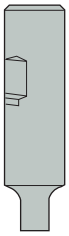
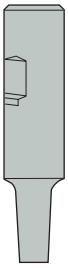
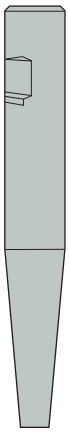
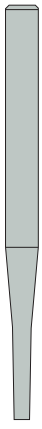
SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 0.013	0,32 0.013	0,42 0.017	0,50 0.020
P2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 0.013	0,32 0.013	0,42 0.017	0,50 0.020
P3	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,30 0.012	0,30 0.012	0,40 0.016	0,48 0.019
P4	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,30 0.012	0,30 0.012	0,38 0.015	0,48 0.019
P5	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 0.011	0,30 0.012	0,38 0.015	0,46 0.018
P6	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 0.011	0,28 0.011	0,38 0.015	0,46 0.018
P7	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 0.011	0,28 0.011	0,38 0.015	0,46 0.018
P8	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,30 0.012	0,30 0.012	0,40 0.016	0,48 0.019
P11	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 0.011	0,28 0.011	0,38 0.015	0,46 0.018
P12	MM08-08.40-HF-MD06 F30M	0,20 *0.0080*	0,20 0.0080	0,20 0.0080	0,25 0.010	0,30 0.012
M1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 0.013	0,32 0.013	0,42 0.017	0,50 0.020
M2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 0.011	0,30 0.012	0,38 0.015	0,46 0.018
M3	MM08-08.40-HF-MD06 F30M	0,20 *0.0080*	0,24 0.0095	0,24 0.0095	0,30 0.012	0,36 0.014
M4	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 0.0080	0,20 0.0080	0,26 0.010	0,32 0.013
M5	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 0.0080	0,20 0.0080	0,26 0.010	0,32 0.013
K1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,32 0.013	0,32 0.013	0,42 0.017	0,50 0.020
K2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 0.011	0,30 0.012	0,38 0.015	0,46 0.018
K3	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 0.011	0,30 0.012	0,38 0.015	0,46 0.018
K4	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 0.011	0,30 0.012	0,38 0.015	0,46 0.018
K5	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,26 0.010	0,26 0.010	0,34 0.013	0,42 0.017
K6	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,28 0.011	0,30 0.012	0,38 0.015	0,46 0.018
K7	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,26 0.010	0,26 0.010	0,34 0.013	0,42 0.017
N1	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,40 0.016	0,40 0.016	0,55 0.022	0,70 0.028
N2	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,40 0.016	0,40 0.016	0,55 0.022	0,70 0.028
N3	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,40 0.016	0,40 0.016	0,55 0.022	0,70 0.028
N11	MM08-08.40-HF-MD06 F30M	0,26 *0.010*	0,40 0.016	0,40 0.016	0,55 0.022	0,70 0.028
S1	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 0.0080	0,20 0.0080	0,26 0.010	0,32 0.013
S2	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 0.0080	0,20 0.0080	0,26 0.010	0,32 0.013
S3	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,19 0.0075	0,19 0.0075	0,24 0.0095	0,30 0.012
S11	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,24 0.0095	0,24 0.0095	0,30 0.012	0,36 0.014
S12	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,24 0.0095	0,24 0.0095	0,30 0.012	0,36 0.014
S13	MM08-08.40-HF-MD06 F30M	0,16 *0.0065*	0,20 0.0080	0,20 0.0080	0,26 0.010	0,32 0.013
H5	MM08-08.40-HF-MD06 F30M	0,20 *0.0080*	0,20 0.0080	0,20 0.0080	0,25 0.010	0,30 0.012
H8	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,16 0.0065	0,15 0.0060	0,19 0.0075	0,24 0.0095
H11	MM08-08.40-HF-MD06 F30M	0,20 *0.0080*	0,20 0.0080	0,20 0.0080	0,25 0.010	0,30 0.012
H12	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,16 0.0065	0,15 0.0060	0,19 0.0075	0,24 0.0095
H21	MM08-08.40-HF-MD06 F30M	0,18 *0.0070*	0,16 0.0065	0,15 0.0060	0,19 0.0075	0,24 0.0095

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM08 Hohe Vorschübe Schnittdaten v_c = (m/min)/(sf/min)

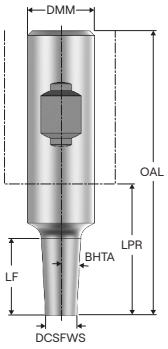
SMG	F30M			
	100%	70%	30%	20%
P1	250 *820*	305 *1000*	350 *1150*	375 *1225*
P2	245 *800*	300 *980*	345 *1125*	365 *1200*
P3	215 *710*	260 *850*	300 *980*	315 *1025*
P4	190 *620*	230 *750*	265 *870*	275 *900*
P5	180 *590*	220 *720*	255 *840*	265 *870*
P6	205 *670*	250 *820*	285 *940*	300 *980*
P7	190 *620*	235 *770*	270 *890*	285 *940*
P8	180 *590*	220 *720*	250 *820*	265 *870*
P11	185 *610*	230 *750*	260 *850*	275 *900*
P12	120 *395*	145 *475*	165 *540*	175 *570*
M1	195 *640*	240 *790*	275 *900*	295 *970*
M2	165 *540*	195 *640*	230 *750*	240 *790*
M3	130 *425*	155 *510*	180 *590*	190 *620*
M4	100 *330*	120 *395*	140 *460*	145 *475*
M5	85 *280*	100 *330*	115 *375*	120 *395*
K1	195 *640*	235 *770*	270 *890*	290 *950*
K2	170 *560*	210 *690*	240 *790*	255 *840*
K3	145 *475*	175 *570*	205 *670*	215 *710*
K4	140 *460*	170 *560*	195 *640*	205 *670*
K5	85 *280*	105 *345*	120 *395*	125 *410*
K6	125 *410*	150 *490*	170 *560*	180 *590*
K7	110 *360*	130 *425*	150 *490*	160 *520*
N1	1475 *4850*	1800 *5900*	2050 *6725*	2125 *6975*
N2	590 *1925*	720 *2350*	820 *2700*	860 *2825*
N3	395 *1300*	480 *1575*	550 *1800*	570 *1875*
N11	450 *1475*	550 *1800*	630 *2075*	650 *2125*
S1	48 *155*	55 *180*	65 *215*	70 *230*
S2	39 *130*	46 *150*	50 *165*	55 *180*
S3	33 *110*	40 *130*	46 *150*	48 *155*
S11	65 *215*	80 *260*	90 *295*	95 *310*
S12	46 *150*	55 *180*	65 *215*	65 *215*
S13	27 *90*	32 *105*	36 *120*	38 *125*
H5	40 *130*	47 *155*	55 *180*	60 *195*
H8	41 *135*	50 *165*	55 *180*	60 *195*
H11	50 *165*	60 *195*	70 *230*	75 *245*
H12	75 *245*	90 *295*	100 *330*	105 *345*
H21	41 *135*	50 *165*	55 *180*	60 *195*

Schaftkonstruktion

Ausführung 1, Keilnut-Schaft	Ausführung 2, Zylindrische/Weldon Schnittstelle und 90° Stirnseite
	
Ausführung 3, Zylindrische/Weldon Schnittstelle und 87°/89° Stirnseite	**Konstruktion 4, Zylindrische/Weldon Schnittstelle und 80°/85°/87° Stirnseite**
	
Ausführung 5, Zylindrische Schnittstelle und doppelt konische Stirnseite 89°/85°	
	

MM10 Schaft

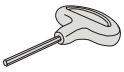




Bezeichnung	Produkt-nummer	DCSFWS	DMM	LF	LPR	OAL	BHTA°	Abb.	CSP	RPMX	Auf-nahmen	Gewicht	Ersatzteil Bezeich-nung
		mm	mm	mm	mm	mm						kg	
MM10-10045.0-0007	00083979	9,6	10,0	7,0	7,0	45,0	0,0	2	■	80000	Cylindrical	0,1	2
MM10-12060.0-0007DS	02580667	9,6	12,0	7,0	15,0	60,0	0,0	2	■	76300	Cylindrical Densimet	0,1	3
MM10-12085.0-3024DS	02580704	9,5	12,0	23,8	40,0	85,0	3,0	4	■	76300	Cylindrical Densimet	0,2	3
MM10-12100.0-1035DS	02580733	9,5	12,0	35,0	55,0	100,0	1,0	3	■	76300	Cylindrical Densimet	0,2	3
MM10-14120.0-1050DS	02580736	9,5	14,0	50,0	75,0	120,0	1,0	3	■	76300	Cylindrical Densimet	0,3	3
MM10-16065.0-0000	75004925	9,5	16,0	0,0	17,0	65,0	60,0	1	■	80000	Cylindrical	0,1	1
MM10-16160.0-1035M	00094757	9,5	16,0	35,0	112,0	160,0	1,0	3	■	80000	Cylindrical	0,2	6
MM10-16160.0-1055M	00094758	9,5	16,0	55,0	112,0	160,0	1,0	3	■	80000	Cylindrical	0,2	7
MM10-16160.0-1075M	00094760	9,5	16,0	75,0	112,0	160,0	1,0	3	■	80000	Cylindrical	0,2	7
MM10-16085.0-0020DS	02580688	9,5	16,0	20,0	37,0	85,0	0,0	2	■	76300	Cylindrical Densimet	0,3	3
MM10-16105.0-0040DS	02580689	9,5	16,0	40,0	57,0	105,0	0,0	2	■	76300	Cylindrical Densimet	0,3	3
MM10-16160.0-1055DS	02580748	9,5	16,0	55,0	112,0	160,0	1,0	3	■	76300	Cylindrical Densimet	0,4	3
MM10-16160.0-1075DS	02580749	9,5	16,0	75,0	112,0	160,0	1,0	3	■	76300	Cylindrical Densimet	0,4	3
MM10-20075.3-0010	75012787	9,5	20,0	10,0	25,0	75,0	0,0	2	■	80000	Weldon	0,2	4
MM10-20085.3-3023	75012788	9,5	20,0	23,0	35,0	85,0	3,0	3	■	80000	Weldon	0,2	4
MM10-20140.3-5060	75012789	9,5	20,0	60,0	90,0	140,0	5,0	4	■	80000	Weldon	0,3	5
MM10-20250.0-1055DS	02580750	9,5	20,0	55,0	200,0	250,0	1,0	5	■	76300	Cylindrical Densimet	1,0	3
MM10-32250.0-10063	75069366	9,5	32,0	63,8	190,0	250,0	10,0	4	■	80000	Cylindrical	1,3	5

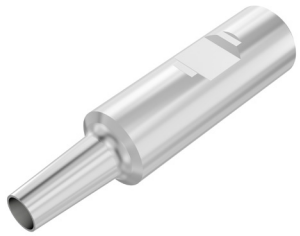
Ersatzteile, im Lieferumfang enthalten

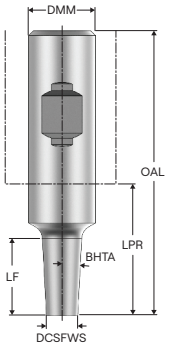
Zubehör

Für Fräser	Hülse	Spannschraube	Schlüssel
			
1	MM-06032	MM10-0627	H06-4
2	MM-06020	MM10-0627	H05-4
3	–	MM10-061027	–
4	MM-06048	MM10-0627	H06-4
5	MM-06116	MM10-0627	H06-4
6	MM-06048	MM10-0651	H06-4
7	MM-06032	MM10-0688	H06-4

Innensechskant-Schlüssel H05-4 für die Hülse kann separat bestellt werden.
Steckschlüssel, siehe Wendeschneidplatten-Programm:

MM10 Schaft – Zoll





Bezeichnung	Produkt-nummer	DCSFMS	DMM	LF	LPR	OAL	BHTA°	Abb.	CSP	RPMX	Auf-nahmen	Gewicht	Ersatzteil Bezeich-nung
		Zoll	Zoll	Zoll	Zoll	Zoll						lbs	
MM10-0.38-1.8-0-0002	00096126	0.360	0.375	0.276	0.276	1.772	0,0	2	■	80000	Cylindrical	0.220	2
MM10-0.62-2.6-0-0000	75005069	0.374	0.625	0	0.669	2.559	60,0	1	■	80000	Cylindrical	0.220	1
MM10-0.62-6.3-0-1021	75054608	0.360	0.625	2.165	4.409	6.299	1,0	3	■	80000	Cylindrical	0.440	7
MM10-0.75-3.0-3-0004	75015052	0.360	0.750	0.394	0.984	2.953	0,0	2	■	80000	Weldon	0.440	3
MM10-0.75-3.3-3-3009	75015053	0.374	0.750	0.906	1.378	3.346	3,0	3	■	80000	Weldon	0.440	3
MM10-0.75-5.5-3-5021	75015054	0.374	0.750	2.150	3.543	5.512	5,0	4	■	80000	Weldon	0.660	5
MM10-0.75-10.0-0-1021DS	02593420	0.360	0.750	2.165	7.874	9.843	1,0	5	■	76300	Cylindrical Densimet	1.980	4
MM10-0.75-4.1-0-0015DS	02593422	0.360	0.750	1.575	2.165	4.134	0,0	2	■	76300	Cylindrical Densimet	0.660	4
MM10-1.25-10.0-0-10024	00096132	0.374	1.250	2.484	7.480	9.843	10,0	4	■	80000	Cylindrical	2.870	5

Ersatzteile, im Lieferumfang enthalten

Zubehör

Für Fräser	Hülse	Spannschraube	Schlüssel
			
1	MM-06032	MM10-0627	H06-4
2	MM-06020	MM10-0627	H05-4
3	MM-06048	MM10-0627	H06-4
4	–	MM10-061027	–
5	MM-06116	MM10-0627	H06-4
7	MM-06032	MM10-0688	H06-4

Innensechskant-Schlüssel H05-4 für die Hülse kann separat bestellt werden.
Steckschlüssel, siehe Wendeschneidplatten-Programm:

Nutfräsen/Eckfräsen

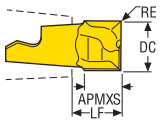


—Drehmomentschlüssel und Drehmomente, siehe Seite 799

												Beschichtung			
Bezeichnung	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Schlüssel		Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*								T60M	F15M	F30M	F40M
MM10-09512-A30-E03	9,525 *0.375*	11,8 *0.465*	–	15,72 *0.619*	15,0	11,6	18,8	30	3	MM0416	✓			■	
MM10-09512-R03A30-M03	9,525 *0.375*	11,8 *0.465*	0,3 *0.012*	15,72 *0.619*	15,0	11,6	18,2	30	3	MM0416	✓				■
MM10-09512-R04A30-M03	9,525 *0.375*	11,8 *0.465*	0,4 *0.016*	15,72 *0.619*	15,0	11,6	18,0	30	3	MM0416	✓				■
MM10-09512-R08A30-M03	9,525 *0.375*	11,8 *0.465*	0,8 *0.031*	15,72 *0.619*	15,0	11,6	17,2	30	3	MM0416	✓				■
MM10-09512-R16A30-M03	9,525 *0.375*	11,8 *0.465*	1,6 *0.063*	15,72 *0.619*	15,0	11,6	15,6	30	3	MM0416	✓				■
MM10-10012-A30-E03	10,0 *0.394*	11,8 *0.465*	–	15,72 *0.619*	15,0	12,2	19,8	30	3	MM0416	✓			■	
MM10-10012-R05A30-M03	10,0 *0.394*	11,8 *0.465*	0,5 *0.020*	15,72 *0.619*	15,0	12,2	18,8	30	3	MM0416	✓				■
MM10-10012-R10A30-D03	10,0 *0.394*	11,8 *0.465*	1,0 *0.039*	15,72 *0.619*	15,0	12,2	17,8	30	3	MM0416	✓			■	
MM10-10012-R10A30-E03	10,0 *0.394*	11,8 *0.465*	1,0 *0.039*	15,72 *0.619*	15,0	12,2	17,8	30	3	MM0416	✓			■	
MM10-10012-R10A30-M03	10,0 *0.394*	11,8 *0.465*	1,0 *0.039*	15,72 *0.619*	15,0	12,2	17,8	30	3	MM0416	✓				■
MM10-10012-R20A30-M03	10,0 *0.394*	11,8 *0.465*	2,0 *0.079*	15,72 *0.619*	15,0	12,2	15,8	30	3	MM0416	✓				■
MM10-10012-R30A30-M03	10,0 *0.394*	11,8 *0.465*	3,0 *0.118*	15,72 *0.619*	15,0	12,2	13,8	30	3	MM0416	✓				■

Nutfräsen/Eckfräsen



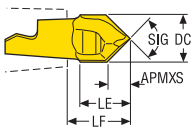


—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Schlüssel	Beschichtung			
											Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*							T60M	F15M	F30M	F40M
MM10-09510-M03	9,525 *0.375*	6,8 *0.268*	–	8,5 *0.335*	15,0	11,6	18,8	0	2	MM0612	■			
MM10-09510-R04-MD04	9,525 *0.375*	6,8 *0.268*	0,4 *0.016*	8,49 *0.334*	15,0	11,6	18,0	0	2	MM0612	■			
MM10-09510-R08A8-E03	9,525 *0.375*	6,6 *0.260*	0,8 *0.031*	8,37 *0.330*	15,0	11,6	17,2	8	2	MM0612			■	
MM10-09807T-R03-D04	9,8 *0.386*	6,8 *0.268*	0,3 *0.012*	8,49 *0.334*	15,0	11,9	18,8	0	2	MM0612	■			
MM10-10007-M03	10,0 *0.394*	6,9 *0.272*	–	8,5 *0.335*	15,0	12,2	19,8	0	2	MM0612	■			
MM10-10007-R04A8-E03	10,0 *0.394*	6,6 *0.260*	0,4 *0.016*	8,44 *0.332*	15,0	12,2	19,0	8	2	MM0612	■		■	
MM10-10007-R04-MD04	10,0 *0.394*	6,8 *0.268*	0,4 *0.016*	8,49 *0.334*	15,0	12,2	19,0	0	2	MM0612	■		■	
MM10-10007-R04P-M03	10,0 *0.394*	6,7 *0.264*	0,4 *0.016*	8,38 *0.330*	15,0	12,2	19,0	0	2	MM0612			■	
MM10-10007-R10-MD04	10,0 *0.394*	6,8 *0.268*	1,0 *0.039*	8,48 *0.334*	15,0	12,2	17,8	0	2	MM0612	■		■	
MM10-10007-R20-MD04	10,0 *0.394*	6,8 *0.268*	2,0 *0.079*	8,46 *0.333*	15,0	12,2	15,8	0	2	MM0612			■	
MM10-10007-R30-MD04	10,0 *0.394*	6,8 *0.268*	3,0 *0.118*	8,44 *0.332*	15,0	12,2	13,8	0	2	MM0612			■	

Zentrierbohren



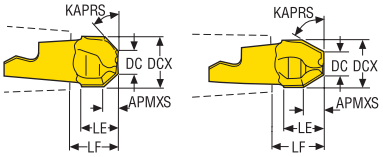


—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DC	APMXS	RE	LF	SIG°	ZEFP	Schlüssel	Beschichtung			
								Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM10-10005-C90-M03	10,0 *0.394*	4,69 *0.185*	– –	11,8 *0.465*	90,0	2	MM0612	■			
MM10-10007-C120-M03	10,0 *0.394*	2,7 *0.106*	– –	11,8 *0.465*	120,0	2	MM0612	■			

Anfasen



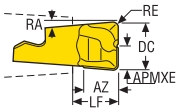


—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DCX	DC	APMXS	RE	LE	LF	KAPRS°	ZEFP	Schlüssel	Beschichtung			
										Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM10-10007-4525-E03	10,0 *0.394*	4,82 *0.190*	2,6 *0.102*	0,3 *0.012*	6,94 *0.273*	8,48 *0.334*	45,0	2	MM0612	■			
MM10-10008-6040-E03	10,0 *0.394*	5,24 *0.206*	4,0 *0.157*	0,3 *0.012*	8,05 *0.317*	9,6 *0.378*	60,0	2	MM0612	■			

Tauchfräser

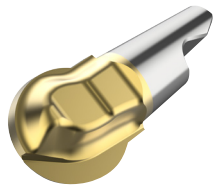




—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DC	APMXE	RE	AZ	LF	RA°	ZEFP	Schlüssel	Beschichtung			
									Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM10-10007-R10-PL-MD04	10,0 *0.394*	5,0 *0.197*	1,0 *0.039*	7,1 *0.280*	8,48 *0.334*	5,0	2	MM0612			■	

Präzisionswendeschneidplatten zum Vorschlichten in allen Werkstoffen



—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DC	APMXS	RE	LE	DN	LF	SA	ZEFP	Schlüssel	Beschichtung			
										Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM10-12012-B120P-M05	12,0 *0.472*	6,0 *0.236*	6,0 *0.236*	12,0 *0.472*	10,0 *0.394*	13,2 *0.520*	247,0	2	MM0612			■	
MM10-12712-B120P-M05	12,7 *0.500*	6,35 *0.250*	6,35 *0.250*	12,4 *0.488*	10,0 *0.394*	13,56 *0.534*	256,0	2	MM1420			■	

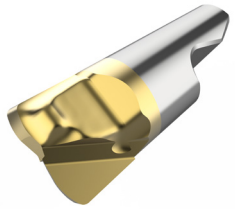
Kopierfräser

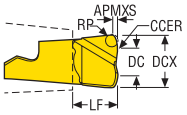


—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DC	APMXS	RE	LF	FHA	ZEFP	Schlüssel		Beschichtung			
									Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*					T60M	F15M	F30M	F40M
MM10-09510-B90P-M04	9,525 *0.375*	8,7 *0.343*	4,763 *0.188*	11,74 *0.462*		2	MM0612		■		■	
MM10-10010-B90-MD04	10,0 *0.394*	10,2 *0.402*	5,0 *0.197*	11,77 *0.463*		2	MM0612		■		■	
MM10-10010-B90PF-M02	10,0 *0.394*	8,73 *0.344*	5,0 *0.197*	11,74 *0.462*		2	MM0612			■		
MM10-10010-B90P-M04	10,0 *0.394*	8,73 *0.344*	5,0 *0.197*	11,74 *0.462*		2	MM0612				■	
MM10-10010-B90S-E04	10,0 *0.394*	10,2 *0.402*	5,0 *0.197*	11,77 *0.463*		2	MM0612				■	
MM10-10012-B90A30-D03	10,0 *0.394*	11,8 *0.465*	5,0 *0.197*	15,72 *0.619*	30,0	3	MM0416	✓			■	
MM10-10012-B90A30-E03	10,0 *0.394*	11,8 *0.465*	5,0 *0.197*	15,72 *0.619*	30,0	3	MM0416	✓			■	
MM10-10012-B90A30-M03	10,0 *0.394*	11,8 *0.465*	5,0 *0.197*	15,72 *0.619*	30,0	3	MM0416	✓				■

Hochvorschubfräser





—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DCX	DC	APMXS	RP	CCER	LF	RMPX°	C min	C max	ZEFP	Schlüssel	Beschichtung			
												Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*						T60M	F15M	F30M	F40M
MM10-10.50-HF-MD08	10,0 *0.394*	5,0 *0.197*	0,44 *0.017*	1,13 *0.044*	5,0 *0.197*	8,5 *0.335*	5,0	12,2	18,2	2	MM0612		■	■	

MM10 - Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,044 0.0017	0,044 0.0017	0,055 0.0022	0,070 0.0028
P2	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,044 0.0017	0,044 0.0017	0,055 0.0022	0,070 0.0028
P3	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,042 0.0017	0,042 0.0017	0,050 0.0020	0,070 0.0028
P4	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,042 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
P5	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 0.0016	0,040 0.0016	0,050 0.0020	0,065 0.0026
P6	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 0.0016	0,040 0.0016	0,048 0.0019	0,065 0.0026
P7	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 0.0016	0,040 0.0016	0,048 0.0019	0,065 0.0026
P8	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,042 0.0017	0,042 0.0017	0,050 0.0020	0,070 0.0028
P11	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 0.0016	0,040 0.0016	0,048 0.0019	0,065 0.0026
P12	MM10-10012-R05A30-M03 F40M	1,7 *0.065*	0,028 0.0011	0,028 0.0011	0,034 0.0013	0,044 0.0017
M1	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,044 0.0017	0,044 0.0017	0,055 0.0022	0,070 0.0028
M2	MM10-10012-R05A30-M03 F40M	2,0 *0.080*	0,040 0.0016	0,040 0.0016	0,050 0.0020	0,065 0.0026
M3	MM10-10012-R05A30-M03 F40M	1,7 *0.065*	0,032 0.0013	0,032 0.0013	0,040 0.0016	0,050 0.0020
M4	MM10-10012-R05A30-M03 F40M	1,2 *0.048*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,046 0.0018
M5	MM10-10012-R05A30-M03 F40M	1,2 *0.048*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,046 0.0018
K1	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,048 0.0019	0,048 0.0019	0,055 0.0022	0,075 0.0030
K2	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
K3	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
K4	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
K5	MM10-10012-R10A30-D03 F30M	2,0 *0.080*	0,040 0.0016	0,038 0.0015	0,044 0.0017	0,060 0.0024
K6	MM10-10012-R10A30-D03 F30M	2,0 *0.080*	0,044 0.0017	0,042 0.0017	0,050 0.0020	0,065 0.0026
K7	MM10-10012-R10A30-D03 F30M	2,0 *0.080*	0,040 0.0016	0,038 0.0015	0,044 0.0017	0,060 0.0024
N1	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N2	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N3	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N11	MM10-10012-R10A30-E03 F30M	2,0 *0.080*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
S1	MM10-10012-R10A30-D03 F30M	1,2 *0.048*	0,036 0.0014	0,034 0.0013	0,036 0.0014	0,046 0.0018
S2	MM10-10012-R10A30-D03 F30M	1,2 *0.048*	0,036 0.0014	0,034 0.0013	0,036 0.0014	0,046 0.0018
S3	MM10-10012-R10A30-D03 F30M	1,2 *0.048*	0,032 0.0013	0,032 0.0013	0,034 0.0013	0,042 0.0017
S11	MM10-10012-R05A30-M03 F40M	1,4 *0.055*	0,034 0.0013	0,034 0.0013	0,040 0.0016	0,050 0.0020
S12	MM10-10012-R05A30-M03 F40M	1,4 *0.055*	0,034 0.0013	0,034 0.0013	0,040 0.0016	0,050 0.0020
S13	MM10-10012-R05A30-M03 F40M	1,2 *0.048*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,046 0.0018
H5	MM10-10012-R10A30-D03 F30M	1,7 *0.065*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,044 0.0017
H8	MM10-10012-R10A30-D03 F30M	1,4 *0.055*	0,025 0.0010	0,024 0.00095	0,026 0.0010	0,034 0.0013
H11	MM10-10012-R10A30-D03 F30M	1,7 *0.065*	0,030 0.0012	0,030 0.0012	0,034 0.0013	0,044 0.0017
H12	MM10-10012-R10A30-D03 F30M	1,4 *0.055*	0,025 0.0010	0,024 0.00095	0,026 0.0010	0,034 0.0013
H21	MM10-10012-R10A30-D03 F30M	1,4 *0.055*	0,025 0.0010	0,024 0.00095	0,026 0.0010	0,034 0.0013

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM10 - Nut- und Eckfräsen – Schnittdaten v_c = (m/min)/(sf/min)

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	265 *870*	330 *1075*	365 *1200*	405 *1325*	250 *820*	315 *1025*	345 *1125*	385 *1275*	190 *620*	240 *790*	270 *890*	295 *970*
P2	260 *850*	320 *1050*	360 *1175*	390 *1275*	245 *800*	305 *1000*	340 *1125*	375 *1225*	185 *610*	235 *770*	260 *850*	290 *950*
P3	225 *740*	280 *920*	315 *1025*	340 *1125*	215 *710*	265 *870*	295 *970*	325 *1075*	165 *540*	205 *670*	230 *750*	250 *820*
P4	200 *660*	245 *800*	275 *900*	305 *1000*	190 *620*	235 *770*	260 *850*	290 *950*	145 *475*	180 *590*	200 *660*	225 *740*
P5	190 *620*	235 *770*	265 *870*	290 *950*	180 *590*	225 *740*	250 *820*	275 *900*	140 *460*	175 *570*	195 *640*	215 *710*
P6	215 *710*	265 *870*	295 *970*	325 *1075*	205 *670*	250 *820*	280 *920*	310 *1025*	155 *510*	195 *640*	220 *720*	240 *790*
P7	200 *660*	250 *820*	280 *920*	310 *1025*	190 *620*	240 *790*	265 *870*	290 *950*	145 *475*	185 *610*	205 *670*	225 *740*
P8	190 *620*	235 *770*	265 *870*	285 *940*	180 *590*	225 *740*	250 *820*	270 *890*	140 *460*	175 *570*	190 *620*	210 *690*
P11	195 *640*	245 *800*	270 *890*	300 *980*	185 *610*	230 *750*	260 *850*	285 *940*	140 *460*	180 *590*	200 *660*	220 *720*
P12	125 *410*	150 *490*	170 *560*	185 *610*	115 *375*	145 *475*	160 *520*	175 *570*	90 *295*	115 *375*	125 *410*	140 *460*
M1	— —	— —	— —	— —	200 *660*	245 *800*	275 *900*	305 *1000*	150 *490*	190 *620*	210 *690*	235 *770*
M2	— —	— —	— —	— —	165 *540*	200 *660*	225 *740*	250 *820*	125 *410*	155 *510*	175 *570*	190 *620*
M3	— —	— —	— —	— —	130 *425*	160 *520*	175 *570*	195 *640*	100 *330*	125 *410*	140 *460*	155 *510*
M4	— —	— —	— —	— —	100 *330*	120 *395*	135 *445*	150 *490*	75 *245*	95 *310*	105 *345*	115 *375*
M5	— —	— —	— —	— —	80 *260*	100 *330*	115 *375*	125 *410*	65 *215*	80 *260*	90 *295*	95 *310*
K1	205 *670*	255 *840*	285 *940*	310 *1025*	195 *640*	240 *790*	270 *890*	300 *980*	150 *490*	185 *610*	205 *670*	230 *750*
K2	180 *590*	225 *740*	250 *820*	275 *900*	170 *560*	215 *710*	235 *770*	260 *850*	130 *425*	165 *540*	185 *610*	200 *660*
K3	150 *490*	190 *620*	210 *690*	235 *770*	145 *475*	180 *590*	200 *660*	220 *720*	110 *360*	140 *460*	155 *510*	170 *560*
K4	145 *475*	180 *590*	200 *660*	225 *740*	140 *460*	170 *560*	190 *620*	210 *690*	105 *345*	130 *425*	150 *490*	165 *540*
K5	90 *295*	110 *360*	125 *410*	135 *445*	85 *280*	105 *345*	115 *375*	125 *410*	65 *215*	80 *260*	90 *295*	100 *330*
K6	130 *425*	160 *520*	180 *590*	195 *640*	120 *395*	150 *490*	170 *560*	185 *610*	95 *310*	115 *375*	130 *425*	145 *475*
K7	110 *360*	140 *460*	155 *510*	170 *560*	105 *345*	135 *445*	150 *490*	165 *540*	85 *280*	105 *345*	115 *375*	125 *410*
N1	1550 *5075*	1925 *6325*	2150 *7050*	2350 *7700*	1475 *4850*	1825 *6000*	2025 *6650*	2250 *7375*	1125 *3700*	1400 *4600*	1550 *5075*	1725 *5650*
N2	630 *2075*	780 *2550*	870 *2850*	950 *3125*	600 *1975*	740 *2425*	820 *2700*	910 *2975*	450 *1475*	570 *1875*	630 *2075*	690 *2275*
N3	415 *1350*	520 *1700*	580 *1900*	630 *2075*	395 *1300*	495 *1625*	550 *1800*	610 *2000*	300 *980*	380 *1250*	420 *1375*	460 *1500*
N11	475 *1550*	590 *1925*	660 *2175*	720 *2350*	455 *1500*	570 *1875*	620 *2025*	690 *2275*	345 *1125*	430 *1400*	480 *1575*	530 *1750*
S1	48 *155*	60 *195*	65 *215*	75 *245*	46 *150*	55 *180*	65 *215*	70 *230*	36 *120*	45 *150*	50 *165*	55 *180*
S2	38 *125*	48 *155*	55 *180*	60 *195*	37 *120*	46 *150*	50 *165*	55 *180*	29 *95*	36 *120*	40 *130*	44 *145*
S3	34 *110*	42 *140*	47 *155*	50 *165*	32 *105*	40 *130*	45 *150*	49 *160*	25 *80*	32 *105*	35 *115*	38 *125*
S11	— —	— —	— —	— —	65 *215*	80 *260*	90 *295*	100 *330*	50 *165*	65 *215*	70 *230*	75 *245*
S12	— —	— —	— —	— —	45 *150*	55 *180*	60 *195*	70 *230*	35 *115*	43 *140*	49 *160*	55 *180*
S13	— —	— —	— —	— —	26 *85*	32 *105*	36 *120*	39 *130*	20 *65*	25 *80*	28 *90*	30 *100*
H5	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	30 *100*	38 *125*	42 *140*	46 *150*
H8	42 *140*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*	31 *100*	39 *130*	44 *145*	48 *155*
H11	50 *165*	65 *215*	70 *230*	80 *260*	49 *160*	60 *195*	70 *230*	75 *245*	38 *125*	48 *155*	55 *180*	60 *195*
H12	75 *245*	95 *310*	105 *345*	115 *375*	70 *230*	90 *295*	100 *330*	110 *360*	55 *180*	70 *230*	80 *260*	85 *280*
H21	42 *140*	50 *165*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*	31 *100*	39 *130*	44 *145*	48 *155*

MM10 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,070 0.0028
P2	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,075 0.0030
P3	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 0.0020	0,050 0.0020	0,050 0.0020	0,070 0.0028
P4	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
P5	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
P6	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
P7	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
P8	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 0.0020	0,050 0.0020	0,050 0.0020	0,070 0.0028
P11	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
P12	MM10-10012-B90A30-M03 F40M	1,7 *0.065*	0,034 0.0013	0,034 0.0013	0,034 0.0013	0,044 0.0018
M1	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,075 0.0030
M2	MM10-10012-B90A30-M03 F40M	2,0 *0.080*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
M3	MM10-10012-B90A30-M03 F40M	1,7 *0.065*	0,042 0.0017	0,040 0.0016	0,042 0.0017	0,055 0.0022
M4	MM10-10012-B90A30-M03 F40M	1,2 *0.048*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
M5	MM10-10012-B90A30-M03 F40M	1,2 *0.048*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
K1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,075 0.0030
K2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
K3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
K4	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
K5	MM10-10012-B90A30-D03 F30M	2,0 *0.080*	0,044 0.0017	0,042 0.0017	0,046 0.0018	0,060 0.0024
K6	MM10-10012-B90A30-D03 F30M	2,0 *0.080*	0,050 0.0020	0,048 0.0019	0,050 0.0020	0,065 0.0026
K7	MM10-10012-B90A30-D03 F30M	2,0 *0.080*	0,044 0.0017	0,042 0.0017	0,046 0.0018	0,060 0.0024
N1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,070 0.0028	0,065 0.0026	0,070 0.0028	0,095 0.0038
N2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,070 0.0028	0,065 0.0026	0,070 0.0028	0,095 0.0038
N3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,070 0.0028	0,065 0.0026	0,070 0.0028	0,095 0.0038
N11	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,070 0.0028	0,065 0.0026	0,070 0.0028	0,095 0.0038
S1	MM10-10012-B90A30-D03 F30M	1,2 *0.048*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
S2	MM10-10012-B90A30-D03 F30M	1,2 *0.048*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
S3	MM10-10012-B90A30-D03 F30M	1,2 *0.048*	0,036 0.0014	0,034 0.0013	0,034 0.0013	0,042 0.0017
S11	MM10-10012-B90A30-M03 F40M	1,4 *0.055*	0,042 0.0017	0,042 0.0017	0,042 0.0017	0,055 0.0022
S12	MM10-10012-B90A30-M03 F40M	1,4 *0.055*	0,042 0.0017	0,042 0.0017	0,042 0.0017	0,055 0.0022
S13	MM10-10012-B90A30-M03 F40M	1,2 *0.048*	0,038 0.0015	0,036 0.0014	0,036 0.0014	0,046 0.0019
H5	MM10-10012-B90A30-D03 F30M	1,7 *0.065*	0,034 0.0013	0,034 0.0013	0,034 0.0013	0,044 0.0018
H8	MM10-10012-B90A30-D03 F30M	1,4 *0.055*	0,028 0.0011	0,026 0.0010	0,026 0.0010	0,034 0.0013
H11	MM10-10012-B90A30-D03 F30M	1,7 *0.065*	0,034 0.0013	0,034 0.0013	0,034 0.0013	0,044 0.0018
H12	MM10-10012-B90A30-D03 F30M	1,4 *0.055*	0,028 0.0011	0,026 0.0010	0,026 0.0010	0,034 0.0013
H21	MM10-10012-B90A30-D03 F30M	1,4 *0.055*	0,028 0.0011	0,026 0.0010	0,026 0.0010	0,034 0.0013

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM10 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 0.0024	0,070 0.0028	0,10 0.0040	0,16 0.0065
P2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 0.0024	0,075 0.0030	0,10 0.0040	0,16 0.0065
P3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,15 0.0060
P4	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,065 0.0026	0,095 0.0038	0,15 0.0060
P5	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
P6	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
P7	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
P8	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,15 0.0060
P11	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
P12	MM10-10012-B90A30-E03 F30M	1,7 *0.065*	0,038 0.0015	0,044 0.0018	0,060 0.0024	0,10 0.0040
M1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 0.0024	0,075 0.0030	0,10 0.0040	0,16 0.0065
M2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
M3	MM10-10012-B90A30-E03 F30M	1,7 *0.065*	0,046 0.0018	0,055 0.0022	0,075 0.0030	0,12 0.0048
M4	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
M5	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
K1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,060 0.0024	0,075 0.0030	0,10 0.0040	0,16 0.0065
K2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K4	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K5	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 0.0020	0,060 0.0024	0,080 0.0032	0,13 0.0050
K6	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K7	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,050 0.0020	0,060 0.0024	0,080 0.0032	0,13 0.0050
N1	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,22 0.0085
N2	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,22 0.0085
N3	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,22 0.0085
N11	MM10-10012-B90A30-E03 F30M	2,0 *0.080*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,22 0.0085
S1	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
S2	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
S3	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,038 0.0015	0,042 0.0017	0,060 0.0024	0,095 0.0038
S11	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,046 0.0018	0,055 0.0022	0,075 0.0030	0,12 0.0048
S12	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,046 0.0018	0,055 0.0022	0,075 0.0030	0,12 0.0048
S13	MM10-10012-B90A30-E03 F30M	1,2 *0.048*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
H5	MM10-10012-B90A30-E03 F30M	1,7 *0.065*	0,038 0.0015	0,044 0.0018	0,060 0.0024	0,10 0.0040
H8	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,030 0.0012	0,034 0.0013	0,048 0.0019	0,075 0.0030
H11	MM10-10012-B90A30-E03 F30M	1,7 *0.065*	0,038 0.0015	0,044 0.0018	0,060 0.0024	0,10 0.0040
H12	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,030 0.0012	0,034 0.0013	0,048 0.0019	0,075 0.0030
H21	MM10-10012-B90A30-E03 F30M	1,4 *0.055*	0,030 0.0012	0,034 0.0013	0,048 0.0019	0,075 0.0030

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM10 Z3 – Kopierfräser – Schnittdaten v_c = (m/min)/(sf/min)

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	280 *920*	330 *1075*	355 *1175*	380 *1250*	380 *1250*	270 *890*	310 *1025*	335 *1100*	365 *1200*	360 *1175*
P2	275 *900*	320 *1050*	340 *1125*	370 *1225*	370 *1225*	260 *850*	305 *1000*	325 *1075*	355 *1175*	355 *1175*
P3	240 *790*	280 *920*	295 *970*	320 *1050*	320 *1050*	230 *750*	265 *870*	280 *920*	305 *1000*	305 *1000*
P4	210 *690*	245 *800*	265 *870*	285 *940*	285 *940*	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*
P5	200 *660*	235 *770*	250 *820*	275 *900*	270 *890*	190 *620*	225 *740*	240 *790*	260 *850*	260 *850*
P6	225 *740*	265 *870*	285 *940*	305 *1000*	305 *1000*	215 *710*	250 *820*	270 *890*	290 *950*	290 *950*
P7	215 *710*	250 *820*	265 *870*	290 *950*	285 *940*	205 *670*	235 *770*	255 *840*	275 *900*	275 *900*
P8	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	235 *770*	260 *850*	260 *850*
P11	205 *670*	240 *790*	260 *850*	280 *920*	280 *920*	195 *640*	230 *750*	245 *800*	265 *870*	265 *870*
P12	130 *425*	160 *520*	160 *520*	175 *570*	175 *570*	125 *410*	150 *490*	155 *510*	165 *540*	165 *540*
M1	220 *720*	255 *840*	275 *900*	300 *980*	300 *980*	210 *690*	245 *800*	260 *850*	285 *940*	285 *940*
M2	180 *590*	210 *690*	225 *740*	245 *800*	245 *800*	175 *570*	200 *660*	215 *710*	235 *770*	230 *750*
M3	145 *475*	175 *570*	175 *590*	190 *620*	190 *620*	135 *445*	165 *540*	170 *560*	185 *610*	180 *590*
M4	95 *310*	140 *460*	135 *475*	145 *475*	145 *475*	95 *310*	130 *425*	130 *445*	140 *460*	140 *460*
M5	80 *260*	115 *375*	115 *395*	120 *395*	120 *395*	75 *245*	110 *360*	105 *375*	115 *375*	115 *375*
K1	220 *720*	255 *840*	270 *890*	295 *970*	295 *970*	205 *670*	240 *790*	255 *840*	280 *920*	280 *920*
K2	190 *620*	220 *720*	240 *790*	260 *850*	255 *840*	180 *590*	210 *690*	230 *750*	245 *800*	245 *800*
K3	160 *520*	190 *620*	200 *660*	220 *720*	215 *710*	155 *510*	180 *590*	195 *640*	210 *690*	205 *670*
K4	155 *510*	180 *590*	195 *640*	210 *690*	205 *670*	145 *475*	170 *560*	185 *610*	200 *660*	195 *640*
K5	95 *310*	110 *360*	115 *375*	125 *410*	125 *410*	90 *295*	105 *345*	110 *360*	120 *395*	120 *395*
K6	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*	130 *425*	150 *490*	160 *520*	175 *570*	175 *570*
K7	120 *395*	140 *460*	150 *490*	160 *520*	160 *520*	115 *375*	130 *425*	140 *460*	155 *510*	155 *510*
N1	1650 *5425*	1925 *6325*	2050 *6725*	2225 *7300*	2200 *7225*	1575 *5175*	1825 *6000*	1950 *6400*	2125 *6975*	2100 *6900*
N2	670 *2200*	780 *2550*	830 *2725*	900 *2950*	890 *2925*	640 *2100*	740 *2425*	790 *2600*	860 *2825*	850 *2800*
N3	445 *1450*	520 *1700*	550 *1800*	600 *1975*	590 *1925*	425 *1400*	495 *1625*	530 *1750*	570 *1875*	560 *1825*
N11	510 *1675*	590 *1925*	630 *2075*	690 *2275*	680 *2225*	485 *1600*	560 *1825*	600 *1975*	650 *2125*	650 *2125*
S1	45 *150*	65 *215*	65 *215*	70 *230*	70 *230*	43 *140*	60 *195*	60 *215*	65 *215*	65 *215*
S2	37 *120*	50 *165*	50 *180*	55 *180*	55 *180*	35 *115*	49 *160*	48 *165*	50 *165*	50 *165*
S3	32 *105*	45 *150*	44 *155*	48 *155*	48 *155*	30 *100*	43 *140*	42 *150*	46 *150*	45 *150*
S11	70 *230*	90 *295*	90 *295*	95 *310*	95 *310*	65 *215*	85 *280*	85 *280*	90 *295*	90 *295*
S12	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	45 *150*	60 *195*	60 *195*	65 *215*	65 *215*
S13	26 *85*	36 *120*	36 *125*	38 *125*	38 *125*	24 *80*	34 *110*	34 *120*	37 *120*	37 *120*
H5	43 *140*	55 *180*	55 *180*	60 *195*	55 *180*	41 *135*	50 *165*	50 *165*	55 *180*	55 *180*
H8	41 *135*	55 *180*	55 *180*	60 *195*	60 *195*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*
H11	55 *180*	65 *215*	70 *230*	75 *245*	75 *245*	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*
H12	75 *245*	100 *330*	100 *330*	105 *345*	105 *345*	70 *230*	95 *310*	95 *310*	100 *330*	100 *330*
H21	41 *135*	55 *180*	55 *180*	60 *195*	60 *195*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*

MM10 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
P2	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,065 0.0026	0,065 0.0026	0,075 0.0030	0,095 0.0038
P3	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,090 0.0036
P4	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,090 0.0036
P5	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,060 0.0024	0,055 0.0022	0,065 0.0026	0,090 0.0036
P6	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,085 0.0034
P7	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,085 0.0034
P8	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,090 0.0036
P11	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,085 0.0034
P12	MM10-10010-B90-MD04 F30M	3,5 *0.14*	0,040 0.0016	0,040 0.0016	0,046 0.0018	0,060 0.0024
M1	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,065 0.0026	0,065 0.0026	0,075 0.0030	0,095 0.0038
M2	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 0.0024	0,055 0.0022	0,065 0.0026	0,090 0.0036
M3	MM10-10010-B90S-E04 F30M	3,5 *0.14*	0,048 0.0019	0,048 0.0019	0,055 0.0022	0,070 0.0028
M4	MM10-10010-B90-MD04 F30M	2,5 *0.10*	0,044 0.0017	0,044 0.0017	0,048 0.0019	0,060 0.0026
M5	MM10-10010-B90-MD04 F30M	2,5 *0.10*	0,044 0.0017	0,044 0.0017	0,048 0.0019	0,060 0.0026
K1	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,065 0.0026	0,065 0.0026	0,075 0.0030	0,095 0.0038
K2	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 0.0024	0,055 0.0022	0,065 0.0026	0,090 0.0036
K3	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 0.0024	0,055 0.0022	0,065 0.0026	0,090 0.0036
K4	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,060 0.0024	0,055 0.0022	0,065 0.0026	0,090 0.0036
K5	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,050 0.0020	0,050 0.0020	0,060 0.0024	0,080 0.0032
K6	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,060 0.0024	0,055 0.0022	0,065 0.0026	0,090 0.0036
K7	MM10-10010-B90-MD04 F30M	4,0 *0.16*	0,050 0.0020	0,050 0.0020	0,060 0.0024	0,080 0.0032
N1	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,080 0.0032	0,080 0.0032	0,095 0.0038	0,12 0.0048
N2	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,080 0.0032	0,080 0.0032	0,095 0.0038	0,12 0.0048
N3	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,080 0.0032	0,080 0.0032	0,095 0.0038	0,12 0.0048
N11	MM10-10010-B90S-E04 F30M	4,0 *0.16*	0,080 0.0032	0,080 0.0032	0,095 0.0038	0,12 0.0048
S1	MM10-10010-B90S-E04 F30M	2,5 *0.10*	0,044 0.0017	0,044 0.0017	0,048 0.0019	0,060 0.0026
S2	MM10-10010-B90S-E04 F30M	2,5 *0.10*	0,044 0.0017	0,044 0.0017	0,048 0.0019	0,060 0.0026
S3	MM10-10010-B90S-E04 F30M	2,5 *0.10*	0,042 0.0017	0,042 0.0017	0,044 0.0017	0,055 0.0024
S11	MM10-10010-B90S-E04 F30M	3,0 *0.12*	0,048 0.0019	0,048 0.0019	0,055 0.0022	0,070 0.0028
S12	MM10-10010-B90S-E04 F30M	3,0 *0.12*	0,048 0.0019	0,048 0.0019	0,055 0.0022	0,070 0.0028
S13	MM10-10010-B90S-E04 F30M	2,5 *0.10*	0,044 0.0017	0,044 0.0017	0,048 0.0019	0,060 0.0026
H5	MM10-10010-B90-MD04 F30M	3,5 *0.14*	0,040 0.0016	0,040 0.0016	0,046 0.0018	0,060 0.0024
H8	MM10-10010-B90-MD04 F30M	3,0 *0.12*	0,032 0.0013	0,032 0.0013	0,036 0.0014	0,046 0.0018
H11	MM10-10010-B90-MD04 F30M	3,5 *0.14*	0,040 0.0016	0,040 0.0016	0,046 0.0018	0,060 0.0024
H12	MM10-10010-B90-MD04 F30M	3,0 *0.12*	0,032 0.0013	0,032 0.0013	0,036 0.0014	0,046 0.0018
H21	MM10-10010-B90-MD04 F30M	3,0 *0.12*	0,032 0.0013	0,032 0.0013	0,036 0.0014	0,046 0.0018

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM10 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,040 0.0016	0,048 0.0019	0,065 0.0026	0,11 0.0044
P2	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,042 0.0017	0,048 0.0019	0,070 0.0028	0,11 0.0044
P3	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,046 0.0018	0,065 0.0026	0,10 0.0040
P4	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,046 0.0018	0,065 0.0026	0,10 0.0040
P5	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,10 0.0040
P6	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
P7	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
P8	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,046 0.0018	0,065 0.0026	0,10 0.0040
P11	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
P12	MM10-10010-B90PF-M02 F15M	3,0 *0.12*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,065 0.0026
M1	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,042 0.0017	0,048 0.0019	0,070 0.0028	0,11 0.0044
M2	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,10 0.0040
M3	MM10-10010-B90PF-M02 F15M	3,0 *0.12*	0,030 0.0012	0,036 0.0014	0,048 0.0019	0,075 0.0030
M4	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 0.0011	0,030 0.0013	0,042 0.0017	0,070 0.0028
M5	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 0.0011	0,030 0.0013	0,042 0.0017	0,070 0.0028
K1	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,042 0.0017	0,048 0.0019	0,070 0.0028	0,11 0.0044
K2	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,10 0.0040
K3	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,10 0.0040
K4	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,10 0.0040
K5	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,034 0.0013	0,040 0.0016	0,055 0.0022	0,085 0.0034
K6	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,10 0.0040
K7	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,034 0.0013	0,040 0.0016	0,055 0.0022	0,085 0.0034
N1	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,050 0.0020	0,060 0.0024	0,085 0.0034	0,14 0.0055
N2	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,050 0.0020	0,060 0.0024	0,085 0.0034	0,14 0.0055
N3	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,050 0.0020	0,060 0.0024	0,085 0.0034	0,14 0.0055
N11	MM10-10010-B90PF-M02 F15M	3,5 *0.14*	0,050 0.0020	0,060 0.0024	0,085 0.0034	0,14 0.0055
S1	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 0.0011	0,030 0.0013	0,042 0.0017	0,070 0.0028
S2	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 0.0011	0,030 0.0013	0,042 0.0017	0,070 0.0028
S3	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,025 0.0010	0,028 0.0012	0,040 0.0016	0,065 0.0026
S11	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,030 0.0012	0,036 0.0014	0,048 0.0019	0,075 0.0030
S12	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,030 0.0012	0,036 0.0014	0,048 0.0019	0,075 0.0030
S13	MM10-10010-B90PF-M02 F15M	2,0 *0.080*	0,028 0.0011	0,030 0.0013	0,042 0.0017	0,070 0.0028
H5	MM10-10010-B90PF-M02 F15M	3,0 *0.12*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,065 0.0026
H8	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,020 0.00080	0,022 0.00095	0,032 0.0013	0,050 0.0020
H11	MM10-10010-B90PF-M02 F15M	3,0 *0.12*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,065 0.0026
H12	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,020 0.00080	0,022 0.00095	0,032 0.0013	0,050 0.0020
H21	MM10-10010-B90PF-M02 F15M	2,5 *0.10*	0,020 0.00080	0,022 0.00095	0,032 0.0013	0,050 0.0020

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM10 Z2 – Kopierfräser – Schnittdaten v_c = (m/min)/(sf/min)

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	305 *1000*	390 *1275*	405 *1325*	440 *1450*	440 *1450*	250 *820*	320 *1050*	340 *1125*	370 *1225*	365 *1200*	205 *670*	260 *850*	275 *900*	300 *980*	295 *970*
P2	295 *970*	380 *1250*	395 *1300*	425 *1400*	425 *1400*	240 *790*	305 *1000*	330 *1075*	355 *1175*	355 *1175*	195 *640*	250 *820*	270 *890*	285 *940*	285 *940*
P3	260 *850*	330 *1075*	340 *1125*	370 *1225*	370 *1225*	210 *690*	265 *870*	285 *940*	310 *1025*	310 *1025*	170 *560*	215 *710*	235 *770*	250 *820*	250 *820*
P4	225 *740*	290 *950*	300 *980*	325 *1075*	325 *1075*	185 *610*	235 *770*	255 *840*	270 *890*	275 *900*	150 *490*	190 *620*	205 *670*	220 *720*	220 *720*
P5	215 *710*	275 *900*	290 *950*	315 *1025*	310 *1025*	175 *570*	225 *740*	240 *790*	265 *870*	260 *850*	145 *475*	185 *610*	195 *640*	215 *710*	210 *690*
P6	245 *800*	310 *1025*	325 *1075*	350 *1150*	350 *1150*	200 *660*	255 *840*	275 *900*	295 *970*	295 *970*	165 *540*	205 *670*	220 *720*	240 *790*	235 *770*
P7	230 *750*	295 *970*	305 *1000*	330 *1075*	330 *1075*	190 *620*	240 *790*	260 *850*	280 *920*	275 *900*	155 *510*	195 *640*	210 *690*	225 *740*	225 *740*
P8	215 *710*	275 *900*	290 *950*	310 *1025*	310 *1025*	175 *570*	225 *740*	240 *790*	260 *850*	260 *850*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*
P11	225 *740*	285 *940*	295 *970*	325 *1075*	320 *1050*	185 *610*	235 *770*	250 *820*	270 *890*	270 *890*	150 *490*	190 *620*	205 *670*	220 *720*	215 *710*
P12	140 *460*	175 *570*	180 *610*	195 *640*	195 *640*	120 *395*	150 *490*	155 *510*	170 *560*	170 *560*	95 *310*	120 *395*	125 *410*	135 *445*	135 *445*
M1	240 *790*	305 *1000*	320 *1050*	345 *1125*	345 *1125*	195 *640*	245 *800*	265 *870*	285 *940*	285 *940*	160 *520*	200 *660*	215 *710*	230 *750*	230 *750*
M2	195 *640*	250 *820*	260 *850*	280 *920*	280 *920*	160 *520*	205 *670*	215 *710*	235 *770*	235 *770*	130 *425*	165 *540*	175 *570*	190 *620*	190 *620*
M3	155 *510*	200 *660*	200 *670*	220 *720*	220 *720*	130 *425*	165 *540*	175 *570*	185 *610*	185 *610*	105 *345*	135 *445*	140 *460*	150 *490*	150 *490*
M4	120 *395*	155 *510*	155 *560*	165 *540*	165 *540*	105 *345*	135 *445*	130 *460*	145 *475*	140 *460*	85 *280*	105 *345*	105 *375*	115 *375*	115 *375*
M5	100 *330*	130 *425*	130 *460*	140 *460*	140 *460*	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	70 *230*	90 *295*	90 *310*	95 *310*	95 *310*
K1	235 *770*	300 *980*	315 *1025*	335 *1100*	335 *1100*	190 *620*	245 *800*	260 *850*	280 *920*	280 *920*	155 *510*	195 *640*	210 *690*	225 *740*	225 *740*
K2	205 *670*	265 *870*	275 *900*	295 *970*	295 *970*	170 *560*	215 *710*	230 *750*	250 *820*	250 *820*	135 *445*	175 *570*	185 *610*	200 *660*	200 *660*
K3	175 *570*	225 *740*	230 *750*	250 *820*	250 *820*	140 *460*	180 *590*	195 *640*	210 *690*	210 *690*	115 *375*	150 *490*	155 *510*	170 *560*	170 *560*
K4	165 *540*	215 *710*	220 *720*	240 *790*	240 *790*	135 *445*	175 *570*	185 *610*	200 *660*	200 *660*	110 *360*	140 *460*	150 *490*	165 *540*	160 *520*
K5	100 *330*	130 *425*	135 *445*	145 *475*	145 *475*	85 *280*	105 *345*	110 *360*	120 *395*	120 *395*	70 *230*	85 *280*	90 *295*	100 *330*	100 *330*
K6	145 *475*	185 *610*	195 *640*	210 *690*	210 *690*	120 *395*	155 *510*	165 *540*	180 *590*	175 *570*	95 *310*	125 *410*	130 *425*	145 *475*	145 *475*
K7	130 *425*	165 *540*	170 *560*	185 *610*	185 *610*	105 *345*	135 *445*	145 *475*	155 *510*	155 *510*	85 *280*	110 *360*	115 *375*	125 *410*	125 *410*
N1	1800 *5900*	2300 *7550*	2425 *7950*	2600 *8525*	2600 *8525*	1450 *4750*	1825 *6000*	1975 *6475*	2150 *7050*	2100 *6900*	1175 *3850*	1475 *4850*	1600 *5250*	1725 *5650*	1700 *5575*
N2	730 *2400*	930 *3050*	970 *3175*	1050 *3450*	1050 *3450*	590 *1925*	740 *2425*	800 *2625*	870 *2850*	850 *2800*	475 *1550*	600 *1975*	650 *2125*	700 *2300*	680 *2225*
N3	485 *1600*	620 *2025*	650 *2125*	700 *2300*	700 *2300*	390 *1275*	495 *1625*	530 *1750*	580 *1900*	560 *1825*	315 *1025*	400 *1300*	435 *1425*	465 *1525*	455 *1500*
N11	550 *1800*	710 *2325*	740 *2425*	800 *2625*	800 *2625*	450 *1475*	570 *1875*	610 *2000*	660 *2175*	640 *2100*	360 *1175*	460 *1500*	495 *1625*	530 *1750*	520 *1700*
S1	55 *180*	70 *230*	70 *260*	80 *260*	75 *245*	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*
S2	46 *150*	60 *195*	60 *215*	65 *215*	60 *195*	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*	32 *105*	40 *130*	40 *140*	43 *140*	43 *140*
S3	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	34 *110*	43 *140*	43 *150*	47 *155*	46 *150*	27 *90*	35 *115*	35 *120*	38 *125*	38 *125*
S11	80 *260*	100 *330*	100 *360*	110 *360*	110 *360*	65 *215*	85 *280*	85 *295*	95 *310*	95 *310*	55 *180*	70 *230*	70 *245*	75 *245*	75 *245*
S12	55 *180*	70 *230*	70 *245*	75 *245*	75 *245*	47 *155*	60 *195*	60 *195*	65 *215*	65 *215*	38 *125*	48 *155*	49 *165*	55 *180*	55 *180*
S13	32 *105*	41 *135*	40 *145*	44 *145*	43 *140*	27 *90*	35 *115*	35 *120*	37 *120*	37 *120*	22 *70*	28 *90*	28 *100*	30 *100*	30 *100*
H5	46 *150*	60 *195*	60 *195*	65 *215*	65 *215*	39 *130*	50 *165*	50 *165*	55 *180*	55 *180*	32 *105*	41 *135*	42 *140*	45 *150*	45 *150*
H8	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	41 *135*	55 *180*	55 *180*	60 *195*	60 *195*	33 *110*	43 *140*	43 *150*	47 *155*	47 *155*
H11	60 *195*	75 *245*	75 *260*	85 *280*	85 *280*	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*	40 *130*	50 *165*	55 *180*	60 *195*	60 *195*
H12	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	75 *245*	95 *310*	95 *330*	105 *345*	105 *345*	60 *195*	75 *245*	80 *260*	85 *280*	85 *280*
H21	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	41 *135*	55 *180*	55 *180*	60 *195*	60 *195*	33 *110*	43 *140*	43 *150*	47 *155*	47 *155*

MM10 Hohe Vorschübe - Auswahl der Wendeschneidplatten – Metrisch/ Zoll

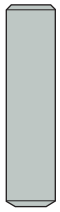
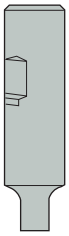
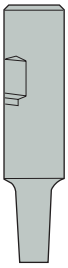
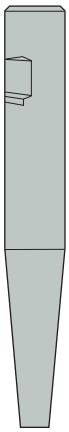
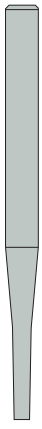
SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,48 0.019	0,48 0.019	0,65 0.026	0,80 0.032
P2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,50 0.020	0,50 0.020	0,65 0.026	0,80 0.032
P3	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,46 0.018	0,46 0.018	0,60 0.024	0,75 0.030
P4	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,46 0.018	0,46 0.018	0,60 0.024	0,75 0.030
P5	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 0.017	0,46 0.018	0,60 0.024	0,75 0.030
P6	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 0.017	0,44 0.017	0,60 0.024	0,75 0.030
P7	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 0.017	0,44 0.017	0,60 0.024	0,75 0.030
P8	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,46 0.018	0,46 0.018	0,60 0.024	0,75 0.030
P11	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 0.017	0,44 0.017	0,60 0.024	0,75 0.030
P12	MM10-10.50-HF-MD08 F30M	0,25 *0.010*	0,30 0.012	0,30 0.012	0,40 0.016	0,48 0.019
M1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,50 0.020	0,50 0.020	0,65 0.026	0,80 0.032
M2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 0.017	0,46 0.018	0,60 0.024	0,75 0.030
M3	MM10-10.50-HF-MD08 F30M	0,25 *0.010*	0,36 0.014	0,36 0.014	0,46 0.018	0,55 0.022
M4	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 0.013	0,32 0.013	0,40 0.016	0,50 0.020
M5	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 0.013	0,32 0.013	0,40 0.016	0,50 0.020
K1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,50 0.020	0,50 0.020	0,65 0.026	0,80 0.032
K2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 0.017	0,46 0.018	0,60 0.024	0,75 0.030
K3	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 0.017	0,46 0.018	0,60 0.024	0,75 0.030
K4	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 0.017	0,46 0.018	0,60 0.024	0,75 0.030
K5	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,40 0.016	0,40 0.016	0,55 0.022	0,65 0.026
K6	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,44 0.017	0,46 0.018	0,60 0.024	0,75 0.030
K7	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,40 0.016	0,40 0.016	0,55 0.022	0,65 0.026
N1	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,65 0.026	0,65 0.026	0,85 0.034	1,1 0.044
N2	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,65 0.026	0,65 0.026	0,85 0.034	1,1 0.044
N3	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,65 0.026	0,65 0.026	0,85 0.034	1,1 0.044
N11	MM10-10.50-HF-MD08 F30M	0,30 *0.012*	0,65 0.026	0,65 0.026	0,85 0.034	1,1 0.044
S1	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 0.013	0,32 0.013	0,40 0.016	0,50 0.020
S2	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 0.013	0,32 0.013	0,40 0.016	0,50 0.020
S3	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,30 0.012	0,30 0.012	0,38 0.015	0,46 0.018
S11	MM10-10.50-HF-MD08 F30M	0,22 *0.0085*	0,36 0.014	0,36 0.014	0,46 0.018	0,55 0.022
S12	MM10-10.50-HF-MD08 F30M	0,22 *0.0085*	0,36 0.014	0,36 0.014	0,46 0.018	0,55 0.022
S13	MM10-10.50-HF-MD08 F30M	0,18 *0.0070*	0,32 0.013	0,32 0.013	0,40 0.016	0,50 0.020
H5	MM10-10.50-HF-MD08 F15M	0,25 *0.010*	0,30 0.012	0,30 0.012	0,40 0.016	0,48 0.019
H8	MM10-10.50-HF-MD08 F15M	0,22 *0.0085*	0,24 0.0095	0,24 0.0095	0,30 0.012	0,36 0.014
H11	MM10-10.50-HF-MD08 F15M	0,25 *0.010*	0,30 0.012	0,30 0.012	0,40 0.016	0,48 0.019
H12	MM10-10.50-HF-MD08 F15M	0,22 *0.0085*	0,24 0.0095	0,24 0.0095	0,30 0.012	0,36 0.014
H21	MM10-10.50-HF-MD08 F15M	0,22 *0.0085*	0,24 0.0095	0,24 0.0095	0,30 0.012	0,36 0.014

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM10 Hohe Vorschübe Schnittdaten v_c = (m/min)/(sf/min)

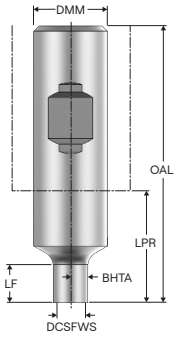
SMG	F15M				F30M			
	100%	70%	30%	20%	100%	70%	30%	20%
P1	—	—	—	—	230	280	325	340
	—	—	—	—	*750*	*920*	*1075*	*1125*
P2	—	—	—	—	225	270	315	330
	—	—	—	—	*740*	*890*	*1025*	*1075*
P3	—	—	—	—	195	240	275	290
	—	—	—	—	*640*	*790*	*900*	*950*
P4	—	—	—	—	170	210	240	255
	—	—	—	—	*560*	*690*	*790*	*840*
P5	—	—	—	—	165	200	230	240
	—	—	—	—	*540*	*660*	*750*	*790*
P6	—	—	—	—	185	225	260	270
	—	—	—	—	*610*	*740*	*850*	*890*
P7	—	—	—	—	175	215	245	255
	—	—	—	—	*570*	*710*	*800*	*840*
P8	—	—	—	—	165	200	230	240
	—	—	—	—	*540*	*660*	*750*	*790*
P11	—	—	—	—	170	210	240	250
	—	—	—	—	*560*	*690*	*790*	*820*
P12	—	—	—	—	110	135	150	160
	—	—	—	—	*360*	*445*	*490*	*520*
M1	—	—	—	—	180	220	255	265
	—	—	—	—	*590*	*720*	*840*	*870*
M2	—	—	—	—	150	180	210	220
	—	—	—	—	*490*	*590*	*690*	*720*
M3	—	—	—	—	120	145	165	175
	—	—	—	—	*395*	*475*	*540*	*570*
M4	—	—	—	—	95	110	130	135
	—	—	—	—	*310*	*360*	*425*	*445*
M5	—	—	—	—	80	95	110	115
	—	—	—	—	*260*	*310*	*360*	*375*
K1	190	230	270	280	175	215	250	260
	620	*750*	*890*	*920*	*570*	*710*	*820*	*850*
K2	170	205	235	245	160	190	220	230
	560	*670*	*770*	*800*	*520*	*620*	*720*	*750*
K3	145	175	200	210	135	160	185	195
	475	*570*	*660*	*690*	*445*	*520*	*610*	*640*
K4	135	165	190	200	125	155	175	185
	445	*540*	*620*	*660*	*410*	*510*	*570*	*610*
K5	85	100	115	125	75	95	105	115
	280	*330*	*375*	*410*	*245*	*310*	*345*	*375*
K6	120	145	170	175	110	135	155	165
	395	*475*	*560*	*570*	*360*	*445*	*510*	*540*
K7	105	130	150	155	100	120	140	145
	345	*425*	*490*	*510*	*330*	*395*	*460*	*475*
N1	—	—	—	—	1325	1600	1850	1925
	—	—	—	—	*4350*	*5250*	*6075*	*6325*
N2	—	—	—	—	530	650	750	780
	—	—	—	—	*1750*	*2125*	*2450*	*2550*
N3	—	—	—	—	355	430	500	520
	—	—	—	—	*1175*	*1400*	*1650*	*1700*
N11	—	—	—	—	405	495	570	590
	—	—	—	—	*1325*	*1625*	*1875*	*1925*
S1	—	—	—	—	45	50	60	65
	—	—	—	—	*150*	*165*	*195*	*215*
S2	—	—	—	—	36	42	49	50
	—	—	—	—	*120*	*140*	*160*	*165*
S3	—	—	—	—	31	37	42	45
	—	—	—	—	*100*	*120*	*140*	*150*
S11	—	—	—	—	60	75	85	90
	—	—	—	—	*195*	*245*	*280*	*295*
S12	—	—	—	—	43	50	60	60
	—	—	—	—	*140*	*165*	*195*	*195*
S13	—	—	—	—	25	29	34	36
	—	—	—	—	*80*	*95*	*110*	*120*
H5	40	48	55	60	37	44	50	55
	130	*155*	*180*	*195*	*120*	*145*	*165*	*180*
H8	42	50	55	60	39	46	55	55
	140	*165*	*180*	*195*	*130*	*150*	*180*	*180*
H11	50	60	70	75	47	55	65	70
	165	*195*	*230*	*245*	*155*	*180*	*215*	*230*
H12	75	90	105	110	70	85	95	100
	245	*295*	*345*	*360*	*230*	*280*	*310*	*330*
H21	42	50	55	60	39	46	55	55
	140	*165*	*180*	*195*	*130*	*150*	*180*	*180*

Schaftkonstruktion

Ausführung 1, Keilnut-Schaft	Ausführung 2, Zylindrische/Weldon Schnittstelle und 90° Stirnseite
	
Ausführung 3, Zylindrische/Weldon Schnittstelle und 87°/89° Stirnseite	**Konstruktion 4, Zylindrische/Weldon Schnittstelle und 80°/85°/87° Stirnseite**
	
Ausführung 5, Zylindrische Schnittstelle und doppelt konische Stirnseite 89°/85°	
	

MM12 Schaft





Bezeichnung	Produkt-nummer	DCSFWS	DMM	LF	LPR	OAL	BHTA°	Abb.	CSP	RPMX	Auf-nahmen	Gewicht	Ersatzteil Bezeich-nung
		mm	mm	mm	mm	mm						kg	
MM12-12055.0-0008	00083978	11,5	12,0	8,5	10,0	55,0	0,0	2	■	80000	Cylindrical	0,1	2
MM12-12070.0-0008DS	02580668	11,5	12,0	8,5	25,0	70,0	0,0	2	■	63600	Cylindrical Densimet	0,1	3
MM12-16065.0-0000	75004926	11,4	16,0	0,0	17,0	65,0	60,0	1	■	80000	Cylindrical	0,1	1
MM12-16170.0-1040	75034505	11,4	16,0	40,0	122,0	170,0	1,0	3	■	80000	Cylindrical	0,3	5
MM12-16170.0-1060	75034506	11,4	16,0	60,0	122,0	170,0	1,0	3	■	80000	Cylindrical	0,2	5
MM12-16170.0-1080	75034507	11,4	16,0	80,0	122,0	170,0	1,0	3	■	80000	Cylindrical	0,2	5
MM12-16095.0-0024DS	02580690	11,4	16,0	24,0	47,0	95,0	0,0	2	■	63600	Cylindrical Densimet	0,3	3
MM12-16090.0-3044DS	02580705	11,4	16,0	43,9	42,0	90,0	3,0	4	■	63600	Cylindrical Densimet	0,3	3
MM12-16120.0-1045DS	02580752	11,4	16,0	45,0	72,0	120,0	1,0	3	■	63600	Cylindrical Densimet	0,3	3
MM12-16115.0-0048DS	02580691	11,4	16,0	48,0	67,0	115,0	0,0	2	■	63600	Cylindrical Densimet	0,3	3
MM12-16170.0-1060DS	02580753	11,4	16,0	60,0	122,0	170,0	1,0	3	■	63600	Cylindrical Densimet	0,5	3
MM12-16170.0-1080DS	02580755	11,4	16,0	80,0	122,0	170,0	1,0	3	■	63600	Cylindrical Densimet	0,5	3
MM12-20080.3-0012	75012864	11,4	20,0	12,0	30,0	80,0	0,0	2	■	80000	Weldon	0,2	4
MM12-20095.3-3027	75012865	11,4	20,0	27,0	45,0	95,0	3,0	3	■	80000	Weldon	0,2	4
MM12-20150.3-5049	75012866	11,4	20,0	49,1	100,0	150,0	5,0	4	■	80000	Weldon	0,3	5
MM12-20250.0-1060DS	02580756	11,4	20,0	60,0	200,0	250,0	1,0	5	■	63600	Cylindrical Densimet	1,0	3

Ersatzteile, im Lieferumfang enthalten

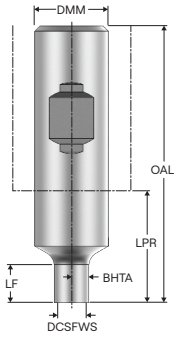
Zubehör

Für Fräser	Hülse	Spannschraube	Schlüssel
			
1	MM-06032	MM12-0637	H06-4
2	MM-06020	MM12-0637	H05-4
3	–	MM12-061037	–
4	MM-06048	MM12-0637	H06-4
5	MM-06116	MM12-0637	H06-4

Innensechskant-Schlüssel H05-4 für die Hülse kann separat bestellt werden.
Steckschlüssel, siehe Wendeschneidplatten-Programm:

MM12 Schaft – Zoll





Bezeichnung	Produkt-nummer	DCSFMS	DMM	LF	LPR	OAL	BHTA°	Abb.	CSP	RPMX	Auf-nahmen	Gewicht	Ersatzteil Bezeich-nung
		Zoll	Zoll	Zoll	Zoll	Zoll						lbs	
MM12-0.50-2.2-0-0003	00096133	0.453	0.500	0.335	0.394	2.165	0,0	2	■	80000	Cylindrical	0.220	2
MM12-0.62-2.6-0-0000	75005070	0.449	0.625	0	0.669	2.559	60,0	1	■	80000	Cylindrical	0.220	1
MM12-0.62-6.7-0-1015	75054728	0.449	0.625	1.575	4.803	6.693	1,0	3	■	80000	Cylindrical	0.440	5
MM12-0.62-6.7-0-1023	75054729	0.449	0.625	2.362	4.803	6.693	1,0	3	■	80000	Cylindrical	0.440	5
MM12-0.62-6.7-0-1023DS	02593423	0.449	0.625	2.362	4.803	6.693	1,0	3	■	63600	Cylindrical Densimet	1.100	4
MM12-0.62-6.7-0-1031DS	02593426	0.449	0.625	3.150	4.803	6.693	1,0	3	■	63600	Cylindrical Densimet	1.100	4
MM12-0.75-3.1-3-0004	75015055	0.449	0.750	0.472	1.181	3.150	0,0	2	■	80000	Weldon	0.440	3
MM12-0.75-3.7-3-3010	75015056	0.449	0.750	1.063	1.772	3.740	3,0	3	■	80000	Weldon	0.440	3
MM12-0.75-5.9-3-5017	75015057	0.449	0.750	1.720	3.937	5.906	5,0	4	■	80000	Weldon	0.660	5
MM12-0.75-10.0-0-1023DS	02593427	0.449	0.750	2.362	7.874	9.843	1,0	5	■	63600	Cylindrical Densimet	1.980	4
MM12-0.75-3.8-0-0009DS	02593428	0.449	0.750	0.945	1.772	3.740	0,0	2	■	63600	Cylindrical Densimet	0.880	4
MM12-0.75-4.5-0-0018DS	02593430	0.449	0.750	1.890	2.559	4.528	0,0	2	■	63600	Cylindrical Densimet	0.880	4

Ersatzteile, im Lieferumfang enthalten

Zubehör

Für Fräser	Hülse	Spannschraube	Schlüssel
			
1	MM-06032	MM12-0637	H06-4
2	MM-06020	MM12-0637	H05-4
3	MM-06048	MM12-0637	H06-4
4	–	MM12-061037	–
5	MM-06116	MM12-0637	H06-4

Innensechskant-Schlüssel H05-4 für die Hülse kann separat bestellt werden.
Steckschlüssel, siehe Wendeschneidplatten-Programm:

Nutfräsen/Eckfräsen

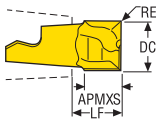


—Drehmomentschlüssel und Drehmomente, siehe Seite 799

												Beschichtung			
Bezeichnung	**DC**	**APMXS**	**RE**	**LF**	**RMPX°**	**C min**	**C max**	**FHA**	**ZEFP**	**Schlüssel**		Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*								T60M	F15M	F30M	F40M
MM12-11715-R03A30-M04	11,7 *0.461*	15,35 *0.604*	0,3 *0.012*	19,9 *0.783*	15,0	14,2	22,6	30	3	MM0416	✓				■
MM12-12015-A30-E04	12,0 *0.472*	15,35 *0.604*	–	19,9 *0.783*	15,0	14,6	23,8	30	3	MM0416	✓			■	
MM12-12015-R05A30-M04	12,0 *0.472*	15,35 *0.604*	0,5 *0.020*	19,9 *0.783*	15,0	14,6	22,8	30	3	MM0416	✓				■
MM12-12015-R10A30-E04	12,0 *0.472*	15,35 *0.604*	1,0 *0.039*	19,9 *0.783*	15,0	14,6	21,8	30	3	MM0416	✓			■	
MM12-12015-R10A30-M04	12,0 *0.472*	15,35 *0.604*	1,0 *0.039*	19,9 *0.783*	15,0	14,6	21,8	30	3	MM0416	✓				■
MM12-12015-R15A30-D04	12,0 *0.472*	15,35 *0.604*	1,5 *0.059*	19,9 *0.783*	15,0	14,6	20,8	30	3	MM0416	✓			■	
MM12-12015-R20A30-M04	12,0 *0.472*	15,35 *0.604*	2,0 *0.079*	19,9 *0.783*	15,0	14,6	19,8	30	3	MM0416	✓				■
MM12-12015-R30A30-E04	12,0 *0.472*	15,3 *0.602*	3,0 *0.118*	19,9 *0.783*	15,0	14,6	17,8	30	3	MM0416	✓			■	
MM12-12015-R30A30-M04	12,0 *0.472*	15,35 *0.604*	3,0 *0.118*	19,9 *0.783*	15,0	14,6	17,8	30	3	MM0416	✓				■
MM12-12015-R40A30-M04	12,0 *0.472*	15,35 *0.604*	4,0 *0.157*	19,9 *0.783*	15,0	14,6	15,8	30	3	MM0416	✓				■
MM12-12715-A30-E04	12,7 *0.500*	15,35 *0.604*	–	19,9 *0.783*	15,0	15,4	25,2	30	3	MM0416	✓			■	
MM12-12715-R08A30-M04	12,7 *0.500*	15,35 *0.604*	0,8 *0.031*	19,9 *0.783*	15,0	15,4	23,6	30	3	MM0416	✓				■
MM12-12715-R16A30-M04	12,7 *0.500*	15,35 *0.604*	1,6 *0.063*	19,9 *0.783*	15,0	15,4	22,0	30	3	MM0416	✓				■

Nutfräsen/Eckfräsen



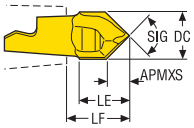


—Drehmomentschlüssel und Drehmomente, siehe Seite 799

											Beschichtung			
Bezeichnung	**DC**	**APMXS**	**RE**	**LF**	**RMPX°**	**C min**	**C max**	**FHA**	**ZEFP**	**Schlüssel**	**Beschichtet**			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*							T60M	F15M	F30M	F40M
MM12-11708T-R03-D05	11,7 *0.461*	8,2 *0.323*	0,3 *0.012*	10,18 *0.401*	15,0	14,2	22,6	0	2	MM0612	■			
MM12-12008-M04	12,0 *0.472*	8,2 *0.323*	–	10,2 *0.402*	15,0	14,6	23,8	0	2	MM0612	■			
MM12-12008-R08A8-E04	12,0 *0.472*	8,1 *0.319*	0,8 *0.031*	10,15 *0.400*	15,0	14,6	22,2	8	2	MM0612	■			
MM12-12008-R08-MD05	12,0 *0.472*	8,2 *0.323*	0,8 *0.031*	10,18 *0.401*	15,0	14,6	22,2	0	2	MM0612	■		■	
MM12-12008-R08P-M04	12,0 *0.472*	8,1 *0.319*	0,8 *0.031*	10,05 *0.396*	15,0	14,6	22,2	0	2	MM0612			■	
MM12-12008-R20-MD05	12,0 *0.472*	8,2 *0.323*	2,0 *0.079*	10,16 *0.400*	15,0	14,6	19,8	0	2	MM0612			■	
MM12-12008-R30-MD05	12,0 *0.472*	8,2 *0.323*	3,0 *0.118*	10,14 *0.399*	15,0	14,6	17,8	0	2	MM0612			■	
MM12-12708-M04	12,7 *0.500*	9,3 *0.366*	–	11,25 *0.443*	15,0	15,4	25,2	0	2	MM1420	■			
MM12-12708-R08-MD05	12,7 *0.500*	9,3 *0.366*	0,8 *0.031*	11,23 *0.442*	15,0	15,4	23,6	0	2	MM1420	■			
MM12-12708-R08P-M04	12,7 *0.500*	9,3 *0.366*	0,8 *0.031*	11,23 *0.442*	15,0	15,4	23,6	0	2	MM1420			■	
MM12-13709T-R03-D05	13,7 *0.539*	9,3 *0.366*	0,3 *0.012*	11,25 *0.443*	15,0	16,6	26,6	0	2	MM1420	■			
MM12-14009-M04	14,0 *0.551*	9,3 *0.366*	–	11,26 *0.443*	15,0	17,0	27,8	0	2	MM1420	■			
MM12-14009-R08A8-E04	14,0 *0.551*	9,2 *0.362*	0,8 *0.031*	11,06 *0.435*	15,0	17,0	26,2	8	2	MM1420	■		■	
MM12-14009-R08-MD05	14,0 *0.551*	9,3 *0.366*	0,8 *0.031*	11,26 *0.443*	15,0	17,0	26,2	0	2	MM1420	■		■	

Zentrierbohren



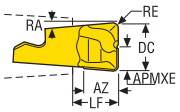


—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DC	APMXS	RE	LF	SIG°	ZEFP	Schlüssel	Beschichtung			
								Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM12-12006-C90-M04	12,0 *0.472*	5,65 *0.222*	– –	14,64 *0.576*	90,0	2	MM0612	■			

Tauchfräser



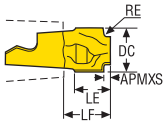


—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DC	APMXE	RE	AZ	LF	RA°	ZEFP	Schlüssel	Beschichtung			
									Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM12-12008-R10-PL-MD05	12,0 *0.472*	6,0 *0.236*	1,0 *0.039*	8,5 *0.335*	10,2 *0.402*	5,0	2	MM0612			■	

Konvexradienfräsen





—Drehmomentschlüssel und Drehmomente, siehe Seite 799

								Beschichtung			
Bezeichnung	**DC**	**APMXS**	**RE**	**LE**	**LF**	**ZEFP**	**Schlüssel**	**Beschichtet**			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*			T60M	F15M	F30M	F40M
MM12-12010-CR10-MD05	12,0 *0.472*	2,2 *0.087*	1,0 *0.039*	10,6 *0.417*	12,14 *0.478*	2	MM0612	■			
MM12-12010-CR20-MD05	12,0 *0.472*	2,4 *0.094*	2,0 *0.079*	10,7 *0.421*	12,25 *0.482*	2	MM0612	■			
MM12-12010-CR30-MD05	12,0 *0.472*	3,3 *0.130*	3,0 *0.118*	10,6 *0.417*	12,2 *0.480*	2	MM0612	■			

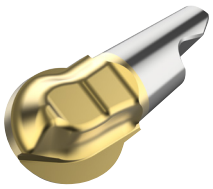
Anfasen



—Drehmomentschlüssel und Drehmomente, siehe Seite 799

										Beschichtung			
Bezeichnung	**DCX**	**DC**	**APMXS**	**DN**	**LF**	**KAPRS°**	**BEC°**	**ZEFP**	**Schlüssel**	**Beschichtet**			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*					T60M	F15M	F30M	F40M
MM12-16016-D3020P-M02	16,0 *0.630*	1,0 *0.039*	4,3 *0.169*	11,5 *0.453*	15,2 *0.598*	30,0	60,0	2	MM1420		■		
MM12-16016-D4520P-M02	16,0 *0.630*	1,0 *0.039*	7,5 *0.295*	11,5 *0.453*	17,2 *0.677*	45,0	90,0	2	MM1420		■		

Präzisionswendeschneidplatten zum Vorschlichten in allen Werkstoffen



—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DC	APMXS	RE	LE	DN	LF	SA	ZEFP	Schlüssel	Beschichtung: Beschichtet T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*							
MM12-14014-B120P-M05	14,0 *0.551*	7,0 *0.276*	7,0 *0.276*	14,0 *0.551*	12,0 *0.472*	15,45 *0.608*	242,0	2	MM1420			■	
MM12-16016-B120PF-M03	16,0 *0.630*	8,0 *0.315*	8,0 *0.315*	16,0 *0.630*	12,0 *0.472*	17,46 *0.687*	263,0	2	MM1420		■		
MM12-16016-B120P-M07	16,0 *0.630*	8,0 *0.315*	8,0 *0.315*	16,0 *0.630*	12,0 *0.472*	17,46 *0.687*	263,0	2	MM1420			■	

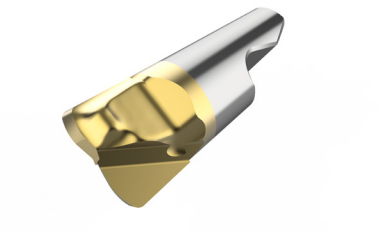
Kopierfräser

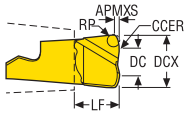


—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DC	APMXS	RE	LF	FHA	ZEFP	Schlüssel		Beschichtung: Beschichtet T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*								
MM12-12012-B90-MD05	12,0 *0.472*	12,2 *0.480*	6,0 *0.236*	14,12 *0.556*		2	MM0612		■		■	
MM12-12012-B90PF-M02	12,0 *0.472*	10,4 *0.409*	6,0 *0.236*	14,09 *0.555*		2	MM0612			■		
MM12-12012-B90P-M05	12,0 *0.472*	10,4 *0.409*	6,0 *0.236*	14,09 *0.555*		2	MM0612				■	
MM12-12012-B90S-E05	12,0 *0.472*	12,3 *0.484*	6,0 *0.236*	14,12 *0.556*		2	MM0612				■	
MM12-12015-B90A30-E04	12,0 *0.472*	15,3 *0.602*	6,0 *0.236*	19,9 *0.783*	30,0	3	MM0416	✓			■	
MM12-12015-B90A30-M04	12,0 *0.472*	15,3 *0.602*	6,0 *0.236*	19,9 *0.783*	30,0	3	MM0416	✓				■
MM12-12713-B90P-M05	12,7 *0.500*	12,2 *0.480*	6,35 *0.250*	15,92 *0.627*		2	MM1420		■		■	
MM12-12715-B90A30-M04	12,7 *0.500*	15,3 *0.602*	6,35 *0.250*	19,75 *0.778*	30,0	3	MM0416	✓				■
MM12-14014-B90S-E05	14,0 *0.551*	14,1 *0.555*	7,0 *0.276*	15,92 *0.627*		2	MM1420				■	

Hochvorschubfräser





—Drehmomentschlüssel und Drehmomente, siehe Seite 799

												Beschichtung			
												Beschichtet			
Bezeichnung	**DCX**	**DC**	**APMXS**	**RP**	**CCER**	**LF**	**RMPX°**	**C min**	**C max**	**ZEFP**	**Schlüssel**	T60M	F15M	F30M	F40M
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*									
MM12-12.60-HF-MD10	12,0 *0.472*	6,0 *0.236*	0,51 *0.020*	1,21 *0.048*	6,5 *0.256*	10,25 *0.404*	5,0	14,6	22,2	2	MM0612		■	■	

MM12 - Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 0.0022	0,060 0.0024	0,070 0.0028	0,095 0.0038
P2	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
P3	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,070 0.0028	0,090 0.0036
P4	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,090 0.0036
P5	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,085 0.0034
P6	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,050 0.0020	0,055 0.0022	0,065 0.0026	0,085 0.0034
P7	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,050 0.0020	0,055 0.0022	0,065 0.0026	0,085 0.0034
P8	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,070 0.0028	0,090 0.0036
P11	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,050 0.0020	0,055 0.0022	0,065 0.0026	0,085 0.0034
P12	MM12-12015-R05A30-M04 F40M	2,0 *0.080*	0,036 0.0014	0,036 0.0014	0,044 0.0017	0,060 0.0024
M1	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
M2	MM12-12015-R05A30-M04 F40M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,085 0.0034
M3	MM12-12015-R05A30-M04 F40M	2,0 *0.080*	0,042 0.0017	0,044 0.0017	0,050 0.0020	0,070 0.0028
M4	MM12-12015-R05A30-M04 F40M	1,6 *0.065*	0,038 0.0015	0,038 0.0015	0,046 0.0018	0,060 0.0024
M5	MM12-12015-R05A30-M04 F40M	1,6 *0.065*	0,038 0.0015	0,038 0.0015	0,046 0.0018	0,060 0.0024
K1	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
K2	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,090 0.0036
K3	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,090 0.0036
K4	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,090 0.0036
K5	MM12-12015-R15A30-D04 F30M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,060 0.0024	0,080 0.0032
K6	MM12-12015-R15A30-D04 F30M	2,5 *0.10*	0,060 0.0024	0,060 0.0024	0,065 0.0026	0,090 0.0036
K7	MM12-12015-R15A30-D04 F30M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,060 0.0024	0,080 0.0032
N1	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,080 0.0032	0,080 0.0032	0,090 0.0036	0,12 0.0048
N2	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,080 0.0032	0,080 0.0032	0,090 0.0036	0,12 0.0048
N3	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,080 0.0032	0,080 0.0032	0,090 0.0036	0,12 0.0048
N11	MM12-12015-R10A30-E04 F30M	2,5 *0.10*	0,080 0.0032	0,080 0.0032	0,090 0.0036	0,12 0.0048
S1	MM12-12015-R15A30-D04 F30M	1,6 *0.065*	0,050 0.0020	0,048 0.0019	0,048 0.0019	0,060 0.0026
S2	MM12-12015-R15A30-D04 F30M	1,6 *0.065*	0,050 0.0020	0,048 0.0019	0,048 0.0019	0,060 0.0026
S3	MM12-12015-R15A30-D04 F30M	1,6 *0.065*	0,046 0.0018	0,044 0.0017	0,044 0.0017	0,055 0.0024
S11	MM12-12015-R05A30-M04 F40M	1,9 *0.075*	0,044 0.0017	0,044 0.0017	0,050 0.0020	0,070 0.0028
S12	MM12-12015-R05A30-M04 F40M	1,9 *0.075*	0,044 0.0017	0,044 0.0017	0,050 0.0020	0,070 0.0028
S13	MM12-12015-R05A30-M04 F40M	1,6 *0.065*	0,038 0.0015	0,038 0.0015	0,046 0.0018	0,060 0.0024
H5	MM12-12015-R15A30-D04 F30M	2,0 *0.080*	0,044 0.0017	0,042 0.0017	0,046 0.0018	0,060 0.0024
H8	MM12-12015-R15A30-D04 F30M	1,9 *0.075*	0,034 0.0013	0,034 0.0013	0,036 0.0014	0,046 0.0018
H11	MM12-12015-R15A30-D04 F30M	2,0 *0.080*	0,044 0.0017	0,042 0.0017	0,046 0.0018	0,060 0.0024
H12	MM12-12015-R15A30-D04 F30M	1,9 *0.075*	0,034 0.0013	0,034 0.0013	0,036 0.0014	0,046 0.0018
H21	MM12-12015-R15A30-D04 F30M	1,9 *0.075*	0,034 0.0013	0,034 0.0013	0,036 0.0014	0,046 0.0018

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM12 - Nut- und Eckfräsen – Schnittdaten v_c = (m/min)/(sf/min)

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	250 *820*	315 *1025*	350 *1150*	385 *1275*	240 *790*	300 *980*	335 *1100*	365 *1200*	185 *610*	225 *740*	255 *840*	280 *920*
P2	245 *800*	305 *1000*	340 *1125*	375 *1225*	235 *770*	290 *950*	325 *1075*	355 *1175*	175 *570*	220 *720*	250 *820*	275 *900*
P3	210 *690*	265 *870*	295 *970*	325 *1075*	200 *660*	250 *820*	280 *920*	310 *1025*	155 *510*	195 *640*	215 *710*	235 *770*
P4	190 *620*	235 *770*	260 *850*	285 *940*	180 *590*	225 *740*	250 *820*	270 *890*	135 *445*	170 *560*	190 *620*	210 *690*
P5	180 *590*	225 *740*	250 *820*	275 *900*	170 *560*	215 *710*	240 *790*	260 *850*	130 *425*	160 *520*	180 *590*	200 *660*
P6	205 *670*	250 *820*	280 *920*	310 *1025*	195 *640*	240 *790*	270 *890*	295 *970*	150 *490*	185 *610*	205 *670*	225 *740*
P7	190 *620*	240 *790*	265 *870*	295 *970*	180 *590*	225 *740*	255 *840*	280 *920*	140 *460*	175 *570*	195 *640*	215 *710*
P8	175 *570*	220 *720*	245 *800*	275 *900*	170 *560*	210 *690*	235 *770*	260 *850*	130 *425*	160 *520*	180 *590*	200 *660*
P11	185 *610*	230 *750*	260 *850*	285 *940*	175 *570*	220 *720*	245 *800*	270 *890*	135 *445*	170 *560*	190 *620*	210 *690*
P12	115 *375*	145 *475*	165 *540*	180 *590*	110 *360*	140 *460*	155 *510*	170 *560*	85 *280*	110 *360*	120 *395*	130 *425*
M1	200 *660*	245 *800*	275 *900*	300 *980*	190 *620*	235 *770*	260 *850*	285 *940*	140 *460*	180 *590*	200 *660*	220 *720*
M2	160 *520*	200 *660*	225 *740*	245 *800*	155 *510*	195 *640*	215 *710*	235 *770*	120 *395*	145 *475*	165 *540*	180 *590*
M3	130 *425*	160 *520*	175 *570*	195 *640*	125 *410*	150 *490*	170 *560*	185 *610*	95 *310*	120 *395*	135 *445*	145 *475*
M4	100 *330*	125 *410*	140 *460*	150 *490*	95 *310*	115 *375*	130 *425*	145 *475*	75 *245*	90 *295*	100 *330*	110 *360*
M5	80 *260*	100 *330*	115 *375*	125 *410*	80 *260*	95 *310*	110 *360*	120 *395*	60 *195*	75 *245*	85 *280*	95 *310*
K1	195 *640*	240 *790*	270 *890*	295 *970*	185 *610*	230 *750*	255 *840*	280 *920*	140 *460*	175 *570*	195 *640*	220 *720*
K2	170 *560*	215 *710*	240 *790*	260 *850*	165 *540*	205 *670*	225 *740*	245 *800*	125 *410*	155 *510*	175 *570*	190 *620*
K3	145 *475*	180 *590*	200 *660*	220 *720*	140 *460*	170 *560*	190 *620*	210 *690*	105 *345*	130 *425*	145 *475*	160 *520*
K4	140 *460*	170 *560*	190 *620*	210 *690*	130 *425*	165 *540*	185 *610*	200 *660*	100 *330*	125 *410*	140 *460*	155 *510*
K5	85 *280*	105 *345*	115 *375*	125 *410*	80 *260*	100 *330*	110 *360*	120 *395*	60 *195*	75 *245*	85 *280*	95 *310*
K6	120 *395*	150 *490*	170 *560*	185 *610*	115 *375*	145 *475*	160 *520*	175 *570*	90 *295*	110 *360*	125 *410*	135 *445*
K7	105 *345*	135 *445*	150 *490*	165 *540*	100 *330*	125 *410*	140 *460*	155 *510*	80 *260*	100 *330*	110 *360*	120 *395*
N1	1450 *4750*	1800 *5900*	2025 *6650*	2225 *7300*	1375 *4500*	1725 *5650*	1925 *6325*	2125 *6975*	1050 *3450*	1300 *4275*	1450 *4750*	1600 *5250*
N2	580 *1900*	730 *2400*	820 *2700*	900 *2950*	560 *1825*	690 *2275*	780 *2550*	860 *2825*	420 *1375*	530 *1750*	590 *1925*	650 *2125*
N3	390 *1275*	485 *1600*	550 *1800*	600 *1975*	370 *1225*	460 *1500*	520 *1700*	570 *1875*	280 *920*	350 *1150*	395 *1300*	435 *1425*
N11	445 *1450*	550 *1800*	620 *2025*	690 *2275*	425 *1400*	530 *1750*	590 *1925*	650 *2125*	320 *1050*	405 *1325*	450 *1475*	495 *1625*
S1	46 *150*	55 *180*	65 *215*	70 *230*	44 *145*	55 *180*	60 *195*	65 *215*	34 *110*	43 *140*	47 *155*	50 *165*
S2	37 *120*	46 *150*	50 *165*	55 *180*	35 *115*	44 *145*	49 *160*	55 *180*	28 *90*	34 *110*	38 *125*	42 *140*
S3	32 *105*	40 *130*	45 *150*	50 *165*	31 *100*	38 *125*	43 *140*	47 *155*	24 *80*	30 *100*	33 *110*	37 *120*
S11	65 *215*	80 *260*	90 *295*	100 *330*	60 *195*	75 *245*	85 *280*	95 *310*	48 *155*	60 *195*	65 *215*	75 *245*
S12	45 *150*	55 *180*	60 *195*	70 *230*	43 *140*	55 *180*	60 *195*	65 *215*	33 *110*	41 *135*	47 *155*	50 *165*
S13	26 *85*	32 *105*	36 *120*	40 *130*	25 *80*	31 *100*	34 *110*	38 *125*	19 *60*	24 *80*	27 *90*	29 *95*
H5	39 *130*	49 *160*	55 *180*	60 *195*	37 *120*	46 *150*	50 *165*	55 *180*	29 *95*	36 *120*	40 *130*	44 *145*
H8	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	30 *100*	37 *120*	42 *140*	46 *150*
H11	49 *160*	60 *195*	70 *230*	75 *245*	47 *155*	60 *195*	65 *215*	70 *230*	37 *120*	46 *150*	50 *165*	55 *180*
H12	75 *245*	90 *295*	100 *330*	110 *360*	70 *230*	85 *280*	95 *310*	105 *345*	55 *180*	65 *215*	75 *245*	85 *280*
H21	41 *135*	50 *165*	55 *180*	60 *195*	39 *130*	48 *155*	55 *180*	60 *195*	30 *100*	37 *120*	42 *140*	46 *150*

MM12 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Schruppen – Metrisch/ Zoll

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 0.0028	0,070 0.0028	0,070 0.0028	0,095 0.0038
P2	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 0.0028	0,070 0.0028	0,075 0.0030	0,095 0.0038
P3	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 0.0028	0,065 0.0026	0,070 0.0028	0,090 0.0036
P4	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,070 0.0028	0,090 0.0036
P5	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,065 0.0026	0,090 0.0036
P6	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,065 0.0026	0,085 0.0034
P7	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,065 0.0026	0,085 0.0034
P8	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 0.0028	0,065 0.0026	0,070 0.0028	0,090 0.0036
P11	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,065 0.0026	0,085 0.0034
P12	MM12-12015-B90A30-M04 F40M	2,0 *0.080*	0,046 0.0018	0,044 0.0017	0,046 0.0018	0,060 0.0024
M1	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,070 0.0028	0,070 0.0028	0,075 0.0030	0,095 0.0038
M2	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,065 0.0026	0,090 0.0036
M3	MM12-12015-B90A30-M04 F40M	2,0 *0.080*	0,055 0.0022	0,055 0.0022	0,055 0.0022	0,070 0.0028
M4	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 0.0020	0,048 0.0019	0,048 0.0019	0,060 0.0026
M5	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 0.0020	0,048 0.0019	0,048 0.0019	0,060 0.0026
K1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,070 0.0028	0,070 0.0028	0,075 0.0030	0,095 0.0038
K2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,065 0.0026	0,090 0.0036
K3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,065 0.0026	0,090 0.0036
K4	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,065 0.0026	0,090 0.0036
K5	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,060 0.0024	0,055 0.0022	0,060 0.0024	0,080 0.0032
K6	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,065 0.0026	0,090 0.0036
K7	MM12-12015-B90A30-M04 F40M	2,5 *0.10*	0,060 0.0024	0,055 0.0022	0,060 0.0024	0,080 0.0032
N1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,090 0.0036	0,090 0.0036	0,095 0.0038	0,12 0.0048
N2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,090 0.0036	0,090 0.0036	0,095 0.0038	0,12 0.0048
N3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,090 0.0036	0,090 0.0036	0,095 0.0038	0,12 0.0048
N11	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,090 0.0036	0,090 0.0036	0,095 0.0038	0,12 0.0048
S1	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 0.0020	0,048 0.0019	0,048 0.0019	0,060 0.0026
S2	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 0.0020	0,048 0.0019	0,048 0.0019	0,060 0.0026
S3	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,046 0.0018	0,046 0.0018	0,046 0.0018	0,055 0.0024
S11	MM12-12015-B90A30-M04 F40M	1,9 *0.075*	0,055 0.0022	0,055 0.0022	0,055 0.0022	0,070 0.0028
S12	MM12-12015-B90A30-M04 F40M	1,9 *0.075*	0,055 0.0022	0,055 0.0022	0,055 0.0022	0,070 0.0028
S13	MM12-12015-B90A30-M04 F40M	1,6 *0.065*	0,050 0.0020	0,048 0.0019	0,048 0.0019	0,060 0.0026
H5	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,046 0.0018	0,044 0.0017	0,046 0.0018	0,060 0.0024
H8	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,036 0.0014	0,036 0.0014	0,036 0.0014	0,046 0.0018
H11	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,046 0.0018	0,044 0.0017	0,046 0.0018	0,060 0.0024
H12	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,036 0.0014	0,036 0.0014	0,036 0.0014	0,046 0.0018
H21	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,036 0.0014	0,036 0.0014	0,036 0.0014	0,046 0.0018

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM12 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Schlichten – Metrisch/ Zoll

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,22 0.0085
P2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,22 0.0085
P3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,13 0.0050	0,20 0.0080
P4	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,12 0.0048	0,20 0.0080
P5	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,12 0.0048	0,20 0.0080
P6	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,085 0.0034	0,12 0.0048	0,19 0.0075
P7	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,085 0.0034	0,12 0.0048	0,19 0.0075
P8	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,13 0.0050	0,20 0.0080
P11	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,085 0.0034	0,12 0.0048	0,19 0.0075
P12	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,050 0.0020	0,060 0.0024	0,080 0.0032	0,13 0.0050
M1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,22 0.0085
M2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,12 0.0048	0,20 0.0080
M3	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,16 0.0065
M4	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 0.0022	0,060 0.0026	0,085 0.0034	0,14 0.0055
M5	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 0.0022	0,060 0.0026	0,085 0.0034	0,14 0.0055
K1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,22 0.0085
K2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,12 0.0048	0,20 0.0080
K3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,12 0.0048	0,20 0.0080
K4	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,12 0.0048	0,20 0.0080
K5	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 0.0026	0,080 0.0032	0,11 0.0044	0,18 0.0070
K6	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,12 0.0048	0,20 0.0080
K7	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,065 0.0026	0,080 0.0032	0,11 0.0044	0,18 0.0070
N1	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,10 0.0040	0,12 0.0048	0,17 0.0065	0,28 0.011
N2	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,10 0.0040	0,12 0.0048	0,17 0.0065	0,28 0.011
N3	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,10 0.0040	0,12 0.0048	0,17 0.0065	0,28 0.011
N11	MM12-12015-B90A30-E04 F30M	2,5 *0.10*	0,10 0.0040	0,12 0.0048	0,17 0.0065	0,28 0.011
S1	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 0.0022	0,060 0.0026	0,085 0.0034	0,14 0.0055
S2	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 0.0022	0,060 0.0026	0,085 0.0034	0,14 0.0055
S3	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,050 0.0020	0,055 0.0024	0,080 0.0032	0,13 0.0050
S11	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,16 0.0065
S12	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,16 0.0065
S13	MM12-12015-B90A30-E04 F30M	1,6 *0.065*	0,055 0.0022	0,060 0.0026	0,085 0.0034	0,14 0.0055
H5	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,050 0.0020	0,060 0.0024	0,080 0.0032	0,13 0.0050
H8	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,040 0.0016	0,046 0.0018	0,065 0.0026	0,10 0.0040
H11	MM12-12015-B90A30-E04 F30M	2,0 *0.080*	0,050 0.0020	0,060 0.0024	0,080 0.0032	0,13 0.0050
H12	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,040 0.0016	0,046 0.0018	0,065 0.0026	0,10 0.0040
H21	MM12-12015-B90A30-E04 F30M	1,9 *0.075*	0,040 0.0016	0,046 0.0018	0,065 0.0026	0,10 0.0040

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM12 Z3 – Kopierfräser – Schnittdaten v_c = (m/min)/(sf/min)

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	270 *890*	315 *1025*	335 *1100*	365 *1200*	360 *1175*	255 *840*	300 *980*	320 *1050*	345 *1125*	340 *1125*
P2	265 *870*	305 *1000*	325 *1075*	355 *1175*	350 *1150*	250 *820*	290 *950*	310 *1025*	335 *1100*	330 *1075*
P3	225 *740*	265 *870*	285 *940*	305 *1000*	305 *1000*	215 *710*	255 *840*	270 *890*	290 *950*	290 *950*
P4	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	235 *770*	260 *850*	255 *840*
P5	195 *640*	225 *740*	240 *790*	260 *850*	255 *840*	185 *610*	215 *710*	225 *740*	245 *800*	245 *800*
P6	215 *710*	255 *840*	270 *890*	290 *950*	290 *950*	205 *670*	240 *790*	255 *840*	275 *900*	275 *900*
P7	205 *670*	240 *790*	255 *840*	275 *900*	275 *900*	195 *640*	230 *750*	240 *790*	260 *850*	260 *850*
P8	190 *620*	225 *740*	240 *790*	255 *840*	255 *840*	180 *590*	215 *710*	225 *740*	245 *800*	245 *800*
P11	200 *660*	235 *770*	245 *800*	265 *870*	265 *870*	190 *620*	220 *720*	235 *770*	255 *840*	255 *840*
P12	125 *410*	150 *490*	155 *510*	170 *560*	165 *540*	120 *395*	140 *460*	145 *490*	160 *520*	160 *520*
M1	210 *690*	245 *800*	265 *870*	285 *940*	280 *920*	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*
M2	175 *570*	205 *670*	215 *710*	235 *770*	230 *750*	165 *540*	195 *640*	205 *670*	220 *720*	220 *720*
M3	140 *460*	165 *540*	170 *560*	185 *610*	185 *610*	130 *425*	155 *510*	160 *540*	175 *570*	175 *570*
M4	100 *330*	130 *425*	130 *460*	140 *460*	140 *460*	95 *310*	125 *410*	125 *425*	135 *445*	135 *445*
M5	80 *260*	110 *360*	110 *375*	115 *375*	115 *375*	80 *260*	105 *345*	105 *360*	110 *360*	110 *360*
K1	210 *690*	240 *790*	260 *850*	280 *920*	275 *900*	200 *660*	230 *750*	245 *800*	265 *870*	265 *870*
K2	185 *610*	215 *710*	225 *740*	245 *800*	245 *800*	175 *570*	205 *670*	215 *710*	235 *770*	230 *750*
K3	155 *510*	180 *590*	190 *620*	210 *690*	205 *670*	145 *475*	175 *570*	180 *590*	200 *660*	195 *640*
K4	150 *490*	175 *570*	180 *590*	200 *660*	195 *640*	140 *460*	165 *540*	175 *570*	190 *620*	185 *610*
K5	90 *295*	105 *345*	110 *360*	120 *395*	120 *395*	85 *280*	100 *330*	105 *345*	115 *375*	115 *375*
K6	130 *425*	155 *510*	160 *520*	175 *570*	175 *570*	125 *410*	145 *475*	155 *510*	165 *540*	165 *540*
K7	115 *375*	135 *445*	140 *460*	155 *510*	155 *510*	110 *360*	125 *410*	135 *445*	145 *475*	145 *475*
N1	1575 *5175*	1825 *6000*	1950 *6400*	2100 *6900*	2100 *6900*	1500 *4925*	1750 *5750*	1850 *6075*	2000 *6550*	2000 *6550*
N2	640 *2100*	740 *2425*	790 *2600*	850 *2800*	840 *2750*	610 *2000*	700 *2300*	750 *2450*	810 *2650*	800 *2625*
N3	425 *1400*	495 *1625*	530 *1750*	570 *1875*	560 *1825*	405 *1325*	470 *1550*	500 *1650*	540 *1775*	540 *1775*
N11	485 *1600*	560 *1825*	600 *1975*	650 *2125*	640 *2100*	460 *1500*	540 *1775*	570 *1875*	620 *2025*	610 *2000*
S1	46 *150*	60 *195*	60 *215*	65 *215*	65 *215*	44 *145*	60 *195*	60 *195*	65 *215*	60 *195*
S2	37 *120*	50 *165*	49 *165*	55 *180*	55 *180*	35 *115*	47 *155*	47 *165*	50 *165*	50 *165*
S3	32 *105*	43 *140*	43 *150*	46 *150*	46 *150*	31 *100*	41 *135*	41 *140*	44 *145*	44 *145*
S11	70 *230*	85 *280*	85 *295*	95 *310*	90 *295*	65 *215*	80 *260*	80 *280*	90 *295*	90 *295*
S12	48 *155*	60 *195*	60 *195*	65 *215*	65 *215*	46 *150*	55 *180*	55 *195*	60 *195*	60 *195*
S13	26 *85*	35 *115*	34 *120*	37 *120*	37 *120*	25 *80*	33 *110*	33 *115*	35 *115*	35 *115*
H5	42 *140*	50 *165*	50 *165*	55 *180*	55 *180*	40 *130*	47 *155*	49 *160*	55 *180*	55 *180*
H8	42 *140*	55 *180*	55 *180*	55 *180*	55 *180*	40 *130*	50 *165*	50 *165*	55 *180*	55 *180*
H11	55 *180*	65 *215*	65 *215*	70 *230*	70 *230*	50 *165*	60 *195*	60 *195*	65 *215*	65 *215*
H12	75 *245*	95 *310*	95 *330*	105 *345*	105 *345*	75 *245*	90 *295*	90 *310*	100 *330*	100 *330*
H21	42 *140*	55 *180*	55 *180*	55 *180*	55 *180*	40 *130*	50 *165*	50 *165*	55 *180*	55 *180*

MM12 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Schruppen – Metrisch/ Zoll

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,075 0.0030	0,080 0.0032	0,090 0.0036	0,12 0.0048
P2	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,080 0.0032	0,080 0.0032	0,090 0.0036	0,12 0.0048
P3	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,075 0.0030	0,075 0.0030	0,085 0.0034	0,11 0.0044
P4	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,075 0.0030	0,075 0.0030	0,085 0.0034	0,11 0.0044
P5	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,085 0.0034	0,11 0.0044
P6	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,080 0.0032	0,11 0.0044
P7	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,080 0.0032	0,11 0.0044
P8	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,075 0.0030	0,075 0.0030	0,085 0.0034	0,11 0.0044
P11	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,080 0.0032	0,11 0.0044
P12	MM12-12012-B90-MD05 F30M	4,0 *0.16*	0,050 0.0020	0,050 0.0020	0,060 0.0024	0,075 0.0030
M1	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,080 0.0032	0,080 0.0032	0,090 0.0036	0,12 0.0048
M2	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,085 0.0034	0,11 0.0044
M3	MM12-12012-B90S-E05 F30M	4,0 *0.16*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,090 0.0036
M4	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 0.0022	0,055 0.0022	0,060 0.0024	0,075 0.0032
M5	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 0.0022	0,055 0.0022	0,060 0.0024	0,075 0.0032
K1	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,080 0.0032	0,080 0.0032	0,090 0.0036	0,12 0.0048
K2	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,085 0.0034	0,11 0.0044
K3	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,085 0.0034	0,11 0.0044
K4	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,085 0.0034	0,11 0.0044
K5	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,065 0.0026	0,065 0.0026	0,075 0.0030	0,10 0.0040
K6	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,085 0.0034	0,11 0.0044
K7	MM12-12012-B90-MD05 F30M	5,0 *0.20*	0,065 0.0026	0,065 0.0026	0,075 0.0030	0,10 0.0040
N1	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
N2	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
N3	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
N11	MM12-12012-B90S-E05 F30M	5,0 *0.20*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
S1	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 0.0022	0,055 0.0022	0,060 0.0024	0,075 0.0032
S2	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 0.0022	0,055 0.0022	0,060 0.0024	0,075 0.0032
S3	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,050 0.0020	0,050 0.0020	0,055 0.0022	0,070 0.0030
S11	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,090 0.0036
S12	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,090 0.0036
S13	MM12-12012-B90-MD05 F30M	3,0 *0.12*	0,055 0.0022	0,055 0.0022	0,060 0.0024	0,075 0.0032
H5	MM12-12012-B90-MD05 F30M	4,0 *0.16*	0,050 0.0020	0,050 0.0020	0,060 0.0024	0,075 0.0030
H8	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,040 0.0016	0,040 0.0016	0,044 0.0017	0,055 0.0024
H11	MM12-12012-B90-MD05 F30M	4,0 *0.16*	0,050 0.0020	0,050 0.0020	0,060 0.0024	0,075 0.0030
H12	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,040 0.0016	0,040 0.0016	0,044 0.0017	0,055 0.0024
H21	MM12-12012-B90-MD05 F30M	3,5 *0.14*	0,040 0.0016	0,040 0.0016	0,044 0.0017	0,055 0.0024

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM12 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,040 0.0016	0,048 0.0019	0,065 0.0026	0,11 0.0044
P2	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,042 0.0017	0,048 0.0019	0,070 0.0028	0,11 0.0044
P3	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,040 0.0016	0,046 0.0018	0,065 0.0026	0,10 0.0040
P4	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 0.0015	0,046 0.0018	0,065 0.0026	0,10 0.0040
P5	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
P6	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
P7	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
P8	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,040 0.0016	0,046 0.0018	0,065 0.0026	0,10 0.0040
P11	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
P12	MM12-12012-B90PF-M02 F15M	3,5 *0.14*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,065 0.0026
M1	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,042 0.0017	0,048 0.0019	0,070 0.0028	0,11 0.0044
M2	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
M3	MM12-12012-B90PF-M02 F15M	3,5 *0.14*	0,030 0.0012	0,036 0.0014	0,050 0.0020	0,075 0.0030
M4	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 0.0011	0,032 0.0013	0,042 0.0017	0,065 0.0026
M5	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 0.0011	0,032 0.0013	0,042 0.0017	0,065 0.0026
K1	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,042 0.0017	0,048 0.0019	0,070 0.0028	0,11 0.0044
K2	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
K3	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
K4	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
K5	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,034 0.0013	0,040 0.0016	0,055 0.0022	0,085 0.0034
K6	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
K7	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,034 0.0013	0,040 0.0016	0,055 0.0022	0,085 0.0034
N1	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,055 0.0022	0,060 0.0024	0,085 0.0034	0,14 0.0055
N2	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,055 0.0022	0,060 0.0024	0,085 0.0034	0,14 0.0055
N3	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,055 0.0022	0,060 0.0024	0,085 0.0034	0,14 0.0055
N11	MM12-12012-B90PF-M02 F15M	4,0 *0.16*	0,055 0.0022	0,060 0.0024	0,085 0.0034	0,14 0.0055
S1	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 0.0011	0,032 0.0013	0,042 0.0017	0,065 0.0026
S2	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 0.0011	0,032 0.0013	0,042 0.0017	0,065 0.0026
S3	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,025 0.0010	0,028 0.0012	0,040 0.0016	0,065 0.0026
S11	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,030 0.0012	0,036 0.0014	0,050 0.0020	0,075 0.0030
S12	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,030 0.0012	0,036 0.0014	0,050 0.0020	0,075 0.0030
S13	MM12-12012-B90PF-M02 F15M	2,5 *0.10*	0,028 0.0011	0,032 0.0013	0,042 0.0017	0,065 0.0026
H5	MM12-12012-B90PF-M02 F15M	3,5 *0.14*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,065 0.0026
H8	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,020 0.00080	0,024 0.00095	0,032 0.0013	0,050 0.0020
H11	MM12-12012-B90PF-M02 F15M	3,5 *0.14*	0,026 0.0010	0,030 0.0012	0,042 0.0017	0,065 0.0026
H12	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,020 0.00080	0,024 0.00095	0,032 0.0013	0,050 0.0020
H21	MM12-12012-B90PF-M02 F15M	3,0 *0.12*	0,020 0.00080	0,024 0.00095	0,032 0.0013	0,050 0.0020

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM12 Z2 – Kopierfräser – Schnittdaten v_c = (m/min)/(sf/min)

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	310 *1025*	390 *1275*	410 *1350*	445 *1450*	440 *1450*	240 *790*	300 *980*	325 *1075*	350 *1150*	345 *1125*	195 *640*	240 *790*	265 *870*	285 *940*	280 *920*
P2	300 *980*	380 *1250*	400 *1300*	430 *1400*	430 *1400*	230 *750*	290 *950*	315 *1025*	340 *1125*	340 *1125*	185 *610*	235 *770*	255 *840*	275 *900*	275 *900*
P3	260 *850*	330 *1075*	345 *1125*	370 *1225*	370 *1225*	200 *660*	255 *840*	275 *900*	295 *970*	295 *970*	160 *520*	205 *670*	225 *740*	240 *790*	240 *790*
P4	230 *750*	290 *950*	305 *1000*	325 *1075*	330 *1075*	175 *570*	225 *740*	245 *800*	260 *850*	260 *850*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*
P5	220 *720*	275 *900*	290 *950*	315 *1025*	315 *1025*	170 *560*	215 *710*	235 *770*	255 *840*	250 *820*	140 *460*	170 *560*	190 *620*	205 *670*	200 *660*
P6	245 *800*	310 *1025*	325 *1075*	355 *1175*	355 *1175*	190 *620*	240 *790*	260 *850*	285 *940*	280 *920*	155 *510*	195 *640*	210 *690*	230 *750*	225 *740*
P7	230 *750*	295 *970*	310 *1025*	335 *1100*	335 *1100*	180 *590*	230 *750*	245 *800*	270 *890*	265 *870*	145 *475*	185 *610*	200 *660*	215 *710*	215 *710*
P8	215 *710*	275 *900*	290 *950*	310 *1025*	315 *1025*	170 *560*	215 *710*	235 *770*	250 *820*	250 *820*	135 *445*	170 *560*	190 *620*	200 *660*	200 *660*
P11	225 *740*	285 *940*	300 *980*	325 *1075*	325 *1075*	175 *570*	220 *720*	240 *790*	260 *850*	255 *840*	140 *460*	180 *590*	195 *640*	210 *690*	210 *690*
P12	140 *460*	180 *590*	180 *610*	195 *640*	200 *660*	115 *375*	145 *475*	150 *510*	165 *540*	160 *520*	95 *310*	120 *395*	120 *410*	135 *445*	130 *425*
M1	240 *790*	305 *1000*	320 *1050*	345 *1125*	345 *1125*	185 *610*	235 *770*	255 *840*	275 *900*	270 *890*	150 *490*	190 *620*	205 *670*	225 *740*	220 *720*
M2	195 *640*	250 *820*	260 *850*	285 *940*	285 *940*	155 *510*	190 *620*	210 *690*	225 *740*	225 *740*	125 *410*	155 *510*	170 *560*	185 *610*	180 *590*
M3	155 *510*	200 *660*	205 *670*	220 *720*	220 *720*	125 *410*	160 *520*	165 *560*	180 *590*	180 *590*	100 *330*	130 *425*	135 *445*	145 *475*	145 *475*
M4	120 *395*	155 *510*	155 *540*	165 *540*	165 *540*	100 *330*	130 *425*	130 *445*	135 *445*	140 *460*	80 *260*	105 *345*	105 *360*	110 *360*	110 *360*
M5	100 *330*	130 *425*	130 *460*	140 *460*	140 *460*	85 *280*	110 *360*	105 *375*	115 *375*	115 *375*	70 *230*	85 *280*	85 *295*	95 *310*	95 *310*
K1	235 *770*	300 *980*	315 *1025*	340 *1125*	340 *1125*	180 *590*	230 *750*	250 *820*	270 *890*	270 *890*	145 *475*	185 *610*	205 *670*	220 *720*	215 *710*
K2	205 *670*	265 *870*	275 *900*	300 *980*	300 *980*	160 *520*	200 *660*	220 *720*	240 *790*	235 *770*	130 *425*	165 *540*	180 *590*	195 *640*	190 *620*
K3	175 *570*	225 *740*	235 *770*	255 *840*	255 *840*	135 *445*	170 *560*	185 *610*	205 *670*	200 *660*	110 *360*	140 *460*	150 *490*	165 *540*	165 *540*
K4	165 *540*	215 *710*	225 *740*	240 *790*	240 *790*	130 *425*	165 *540*	180 *590*	195 *640*	190 *620*	105 *345*	130 *425*	145 *475*	155 *510*	155 *510*
K5	100 *330*	130 *425*	135 *445*	145 *475*	145 *475*	80 *260*	100 *330*	110 *360*	115 *375*	115 *375*	65 *215*	80 *260*	85 *280*	95 *310*	95 *310*
K6	145 *475*	185 *610*	195 *640*	215 *710*	215 *710*	115 *375*	145 *475*	155 *510*	170 *560*	170 *560*	95 *310*	115 *375*	125 *410*	140 *460*	135 *445*
K7	130 *425*	165 *540*	170 *560*	185 *610*	185 *610*	100 *330*	125 *410*	140 *460*	150 *490*	150 *490*	80 *260*	105 *345*	110 *360*	120 *395*	120 *395*
N1	1825 *6000*	2300 *7550*	2425 *7950*	2625 *8600*	2600 *8525*	1375 *4500*	1725 *5650*	1900 *6225*	2025 *6650*	2000 *6550*	1100 *3600*	1400 *4600*	1525 *5000*	1650 *5425*	1625 *5325*
N2	730 *2400*	930 *3050*	980 *3225*	1050 *3450*	1050 *3450*	550 *1800*	690 *2275*	760 *2500*	820 *2700*	810 *2650*	450 *1475*	560 *1825*	620 *2025*	660 *2175*	660 *2175*
N3	490 *1600*	620 *2025*	650 *2125*	710 *2325*	700 *2300*	370 *1225*	465 *1525*	510 *1675*	550 *1800*	540 *1775*	300 *980*	375 *1225*	410 *1350*	440 *1450*	440 *1450*
N11	560 *1825*	710 *2325*	750 *2450*	810 *2650*	800 *2625*	425 *1400*	530 *1750*	580 *1900*	620 *2025*	620 *2025*	340 *1125*	430 *1400*	470 *1550*	500 *1650*	500 *1650*
S1	55 *180*	70 *230*	70 *260*	80 *260*	80 *260*	47 *155*	60 *195*	60 *215*	65 *215*	65 *215*	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*
S2	45 *150*	60 *195*	60 *215*	65 *215*	65 *215*	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*	31 *100*	39 *130*	39 *135*	42 *140*	42 *140*
S3	39 *130*	50 *165*	50 *180*	55 *180*	55 *180*	33 *110*	43 *140*	42 *145*	45 *150*	45 *150*	27 *90*	34 *110*	34 *120*	37 *120*	36 *120*
S11	80 *260*	105 *345*	105 *360*	110 *360*	110 *360*	65 *215*	85 *280*	85 *280*	90 *295*	90 *295*	55 *180*	70 *230*	70 *230*	75 *245*	75 *245*
S12	55 *180*	70 *230*	70 *245*	75 *245*	75 *245*	45 *150*	60 *195*	60 *195*	65 *215*	60 *195*	37 *120*	47 *155*	47 *160*	50 *165*	50 *165*
S13	32 *105*	41 *135*	40 *145*	44 *145*	44 *145*	26 *85*	34 *110*	34 *120*	36 *120*	36 *120*	21 *70*	28 *90*	27 *95*	29 *95*	29 *95*
H5	46 *150*	60 *195*	60 *195*	65 *215*	65 *215*	38 *125*	48 *155*	50 *165*	55 *180*	55 *180*	31 *100*	39 *130*	41 *135*	44 *145*	44 *145*
H8	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	33 *110*	42 *140*	42 *140*	46 *150*	45 *150*
H11	60 *195*	75 *245*	75 *260*	85 *280*	85 *280*	49 *160*	60 *195*	65 *215*	70 *230*	70 *230*	39 *130*	50 *165*	50 *165*	55 *180*	55 *180*
H12	85 *280*	110 *360*	110 *375*	120 *395*	120 *395*	70 *230*	95 *310*	95 *310*	100 *330*	100 *330*	60 *195*	75 *245*	75 *260*	80 *260*	80 *260*
H21	48 *155*	60 *195*	60 *215*	65 *215*	65 *215*	40 *130*	50 *165*	50 *180*	55 *180*	55 *180*	33 *110*	42 *140*	42 *140*	46 *150*	45 *150*

MM12 Hohe Vorschübe – Auswahl der Wendeschneidplatten – Schlichten – mm/Zoll

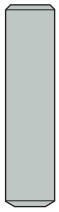
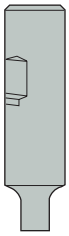
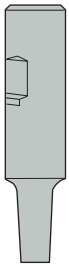
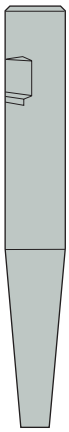
SMG		a_p	f_z			
			100%	70%	30%	20%
P1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 0.022	0,55 0.022	0,75 0.030	0,95 0.038
P2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 0.022	0,60 0.024	0,75 0.030	0,95 0.038
P3	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 0.022	0,55 0.022	0,70 0.028	0,90 0.036
P4	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 0.022	0,55 0.022	0,70 0.028	0,90 0.036
P5	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 0.020	0,55 0.022	0,70 0.028	0,85 0.034
P6	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 0.020	0,50 0.020	0,70 0.028	0,85 0.034
P7	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 0.020	0,50 0.020	0,70 0.028	0,85 0.034
P8	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 0.022	0,55 0.022	0,70 0.028	0,90 0.036
P11	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 0.020	0,50 0.020	0,70 0.028	0,85 0.034
P12	MM12-12.60-HF-MD10 F30M	0,28 *0.011*	0,36 0.014	0,36 0.014	0,46 0.018	0,55 0.022
M1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 0.022	0,60 0.024	0,75 0.030	0,95 0.038
M2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 0.020	0,55 0.022	0,70 0.028	0,85 0.034
M3	MM12-12.60-HF-MD10 F30M	0,28 *0.011*	0,42 0.017	0,42 0.017	0,55 0.022	0,65 0.026
M4	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 0.014	0,36 0.014	0,48 0.019	0,60 0.024
M5	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 0.014	0,36 0.014	0,48 0.019	0,60 0.024
K1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,55 0.022	0,60 0.024	0,75 0.030	0,95 0.038
K2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 0.020	0,55 0.022	0,70 0.028	0,85 0.034
K3	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 0.020	0,55 0.022	0,70 0.028	0,85 0.034
K4	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 0.020	0,55 0.022	0,70 0.028	0,85 0.034
K5	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,48 0.019	0,48 0.019	0,60 0.024	0,75 0.030
K6	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,50 0.020	0,55 0.022	0,70 0.028	0,85 0.034
K7	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,48 0.019	0,48 0.019	0,60 0.024	0,75 0.030
N1	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,75 0.030	0,75 0.030	1,0 0.040	1,3 0.050
N2	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,75 0.030	0,75 0.030	1,0 0.040	1,3 0.050
N3	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,75 0.030	0,75 0.030	1,0 0.040	1,3 0.050
N11	MM12-12.60-HF-MD10 F30M	0,36 *0.014*	0,75 0.030	0,75 0.030	1,0 0.040	1,3 0.050
S1	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 0.014	0,36 0.014	0,48 0.019	0,60 0.024
S2	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 0.014	0,36 0.014	0,48 0.019	0,60 0.024
S3	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,34 0.013	0,34 0.013	0,44 0.017	0,55 0.022
S11	MM12-12.60-HF-MD10 F30M	0,25 *0.010*	0,42 0.017	0,42 0.017	0,55 0.022	0,65 0.026
S12	MM12-12.60-HF-MD10 F30M	0,25 *0.010*	0,42 0.017	0,42 0.017	0,55 0.022	0,65 0.026
S13	MM12-12.60-HF-MD10 F30M	0,22 *0.0085*	0,36 0.014	0,36 0.014	0,48 0.019	0,60 0.024
H5	MM12-12.60-HF-MD10 F15M	0,28 *0.011*	0,36 0.014	0,36 0.014	0,46 0.018	0,55 0.022
H8	MM12-12.60-HF-MD10 F15M	0,25 *0.010*	0,28 0.011	0,28 0.011	0,36 0.014	0,42 0.017
H11	MM12-12.60-HF-MD10 F15M	0,28 *0.011*	0,36 0.014	0,36 0.014	0,46 0.018	0,55 0.022
H12	MM12-12.60-HF-MD10 F15M	0,25 *0.010*	0,28 0.011	0,28 0.011	0,36 0.014	0,42 0.017
H21	MM12-12.60-HF-MD10 F15M	0,25 *0.010*	0,28 0.011	0,28 0.011	0,36 0.014	0,42 0.017

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM12 Hohe Vorschübe Schnittdaten v_c = (m/min)/(sf/min)

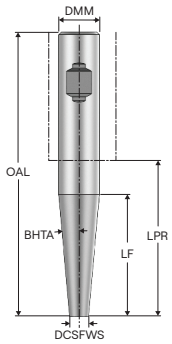
SMG	F15M				F30M			
	100%	70%	30%	20%	100%	70%	30%	20%
P1	—	—	—	—	225	275	315	330
	—	—	—	—	*740*	*900*	*1025*	*1075*
P2	—	—	—	—	220	265	310	320
	—	—	—	—	*720*	*870*	*1025*	*1050*
P3	—	—	—	—	190	230	270	280
	—	—	—	—	*620*	*750*	*890*	*920*
P4	—	—	—	—	165	205	235	245
	—	—	—	—	*540*	*670*	*770*	*800*
P5	—	—	—	—	165	195	225	240
	—	—	—	—	*540*	*640*	*740*	*790*
P6	—	—	—	—	185	225	255	270
	—	—	—	—	*610*	*740*	*840*	*890*
P7	—	—	—	—	170	210	240	255
	—	—	—	—	*560*	*690*	*790*	*840*
P8	—	—	—	—	160	195	225	235
	—	—	—	—	*520*	*640*	*740*	*770*
P11	—	—	—	—	165	205	235	245
	—	—	—	—	*540*	*670*	*770*	*800*
P12	—	—	—	—	110	130	150	160
	—	—	—	—	*360*	*425*	*490*	*520*
M1	—	—	—	—	175	215	250	260
	—	—	—	—	*570*	*710*	*820*	*850*
M2	—	—	—	—	145	175	205	215
	—	—	—	—	*475*	*570*	*670*	*710*
M3	—	—	—	—	120	140	165	175
	—	—	—	—	*395*	*460*	*540*	*570*
M4	—	—	—	—	95	110	125	130
	—	—	—	—	*310*	*360*	*410*	*425*
M5	—	—	—	—	80	90	105	110
	—	—	—	—	*260*	*295*	*345*	*360*
K1	185	225	260	275	175	210	245	255
	610	*740*	*850*	*900*	*570*	*690*	*800*	*840*
K2	165	200	230	245	155	185	215	225
	540	*660*	*750*	*800*	*510*	*610*	*710*	*740*
K3	140	170	195	205	130	155	180	190
	460	*560*	*640*	*670*	*425*	*510*	*590*	*620*
K4	135	160	185	195	125	150	175	185
	445	*520*	*610*	*640*	*410*	*490*	*570*	*610*
K5	80	100	115	120	75	90	105	110
	260	*330*	*375*	*395*	*245*	*295*	*345*	*360*
K6	120	140	165	175	110	130	155	160
	395	*460*	*540*	*570*	*360*	*425*	*510*	*520*
K7	105	125	145	155	95	115	135	145
	345	*410*	*475*	*510*	*310*	*375*	*445*	*475*
N1	—	—	—	—	1275	1575	1800	1875
	—	—	—	—	*4175*	*5175*	*5900*	*6150*
N2	—	—	—	—	520	630	730	750
	—	—	—	—	*1700*	*2075*	*2400*	*2450*
N3	—	—	—	—	345	420	485	500
	—	—	—	—	*1125*	*1375*	*1600*	*1650*
N11	—	—	—	—	395	480	550	570
	—	—	—	—	*1300*	*1575*	*1800*	*1875*
S1	—	—	—	—	44	50	60	60
	—	—	—	—	*145*	*165*	*195*	*195*
S2	—	—	—	—	35	41	47	50
	—	—	—	—	*115*	*135*	*155*	*165*
S3	—	—	—	—	31	36	42	44
	—	—	—	—	*100*	*120*	*140*	*145*
S11	—	—	—	—	60	70	85	90
	—	—	—	—	*195*	*230*	*280*	*295*
S12	—	—	—	—	42	50	55	60
	—	—	—	—	*140*	*165*	*180*	*195*
S13	—	—	—	—	25	29	33	35
	—	—	—	—	*80*	*95*	*110*	*115*
H5	39	46	55	55	36	43	50	55
	130	*150*	*180*	*180*	*120*	*140*	*165*	*180*
H8	41	49	55	60	38	45	50	55
	135	*160*	*180*	*195*	*125*	*150*	*165*	*180*
H11	49	60	70	70	46	55	65	65
	160	*195*	*230*	*230*	*150*	*180*	*215*	*215*
H12	75	90	100	105	70	80	95	100
	245	*295*	*330*	*345*	*230*	*260*	*310*	*330*
H21	41	49	55	60	38	45	50	55
	135	*160*	*180*	*195*	*125*	*150*	*165*	*180*

Schaftkonstruktion

Ausführung 1, Keilnut-Schaft	Ausführung 2, Zylindrische/Weldon Schnittstelle und 90° Stirnseite
	
Ausführung 3, Zylindrische/Weldon Schnittstelle und 87°/89° Stirnseite	**Konstruktion 4, Zylindrische/Weldon Schnittstelle und 80°/85°/87° Stirnseite**
	
Ausführung 5, Zylindrische Schnittstelle und doppelt konische Stirnseite 89°/85°	
	

MM16 Schaft





Bezeichnung	Produkt-nummer	DCSFWS	DMM	LF	LPR	OAL	BHTA°	Abb.	CSP	RPMX	Auf-nahmen	Gewicht	Ersatzteil Bezeich-nung
		mm	mm	mm	mm	mm						kg	
MM16-16070.0-0011M	00023547	15,2	16,0	11,3	22,0	70,0	0,0	2	■	63600	Cylindrical	0,1	1
MM16-16150.0-0080DS	02580692	15,2	16,0	80,0	102,0	150,0	0,0	2	■	47600	Cylindrical Densimet	0,4	2
MM16-20115.3-3045	75014109	15,2	20,0	45,8	65,0	115,0	3,0	4	■	63600	Weldon	0,2	3
MM16-20070.0-0000	00023548	15,2	20,0	0,0	20,0	70,0	60,0	1	■	63600	Cylindrical	0,2	1
MM16-20190.0-1055M	00094766	15,2	20,0	55,0	140,0	190,0	1,0	3	■	63600	Cylindrical	0,4	5
MM16-20190.0-1075M	00094768	15,2	20,0	75,0	140,0	190,0	1,0	3	■	63600	Cylindrical	0,4	5
MM16-20190.0-1095M	00094770	15,2	20,0	95,0	140,0	190,0	1,0	3	■	63600	Cylindrical	0,4	6
MM16-20080.0-0011DS	02580669	15,2	20,0	11,3	30,0	80,0	0,0	2	■	47600	Cylindrical Densimet	0,3	2
MM16-20150.0-0038DS	02580695	15,2	20,0	38,0	100,0	150,0	0,0	2	■	47600	Cylindrical Densimet	0,6	2
MM16-20160.0-0076DS	02580699	15,2	20,0	76,0	110,0	160,0	0,0	2	■	47600	Cylindrical Densimet	0,6	2
MM16-20130.0-1045DS	02580757	15,2	20,0	45,0	80,0	130,0	1,0	3	■	47600	Cylindrical Densimet	0,5	2
MM16-20190.0-1075DS	02580758	15,2	20,0	75,0	140,0	190,0	1,0	3	■	47600	Cylindrical Densimet	0,8	2
MM16-20190.0-1095DS	02580760	15,2	20,0	95,0	140,0	190,0	1,0	3	■	47600	Cylindrical Densimet	0,8	2
MM16-25100.3-0019	75012790	15,2	25,0	19,0	40,0	100,0	0,0	2	■	63600	Weldon	0,3	3
MM16-25115.3-3035	75012791	15,2	25,0	35,0	59,0	115,0	3,0	3	■	63600	Weldon	0,3	3
MM16-25170.3-5056	75012792	15,2	25,0	56,0	114,0	170,0	5,0	4	■	63600	Weldon	0,6	4
MM16-25170.0-1060	00094767	19,0	25,0	60,0	114,0	170,0	1,0	3	■	63600	Cylindrical	0,5	5
MM16-25250.0-1075DS	02580761	15,2	25,0	75,0	194,0	250,0	1,0	5	■	47600	Cylindrical Densimet	1,5	2
MM16-32250.0-10047	75069368	15,2	32,0	47,6	190,0	250,0	10,0	4	■	63600	Cylindrical	1,3	4

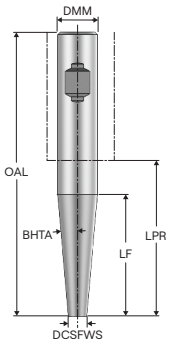
Ersatzteile, im Lieferumfang enthalten

Für Fräser	Hülse	Spannschraube
		
1	MM-10030	MM16-1045
2	–	MM16-1045
3	MM-10062	MM16-1045
4	MM-10132	MM16-1045
5	MM-10062	MM16-1093
6	MM-10062	MM16-10113

Innensechskant-Schlüssel H05-4 für die Hülse kann separat bestellt werden.
Steckschlüssel, siehe Wendeschneidplatten-Programm:

MM16 Schaft – Zoll





Bezeichnung	Produkt-nummer	DCSFMS	DMM	LF	LPR	OAL	BHTA°	Abb.	CSP	RPMX	Auf-nahmen	Gewicht	Ersatzteil Bezeich-nung
		Zoll	Zoll	Zoll	Zoll	Zoll						lbs	
MM16-0.62-2.8-0M-0004	00037209	0.598	0.625	0.445	0.866	2.756	0,0	2	■	63600	Cylindrical	0.220	1
MM16-0.75-4.5-3-3018	75054603	0.598	0.750	1.445	2.559	4.528	3,0	3	■	63600	Weldon	0.440	4
MM16-0.75-2.8-0-0000	00037175	0.598	0.750	0	0.787	2.756	60,0	1	■	63600	Cylindrical	0.440	1
MM16-0.75-7.5-0-1021	75054731	0.598	0.750	2.165	5.512	7.480	1,0	3	■	63600	Cylindrical	0.660	6
MM16-0.75-7.5-0-1037	75054733	0.598	0.750	3.740	5.512	7.480	1,0	3	■	63600	Cylindrical	0.880	7
MM16-0.75-7.5-0-1029DS	02567719	0.598	0.750	2.953	5.512	7.480	1,0	3	■	47600	Cylindrical Densimet	1.760	3
MM16-0.75-7.5-0-1037DS	02593431	0.598	0.750	3.740	5.512	7.480	1,0	3	■	47600	Cylindrical Densimet	1.540	3
MM16-1.00-3.9-3-0007	75015058	0.598	1.000	0.748	1.732	3.937	0,0	2	■	63600	Weldon	0.660	4
MM16-1.00-4.5-3-3013	75015059	0.598	1.000	1.378	2.323	4.528	3,0	3	■	63600	Weldon	0.880	4
MM16-1.00-6.7-3-5022	75015060	0.598	1.000	2.295	4.488	6.693	5,0	4	■	63600	Weldon	1.320	5
MM16-1.00-5.9-0-0015DS	02593433	0.598	1.000	1.496	3.701	5.906	0,0	2	■	47600	Cylindrical Densimet	2.200	3
MM16-1.00-6.3-0-0030DS	02593434	0.598	1.000	2.992	4.094	6.299	0,0	2	■	47600	Cylindrical Densimet	1.980	3

Ersatzteile, im Lieferumfang enthalten

Für Fräser	Hülse	Spannschraube
		
1	MM-10030	MM16-1045
3	–	MM16-1045
4	MM-10062	MM16-1045
5	MM-10132	MM16-1045
6	MM-10062	MM16-1093
7	MM-10062	MM16-10113

Innensechskant-Schlüssel H05-4 für die Hülse kann separat bestellt werden.
Steckschlüssel, siehe Wendeschneidplatten-Programm:

Nutfräsen/Eckfräsen

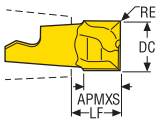


—Drehmomentschlüssel und Drehmomente, siehe Seite 799

												Beschichtung			
Bezeichnung	**DC**	**APMXS**	**RE**	**LF**	**RMPX°**	**C min**	**C max**	**FHA**	**ZEFP**	**Schlüssel**		Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*								T60M	F15M	F30M	F40M
MM16-15719-R03A30-M06	15,7 *0.618*	19,05 *0.750*	0,3 *0.012*	24,5 *0.965*	15,0	19,0	30,6	30	3	MM0416	✓				■
MM16-15919-R08A30-M06	15,875 *0.625*	19,05 *0.750*	0,8 *0.031*	24,5 *0.965*	15,0	19,2	29,9	30	3	MM0416	✓				■
MM16-16019-A30-E06	16,0 *0.630*	19,05 *0.750*	–	24,5 *0.965*	15,0	19,4	31,8	30	3	MM0416	✓			■	
MM16-16019-R05A30-M06	16,0 *0.630*	19,05 *0.750*	0,5 *0.020*	24,5 *0.965*	15,0	19,4	30,8	30	3	MM0416	✓				■
MM16-16019-R10A30-E06	16,0 *0.630*	19,05 *0.750*	1,0 *0.039*	24,5 *0.965*	15,0	19,4	29,8	30	3	MM0416	✓			■	
MM16-16019-R10A30-M06	16,0 *0.630*	19,05 *0.750*	1,0 *0.039*	24,5 *0.965*	15,0	19,4	29,8	30	3	MM0416	✓				■
MM16-16019-R20A30-M06	16,0 *0.630*	19,05 *0.750*	2,0 *0.079*	24,5 *0.965*	15,0	19,4	27,8	30	3	MM0416	✓				■
MM16-16019-R30A30-E06	16,0 *0.630*	19,05 *0.750*	3,0 *0.118*	24,5 *0.965*	15,0	19,4	25,8	30	3	MM0416	✓			■	
MM16-16019-R30A30-M06	16,0 *0.630*	19,05 *0.750*	3,0 *0.118*	24,5 *0.965*	15,0	19,4	25,8	30	3	MM0416	✓				■
MM16-16019-R40A30-M06	16,0 *0.630*	19,05 *0.750*	4,0 *0.157*	24,5 *0.965*	15,0	19,4	23,8	30	3	MM0416	✓				■
MM16-16019-R50A30-M06	16,0 *0.630*	19,05 *0.750*	5,0 *0.197*	24,5 *0.965*	15,0	19,4	21,8	30	3	MM0416	✓				■
MM16-16019-R60A30-M06	16,0 *0.630*	19,05 *0.750*	6,0 *0.236*	24,5 *0.965*	15,0	19,4	19,8	30	3	MM0416	✓				■
MM16-20015-A30-E06	20,0 *0.787*	15,0 *0.591*	–	20,15 *0.793*	15,0	24,2	39,8	30	3	MM0416	✓			■	
MM16-20015-R05A30-M06	20,0 *0.787*	15,0 *0.591*	0,5 *0.020*	20,15 *0.793*	15,0	24,2	38,8	30	3	MM0416	✓				■
MM16-20015-R10A30-M06	20,0 *0.787*	15,0 *0.591*	1,0 *0.039*	20,15 *0.793*	15,0	24,2	37,8	30	3	MM0416	✓				■
MM16-20015-R20A30-D06	20,0 *0.787*	15,0 *0.591*	2,0 *0.079*	20,15 *0.793*	15,0	24,2	35,8	30	3	MM0416	✓			■	
MM16-20015-R30A30-M06	20,0 *0.787*	15,0 *0.591*	3,0 *0.118*	20,15 *0.793*	15,0	24,2	33,8	30	3	MM0416	✓				■
MM16-20015-R50A30-M06	20,0 *0.787*	15,0 *0.591*	5,0 *0.197*	20,15 *0.793*	15,0	24,2	29,8	30	3	MM0416	✓				■

Nutfräsen/Eckfräsen



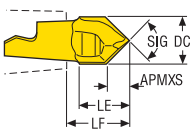


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Bezeichnung	DC	APMXS	RE	LF	RMPX°	C min	C max	FHA	ZEFP	Schlüssel	Beschichtung			
											Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*							T60M	F15M	F30M	F40M
MM16-15711T-R03-D07	15,7 *0.618*	11,0 *0.433*	0,3 *0.012*	13,6 *0.535*	15,0	19,0	30,6	0	2	MM1420	■			
MM16-16011-M06	16,0 *0.630*	11,0 *0.433*	–	13,6 *0.535*	15,0	19,4	31,8	0	2	MM1420	■			
MM16-16011-R08A8-E06	16,0 *0.630*	10,5 *0.413*	0,8 *0.031*	13,62 *0.536*	15,0	19,4	30,2	8	2	MM1420	■		■	
MM16-16011-R08-MD07	16,0 *0.630*	11,0 *0.433*	0,8 *0.031*	13,58 *0.535*	15,0	19,4	30,2	0	2	MM1420	■		■	
MM16-16011-R08P-M05	16,0 *0.630*	10,8 *0.425*	0,8 *0.031*	13,41 *0.528*	15,0	19,4	30,2	0	2	MM1420			■	
MM16-16011-R20-MD07	16,0 *0.630*	10,9 *0.429*	2,0 *0.079*	13,55 *0.533*	15,0	19,4	27,8	0	2	MM1420			■	
MM16-16011-R30-MD07	16,0 *0.630*	10,9 *0.429*	3,0 *0.118*	13,54 *0.533*	15,0	19,4	25,8	0	2	MM1420			■	
MM16-16011-R40-MD07	16,0 *0.630*	10,9 *0.429*	4,0 *0.157*	13,52 *0.532*	15,0	19,4	23,8	0	2	MM1420	■			
MM16-16011-R50-MD07	16,0 *0.630*	10,9 *0.429*	5,0 *0.197*	13,5 *0.531*	15,0	19,4	21,8	0	2	MM1420	■			
MM16-19013-R08A8-E06	19,05 *0.750*	12,7 *0.500*	0,8 *0.031*	15,39 *0.606*	15,0	23,1	36,3	8	2	MM1420			■	
MM16-20013-R08A8-E06	20,0 *0.787*	12,7 *0.500*	0,8 *0.031*	15,42 *0.607*	15,0	24,2	38,2	8	2	MM1420	■		■	

Zentrierbohren



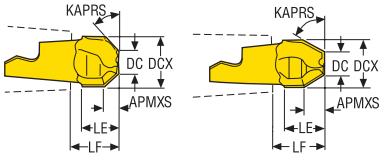


—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DC	APMXS	RE	LF	SIG°	ZEFP	Schlüssel	Beschichtung			
								Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM16-16008-C90-M06	16,0 *0.630*	7,53 *0.296*	– –	19,2 *0.756*	90,0	2	MM1420	■			
MM16-16011-C120-M06	16,0 *0.630*	4,3 *0.169*	– –	18,9 *0.744*	120,0	2	MM1420	■			
MM16-19019-C90	19,05 *0.750*	9,6 *0.378*	– –	22,15 *0.872*	90,0	2	MM1420	■			

Anfasen



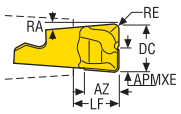


—Drehmomentschlüssel und Drehmomente, siehe Seite 799

										Beschichtung			
										Beschichtet			
Bezeichnung	**DCX**	**DC**	**APMXS**	**RE**	**LE**	**LF**	**KAPRS°**	**ZEFP**	**Schlüssel**				
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM16-16011-4540-E06	16,0 *0.630*	7,69 *0.303*	3,9 *0.154*	0,4 *0.016*	10,9 *0.429*	13,25 *0.522*	45,0	2	MM1420	■			
MM16-16012-6060-E06	16,0 *0.630*	8,38 *0.330*	6,7 *0.264*	0,5 *0.020*	12,9 *0.508*	15,3 *0.602*	60,0	2	MM1420	■			

Tauchfräser

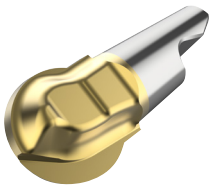




—Drehmomentschlüssel und Drehmomente, siehe Seite 799

									Beschichtung			
									Beschichtet			
Bezeichnung	**DC**	**APMXE**	**RE**	**AZ**	**LF**	**RA°**	**ZEFP**	**Schlüssel**				
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM16-16011-R10-PL-MD07	16,0 *0.630*	8,0 *0.315*	1,0 *0.039*	11,3 *0.445*	11,3 *0.445*	5,0	2	MM1420			■	
MM16-16011-R20-PL-MD07	16,0 *0.630*	8,0 *0.315*	2,0 *0.079*	11,3 *0.445*	11,3 *0.445*	5,0	2	MM1420			■	

Präzisionswendeschneidplatten zum Vorschlichten in allen Werkstoffen



—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DC	APMXS	RE	LE	DN	LF	SA	ZEFP	Schlüssel	Beschichtung			
										Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*				T60M	F15M	F30M	F40M
MM16-20020-B120PF-M04	20,0 *0.787*	10,0 *0.394*	10,0 *0.394*	20,0 *0.787*	15,9 *0.626*	21,94 *0.864*	254,0	2	MM1420		■		
MM16-20020-B120P-M07	20,0 *0.787*	10,0 *0.394*	10,0 *0.394*	20,0 *0.787*	15,9 *0.626*	21,94 *0.864*	254,0	2	MM1420			■	

Kopierfräser



—Drehmomentschlüssel und Drehmomente, siehe Seite 799

Bezeichnung	DC	APMXS	RE	LF	FHA	ZEFP	Schlüssel		Beschichtung			
									Beschichtet			
	mm *Zoll*	mm *Zoll*	mm *Zoll*	mm *Zoll*					T60M	F15M	F30M	F40M
MM16-15916-B90P-M07	15,875 *0.625*	13,8 *0.543*	7,938 *0.313*	18,4 *0.724*		2	MM1420				■	
MM16-16016-B90-MD07	16,0 *0.630*	16,2 *0.638*	8,0 *0.315*	18,4 *0.724*		2	MM1420		■		■	
MM16-16016-B90PF-M03	16,0 *0.630*	13,8 *0.543*	8,0 *0.315*	18,4 *0.724*		2	MM1420			■		
MM16-16016-B90P-M07	16,0 *0.630*	13,8 *0.543*	8,0 *0.315*	18,4 *0.724*		2	MM1420				■	
MM16-16019-B90A30-E06	16,0 *0.630*	19,0 *0.748*	8,0 *0.315*	24,5 *0.965*	30,0	3	MM1420	✓			■	
MM16-16019-B90A30-M06	16,0 *0.630*	19,0 *0.748*	8,0 *0.315*	24,5 *0.965*	30,0	3	MM1420	✓				■
MM16-19020-B90P-M07	19,05 *0.750*	17,4 *0.685*	9,525 *0.375*	22,12 *0.871*		2	MM1420		■			
MM16-20015-B90A30-E06	20,0 *0.787*	15,0 *0.591*	10,0 *0.394*	20,15 *0.793*	30,0	3	MM1420	✓			■	
MM16-20015-B90A30-M06	20,0 *0.787*	15,0 *0.591*	10,0 *0.394*	20,15 *0.793*	30,0	3	MM1420	✓				■
MM16-20020-B90-MD07	20,0 *0.787*	20,3 *0.799*	10,0 *0.394*	22,15 *0.872*		2	MM1420		■		■	
MM16-20020-B90P-M07	20,0 *0.787*	17,4 *0.685*	10,0 *0.394*	22,12 *0.871*		2	MM1420				■	

MM16 - Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,085 0.0034	0,085 0.0034	0,11 0.0044	0,14 0.0055
P2	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,085 0.0034	0,090 0.0036	0,11 0.0044	0,14 0.0055
P3	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 0.0032	0,085 0.0034	0,10 0.0040	0,14 0.0055
P4	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 0.0032	0,080 0.0032	0,10 0.0040	0,13 0.0050
P5	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 0.0032	0,080 0.0032	0,10 0.0040	0,13 0.0050
P6	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 0.0032	0,080 0.0032	0,095 0.0038	0,13 0.0050
P7	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 0.0032	0,080 0.0032	0,095 0.0038	0,13 0.0050
P8	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 0.0032	0,085 0.0034	0,10 0.0040	0,14 0.0055
P11	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 0.0032	0,080 0.0032	0,095 0.0038	0,13 0.0050
P12	MM16-16019-R05A30-M06 F40M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,090 0.0036
M1	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,085 0.0034	0,090 0.0036	0,11 0.0044	0,14 0.0055
M2	MM16-16019-R05A30-M06 F40M	3,5 *0.14*	0,080 0.0032	0,080 0.0032	0,10 0.0040	0,13 0.0050
M3	MM16-16019-R05A30-M06 F40M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,080 0.0032	0,10 0.0040
M4	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 0.0022	0,055 0.0022	0,070 0.0028	0,090 0.0036
M5	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 0.0022	0,055 0.0022	0,070 0.0028	0,090 0.0036
K1	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,090 0.0036	0,090 0.0036	0,11 0.0044	0,14 0.0055
K2	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,080 0.0032	0,080 0.0032	0,10 0.0040	0,13 0.0050
K3	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,080 0.0032	0,080 0.0032	0,10 0.0040	0,13 0.0050
K4	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,080 0.0032	0,080 0.0032	0,10 0.0040	0,13 0.0050
K5	MM16-16019-R10A30-M06 F40M	3,5 *0.14*	0,075 0.0030	0,075 0.0030	0,090 0.0036	0,12 0.0048
K6	MM16-16019-R10A30-M06 F40M	3,5 *0.14*	0,080 0.0032	0,080 0.0032	0,10 0.0040	0,13 0.0050
K7	MM16-16019-R10A30-M06 F40M	3,5 *0.14*	0,075 0.0030	0,075 0.0030	0,090 0.0036	0,12 0.0048
N1	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,11 0.0044	0,14 0.0055	0,18 0.0070
N2	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,11 0.0044	0,14 0.0055	0,18 0.0070
N3	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,11 0.0044	0,14 0.0055	0,18 0.0070
N11	MM16-16019-R10A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,11 0.0044	0,14 0.0055	0,18 0.0070
S1	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 0.0022	0,055 0.0022	0,070 0.0028	0,090 0.0036
S2	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 0.0022	0,055 0.0022	0,070 0.0028	0,090 0.0036
S3	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,050 0.0020	0,055 0.0022	0,065 0.0026	0,085 0.0034
S11	MM16-16019-R05A30-M06 F40M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,080 0.0032	0,10 0.0040
S12	MM16-16019-R05A30-M06 F40M	2,5 *0.10*	0,065 0.0026	0,065 0.0026	0,080 0.0032	0,10 0.0040
S13	MM16-16019-R05A30-M06 F40M	2,0 *0.080*	0,055 0.0022	0,055 0.0022	0,070 0.0028	0,090 0.0036
H5	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,090 0.0036
H8	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,044 0.0017	0,044 0.0017	0,050 0.0020	0,070 0.0028
H11	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,055 0.0022	0,055 0.0022	0,065 0.0026	0,090 0.0036
H12	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,044 0.0017	0,044 0.0017	0,050 0.0020	0,070 0.0028
H21	MM16-16019-R10A30-E06 F30M	2,5 *0.10*	0,044 0.0017	0,044 0.0017	0,050 0.0020	0,070 0.0028

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM16 - Nut- und Eckfräsen – Schnittdaten v_c = (m/min)/(sf/min)

SMG	F30M				F40M				T60M			
	100%	40%	20%	10%	100%	40%	20%	10%	100%	40%	20%	10%
P1	230 *750*	285 *940*	315 *1025*	350 *1150*	215 *710*	270 *890*	300 *980*	335 *1100*	200 *660*	250 *820*	275 *900*	310 *1025*
P2	220 *720*	275 *900*	310 *1025*	345 *1125*	210 *690*	260 *850*	290 *950*	325 *1075*	195 *640*	240 *790*	270 *890*	295 *970*
P3	195 *640*	240 *790*	270 *890*	295 *970*	185 *610*	225 *740*	255 *840*	280 *920*	170 *560*	210 *690*	235 *770*	260 *850*
P4	170 *560*	215 *710*	240 *790*	265 *870*	160 *520*	205 *670*	225 *740*	250 *820*	150 *490*	185 *610*	205 *670*	225 *740*
P5	165 *540*	205 *670*	230 *750*	250 *820*	155 *510*	195 *640*	215 *710*	240 *790*	140 *460*	175 *570*	200 *660*	220 *720*
P6	185 *610*	230 *750*	260 *850*	285 *940*	175 *570*	215 *710*	245 *800*	270 *890*	160 *520*	200 *660*	220 *720*	245 *800*
P7	175 *570*	220 *720*	245 *800*	265 *870*	165 *540*	205 *670*	230 *750*	255 *840*	150 *490*	190 *620*	210 *690*	235 *770*
P8	160 *520*	205 *670*	230 *750*	250 *820*	155 *510*	190 *620*	215 *710*	235 *770*	140 *460*	175 *570*	200 *660*	215 *710*
P11	170 *560*	210 *690*	235 *770*	260 *850*	160 *520*	200 *660*	225 *740*	245 *800*	145 *475*	185 *610*	205 *670*	225 *740*
P12	110 *360*	135 *445*	150 *490*	165 *540*	105 *345*	130 *425*	145 *475*	155 *510*	95 *310*	120 *395*	130 *425*	145 *475*
M1	180 *590*	225 *740*	250 *820*	275 *900*	170 *560*	210 *690*	235 *770*	260 *850*	155 *510*	190 *620*	215 *710*	240 *790*
M2	150 *490*	185 *610*	205 *670*	225 *740*	140 *460*	175 *570*	195 *640*	215 *710*	125 *410*	160 *520*	180 *590*	200 *660*
M3	120 *395*	150 *490*	165 *540*	180 *590*	110 *360*	140 *460*	155 *510*	175 *570*	105 *345*	130 *425*	145 *475*	155 *510*
M4	90 *295*	115 *375*	130 *425*	140 *460*	85 *280*	110 *360*	120 *395*	135 *445*	80 *260*	100 *330*	110 *360*	120 *395*
M5	75 *245*	95 *310*	105 *345*	115 *375*	75 *245*	90 *295*	100 *330*	110 *360*	65 *215*	85 *280*	95 *310*	100 *330*
K1	175 *570*	220 *720*	245 *800*	270 *890*	165 *540*	205 *670*	230 *750*	260 *850*	150 *490*	190 *620*	210 *690*	235 *770*
K2	155 *510*	195 *640*	215 *710*	240 *790*	145 *475*	185 *610*	205 *670*	225 *740*	135 *445*	170 *560*	190 *620*	210 *690*
K3	130 *425*	165 *540*	185 *610*	205 *670*	125 *410*	155 *510*	175 *570*	190 *620*	115 *375*	145 *475*	160 *520*	175 *570*
K4	125 *410*	160 *520*	175 *570*	195 *640*	120 *395*	150 *490*	165 *540*	185 *610*	110 *360*	135 *445*	150 *490*	170 *560*
K5	75 *245*	95 *310*	105 *345*	115 *375*	75 *245*	90 *295*	100 *330*	110 *360*	65 *215*	80 *260*	95 *310*	100 *330*
K6	110 *360*	140 *460*	155 *510*	170 *560*	105 *345*	130 *425*	145 *475*	160 *520*	95 *310*	120 *395*	135 *445*	150 *490*
K7	100 *330*	120 *395*	135 *445*	150 *490*	95 *310*	115 *375*	130 *425*	140 *460*	85 *280*	105 *345*	120 *395*	130 *425*
N1	1325 *4350*	1650 *5425*	1825 *6000*	2025 *6650*	1225 *4025*	1550 *5075*	1725 *5650*	1925 *6325*	1125 *3700*	1425 *4675*	1575 *5175*	1750 *5750*
N2	530 *1750*	670 *2200*	730 *2400*	820 *2700*	500 *1650*	630 *2075*	690 *2275*	770 *2525*	455 *1500*	570 *1875*	640 *2100*	700 *2300*
N3	355 *1175*	445 *1450*	490 *1600*	540 *1775*	335 *1100*	420 *1375*	465 *1525*	520 *1700*	305 *1000*	385 *1275*	425 *1400*	470 *1550*
N11	405 *1325*	510 *1675*	560 *1825*	620 *2025*	380 *1250*	475 *1550*	530 *1750*	590 *1925*	345 *1125*	435 *1425*	485 *1600*	540 *1775*
S1	43 *140*	55 *180*	60 *195*	65 *215*	41 *135*	50 *165*	55 *180*	60 *195*	38 *125*	46 *150*	50 *165*	55 *180*
S2	35 *115*	43 *140*	48 *155*	55 *180*	33 *110*	41 *135*	45 *150*	50 *165*	30 *100*	37 *120*	42 *140*	46 *150*
S3	30 *100*	38 *125*	42 *140*	46 *150*	29 *95*	35 *115*	40 *130*	44 *145*	27 *90*	33 *110*	37 *120*	40 *130*
S11	60 *195*	75 *245*	85 *280*	90 *295*	55 *180*	70 *230*	80 *260*	90 *295*	50 *165*	65 *215*	75 *245*	80 *260*
S12	42 *140*	50 *165*	60 *195*	65 *215*	39 *130*	49 *160*	55 *180*	60 *195*	36 *120*	45 *150*	50 *165*	55 *180*
S13	24 *80*	30 *100*	34 *110*	37 *120*	23 *75*	29 *95*	32 *105*	35 *115*	21 *70*	26 *85*	29 *95*	32 *105*
H5	36 *120*	45 *150*	50 *165*	55 *180*	34 *110*	43 *140*	48 *155*	50 *165*	31 *100*	39 *130*	44 *145*	48 *155*
H8	38 *125*	47 *155*	55 *180*	60 *195*	36 *120*	45 *150*	50 *165*	55 *180*	33 *110*	41 *135*	46 *150*	50 *165*
H11	46 *150*	60 *195*	65 *215*	70 *230*	43 *140*	55 *180*	60 *195*	65 *215*	40 *130*	50 *165*	55 *180*	60 *195*
H12	70 *230*	85 *280*	95 *310*	105 *345*	65 *215*	80 *260*	90 *295*	100 *330*	60 *195*	75 *245*	85 *280*	90 *295*
H21	38 *125*	47 *155*	55 *180*	60 *195*	36 *120*	45 *150*	50 *165*	55 *180*	33 *110*	41 *135*	46 *150*	50 *165*

MM16 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,11 0.0044	0,10 0.0040	0,11 0.0044	0,14 0.0055
P2	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,11 0.0044	0,10 0.0040	0,11 0.0044	0,15 0.0060
P3	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 0.0040	0,10 0.0040	0,10 0.0040	0,14 0.0055
P4	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 0.0040	0,095 0.0038	0,10 0.0040	0,13 0.0050
P5	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 0.0040	0,095 0.0038	0,10 0.0040	0,13 0.0050
P6	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,095 0.0038	0,095 0.0038	0,10 0.0040	0,13 0.0050
P7	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,095 0.0038	0,095 0.0038	0,10 0.0040	0,13 0.0050
P8	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 0.0040	0,10 0.0040	0,10 0.0040	0,14 0.0055
P11	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,095 0.0038	0,095 0.0038	0,10 0.0040	0,13 0.0050
P12	MM16-16019-B90A30-M06 F40M	2,5 *0.10*	0,070 0.0028	0,070 0.0028	0,070 0.0028	0,090 0.0036
M1	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,11 0.0044	0,10 0.0040	0,11 0.0044	0,15 0.0060
M2	MM16-16019-B90A30-M06 F40M	3,5 *0.14*	0,10 0.0040	0,095 0.0038	0,10 0.0040	0,13 0.0050
M3	MM16-16019-B90A30-M06 F40M	2,5 *0.10*	0,085 0.0034	0,080 0.0032	0,080 0.0032	0,11 0.0044
M4	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 0.0030	0,075 0.0030	0,075 0.0030	0,090 0.0038
M5	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 0.0030	0,075 0.0030	0,075 0.0030	0,090 0.0038
K1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,10 0.0040	0,11 0.0044	0,15 0.0060
K2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 0.0040	0,095 0.0038	0,10 0.0040	0,13 0.0050
K3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 0.0040	0,095 0.0038	0,10 0.0040	0,13 0.0050
K4	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 0.0040	0,095 0.0038	0,10 0.0040	0,13 0.0050
K5	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,090 0.0036	0,085 0.0034	0,090 0.0036	0,12 0.0048
K6	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 0.0040	0,095 0.0038	0,10 0.0040	0,13 0.0050
K7	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,090 0.0036	0,085 0.0034	0,090 0.0036	0,12 0.0048
N1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,14 0.0055	0,13 0.0050	0,14 0.0055	0,19 0.0075
N2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,14 0.0055	0,13 0.0050	0,14 0.0055	0,19 0.0075
N3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,14 0.0055	0,13 0.0050	0,14 0.0055	0,19 0.0075
N11	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,14 0.0055	0,13 0.0050	0,14 0.0055	0,19 0.0075
S1	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 0.0030	0,075 0.0030	0,075 0.0030	0,090 0.0038
S2	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 0.0030	0,075 0.0030	0,075 0.0030	0,090 0.0038
S3	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,070 0.0028	0,070 0.0028	0,070 0.0028	0,085 0.0036
S11	MM16-16019-B90A30-M06 F40M	2,5 *0.10*	0,085 0.0034	0,080 0.0032	0,085 0.0034	0,11 0.0044
S12	MM16-16019-B90A30-M06 F40M	2,5 *0.10*	0,085 0.0034	0,080 0.0032	0,085 0.0034	0,11 0.0044
S13	MM16-16019-B90A30-M06 F40M	2,0 *0.080*	0,075 0.0030	0,075 0.0030	0,075 0.0030	0,090 0.0038
H5	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,070 0.0028	0,070 0.0028	0,070 0.0028	0,090 0.0036
H8	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,070 0.0028
H11	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,070 0.0028	0,070 0.0028	0,070 0.0028	0,090 0.0036
H12	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,070 0.0028
H21	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,055 0.0022	0,050 0.0020	0,055 0.0022	0,070 0.0028

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM16 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 0.0048	0,14 0.0055	0,20 0.0080	0,32 0.013
P2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 0.0048	0,15 0.0060	0,20 0.0080	0,34 0.013
P3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 0.0048	0,14 0.0055	0,19 0.0075	0,32 0.013
P4	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,13 0.0050	0,19 0.0075	0,30 0.012
P5	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,13 0.0050	0,18 0.0070	0,30 0.012
P6	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,13 0.0050	0,18 0.0070	0,30 0.012
P7	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,13 0.0050	0,18 0.0070	0,30 0.012
P8	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 0.0048	0,14 0.0055	0,19 0.0075	0,32 0.013
P11	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,13 0.0050	0,18 0.0070	0,30 0.012
P12	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,12 0.0048	0,20 0.0080
M1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 0.0048	0,15 0.0060	0,20 0.0080	0,34 0.013
M2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,13 0.0050	0,18 0.0070	0,30 0.012
M3	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,090 0.0036	0,11 0.0044	0,15 0.0060	0,24 0.0095
M4	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 0.0032	0,090 0.0038	0,13 0.0050	0,20 0.0080
M5	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 0.0032	0,090 0.0038	0,13 0.0050	0,20 0.0080
K1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,12 0.0048	0,15 0.0060	0,20 0.0080	0,34 0.013
K2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,13 0.0050	0,18 0.0070	0,30 0.012
K3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,13 0.0050	0,18 0.0070	0,30 0.012
K4	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,13 0.0050	0,18 0.0070	0,30 0.012
K5	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 0.0040	0,12 0.0048	0,17 0.0065	0,26 0.010
K6	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,11 0.0044	0,13 0.0050	0,18 0.0070	0,30 0.012
K7	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,10 0.0040	0,12 0.0048	0,17 0.0065	0,26 0.010
N1	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,16 0.0065	0,19 0.0075	0,26 0.010	0,44 0.017
N2	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,16 0.0065	0,19 0.0075	0,26 0.010	0,44 0.017
N3	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,16 0.0065	0,19 0.0075	0,26 0.010	0,44 0.017
N11	MM16-16019-B90A30-E06 F30M	3,5 *0.14*	0,16 0.0065	0,19 0.0075	0,26 0.010	0,44 0.017
S1	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 0.0032	0,090 0.0038	0,13 0.0050	0,20 0.0080
S2	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 0.0032	0,090 0.0038	0,13 0.0050	0,20 0.0080
S3	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,075 0.0030	0,085 0.0036	0,12 0.0048	0,19 0.0075
S11	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,090 0.0036	0,11 0.0044	0,15 0.0060	0,24 0.0095
S12	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,090 0.0036	0,11 0.0044	0,15 0.0060	0,24 0.0095
S13	MM16-16019-B90A30-E06 F30M	2,0 *0.080*	0,080 0.0032	0,090 0.0038	0,13 0.0050	0,20 0.0080
H5	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,12 0.0048	0,20 0.0080
H8	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,15 0.0060
H11	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,075 0.0030	0,090 0.0036	0,12 0.0048	0,20 0.0080
H12	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,15 0.0060
H21	MM16-16019-B90A30-E06 F30M	2,5 *0.10*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,15 0.0060

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM16 Z3 – Kopierfräser – Schnittdaten v_c = (m/min)/(sf/min)

SMG	F30M					F40M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	245 *800*	295 *970*	310 *1025*	335 *1100*	335 *1100*	235 *770*	280 *920*	295 *970*	320 *1050*	320 *1050*
P2	240 *790*	285 *940*	300 *980*	325 *1075*	320 *1050*	230 *750*	270 *890*	285 *940*	310 *1025*	305 *1000*
P3	210 *690*	250 *820*	260 *850*	285 *940*	280 *920*	200 *660*	240 *790*	250 *820*	270 *890*	265 *870*
P4	185 *610*	220 *720*	235 *770*	250 *820*	250 *820*	175 *570*	210 *690*	225 *740*	240 *790*	240 *790*
P5	175 *570*	210 *690*	225 *740*	240 *790*	240 *790*	170 *560*	200 *660*	215 *710*	230 *750*	230 *750*
P6	200 *660*	235 *770*	250 *820*	270 *890*	270 *890*	190 *620*	225 *740*	240 *790*	260 *850*	255 *840*
P7	190 *620*	225 *740*	235 *770*	255 *840*	255 *840*	180 *590*	210 *690*	225 *740*	245 *800*	240 *790*
P8	175 *570*	210 *690*	220 *720*	240 *790*	235 *770*	170 *560*	200 *660*	210 *690*	230 *750*	225 *740*
P11	185 *610*	215 *710*	230 *750*	250 *820*	245 *800*	175 *570*	205 *670*	220 *720*	235 *770*	235 *770*
P12	115 *375*	145 *475*	145 *475*	160 *520*	155 *510*	110 *360*	140 *460*	140 *460*	150 *490*	150 *490*
M1	195 *640*	230 *750*	240 *790*	265 *870*	260 *850*	185 *610*	220 *720*	230 *750*	250 *820*	245 *800*
M2	160 *520*	190 *620*	200 *660*	220 *720*	215 *710*	150 *490*	180 *590*	190 *620*	205 *670*	205 *670*
M3	130 *425*	160 *520*	160 *520*	170 *560*	170 *560*	120 *395*	150 *490*	150 *490*	165 *540*	165 *540*
M4	90 *295*	125 *410*	125 *425*	130 *425*	135 *445*	85 *280*	120 *395*	115 *410*	125 *410*	125 *410*
M5	75 *245*	105 *345*	100 *360*	110 *360*	110 *360*	70 *230*	100 *330*	100 *345*	105 *345*	105 *345*
K1	190 *620*	225 *740*	235 *770*	260 *850*	255 *840*	180 *590*	215 *710*	225 *740*	245 *800*	245 *800*
K2	170 *560*	200 *660*	210 *690*	230 *750*	225 *740*	160 *520*	190 *620*	200 *660*	220 *720*	215 *710*
K3	140 *460*	170 *560*	180 *590*	195 *640*	190 *620*	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*
K4	135 *445*	160 *520*	170 *560*	185 *610*	185 *610*	130 *425*	155 *510*	165 *540*	175 *570*	175 *570*
K5	85 *280*	100 *330*	105 *345*	110 *360*	110 *360*	80 *260*	95 *310*	100 *330*	105 *345*	105 *345*
K6	120 *395*	140 *460*	150 *490*	165 *540*	160 *520*	115 *375*	135 *445*	145 *475*	155 *510*	155 *510*
K7	105 *345*	125 *410*	130 *425*	145 *475*	145 *475*	100 *330*	120 *395*	125 *410*	135 *445*	135 *445*
N1	1425 *4675*	1700 *5575*	1775 *5825*	1925 *6325*	1900 *6225*	1350 *4425*	1625 *5325*	1700 *5575*	1850 *6075*	1800 *5900*
N2	580 *1900*	690 *2275*	720 *2350*	780 *2550*	770 *2525*	550 *1800*	650 *2125*	680 *2225*	740 *2425*	730 *2400*
N3	385 *1275*	455 *1500*	480 *1575*	520 *1700*	510 *1675*	365 *1200*	435 *1425*	455 *1500*	495 *1625*	485 *1600*
N11	440 *1450*	520 *1700*	550 *1800*	600 *1975*	580 *1900*	420 *1375*	495 *1625*	520 *1700*	570 *1875*	560 *1825*
S1	42 *140*	60 *195*	55 *195*	60 *195*	60 *195*	40 *130*	55 *180*	55 *195*	60 *195*	60 *195*
S2	34 *110*	48 *155*	46 *160*	50 *165*	50 *165*	33 *110*	45 *150*	44 *155*	47 *155*	48 *155*
S3	30 *100*	41 *135*	40 *140*	43 *140*	43 *140*	28 *90*	39 *130*	38 *135*	41 *135*	41 *135*
S11	65 *215*	80 *260*	80 *280*	85 *280*	85 *280*	60 *195*	80 *260*	75 *260*	85 *280*	80 *260*
S12	45 *150*	55 *180*	55 *195*	60 *195*	60 *195*	43 *140*	55 *180*	55 *180*	55 *180*	55 *180*
S13	24 *80*	33 *110*	32 *110*	35 *115*	35 *115*	23 *75*	32 *105*	31 *110*	33 *110*	33 *110*
H5	39 *130*	48 *155*	48 *160*	55 *180*	50 *165*	37 *120*	46 *150*	46 *150*	50 *165*	50 *165*
H8	40 *130*	50 *165*	50 *165*	55 *180*	55 *180*	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*
H11	50 *165*	60 *195*	60 *195*	65 *215*	65 *215*	47 *155*	60 *195*	60 *195*	65 *215*	65 *215*
H12	70 *230*	90 *295*	90 *310*	100 *330*	100 *330*	70 *230*	85 *280*	85 *295*	95 *310*	95 *310*
H21	40 *130*	50 *165*	50 *165*	55 *180*	55 *180*	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*

MM16 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

SMG		a_p	f_z			
			100%	40%	20%	10%
P1	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 0.0044	0,11 0.0044	0,13 0.0050	0,17 0.0065
P2	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 0.0044	0,11 0.0044	0,13 0.0050	0,17 0.0065
P3	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 0.0044	0,10 0.0040	0,12 0.0048	0,16 0.0065
P4	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,16 0.0065
P5	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
P6	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
P7	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
P8	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 0.0044	0,10 0.0040	0,12 0.0048	0,16 0.0065
P11	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
P12	MM16-16016-B90-MD07 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,080 0.0032	0,10 0.0044
M1	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 0.0044	0,11 0.0044	0,13 0.0050	0,17 0.0065
M2	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
M3	MM16-16016-B90-MD07 F30M	5,0 *0.20*	0,085 0.0034	0,080 0.0032	0,095 0.0038	0,12 0.0050
M4	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 0.0032	0,080 0.0032	0,085 0.0034	0,11 0.0044
M5	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 0.0032	0,080 0.0032	0,085 0.0034	0,11 0.0044
K1	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,11 0.0044	0,11 0.0044	0,13 0.0050	0,17 0.0065
K2	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
K3	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
K4	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
K5	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,090 0.0036	0,090 0.0036	0,11 0.0044	0,14 0.0055
K6	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,10 0.0040	0,10 0.0040	0,12 0.0048	0,15 0.0060
K7	MM16-16016-B90-MD07 F30M	6,0 *0.24*	0,090 0.0036	0,090 0.0036	0,11 0.0044	0,14 0.0055
N1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N3	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
N11	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 0.0024	0,060 0.0024	0,070 0.0028	0,095 0.0038
S1	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 0.0032	0,080 0.0032	0,085 0.0034	0,11 0.0044
S2	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 0.0032	0,080 0.0032	0,085 0.0034	0,11 0.0044
S3	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,070 0.0028	0,070 0.0028	0,080 0.0032	0,10 0.0040
S11	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,085 0.0034	0,085 0.0034	0,095 0.0038	0,12 0.0050
S12	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,085 0.0034	0,085 0.0034	0,095 0.0038	0,12 0.0050
S13	MM16-16016-B90-MD07 F30M	4,0 *0.16*	0,080 0.0032	0,080 0.0032	0,085 0.0034	0,11 0.0044
H5	MM16-16016-B90-MD07 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,080 0.0032	0,10 0.0044
H8	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,055 0.0022	0,055 0.0022	0,060 0.0024	0,080 0.0032
H11	MM16-16016-B90-MD07 F30M	5,0 *0.20*	0,070 0.0028	0,070 0.0028	0,080 0.0032	0,10 0.0044
H12	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,055 0.0022	0,055 0.0022	0,060 0.0024	0,080 0.0032
H21	MM16-16016-B90-MD07 F30M	4,5 *0.18*	0,055 0.0022	0,055 0.0022	0,060 0.0024	0,080 0.0032

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM16 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Schlichten – mm/Zoll

SMG		a_p	f_z			
			15%	10%	5%	2%
P1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 0.0024	0,070 0.0028	0,10 0.0040	0,16 0.0065
P2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 0.0024	0,075 0.0030	0,10 0.0040	0,16 0.0065
P3	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,15 0.0060
P4	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 0.0022	0,070 0.0028	0,095 0.0038	0,15 0.0060
P5	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
P6	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,14 0.0055
P7	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,14 0.0055
P8	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 0.0024	0,070 0.0028	0,095 0.0038	0,15 0.0060
P11	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,14 0.0055
P12	MM16-16016-B90PF-M03 F15M	4,5 *0.18*	0,038 0.0015	0,046 0.0018	0,060 0.0024	0,10 0.0040
M1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 0.0024	0,075 0.0030	0,10 0.0040	0,16 0.0065
M2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
M3	MM16-16016-B90PF-M03 F15M	4,5 *0.18*	0,046 0.0018	0,055 0.0022	0,075 0.0030	0,12 0.0048
M4	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
M5	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
K1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,060 0.0024	0,075 0.0030	0,10 0.0040	0,16 0.0065
K2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K3	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K4	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K5	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,050 0.0020	0,060 0.0024	0,085 0.0034	0,13 0.0050
K6	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,055 0.0022	0,065 0.0026	0,090 0.0036	0,15 0.0060
K7	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,050 0.0020	0,060 0.0024	0,085 0.0034	0,13 0.0050
N1	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,20 0.0080
N2	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,20 0.0080
N3	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,20 0.0080
N11	MM16-16016-B90PF-M03 F15M	6,0 *0.24*	0,080 0.0032	0,095 0.0038	0,13 0.0050	0,20 0.0080
S1	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
S2	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
S3	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,038 0.0015	0,044 0.0017	0,060 0.0024	0,095 0.0038
S11	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,046 0.0018	0,055 0.0022	0,075 0.0030	0,12 0.0048
S12	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,046 0.0018	0,055 0.0022	0,075 0.0030	0,12 0.0048
S13	MM16-16016-B90PF-M03 F15M	3,5 *0.14*	0,040 0.0016	0,046 0.0019	0,065 0.0026	0,10 0.0040
H5	MM16-16016-B90PF-M03 F15M	4,5 *0.18*	0,038 0.0015	0,046 0.0018	0,060 0.0024	0,10 0.0040
H8	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,030 0.0012	0,034 0.0014	0,048 0.0019	0,075 0.0030
H11	MM16-16016-B90PF-M03 F15M	4,5 *0.18*	0,038 0.0015	0,046 0.0018	0,060 0.0024	0,10 0.0040
H12	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,030 0.0012	0,034 0.0014	0,048 0.0019	0,075 0.0030
H21	MM16-16016-B90PF-M03 F15M	4,0 *0.16*	0,030 0.0012	0,034 0.0014	0,048 0.0019	0,075 0.0030

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
Alle Schnittdaten sind Startwerte

MM16 Z2 – Kopierfräser – Schnittdaten v_c = (m/min)/(sf/min)

SMG	F15M					F30M					T60M				
	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%	100%	20%	10%	5%	2%
P1	285 *940*	360 *1175*	390 *1275*	420 *1375*	415 *1350*	225 *740*	280 *920*	300 *980*	325 *1075*	325 *1075*	185 *610*	225 *740*	245 *800*	265 *870*	265 *870*
P2	275 *900*	350 *1150*	375 *1225*	405 *1325*	405 *1325*	220 *720*	270 *890*	295 *970*	315 *1025*	315 *1025*	180 *590*	220 *720*	240 *790*	255 *840*	255 *840*
P3	240 *790*	305 *1000*	325 *1075*	355 *1175*	355 *1175*	190 *620*	240 *790*	255 *840*	280 *920*	275 *900*	155 *510*	195 *640*	210 *690*	225 *740*	225 *740*
P4	215 *710*	270 *890*	285 *940*	310 *1025*	310 *1025*	170 *560*	210 *690*	225 *740*	245 *800*	245 *800*	140 *460*	170 *560*	185 *610*	200 *660*	195 *640*
P5	205 *670*	255 *840*	275 *900*	300 *980*	295 *970*	165 *540*	200 *660*	220 *720*	235 *770*	230 *750*	130 *425*	160 *520*	175 *570*	190 *620*	190 *620*
P6	230 *750*	290 *950*	310 *1025*	335 *1100*	335 *1100*	180 *590*	225 *740*	245 *800*	265 *870*	265 *870*	150 *490*	180 *590*	200 *660*	215 *710*	215 *710*
P7	215 *710*	275 *900*	290 *950*	315 *1025*	315 *1025*	170 *560*	210 *690*	230 *750*	250 *820*	250 *820*	140 *460*	170 *560*	190 *620*	200 *660*	200 *660*
P8	200 *660*	255 *840*	275 *900*	295 *970*	295 *970*	160 *520*	200 *660*	215 *710*	235 *770*	230 *750*	130 *425*	160 *520*	175 *570*	190 *620*	190 *620*
P11	210 *690*	265 *870*	285 *940*	310 *1025*	310 *1025*	165 *540*	205 *670*	225 *740*	240 *790*	240 *790*	135 *445*	165 *540*	180 *590*	195 *640*	195 *640*
P12	135 *445*	175 *570*	175 *590*	190 *620*	190 *620*	110 *360*	140 *460*	145 *475*	155 *510*	155 *510*	90 *295*	110 *360*	115 *375*	125 *410*	125 *410*
M1	225 *740*	285 *940*	300 *980*	330 *1075*	325 *1075*	175 *570*	220 *720*	235 *770*	255 *840*	250 *820*	145 *475*	180 *590*	190 *620*	205 *670*	205 *670*
M2	185 *610*	230 *750*	250 *820*	270 *890*	265 *870*	145 *475*	180 *590*	195 *640*	210 *690*	210 *690*	120 *395*	145 *475*	160 *520*	170 *560*	170 *560*
M3	150 *490*	190 *620*	195 *660*	210 *690*	210 *690*	120 *395*	150 *490*	155 *520*	170 *560*	170 *560*	95 *310*	125 *410*	125 *425*	135 *445*	135 *445*
M4	115 *375*	150 *490*	150 *520*	160 *520*	160 *520*	95 *310*	125 *410*	120 *425*	130 *425*	130 *425*	75 *245*	100 *330*	95 *345*	105 *345*	105 *345*
M5	95 *310*	125 *410*	125 *445*	135 *445*	135 *445*	80 *260*	100 *330*	100 *345*	110 *360*	110 *360*	65 *215*	85 *280*	80 *280*	90 *295*	85 *280*
K1	220 *720*	280 *920*	295 *970*	320 *1050*	320 *1050*	175 *570*	215 *710*	235 *770*	250 *820*	250 *820*	140 *460*	175 *570*	190 *620*	205 *670*	200 *660*
K2	195 *640*	245 *800*	260 *850*	285 *940*	280 *920*	155 *510*	190 *620*	210 *690*	220 *720*	220 *720*	125 *410*	155 *510*	170 *560*	180 *590*	180 *590*
K3	165 *540*	205 *670*	220 *720*	240 *790*	240 *790*	130 *425*	160 *520*	175 *570*	190 *620*	185 *610*	105 *345*	130 *425*	140 *460*	150 *490*	150 *490*
K4	155 *510*	195 *640*	210 *690*	230 *750*	225 *740*	125 *410*	155 *510*	170 *560*	180 *590*	180 *590*	100 *330*	125 *410*	135 *445*	145 *475*	145 *475*
K5	95 *310*	120 *395*	125 *410*	135 *445*	140 *460*	75 *245*	95 *310*	100 *330*	110 *360*	110 *360*	60 *195*	75 *245*	80 *260*	90 *295*	90 *295*
K6	135 *445*	175 *570*	185 *610*	200 *660*	200 *660*	110 *360*	135 *445*	150 *490*	160 *520*	155 *510*	90 *295*	110 *360*	120 *395*	130 *425*	125 *410*
K7	120 *395*	150 *490*	165 *540*	175 *570*	175 *570*	95 *310*	120 *395*	130 *425*	140 *460*	140 *460*	80 *260*	95 *310*	105 *345*	115 *375*	115 *375*
N1	1675 *5500*	2125 *6975*	2250 *7375*	2450 *8050*	2450 *8050*	1300 *4275*	1625 *5325*	1725 *5650*	1875 *6150*	1850 *6075*	1050 *3450*	1325 *4350*	1400 *4600*	1525 *5000*	1500 *4925*
N2	680 *2225*	860 *2825*	910 *2975*	990 *3250*	990 *3250*	530 *1750*	660 *2175*	700 *2300*	760 *2500*	750 *2450*	425 *1400*	530 *1750*	570 *1875*	620 *2025*	610 *2000*
N3	450 *1475*	570 *1875*	610 *2000*	660 *2175*	660 *2175*	350 *1150*	435 *1425*	465 *1525*	510 *1675*	500 *1650*	285 *940*	355 *1175*	380 *1250*	410 *1350*	405 *1325*
N11	520 *1700*	650 *2125*	690 *2275*	750 *2450*	760 *2500*	400 *1300*	500 *1650*	530 *1750*	580 *1900*	570 *1875*	325 *1075*	405 *1325*	430 *1400*	470 *1550*	465 *1525*
S1	55 *180*	70 *230*	70 *245*	75 *245*	75 *245*	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	36 *120*	46 *150*	45 *160*	49 *160*	49 *160*
S2	44 *145*	55 *180*	55 *195*	60 *195*	60 *195*	35 *115*	46 *150*	45 *155*	49 *160*	49 *160*	29 *95*	37 *120*	36 *130*	40 *130*	39 *130*
S3	38 *125*	49 *160*	48 *165*	50 *165*	50 *165*	31 *100*	40 *130*	39 *140*	43 *140*	43 *140*	25 *80*	32 *105*	32 *110*	35 *115*	35 *115*
S11	75 *245*	100 *330*	100 *345*	105 *345*	105 *345*	60 *195*	80 *260*	80 *260*	85 *280*	85 *280*	50 *165*	65 *215*	65 *215*	70 *230*	70 *230*
S12	55 *180*	70 *230*	70 *230*	75 *245*	75 *245*	43 *140*	55 *180*	55 *180*	60 *195*	60 *195*	35 *115*	44 *145*	44 *150*	48 *155*	48 *155*
S13	31 *100*	39 *130*	39 *140*	42 *140*	42 *140*	25 *80*	32 *105*	31 *110*	34 *110*	34 *110*	20 *65*	26 *85*	25 *90*	28 *90*	28 *90*
H5	45 *150*	55 *180*	60 *195*	65 *215*	65 *215*	36 *120*	46 *150*	48 *155*	50 *165*	50 *165*	30 *100*	37 *120*	39 *130*	41 *135*	41 *135*
H8	46 *150*	60 *195*	60 *215*	65 *215*	65 *215*	39 *130*	50 *165*	50 *165*	55 *180*	55 *180*	31 *100*	40 *130*	40 *140*	44 *145*	43 *140*
H11	55 *180*	75 *245*	75 *245*	80 *260*	80 *260*	46 *150*	60 *195*	60 *195*	65 *215*	65 *215*	38 *125*	47 *155*	49 *165*	55 *180*	50 *165*
H12	85 *280*	105 *345*	105 *375*	115 *375*	115 *375*	70 *230*	90 *295*	90 *310*	95 *310*	95 *310*	55 *180*	70 *230*	70 *245*	80 *260*	80 *260*
H21	46 *150*	60 *195*	60 *215*	65 *215*	65 *215*	39 *130*	50 *165*	50 *165*	55 *180*	55 *180*	31 *100*	40 *130*	40 *140*	44 *145*	43 *140*

Drehmomentschlüssel und maximale Drehzahl

Drehmomentschlüssel

Die empfohlene Maximaldrehzahl, die aus Sicherheitsgründen nicht überschritten werden darf, ist auf jeder Produktseite angegeben.
Normalerweise ist es nicht notwendig, Werkzeuge bis 10.000 U/min auszuwuchten.
Trotzdem kann eine Auswuchtung in einigen Fällen erforderlich sein, z. B. wenn schwere Werkzeuge und Aufnahmen auf kleinen Maschinen eingesetzt werden.



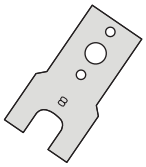
Drehmomentschlüssel für feste Drehmomente generieren automatisch die richtige Klemmkraft beim Einsatz des Minimaster-Schneidkopfes in die Aufnahme.
Drehmomentschlüssel sind gemäß ISO 6789 voreingestellt.
Code-Schlüssel: MM02-4006
MM02 = 2-schneidig
(MM03 = 3-schneidig)
40 = Drehmoment 4,0 Nm
06 = Schneidkopf-Größe

Über 10.000 U/min:
Wir empfehlen, Werkzeug und Aufnahme separat auszuwuchten.
Über 20.000 U/min:
Werkzeug und Aufnahme müssen als Einheit ausgewuchtet werden.
Über 30.000 U/min:
Werkzeug und Aufnahme müssen als Einheit ausgewuchtet werden.
Die maximale Drehzahl laut Tabelle muss eingehalten werden.

Schneidkopf 2-schneidig

Wendeplattengröße	Drehmoment-schlüssel (einschließlich Schlüsselkopf)	Austausch-barer Schlüsselkopf	Drehmoment
			
MM06	MM02-4006	MM02-06	4 Nm
MM08	MM02-8008	MM02-08	8 Nm
MM10	MM02-1201012	MM02-1012	12 Nm
MM12	MM02-1201012	MM02-1012	12 Nm
MM12 DC = Ø 14,0	MM02-16014	MM02-14	16 Nm
MM12 DCX = Ø 16,0	MM02-1601620	MM02-1620	16 Nm
MM16	MM02-1601620	MM02-1620	16 Nm

Schneidkopf 3-schneidig

Wendeplattengröße	Drehmoment-schlüssel (einschließlich Schlüsselkopf)	Austausch-barer Schlüsselkopf	Drehmoment
			
MM06	MM03-4006	MM03-06	4 Nm
MM08	MM03-8008	MM03-08	8 Nm
MM10	MM03-1201012	MM03-1012	12 Nm
MM12	MM03-1201012	MM03-1012	12 Nm
MM16	MM03-16016	MM03-16	16 Nm



SMG – Einführung

Die Basis für SMG ist eine Klassifizierung der Werkstoffe auf der Grundlage ihres Typs und nicht ihrer relativen Zerspanbarkeit; sie enthält folglich Werkstoffe wie beispielsweise Verbundwerkstoffe. Sie ist umfangreich und dabei gleichzeitig übersichtlich, so dass es einfach ist, zu ermitteln, zu welcher Seco Werkstoff-Gruppe ein Werkstoff gehört.
Jede Werkstoffgruppe verfügt über einen spezifischen Werkstoffstandard in einer speziellen Ausführung als Referenz. So sind die Schnittdaten für jeden vorhandenen Werkstoff im Vergleich zu jedem Seco Referenz-Werkstoff leicht anzupassen, siehe Seite 802 - 805.
Als Beispiel werden die Referenzwerkstoffe EN C45E für SMG P4 und EN 42 CrMo 4 für die beiden Materialgruppen SMG P5 und SMG H5 in der nachstehenden Tabelle dargestellt. Die entsprechenden Materialeigenschaften sind mit aufgeführt.

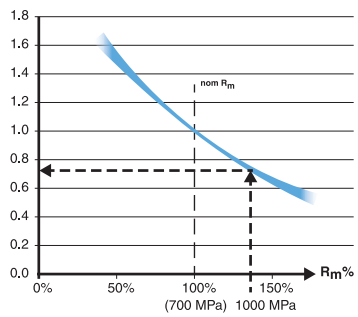
P4	Niedrig legierte Baustähle mit 0,25% < C < 0,67%wt Niedrig legierte Vergütungs- stähle	520 < R_m < 1200	C 45E R_m = 660 N/mm²
P5	Baustähle mit 0,25% < C < 0,67%wt Vergütungsstähle	550 < R_m < 1200	42 CrMo 4 R_m = 700 N/mm²

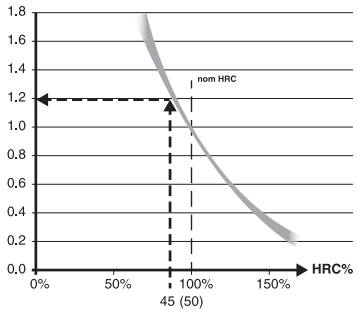
H5	Vergütungsstähle	38 < HRC < 56	42 CrMo 4 50 HRC

Bei dem Werkstoff EN 42 CrMo 4 in lösungsgeglühtem Zustand liegt die Bruchfestigkeit Rm typischerweise zwischen R_m = 630 N/mm² und R_m = 780 N/mm² und bietet damit einen Referenzbereich für SMG P5. Im geglühten Zustand liegt die Bruchfestigkeit R_m typischerweise zwischen R_m = 900 N/mm² und R_m = 1100 N/mm² . Damit wird dieser Werkstoff immer noch der Materialgruppe SMG P5 zugeordnet.

P5	42 CrMo 4	1,1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Geglüht	700	
	42 CrMo 4	1,1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Angelassen & vergütet	1000	
H5	42 CrMo 4	1,1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Angelassen & vergütet		45
	42 CrMo 4	1,1201	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	4142, 4140	38HM	Angelassen & vergütet		50

Ab einer Zugfestigkeit von R_m = 1200 N/mm² gehört EN 42 CrMo 4 zur Materialgruppe SMG H5. Am Beispiel des Werkstoffes vergüteter Stahl EN 42CrMo4 wird die Abhängigkeit der Bearbeitbarkeit der Werkstoffe von den Werkstoffeigenschaften erläutert und die Ermittlung des Schnittdatenfaktors dargestellt.
Die nachstehenden Graphiken zeigen, wie die Schnittdatenempfehlung für nominelle Werkstoffausführungen an entsprechende R_m (linkes Diagramm für ISO-P) und an entsprechende HRC (für ISO-H) angepasst werden kann.





Ermittlung der Schnittdaten für EN 42 CrMo4 BIS Rm = 1200 N/mm²: Um darzustellen, wie in der SMG die nominelle Schnittgeschwindigkeit der SMG P5 genauer berechnet werden kann, benötigen wir die Zugfestigkeit Rm. In diesem Falle verwenden wir EN 42 CrMo 4 vergütet auf Rm = 1000 N/mm² gemäß der obigen Tabelle.
Bei der SMG P5 beträgt die nominelle Schnittgeschwindigkeit für ein Produkt z.B. v_c = 280 m/min. Bei einer Zugfestigkeit R_m = 1000 N/mm² ergibt sich ein Schnittdatenfaktor von 0,75 (siehe Abbildung links). Daraus errechnet sich die empfohlene Schnittgeschwindigkeit v_c = 280 m/min x 0,75 = 210 m/min.
Ermittlung der Schnittdaten für EN 42 CrMo4 AB R_m = 1200 N/mm² (entsprechen 38 HRC). Die Anpassung der nominellen Schnittgeschwindigkeit des gehärteten Werkstoffes EN 42 CrMo 4 mit einer Härte von HRC 45 erfolgt auf die gleiche Weise (siehe dazu Darstellung mit grauer Kurve rechts). Wir gehen davon aus, dass die nominelle Schnittgeschwindigkeit für SMG H5 v_c = 50 m/min für ein bestimmtes Produkt und eine bestimmte Bearbeitung beträgt. Daraus errechnet sich der Schnittdatenfaktor 1,2. Die tatsächliche Schnittgeschwindigkeit beträgt dann v_c = 50 m/min x 1,2 = 60 m/min.
Weitere Werkstoffdetails finden Sie auf Seite(n) 266-273, weitere Schnittdatenempfehlungen auf den entsprechenden Katalogseiten.

Auf www.secotools.com können Sie die Schnittdaten für Ihre individuelle Anwendung ganz einfach berechnen.

Stahl, ferritische und martensitisch rostfreie Stähle

SMG	Bezeichnung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
P1	Automatenstähle mit niedrigem Kohlenstoffgehalt	360 < R_m < 880	11 SMn30 R_m = 385 N/mm²	1500	0,14
P2	Niedrig legierte ferritische Stähle mit C < 0,25%wt Niedrig legierte normale Baustähle	320 < R_m < 600	S235JRG2 R_m = 420 N/mm²	1600	0,23
P3	Ferritische und ferritisch/perlitische Stähle mit C < 0,25%wt schweißbare Baustähle Einsatzstähle	430 < R_m < 610	16 MnCr 5 R_m = 550 N/mm²	1800	0,14
P4	Niedrig legierte Baustähle mit 0,25% < C < 0,67%wt Niedrig legierte Vergütungs-stähle	520 < R_m < 1200	C 45E R_m = 660 N/mm²	2000	0,15
P5	Baustähle mit 0,25% < C < 0,67%wt Vergütungsstähle	550 < R_m < 1200	42 CrMo 4 R_m = 700 N/mm²	2020	0,18
P6	Niedrig legierte härtbare Stähle mit C > 0,67%wt Niedrig legierte Feder- und Lagerstähle	520 < R_m < 1200	C 100S R_m = 600 N/mm²	2100	0,17
P7	Härtbare Stähle mit C > 0,67%wt Feder- und Lagerstähle	600 < R_m < 1200	100 Cr 6 R_m = 650 N/mm²	2160	0,17
P8	Werkzeugstähle Schnellarbeitsstähle (HSS)	600 < R_m < 1200	X 40 CrMoV 5 1 R_m = 700 N/mm²	2400	0,20
P11	Ferritische und martensitische Stähle	415 < R_m < 1200	X 20 Cr 13 R_m = 675 N/mm²	2000	0,15
P12	Martensitaushärtbares und lösungsbehandeltes Rostfrei	500 < R_m < 1200	X 5 CrNiCuNb 16 4 R_m = 1100 N/mm²	2100	0,17

Austenitisch rostfreie Stähle

SMG	Bezeichnung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
M1	Leicht schneidendes Rostfrei		X 10 CrNiS 18 9	1700	0,14
M2	Niedrig legierte austenitische rostfreie Stähle		X 5 CrNi 18 10	1920	0,18
M3	Legierte austenitische rostfreie Stähle		X 2 CrNiMo 18 14 3	2070	0,17
M4	Hoch legierte rostfreie Stähle (Austenit und Duplex)		X 2 CrNiMoN 22 5 3	2230	0,16
M5	Austenit und Duplex, sehr schwierig zerspanbar		X 2 CrNiMoN 25 7 4	2510	0,13

Guss

SMG	Bezeichnung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
K1	Grauguss (GCI)		EN-GJL-250	930	0,32
K2	Vermikularguss (CGI)		EN-GJV-400	1000	0,35
K3	Temperguss (MCI)		EN-GJMB-550-4	1050	0,37
K4	Sphäroguss, Kugelgrafitguss (SGI)		EN-GJS-500-7	1160	0,37
K5	Wärmebehandelter Kugelgrafitguss (ADI)		EN-GJS-1000-5	0	
K6	Austenitischer Guss mit Lamellengrafit		EN-GJLA-XNiCuCr15-6-2	0	
K7	Austenitischer Sphäroguss		EN-GJSA-XNiMn23-4	0	

Nicht-Eisen-Metalle

SMG	Bezeichnung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
N1	Aluminiumlegierungen, Si < 9%		AW-7075	0	
N2	Aluminiumlegierungen, 9% < Si < 16%		AC-44200 Si = 12%	0	
N3	Aluminiumlegierungen, Si >16%		AlSi17Cu5	0	
N11	Kupferlegierungen		CW614N	740	0,26

Superlegierungen und Titan

SMG	Bezeichnung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
S1	Superlegierungen auf Fe-Basis		Discalloy	0	
S2	Superlegierungen auf Co-Basis		Stellite 21	0	
S3	Superlegierungen auf Ni-Basis		Inconel 718	2530	0,21
S11	Titan, niedrig legiert, (α)		Ti	0	
S12	Titan, mittlere Legierung, (α+β)		TiAl6V4	1500	0,24
S13	Titan, hoch legiert, (nahe β und β)		Ti10V2Fe3Al	0	

Harte Werkstoffe

SMG	Bezeichnung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
H3	Einsatzstahl gehärtet	58 < HRC < 62	16 MnCr 5 60 HRC	2070	0,14
H5	Vergütungsstähle	38 < HRC < 56	42 CrMo 4 50 HRC	2320	0,18
H7	Vergütungsstähle Lagerstähle	56 < HRC < 64	100 Cr 6 60 HRC	2480	0,17
H8	Werkzeugstähle Schnellarbeitsstähle (HSS)	38 < HRC < 64	X 40 CrMoV 5 1 50 HRC	2750	0,20
H11	Martensitische, rostfreie Stähle	38 < HRC < 50	X 20 Cr 13 45 HRC	2300	0,15
H12	Martensitausgehärtetes und lösungsbehandeltes Rostfrei	1200 < R_m < 1650	X 5 CrNiCuNb 16 4 R_m = 1450 N/mm^2	2410	0,17
H21	Manganstahl	23 < HRC < 64	X 120 Mn 12 50 HRC	0	
H31	Weißhartguss	50 < HRC < 64	EN-GJN-HV600(XCr11) 55 HRC	0	

Andere Werkstoffe

SMG	Bezeichnung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
PM1	Niedrig legierte Pulvermetall-Werkstoffe		F-0008 Fe-0.7C	0	
PM2	PM-Werkstofflegierungen im mittleren Bereich		FLC-4608 Fe2Cu1.8Ni 0.5Mo0.2Mn0.8C	0	
PM3	Hoch legierte PM-Werkstoffe Werkstoffe für Abgasventilsitze, etc.			0	
HF1	Aufschweißlegierungen Geschweißte oder Plasma-beschichtete Legierungen auf Eisen-Basis			0	
HF2	Aufschweißlegierungen Geschweißte oder Plasma-beschichtete Kobalt- und Nickel-basis-Legierungen			0	
CC1	Gesintertes Wolfram-Hartmetall		G50	0	

Kunststoffe und Composite

SMG	Bezeichnung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
TS1	Duroplaste		Urea Formaldehyde (UF)	0	
TS2	Duroplastische Kohlenstoff-faser-Verbundwerkstoffe		T300 T700 T800 HTA-S IMA - Epoxy (M21)...	0	
TS3	Duroplastische Glasfaser-Verbundwerkstoffe		Epoxy - HX..(42..)/E-Glas (7781...)...	0	
TS4	Duroplastische Aramidfaser-Verbundwerkstoffe		Kevlar 49	0	
TP1	Thermoplastische Polymere		Polycarbonat (PC)	0	
TP2	Thermoplastische Kohlenstofffaser-Verbun-dwerkstoffe		PPS/PEEK - T300..	0	
TP3	Thermoplastische Glasfaser-Verbundwerkstoffe		PPS/PEEK - E-Glas oder A-Glas...	0	
TP4	Thermoplastische Aramidfaser-Verbundwerkst-offe			0	

Graphit

SMG	Bezeichnung	Bezeichnung	Referenz	$k_{c1.1}$	m_c
GR1	Graphit		R 8500	0	

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
	11 SMn 30	1.0715	1.0715	9 SMn 28	S 250	230 M 07	CF 9 SMn 28	SUM 22	1912	G12130
	11 SMnPb 30	1.0718	1.0718	9 SMnPb 28	S 250 Pb		CF 9 SMnPb 28	SUM 22 L	1914	G12134
	10 S 20	1.0721	1.0721	10 S 20	10 F 1	210 M 15	CF 10 S 20			
			1.0722	10 SPb 20	10 PbF 2		CF 10 SPb 20			
P1	15 SMn 13	1.0725	1.0723	15 S 20		210 A 15		SUM 32	1922	
	35 S20	1.0726	1.0726	35 S 20	35 MF 4	212 M 36			1957	G11400
	46 S20	1.0727	1.0727	46 S 20	45 MF 4	212 M 44			1973	G11460
	11 SMn 37	1.0736	1.0736	9 SMn 36	S 300	240 M 07	CF 9 SMn 36			G12150
	11 SMn 37	1.0736	1.0736	9 SMn 36	S 300	240 M 07	CF 9 SMn 36			G12150
	S235JR	1.0037	1.0037	St 37-2	E 24-2		Fe 360 B	STKM 12 C	1311	
	S235JRG2	1.0038	1.0116	St 37-3	E 24-3, E 24-4	4360-40 C	Fe 360 D FF		1312, 1313	
	S275J2G3	1.0144	1.0144	St 44-3 N	E 28-3, E 28-4	4360-43 C	Fe 430 D FF	SM 41 C	1412, 1414	
	C 10	1.0301	1.0301	C 10	AF 34 C 10, XC 10	045 M 10	C 10	S 10 C		G10100
P2			1.0401	C 15	AF 37 C 12, XC 18	080 M 15	C 15, C 16		1350	G10170
	C22	1.0402	1.0402	C 22	C 20	050 A 20	C 20, C 21		1450	G10200
	S355JR	1.0570	1.0570	St 52-3	E 36-3, E 36-4	4360-50 C	Fe 510 B	SM 50 YA	2172, 2132	
	C 15R	1.1141	1.1141	Ck 15	XC 15, XC 18	080 M 15	C 15, C 16	S 15 C, S 15 CK	1370	G10170
			1.1158	Ck 25	XC 25	060 A 25	C 25	S 25 C		G10250
			1.2162	21 MnCr 5	20 NC 5			SCR 420 H		
	16 Mo 3	1.5415	1.5415	15 Mo 3	15 D 3	1501-240	16 Mo 3		2912	
			1.5423	16 Mo 5		1503-245-420	16 Mo 5	SB 450 M		G45200
	14 NiCr 14	1.5752	1.5752	14 NiCr 14	12 NC 15	655 M 13		SNC 815 (H)		G33106
			1.5919	15 CrNi 6	16 NC 6	S 107	16 CrNi 4			
	18 NiCrMo 7 6	1.6587	1.6587	18 CrNiMo 7 6	18 NCD 6	820 A 16	18 NiCrMo 7			
P3	16 MnCr 5	1.7131	1.7131	16 MnCr 5	16 MC 5	527 M 17	16 MnCr 5	SCR 415	2511	G51170
	16 MnCrS 5	1.7139	1.7139	16 MnCrS 5						
	20 MnCr 5	1.7147	1.7147	20 MnCr 5	20 MC 5		20 MnCr 5	SMnC 420 (H)		G51200
	20 MnCrS 5	1.7149	1.7149	20 MnCrS 5	20 MnCrS 5			SMnC 21 H		
	13 CrMo 4 5	1.7335	1.7335	13 CrMo 4 4	15 CD 3,5	1501-620 Gr. 27	14 CrMo 4 5		2216	
			1.7337	16 CrMo 4 4	15 CD 4,5	1501-620 Gr. 27	14 CrMo 4 5		2216	
	10 CrMo 9 10	1.7380	1.7380	10 CrMo 9 10	10 CD 9.10	1501-622 Gr. 31	12 CrMo 9 10		2218	J21890
	C35		1.0501	C 35	55 C 35	060 A 35	C 35		1550	G10350
	E 335	1.0503	1.0503	C 45	65 C 45	80 M 46	C 45	S 45 C	1650	G10430
	C40		1.0511	C 40	60 C 40	080 M 40	C 40	S 40 C		
	E 360	1.0070	1.0535	St 70-2	A 70-2		Fe 690		1655	
	C60	1.0601	1.0601	C 60	CC 55	080 A 62	C 60			G10600
P4			1.1157	40 Mn 4	35 M 5	150 M 36				G10390
	G 28 Mn6	1.1165	1.1165	30 Mn 5		120 M 36		SMn 1 H, SCMn 2		G13300
	C 35E	1.1181	1.1181	Ck 35	XC 38 H1	080 M 36	C 35	S 35 C	1572	G10340
	C 45E	1.1191	1.1191	Ck 45	XC 42	080 M 46	C 45	S 45 C	1672	G10420
	C 60E	1.1221	1.1221	Ck 60	XC 60	080 A 62	C 60	S 58 C	1665, 1678	G10640
			1.1740	C 60 W	Y3 55			SK 7		
	55 SiCr7	1.7100	1.0904	55 Si 7	55 S 7	250 A 53	55 Si 8		2085, 2090	
			1.2330	35 CrMo 4	34 CD 4	708 A 37	35 CrMo 4		2234	T51620
			1.2542	45 WCrV 7		BS 1	45 WCrV 8 KU		2710	T41901
		1.2714	1.2714	56 NiCrMoV 7		BH 224-5	56 NiCrMoV7-KU	SKT 4		T61206
			1.5121	46 MnSi 4						
			1.5710	36 NiCr 6	35 NC 6	640 A 35		SNC 236		
			1.5736	36 NiCr 10	35 NC 11		35 NiCr 9	SNC 631 (H)		
	36 CrNiMo 4		1.6511	36 CrNiMo 4	40 NCD 3	816 M 40	38 NiCrMo 4 (KB)			G98400
P5	34 CrNiMo 6	1.6582	1.6582	34 CrNiMo 6	35 NCD 6	817 M 40	35 NiCrMo 6 (KW)	SNCM 447	2541	G43400
	34 Cr 4	1.7033	1.7033	34 Cr 4	32 C 4	530 A 32	34 Cr 4 (KB)	SCr 430 (H)		G51320
	41 Cr 4	1.7035	1.7035	41 Cr 4	42 C 4	530 M 40	41 Cr 4	SCr 440 (H)		G51400
	25 CrMo 4	1.7218	1.7218	25 CrMo 4	25 CD 4 S	708 M 25	25 CrMo 4 (KB)	SCM 425	2225	G41300
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
			1.7361	32 CrMo 12	30 CD 12	722 M 24	32 CrMo 12		2240	
	50 CrV 4	1.8159	1.8159	50 CrV 4	50 CV 4	735 A 50	51 CrV 4	SUP 10	2230	H61500
	41 CrAlMo 7 10	1.8509	1.8509	41 CrAlMo 7	40 CAD 6.12	905 M 39	41 CrAlMo 7	SACM 645	2940	K24065
	C 67S	1.1231	1.1231	Ck 67	XC 68	060 A 67	C 70		1770	G10700
	C 100S	1.1274	1.1274	Ck 101		060 A 96		SUP 4	1870	G10950
P6	C 105U	1.1545	1.1545	C 105 W1	Y1 105		C 100 KU		1880	
			1.1645	C 105 W2	Y1 105		C 100 KU	SK 3		
			1.1663	C 125 W	Y2 120		C 120 KU	SK 2		

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Div. Marken	Ausführung	Struktur
	1213				geglüht	
	12 L 13				geglüht	
	1108				geglüht	
	11 L 08				geglüht	
					geglüht	
	1140	40			geglüht	
	1146				geglüht	
	1215				geglüht	
	12 L 14				geglüht	
		16D			geglüht	
	ASTM Grade 58	18kp	11 378		geglüht	
	ASTM Grade 70	St14kP	11 448		geglüht	
	1010	10			geglüht	
F.1110	1015	15			geglüht	
	1020, 1023	20	12 024		geglüht	
		17G1S	11 523		geglüht	
F.1511	1015	15			geglüht	
F.1120	1025	25			geglüht	
					geglüht	
	A204 Grade A		15 020		geglüht	
	4520				geglüht	
	3310, 9314	20X2H4A	16 420		geglüht	
	4320		16 220		geglüht	
					geglüht	
F.1516	5115	12KHN2	14 220		geglüht	
		18HG			geglüht	
	5120	20KH	14 221		geglüht	
	5120 H	20KH			geglüht	
	A182-F11, A182-F12	12KHM	15 121		geglüht	
	A387 Grade 12 Cl. 2				geglüht	
F.155	A182-F22	12KH8	15 313		geglüht	
F.1130	1035	35	12 040		geglüht	
F.5110	1045	45	12 050		geglüht	
	1040	40	12 041		geglüht	
F.1150	1055	55			geglüht	
	1060	60	12 061		geglüht	
	1039	40G			geglüht	
	1330	30G2			geglüht	
F.1135	1035	35			geglüht	
F.1140	1045	45	12 050		geglüht	
F.1150	1064	60			geglüht	
	1060	60			geglüht	
F.144	9255	55S2			geglüht	
F.1250	4135	35KHM			geglüht	
F.5241	S1	5KHV2S			geglüht	
	L6	5KHNV			geglüht	
	5045				geglüht	
	3135				vergütet	
	3435				geglüht	
	9840				vergütet	
F.1280	4340	38H2N2MA	16 343		geglüht	
	5132	35KH			vergütet	
	5140	40H	14 140		vergütet	
F.1251	4130	20KHM	15 130		vergütet	
F.1252	4142, 4140	38HM	15 142		geglüht	
F.1252	4142, 4140	38HM	15 142		vergütet	
					vergütet	
F.143	6150	50KHFA	15 260		vergütet	
F.1740	A355 Cl. A				geglüht	
F.5103	1070	70			geglüht	
F.5117	1095				geglüht	
F.5118	W1	U10A			geglüht	
		U10			geglüht	
	W1	U13			geglüht	

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
P7	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202
			1.2510	100 MnCrW 4	90 MWCV 5	BO 1	95 MnWCr 5 KU	SKS 3	2140	T31501
	90 MnCrV 8	1.2842	1.2842	90 MnCrV 8	90 MV 8	BO 2	90 MnVCr 8 KU			T31502
	100 Cr 6	1.3505	1.3505	100 Cr 6	100 C 6	534 A 99	100 Cr 6	SUJ 2	2258	G51986
P8	X 210 Cr 12	1.2080	1.2080	X 210 Cr 12	Z 200 C 12	BD 3	X 210 Cr 13 KU	SKD 1		T30403
			1.2343	X 38 CrMoV 5 1	Z 38 CDV 5	BH 11	X 37 CrMoV 5 1 KU	SKD 6		T20811
	X 40 CrMoV 5 1	1.2344	1.2344	X 40 CrMoV 5 1	Z 40 CDV 5	BH 13	X 40 CrMo 5 1 1 KU	SKD 61	2242	T20813
	X 100 CrMoV 5	1.2363	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	BA 2	X 100 CrMoV 5 1 KU	SKD 12	2260	T30102
			1.2365	X 32 CrMoV 3 3	32 DCV 28	BH 10	30 CrMoV 12 27 KU	SKD 7		T20810
			1.2436	X 210 CrW 12			X 215 CrW 12 1 KU	SKD 2	2312	
			1.2601	X 165 CrMoV 12			X 165 CrMoW 12 KU		2310	
			1.2713	55 NiCrMoV 6	55 NCDV 7			SKT 4		T61206
	HS 6-5-2-5	1.3243	1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05-04-02		HS 6-5-2-5	SKH 55	2723	
	HS 2-10-1-8	1.3247	1.3247	S 2-10-1-8	Z 110 DKCWV 09-08-04	BM 42	HS 2-9-1-8	SKH 51		T11342
	HS 18-1-2-5	1.3255	1.3255	S 18-1-2-5	Z 80 WKCV 18-05-04-01	BT 4	HS 18-1-1-5	SKH 3		T12004
	HS 6-5-2	1.3343	1.3343	S 6-5-2	Z 85 WDCV 06-05-04-02	BM 2	HS 6-5-2	SKH 9, SKH 51	2722	T11302
	HS 2-9-2	1.3348	1.3348	S 2-9-2	Z 100 DCWV 09-04-02-02		HS 2-9-2	SKH 58	2782	T11307
	HS 18-0-1	1.3355	1.3355	S 18-0-1	Z 80 WCV 18-04-01	BT 1	HS 18-0-1	SKH 2		T12001
P11	X 6 Cr 13	1.4000	1.4000	X 6 Cr 13	Z 6 C 12	403 S 17	X 6 Cr 13	SUS 403	2301	S41008
	X 12 Cr 13	1.4006	1.4006	X 10 Cr 13	Z 10 C 13	410 S 21	X 12 Cr 13	SUS 410	2302	S41000
	X 6 Cr 17	1.4016	1.4016	X 6 Cr 17	Z 8 C 17	430 S 15	X 8 Cr 17	SUS 430	2320	S43000
	X 20 Cr 13	1.4021	1.4021	X 20 Cr 13	Z 20 C 13	420 S 37	X 20 Cr 13	SUS 420 J 1	2303	S42000
	X 39 Cr 13	1.4031	1.4031	X 40 Cr 13	Z 40 C 14	420 S 45	X 40 Cr 14	SUS 420	2304	S40280
	X 70 CrMo 15	1.4109	1.4109	X 65 CrMo 14	Z 70 D 14			SUS 440 A		S44002
	X 90 CrMoV 18	1.4112	1.4112	X 90 CrMoV 18	Z 2 CND 18 05	409 S 19	X CrTi 12	SUS 440 B	2327	S44003
	X 105 CrMo 17	1.4125	1.4125	X 105 CrMo 17	Z 100 CD 17		X 105 CrMo 17	SUS 440 C		S44004
	X 3 CrNIMo 13 3	1.4313	1.4313	X 5 CrNi 13 4	Z 5 CN 13.4	425 C 11	X 6 CrNi 13 04	SCS 5	2385	S41500
	X 18 CrN 28	1.4749	1.4749	X 18 CrN 28	Z 18 C 25				2322	S44600
P12	X 6 NiCrTiMoV 25 15	1.4534	1.4534	X 3 CrNiMoAl 13 8 2						S13800
	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
		1.4540	1.4540	X 4 CrNiCuNb 16 4	Z 4 CNUNb 16.4 M					S15500
	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 5 CrNiCuNb 17 4	1.4548	1.4542	X 5 CrNiCuNb 17 4	Z 6 CNU 17.4			SCS 24, SUS 630		S17400
	X 7 CrNiAl 17 7	1.4564	1.4564	X 7 CrNiAl 17 7	Z 9 CAN 17.7	301 S 81	X 7 CrNiAl 17 7	SUS 631	2388	S17700
	X 2 NiCoMoTi 18 12 4	1.6356	1.6356	X 2 NiCoMoTi 18 12 4						K93160
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 CrNiMoAl 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 CrNiMoAl 18 8 5	1.6359	1.6359	X 2 CrNiMoAl 18 8 5		S 162				K92890
	X 2 CrNiMoAl 18 8 5	1.6359	1.6359	X 2 CrNiMoAl 18 8 5		S 162				K92890
M1	X 10 CrNiS 18 9	1.4305	1.4305	X 10 CrNiS 18 9	Z 10 CNF 18.09	303 S 31	X 10 CrNi 18 09	SUS 303	2346	S30300
M2	X 2 CrNi 19 11	1.4306	1.4306	X 2 CrNi 19 11	Z 2 CN 18.10	304 S 12	X 3 Cr Ni 18 11	SUS 304 L	2352	S30403
	X 5 CrNi 18 10	1.4301	1.4301	X 5 CrNi 18 10	Z 6 CN 18.09	304 S 31	X 5 CrNi 18 11	SUS 304	2333	S30400
	X 5 CrNiMo 17 12 2	1.4401	1.4401	X 5 CrNiMo 17 12 2	Z 3 CND 17.11.1	316 S 31	X 5 CrNiMo 17 12	SUS 316	2347	S31600
	X 6 CrNiNb 18 10	1.4550	1.4550	X 6 CrNiNb 18 10	Z 6 CNNb 18.10	347 S 31	X 6 CrNiNb 18 11	SUS 347	2338	S34700
	X 9 CrNi 18 8	1.4310	1.4310	X 12 CrNi 17 7	Z 12 CN 17.07	301 S 21	X 12 CrNi 17 07	SUS 301	(2331)	S30100
	X 12 CrNi 18 8	1.4300	1.4300	X 12 CrNi 18 8	Z 12 CN 18	302 S 25		SUS 302	2331	S30200
M3	X 2 CrNiMo 18 14 3	1.4435	1.4435	X 2 CrNiMo 18 14 3	Z 2 CND 17.13	316 S 12	X 2 CrNiMo 17 13 2	SCS 16, SUS 316 L	2353	S31603
	X 2 CrNiMoN 17 13 3	1.4429	1.4429	X 2 CrNiMoN 17 13 3	Z 2 CND 17.13 Az	316 S 62	X 2 CrNiMoN 17 13 3	SUS 316 LN	2375	S31653
	X 2 CrNiN 18 10	1.4311	1.4311	X 2 CrNiN 19 11	Z 2 CN 18 .10 Az	304 S 62	X 2 CrNiN 18 11	SUS 304 LN	2371	S30453
	X 3 CrNiMo 18 12 3	1.4466	1.4466	X 5 CrNi 18 15		317 S 16	X 5 CrNi 18 15	SUS 317	2366	S31700
	X 9 CrNiSiNCe 21 11 2	1.4835	1.4893	X 9 CrNiSiNCe 21 11 2		310 S 31			2368	S30815
	X 12 CrNi 25 21	1.4335	1.4335	X 12 CrNi 25 21	Z 12 CN 25.20	310 S 24	X 6 CrNi 26 20	SUH 310, SUS 310 S	2361	S31008
M4	X 2 CrNiMoN 22 5 3	1.4462	1.4462	X 2 CrNiMoN 22 5	Z 2 CND 22.05 Az	332 S 15	X 2 CrNiMoN 22 5		2377	S31803
	X 2 CrNiMoSi 19 5	1.4424	1.4417	X 2 CrNiMoSi 19 5	Z 2 CND 18.05.03				2376	S31500
	X 2 NiCrMoCu 25 20 5	1.4539	1.4539	X 2 NiCrMoCu 25 20 5	Z 2 NCDU 25 20	904 S 13			2562	N08904
	X 3 CrNiMo 27 5 2	1.4460	1.4460	X 4 CrNiMo 27 5 2	Z 3 CND 25.7 Az		X 3 CrNiMo 27 5 2	SUS 329 J 1	2324	S32900
	X 5 CrNiCuNb 16 4	1.4980	1.4943	X 4 NiCrTi 25 15	Z 6 NCTDV 25.15	HR 51		SUH 660	2570	S66286
M5	X 1 CrNiMoN 20 18 7	1.4547	1.4529	X 1 CrNiMoN 20 18 7	Z 1 CNDU 20.18.05 Az		X 1 CrNiMoN 20 18 7		2778	S31254
	X 1 CrNiMoN 25 22 8	1.4652	1.4652	X 2 CrNiMoN 25 22 7						S32654
	X 10 NiCrAlTi 32 20	1.4876	1.4876	X 10 NiCrAlTi 32 20	Z 10 NC 32.21			NCF 800		N08800
	X 2 CrNiMoN 25 7 4	1.4410	1.4410	X 2 CrNiMoN 25 7 4	Z 3 CND 25.07 Az		X 2 CrNiMoN 25 7 4		2328	S32750

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Div. Marken	Ausführung	Struktur
F.520L	L2	11KHF			geglüht	
F.5220	O1	9KHVG			geglüht	
	O2	9G2F			geglüht	
F.5230	52100	SHKH15	14 109		geglüht	
F.5212	D3	KH12			geglüht	
	H11	4KH5MFS			geglüht	
F.5318	H13	4KH5MF1S			geglüht	
F.5227	A2	9KH5VF			geglüht	
	H10	3KH3M3F			geglüht	
F.5213		KH12			geglüht	
		KH12MF			geglüht	
F.520.S	L6	5KHNM			geglüht	
F.5613	M35	R6M5K5			geglüht	
	M42	R2AM9K5			geglüht	
	T4	R18K5F2			geglüht	
F.5603	M2	R6M5			geglüht	
	M7				geglüht	
	T1	R18			geglüht	
	403	08KH13			geglüht	ferritisch
F.3401	410, -15	12KH13, 08KH13			geglüht	martensitisch
F.3113	430	12KH17			geglüht	ferritisch
F.5261	420	20KH13	17 022		geglüht	martensitisch
F.3404	420	40KH13			geglüht	martensitisch
	440 A				geglüht	martensitisch
	440 B	95KH18			geglüht	martensitisch
	440 C	95KH18			geglüht	martensitisch
	A182 F6NM			F6NM	geglüht	martensitisch
	446	15KH28			geglüht	ferritisch
	XM-13			PH 13-8 Mo	lösungsgeglüht	austenitisch
	XM-12			15-5-PH	ausscheidungsgehärtet H1150	martensitisch
	XM-12			15-5-PH	lösungsgeglüht	martensitisch
	XM-12			15-5-PH	ausscheidungsgehärtet H1025	martensitisch
	IN 630			17-4-PH	ausscheidungsgehärtet H1150	martensitisch
	630			17-4-PH	lösungsgeglüht	martensitisch
	631	09KH17N7YU1		17-7-PH	lösungsgeglüht	austenitisch/ferritisch
	AMS 6515			Marage 350	lösungsgeglüht	martensitisch
	AMS 6521			Marage 300	lösungsgeglüht	martensitisch
	AMS 6514			Marage 300, Vascomax C300	lösungsgeglüht	martensitisch
	AMS 6512			Marage 250	lösungsgeglüht	martensitisch
	AMS 6512			Marage 250, Vascomax C250	lösungsgeglüht	martensitisch
F.3508	303	12KH19N9			geglüht	austenitisch
F.3504	304 L	03KH18N11			geglüht	austenitisch
F.3504	304	08KH18N10	17 240		geglüht	austenitisch
F.3534	316	08KH17H13M2T	17 346		geglüht	austenitisch
F.3524	347	08KH18N12B			geglüht	austenitisch
F.3517	301	07KH16N6			geglüht	austenitisch
	302	12KH18N9			geglüht	austenitisch
F.3533	316 L	03KH17N14M3	17 349		geglüht	austenitisch
	316 LN	03KH16N15M3			geglüht	austenitisch
F.3541	304 LN	03KH18N11			geglüht	austenitisch
	317	08KH17H15M3T			geglüht	austenitisch
				253 MA	geglüht	austenitisch
	310 S	12KH25N20			geglüht	austenitisch
	329 LN			SAF 2205	geglüht	Duplex
				3RE60	geglüht	Duplex
	904L				geglüht	Super Austenit
	329				geglüht	Duplex
	660			A286	lösungsgeglüht	austenitisch
				254 SMO	geglüht	Super Austenit
				654 SMO	geglüht	Super Austenit
				Alloy 800	geglüht	austenitisch
	F 53			SAF 2507	geglüht	Super Duplex

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
K1	EN-GJL-150	0.6150	0.6150	GG-15	Ft 15 D	Grade 150	G15	FC 150	01 15-00	F11601
	EN-GJL-200	0.6200	0.6200	GG-20	Ft 20 D	Grade 220	G20	FC 200	01 20-00	F12101
	EN-GJL-250	0.6250	0.6250	GG-25	Ft 25 D	Grade 260	G25	FC 250	01 25-00	F12401
	EN-GJL-350	0.6350	0.6350	GG-35	Ft 35 D	Grade 350	G35	FC 350	01 35-00	F13502
	EN-GJL-215			GG-220 HB					02 19	
K2	EN-GJV-300			GJV-300						
	EN-GJV-350			GJV-350						
	EN-GJV-400			GJV-400						
	EN-GJV-450			GJV-450						
	EN-GJV-500			GJV-500						
K3	EN-GJMB-550-4	0.8155		GTS-55-04	P 540/5	P 540/5	P 55-04	PCMP55-04	08 54-00	F24130
K4	EN-GJS-350-22	0.7033	0.7033	DMM=-35,3	FGS 370-17	Grade 350/22		FCD 350-22L	07 17-15	
	EN-GJS-400-15	0.7040	0.7040	GGG-40	FGS 400-12	Grade 420/12	GS 400-12	FCD 400-18L	07 17-02	F32800
	EN-GJS-400-18	0.7043	0.7043	DMM=-40,3	FGS 370-17	Grade 370/17	GSO 42/17		07 17-12	F32800
	EN-GJS-500-7	0.7050	0.7050	GGG-50	FGS 500-7	Grade 500/7	GS 500-7	FCD 500-7	07 27-02	F33800
	EN-GJS-600-3	0.7060	0.7060	GGG-60	FGS 600-3	Grade 600/3	GS 600-3	FCD 600-3	07 32-03	F34100
	EN-GJS-700-2	0.7070	0.7070	GGG-70	FGS 700-2	Grade 700/2	GS 700-2	FCD 700-2	07 37-01	F34800
K5										ADI grade 5
	EN-GJS-1000-5			GJS-1000-5						ADI grade 2
	EN-GJS-1200-2			GJS-1200-2						ADI grade 3
	EN-GJS-1400-1			GJS-1400-1						ADI grade 4
	EN-GJS-800-8			GJS-800-8						ADI grade 1
K6	EN-GJLA-XNiCr 20-2	0.6660	0.6660	GGL-NiCr 20 2	FGL Ni20 Cr2	Grade F2			05 23-00	F41002
	EN-GJLA-XNiCr 30-3	0.6676	0.6676	GGL-NiCr 30 3	FGL Ni30 Cr3	Grade F3				F41004
	EN-GJLA-XNiCuCr 15-6-2	0.6655	0.6655	GGL-NiCuCr 15 6 2	FGL Ni15 Cu6 Cr2	Grade F1				F41000
K7	EN-GJSA-XNiMn 13-7	0.7652	0.7652	GGG-NiMn 13 7	FGS Ni13 Mn7	Grade S6			07 72-00	
	EN-GJSA-XNiCr 20-2	0.7660	0.7660	GGG-NiCr 20 2	FGS Ni20 Cr2	Grade S2				F43000
	EN-GJSA-XNiMn 23-4	0.7673	0.7673	GGG-NiMn 23 4	FGS Ni23 Mn4	Grade S2M				F43010
	EN-GJSA-XNiCr 30-3	0.7676	0.7676	GGG-NiCr 30 3	FGS Ni30 Cr3	Grade S3				F43003
	EN-GJSA-XNi 35	0.7683	0.7683	GGG-Ni 35	FGS Ni35					F43006
N1	AW-1050A	Al99.5	3.0255	Al99.5	-51050A	1B		(A1050)	4007	AA1050A
	AW-2011	AlCuBiPb	3.1655	AlCuBiPb	A-U5PbBi/2011	FC1		A2011	4355	AA2011
	AW-2014	AlCuSiMn	3.1255	AlCuSiMn	A-U4SG/2014	H15			4338	AA2014
	AW-5005	AlMg1	3.3315	AlMg1	A-G0.6	N41			4106	AA5005
	AW-6060	AlMgSi0.5	3.3206	AlMgSi0.5	A-GS/6060	(H9)			4103	AA6060
	AW-6063	AlMgSi0.7	3.3210	AlMgSi0.7	A-GSUC/6061	(H10)		(A6063)	4104, 4107	AA6005
	AW-3103	AlMn1	3.0515	AlMn1		N3			4054	AA3103
	AW-3003	AlMn1Cu	3.0517	AlMn1Cu	A-M1/3003			A3003		AA3003
	AW-7020	AlZn4.5Mg1	3.4335	AlZn4.5Mg1	A-Z5G/7020	H17			4425	AA7020
	AW-7075		3.4365	AlZnMgCu1.5	A-Z5GU/7075	2L95/2L96		A7075		AA7075
	AC-42000		3.2341	G-AlSi5Mg	A-S7G	LM25	3599	AC 4C	4244	
	AC-46200	AlSi8Cu3(Si)	3.2161	G-AlSi8Cu3					4251	A13800
	MG-P-63	MgAl6Zn	3.5612	G-MgAl6Zn	G-A6-Z1	MAG-E-121				M11600
	MG-P-61	MgAl8Zn	3.5812	G-MgAl8Zn	(G-A7-Z1)					
	MN65120	MgSe3Zn2Zr1	3.5103	G-MgSe3Zn2Zr1	ZRE1	MAG6-TE				M12330
N2	AC-43400	AlSi10Mg(Fe)	3.2381	G-AlSi10Mg	A-S10G	LM9			4253	A13600
	AC-44200	AlSi12	3.2382	GD-AlSi12						
	AW-6082	AlMgSi1	3.2315	AlMgSi1	A-SGM0.7/6082	H30			4212	AA6082
N3		AlSi17Cu5						ADC14		
N11	CC331G		2.0940.01	CuAl10Fe	CuAl10Fe	AB1			5710	C95200
	CC333G		2.0975.01	CuAl10Ni	CuAl10Ni5Fe5	AB2			5716	C95500
		CuNi10Fe1Mn	2.0872	CuNi10Fe1Mn	CuNi10Fe1Mn	CN102			5667	C70600
				CuNi10Zn45						
		CW408J	2.0790	CuNi18Zn19Pb	CuNi18Zn19Pb1					C76300
	CW352H		2.1176	CuPb10Sn	CuSn10Pb10	LB2			5640	C93700
	CC480K		2.1050.01	CuSn10	CuSn10	CT1			5443	C90700
			2.1087	CuSn10Zn					5458	C90500
	CW452K	CuSn6	2.1020	CuSn6	CuSn6	PB103		C5191	5428	C51900
	CW502L	CuZn15	2.0240	CuZn15	CuZn15	CZ102		C2300	5112	C23000
	CW706R	CuZn28Sn1	2.0470	CuZn28Sn1	CuZn29Sn1				5220	C44300
	CW508L	CuZn37	2.0321	CuZn37	CuZn37	CZ108			5150	C27200
	CW717R	CuZn38Sn1	2.0530	CuZn38Sn1						C46400
	CW614N	CuZn39Pb3	2.0401	CuZn39Pb3	CuZn39Pb3	CZ121			5170	C38500
	CW612N	CuZn40Pb2	2.0402	CuZn40Pb2	CuZn39Pb2	CZ120			5168	C37800
	CW622N	CuZn44Pb2	2.0410	CuZn44Pb2		CZ104			5272	C68700

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Div. Marken	Ausführung	Struktur
	A48 25 B	Sc 15	422 415			Grauguss (GCI)
	A48 30 B	Sc 20	422 420			Grauguss (GCI)
	A48 35 B	Sc 25	422 425			Grauguss (GCI)
	A48 50 B	Sc 35				Grauguss (GCI)
	G 3500					Grauguss (GCI)
	Grade 350					Vermikularguss (CGI)
	Grade 400					Vermikularguss (CGI)
	Grade 400-15					Vermikularguss (CGI)
	Grade 450					Vermikularguss (CGI)
	Grade 500					Vermikularguss (CGI)
	A220 60004				geglüht	Temperguss (MCI)
						Sphäroguss (SGI)
FGE 38-17	60-40-18	Vc 42-12	422 304			Sphäroguss (SGI)
	60-40-18	Vc 42-12				Sphäroguss (SGI)
FGE 50-7	A536 80-55-06	Vc 50-2	422 305			Sphäroguss (SGI)
FGE 60-2	A476 80-60-03	Vc 60-2	422 306			Sphäroguss (SGI)
FGE 70-2	A536 100-70-03	Vc 70-2				Sphäroguss (SGI)
	1600/1300					wärmebehandelter Kugelgrafitguss (ADI)
	1050/700/7					wärmebehandelter Kugelgrafitguss (ADI)
	1200/850/4					wärmebehandelter Kugelgrafitguss (ADI)
	1400/1100/1					wärmebehandelter Kugelgrafitguss (ADI)
	850/550/10					wärmebehandelter Kugelgrafitguss (ADI)
	A436 Type 2			Ni-Resist 2		austenitischer Guss mit Lamellengrafit
	A436 Type 3			Ni-Resist 3		austenitischer Guss mit Lamellengrafit
	A436 Type 1			Ni-Resist 1		austenitischer Guss mit Lamellengrafit
				Nodumag		austenitischer Sphäroguss
	A436 Type D-2			Ni-Resist D-2		austenitischer Sphäroguss
	A439 Type D-2M			Ni-Resist D-2M		austenitischer Sphäroguss
	A436 Type D-3			Ni-Resist D-3		austenitischer Sphäroguss
	A439 Type D-5			Ni-Resist D-5		austenitischer Sphäroguss
	B26					
	A380					
	AZ61A					
	AZ80A					
	AMS 4442					
	B85					
	A413.2					
	B390.0					
	CA952	BrA9ZH3L				
	CA955	BrA10ZH4N4L				
	CA937					
		BrOF6.5-0.15				
		L90				
		LOMsh70-1-0.05				
		LO60-1				
		LAMsh77-2-0.05				

SMG	EN	EN-Nr	W.-Nr	DIN	AFNOR	BS	UNI	JIS	SS	UNS
S1										
S2										
S3	NiMo30		2.4810							N10002
	NiMo16Cr15W		2.4819							N10276
	NiCr19Fe19Nb5Mo3		2.4668							N07718
			2.4669							N07750
	NiCr20TiAl		2.4631							N07080
	NiCr19Co18Mo4Ti3Al3									N07500
	NiCr20Co13Mo4Ti3Al		2.4654							N07001
S11			3.7024							
										R54620
S12										R56320
	TiAl6V4		3.7164							R56400
S13				TiV10Fe2Al3						
H3	16 MnCr 5	1.7131	1.7131	16 MnCr 5	16 MC 5	527 M 17	16 MnCr 5	SCR 415	2511	G51170
H5	C 67S	1.1231	1.1231	Ck 67	XC 68	060 A 67	C 70		1770	G10700
	C 75S	1.1248	1.1248	Ck 75	XC 75	060 A 78	C 75		1774, 1778	G10780
	C 100S	1.1274	1.1274	Ck 101		060 A 96		SUP 4	1870	G10950
	C 105U	1.1545	1.1545	C 105 W1	Y1 105		C 100 KU		1880	
			1.2550	60 WCrV 7	55 WC 20		55 WCrV 8 KU			
	55 Cr 3	1.7176	1.7176	55 Cr 3	55 C 3	527 A 60	55 Cr 3	SUP 9 (A)	2253	G51550
	42 CrMo 4	1.7225	1.7225	42 CrMo 4	42 CD 4	708 M 40	42 CrMo 4	SCM 440 (H)	2244	G41400
H7	107 CrV 3	1.2210	1.2210	115 CrV 3	100 C 3		107 CrV 3 KU			T61202
			1.2510	100 MnCrW 4	90 MWCV 5	BO 1	95 MnWCr 5 KU	SKS 3	2140	T31501
	90 MnCrV 8	1.2842	1.2842	90 MnCrV 8	90 MV 8	BO 2	90 MnVCr 8 KU			T31502
	100 Cr 6	1.3505	1.3505	100 Cr 6	100 C 6	534 A 99	100 Cr 6	SUJ 2	2258	G51986
H8	X 40 CrMoV 5 1	1.2344	1.2344	X 40 CrMoV 5 1	Z 40 CDV 5	BH 13	X 40 CrMo 5 1 1 KU	SKD 61	2242	T20813
	X 100 CrMoV 5	1.2363	1.2363	X 100 CrMoV 5 1	Z 100 CDV 5	BA 2	X 100 CrMoV 5 1 KU	SKD 12	2260	T30102
	X 155 CrVMo 12 1		1.2379	X 155 CrVMo 12 1	Z 160 CDV 12	BD 2	X 155 CrVMo 12 1 KU	SKD 11		T30402
			1.2436	X 210 CrW 12			X 215 CrW 12 1 KU	SKD 2	2312	
			1.2601	X 165 CrMoV 12			X 165 CrMoW 12 KU		2310	
			1.2713	55 NiCrMoV 6	55 NCDV 7			SKT 4		T61206
	HS 6-5-2-5	1.3243	1.3243	S 6-5-2-5	Z 85 WDKCV 06-05-05-04-02		HS 6-5-2-5	SKH 55	2723	
	HS 2-10-1-8	1.3247	1.3247	S 2-10-1-8	Z 110 DKCWV 09-08-04	BM 42	HS 2-9-1-8	SKH 51		T11342
	HS 18-0-1	1.3355	1.3355	S 18-0-1	Z 80 WCV 18-04-01	BT 1	HS 18-0-1	SKH 2		T12001
H11	X 20 Cr 13	1.4021	1.4021	X 20 Cr 13	Z 20 C 13	420 S 37	X 20 Cr 13	SUS 420 J 1	2303	S42000
	X 70 CrMo 15	1.4109	1.4109	X 65 CrMo 14	Z 70 D 14			SUS 440 A		S44002
	X 90 CrMoV 18	1.4112	1.4112	X 90 CrMoV 18	Z 2 CND 18 05	409 S 19	X CrTi 12	SUS 440 B	2327	S44003
	X 105 CrMo 17	1.4125	1.4125	X 105 CrMo 17	Z 100 CD 17		X 105 CrMo 17	SUS 440 C		S44004
H12	X 4 CrNiCuNb 16 4	1.4540	1.4540	X 4 CrNiCuNb 16 4						S15500
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 5 CrNiCuNb 16 4	1.4542	1.4542	X 5 CrNiCuNb 16 4				SUS 630		S17400
	X 7 CrNiAl 17 7	1.4568	1.4568	X 7 CrNiAl 17 7	Z 9 CAN 17.7	301 S 81	X 7 CrNiAl 17 7	SUS 631	2388	S17700
	X 8 CrNiMoAl 15 7 5	1.4574	1.4574	X 8 CrNiMoAl 15 7 5						S15700
	X 6 NiCrTiMoV 25 15	1.4980	1.4943	X 4 NiCrTi 25 15	Z 6 NCTDV 25.15	HR 51		SUH 660	2570	S66286
	X 2 CrNiMoAl 18 8 5	1.6359	1.6359	X 2 CrNiMoAl 18 8 5		S 162				K92890
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMoTi 18 9 5	1.6358	1.6358	X 2 NiCoMoTi 18 9 5	Z 2 NKD 19-09					K93120
	X 2 NiCoMoTi 18 12 4	1.6356	1.6356	X 2 NiCoMoTi 18 12 4						K93160
H21	X 120 Mn 12	1.3401	1.3401	X 120 Mn 12	Z 120 M 12	BW 10		SC MnH 1	2183	
H31	EN-GJN-HV520	0.9620	0.9620	G-X330 NiCr 4 2	FB Ni4 Cr2 BC	Grade 2 A			05 12-00	F45001
	EN-GJN-HV550	0.9625	0.9625	G-X260 NiCr 4 2	FB Ni4 Cr2 HC	Grade 2 B			05 13-00	F45000
	EN-GJN-HV600(XCr11)	0.9630	0.9630	G-X300 CrNiSi 9 5 2	FB Cr9 Ni5	Grade 2 C, D, E			04 57-00	F45003

U.N.E./ I.H.A.	AISI / ASTM	GOST	ČSN	Div. Marken	Ausführung	Struktur
				Discalloy	ausscheidungsgehärtet	
				Haynes 25		
				Stellite 21		
				Hastelloy C		
		KHN65MV		Hastelloy C-276		
				IN 100		
				Inconel 718		
				Inconel -750	lösungsgeglüht	
				Nimonic 80A		
				René 41		
				Udimet 500		
				Waspalloy		
				Ti	technisch rein	Ti (α)
	AMS 4919			Ti 6-2-4-2	geglüht	Ti (α)
	AMS 4943			Ti 3Al-2.5V (grd 9)	geglüht	Ti (α+β)
	AMS 4920, Grd 5	VT6		Ti 6Al-4V	geglüht	Ti (α+β)
	AMS 4986			Ti 10V-2Fe-3Al	geglüht	Ti (β)
F.1516	5115	12KHN2	14 220		einsatzgehärtet	
F.5103	1070	70			vergütet	
F.5107	1078, 1080	75			vergütet	
F.5117	1095				vergütet	
F.5118	W1	U10A			vergütet	
	S1	5KHV2SF			vergütet	
	5155				vergütet	
F.1252	4142, 4140	38HM	15 142		vergütet	
F.520L	L2	11KHF			vergütet	
F.5220	O1	9KHVG			vergütet	
	O2	9G2F			vergütet	
F.5230	52100	SHKH15	14 109		vergütet	
F.5318	H13	4KH5MF1S			vergütet	
F.5227	A2	9KH5VF			vergütet	
F.5211	D2	KH12MF			vergütet	
F.5213		KH12			vergütet	
		KH12MF			vergütet	
F.520.S	L6	5KHNM			vergütet	
F.5613	M35	R6M5K5			vergütet	
	M42	R2AM9K5			vergütet	
	T1	R18			vergütet	
F.5261	420	20KH13	17 022		vergütet	martensitisch
	440 A				vergütet	martensitisch
	440 B	95KH18			vergütet	martensitisch
	440 C	95KH18			vergütet	martensitisch
	XM-12			15-5-PH	ausscheidungsgehärtet H900	martensitisch
	IN 630			17-4-PH	ausscheidungsgehärtet H1025	martensitisch
	IN 630			17-4-PH	ausscheidungsgehärtet H900	martensitisch
	AMS 5528	09KH17N7YU1		17-7-PH	ausscheidungsgehärtet TH1050	martensitisch
	632			PH 15-7 Mo	ausscheidungsgehärtet TH1050	martensitisch
	660			A286	ausscheidungsgehärtet	austenitisch
	AMS 6512			Marage 250	ausscheidungsgehärtet	martensitisch
	AMS 6521			Marage 300	ausscheidungsgehärtet	martensitisch
	AMS 6521			Marage 300	ausscheidungsgehärtet	martensitisch
	AMS 6515			Marage 350	ausscheidungsgehärtet	martensitisch
	A128 Grade A			Hadfield		
	A532 IB (NiCr-LC			Ni-Hard 2		Weißhartguss
	A532 IA (NiCr-HC)			Ni-Hard 1		Weißhartguss
	A532 ID (Ni-HiCr)			Ni-Hard 4		Weißhartguss

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