

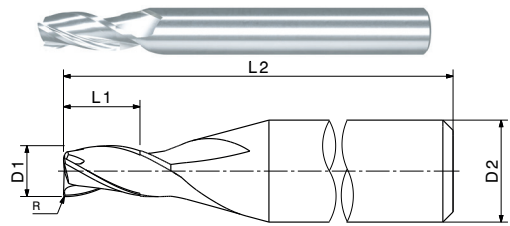
MI0112-SR04105

Keramik Mikrofräser
Ceramic micro end mill



K1 N1 N2

N3 N4 N5 N6 N7 N8



D1 ±0.01	L1	D2	L2	R	Z	CER Art. N°
1.00	2.00	3	39	0.03	3	443856
1.50	3.00	3	39	0.04	3	443857
2.00	4.00	3	39	0.05	3	443858
3.00	6.00	5	39	0.08	3	443859
4.00	8.00	5	51	0.10	3	443860
5.00	10.00	6	51	0.13	3	443861
6.00	12.00	6	51	0.15	3	443862

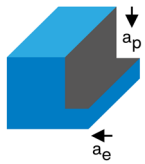
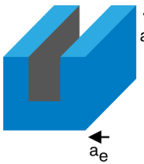
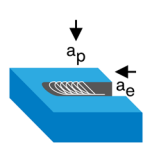
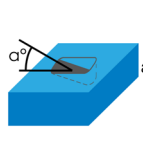
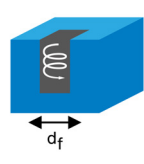


D1 ±0.01	L1	D2	L2	R	Z	CER Art. N°
0.50	0.75	3	39	0.02	3	443850
0.80	1.20	3	39	0.02	3	443851
1.00	1.50	3	39	0.03	3	443852
1.50	2.25	3	39	0.04	3	443853
2.00	3.00	3	39	0.05	3	443854
3.00	4.50	5	51	0.08	3	443855

Weitere Beschichtungen oder kundenspezifische Lösungen auf Anfrage
Other coatings or customized solutions are available on request

MI0112-SR04105

Schnittparameter
Cutting parameters

Anwendung Application	Eckfräsen Side Milling	Nutenfräsen Slotting	Trochoidalfräsen Trochoidal milling	Rampenfräsen Diagonal plunging	Helixinterpolation Helical interpolation
Funktion Function					
	a_p	a_p	a_p	Angle	Angle
	$\leq 1 \times D_1$	$\leq 0.5 \times D_1$	$\leq 1.5 \times D_1$	8°	8°
	a_e	a_e	a_e	a_p	D_f
	$\leq 0.15 \times D_1$	$1 \times D_1$	$\leq 0.1 \times D_1$	$\leq 1 \times D_1$	$\leq 1 \times D_1$
	V_c	V_c	V_c	f_z	f_z
	$\times 1$	$\times 0.7$	$\times 1.2$	$\times 0.7$	$\times 0.7$
	f_z	f_z	f_z		
	$\times 1$	$\times 0.6$	$\times 1.2$		

		f_z [mm]			
ISO	V_c [m/min]	$\varnothing 0.30 - 0.80$	$\varnothing 0.90 - 1.20$	$\varnothing 1.30 - 2.90$	$\varnothing 3.00 - 6.00$
P1					
P2					
P3					
P4					
P5					
M1					
M2					
M3					
K1	90 - 120	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N1	220 - 270	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N2	220 - 270	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N3	160 - 200	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N4	160 - 200	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N5	160 - 200	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N6	160 - 200	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N7	160 - 200	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
N8	250 - 300	0.004 - 0.009	0.008 - 0.025	0.020 - 0.040	0.030 - 0.060
S1					
S2					
S3					
H1					
H2					

Richtwerte
Indicative values