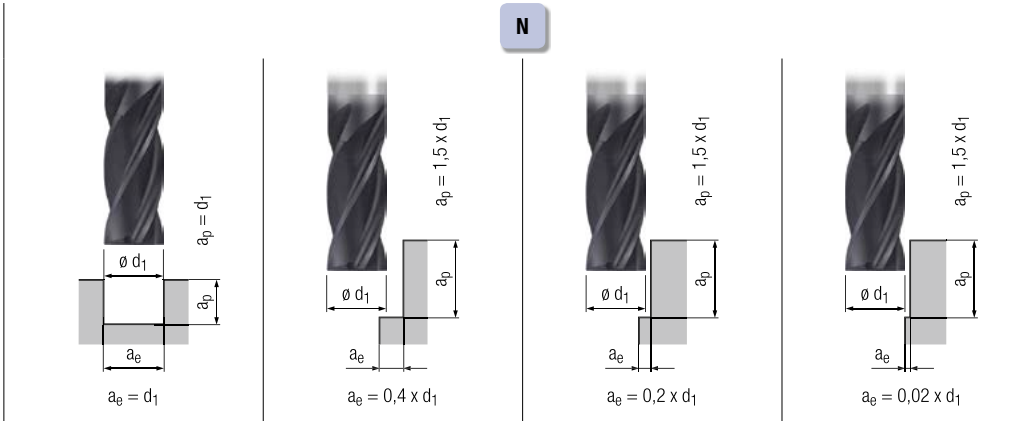


Schnittwerte Hartmetall-Schafffräser

Lange Ausführung



Gültig für

RG24-57L
RG24-39L

		Vc [m/min]		fz [mm]		Vc [m/min]		fz [mm]				MMS	
P	1.1	140	$0,005 \times d_1$	150	$0,005 \times d_1$	170	$0,006 \times d_1$	200	$0,007 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.1	130	$0,004 \times d_1$	140	$0,005 \times d_1$	160	$0,005 \times d_1$	180	$0,006 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	3.1	110	$0,004 \times d_1$	120	$0,004 \times d_1$	130	$0,005 \times d_1$	150	$0,005 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	4.1	100	$0,003 \times d_1$	110	$0,003 \times d_1$	120	$0,004 \times d_1$	140	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	5.1	90	$0,003 \times d_1$	100	$0,003 \times d_1$	110	$0,003 \times d_1$	130	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
M	1.1	70	$0,003 \times d_1$	80	$0,003 \times d_1$	80	$0,004 \times d_1$	100	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.1	60	$0,003 \times d_1$	70	$0,003 \times d_1$	70	$0,004 \times d_1$	80	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	3.1	40	$0,002 \times d_1$	40	$0,003 \times d_1$	50	$0,003 \times d_1$	60	$0,003 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	4.1	30	$0,002 \times d_1$	30	$0,003 \times d_1$	40	$0,003 \times d_1$	40	$0,003 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
K	1.1	140	$0,005 \times d_1$	150	$0,006 \times d_1$	170	$0,006 \times d_1$	200	$0,007 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	1.2	140	$0,005 \times d_1$	150	$0,006 \times d_1$	170	$0,006 \times d_1$	200	$0,007 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	2.1	130	$0,004 \times d_1$	140	$0,005 \times d_1$	160	$0,005 \times d_1$	180	$0,006 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	2.2	130	$0,004 \times d_1$	140	$0,005 \times d_1$	160	$0,005 \times d_1$	180	$0,006 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	3.1	110	$0,004 \times d_1$	120	$0,005 \times d_1$	130	$0,005 \times d_1$	150	$0,006 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	3.2	110	$0,004 \times d_1$	120	$0,005 \times d_1$	130	$0,005 \times d_1$	150	$0,006 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	4.1	90	$0,003 \times d_1$	100	$0,003 \times d_1$	110	$0,004 \times d_1$	130	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	4.2	70	$0,003 \times d_1$	80	$0,003 \times d_1$	80	$0,004 \times d_1$	100	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
N	1.1	220	$0,009 \times d_1$	250	$0,010 \times d_1$	280	$0,011 \times d_1$	300	$0,013 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	1.2	220	$0,008 \times d_1$	250	$0,009 \times d_1$	280	$0,010 \times d_1$	300	$0,011 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	1.3	220	$0,007 \times d_1$	250	$0,008 \times d_1$	280	$0,009 \times d_1$	300	$0,010 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	1.4	200	$0,008 \times d_1$	250	$0,009 \times d_1$	280	$0,010 \times d_1$	300	$0,011 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	1.5												
	1.6												
	2.1	130	$0,005 \times d_1$	140	$0,006 \times d_1$	160	$0,006 \times d_1$	180	$0,007 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.2	130	$0,005 \times d_1$	140	$0,006 \times d_1$	160	$0,006 \times d_1$	180	$0,007 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.3	130	$0,005 \times d_1$	140	$0,006 \times d_1$	160	$0,006 \times d_1$	180	$0,007 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.4	120	$0,004 \times d_1$	130	$0,005 \times d_1$	140	$0,005 \times d_1$	170	$0,006 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.5	120	$0,004 \times d_1$	130	$0,005 \times d_1$	140	$0,005 \times d_1$	170	$0,006 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.6	120	$0,004 \times d_1$	130	$0,005 \times d_1$	140	$0,005 \times d_1$	170	$0,006 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.7	70	$0,003 \times d_1$	80	$0,003 \times d_1$	80	$0,004 \times d_1$	100	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.8	70	$0,003 \times d_1$	80	$0,003 \times d_1$	80	$0,004 \times d_1$	100	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	3.1	290	$0,009 \times d_1$	320	$0,010 \times d_1$	350	$0,011 \times d_1$	410	$0,013 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	3.2	290	$0,007 \times d_1$	320	$0,008 \times d_1$	350	$0,009 \times d_1$	410	$0,010 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
4.1	290	$0,008 \times d_1$	320	$0,009 \times d_1$	350	$0,009 \times d_1$	410	$0,011 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
4.2	430	$0,008 \times d_1$	470	$0,009 \times d_1$	520	$0,009 \times d_1$	600	$0,011 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>	
4.3													
4.4													
5.1													
5.2	70	$0,003 \times d_1$	80	$0,003 \times d_1$	80	$0,004 \times d_1$	100	$0,004 \times d_1$				<input checked="" type="checkbox"/>	
5.3													
S	1.1	70	$0,004 \times d_1$	80	$0,004 \times d_1$	80	$0,004 \times d_1$	100	$0,005 \times d_1$				<input checked="" type="checkbox"/>
	1.2	60	$0,003 \times d_1$	70	$0,003 \times d_1$	70	$0,004 \times d_1$	80	$0,004 \times d_1$				<input checked="" type="checkbox"/>
	1.3	40	$0,003 \times d_1$	40	$0,003 \times d_1$	50	$0,003 \times d_1$	60	$0,004 \times d_1$				<input checked="" type="checkbox"/>
	2.1	60	$0,002 \times d_1$	70	$0,002 \times d_1$	70	$0,003 \times d_1$	80	$0,003 \times d_1$				<input checked="" type="checkbox"/>
	2.2	20	$0,002 \times d_1$	20	$0,002 \times d_1$	15	$0,003 \times d_1$	30	$0,003 \times d_1$				<input checked="" type="checkbox"/>
	2.3	20	$0,002 \times d_1$	25	$0,002 \times d_1$	25	$0,003 \times d_1$	30	$0,003 \times d_1$				<input checked="" type="checkbox"/>
	2.4	20	$0,002 \times d_1$	25	$0,002 \times d_1$	25	$0,003 \times d_1$	30	$0,003 \times d_1$				<input checked="" type="checkbox"/>
2.5	20	$0,002 \times d_1$	20	$0,002 \times d_1$	20	$0,003 \times d_1$	30	$0,003 \times d_1$				<input checked="" type="checkbox"/>	
2.6	20	$0,002 \times d_1$	20	$0,002 \times d_1$	20	$0,003 \times d_1$	30	$0,003 \times d_1$				<input checked="" type="checkbox"/>	
H	1.1	90	$0,003 \times d_1$	100	$0,003 \times d_1$	110	$0,003 \times d_1$	130	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	1.2	70	$0,003 \times d_1$	80	$0,003 \times d_1$	80	$0,003 \times d_1$	100	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	1.3			70	$0,003 \times d_1$	70	$0,003 \times d_1$	80	$0,003 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	1.4												
	1.5												