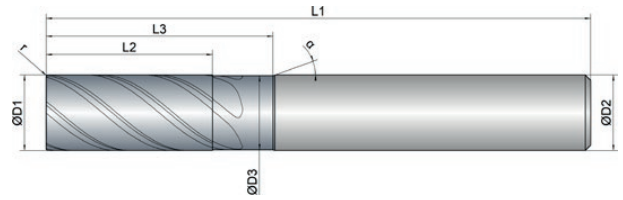


|              |                     |
|--------------|---------------------|
| Kühlung      |                     |
| Toleranz     | e8                  |
| Beschichtung | AlphaFerro Platin X |

|               |            |            |  |
|---------------|------------|------------|--|
| Strategie     | <b>ETC</b> | <b>HPC</b> |  |
| Anwendung     |            |            |  |
| Eigenschaften | <b>HA</b>  | <b>≠</b>   |  |



- Ungleichteilung und variable Spiralsteigung für ruhigen Lauf
  - Definierte Schneidkantenengeometrie für Stabilisierung bei hohen Zustellungen
  - Verstärkter Werkzeugkern für hohe Bruchfestigkeit
- 
- Zum Schruppen und Schlichten



**Schruppen**









**Schlichten**



| EXPK1-M01-0223 | D1<br><br>mm<br>∅ | D3<br><br>mm<br>∅ | L2<br><br>mm | L3<br><br>mm | L1<br><br>mm | D2<br><br>mm<br>∅ | z<br><br># | r<br><br>mm | <br>° | α<br><br>° |
|----------------|-------------------|-------------------|--------------|--------------|--------------|-------------------|------------|-------------|-------|------------|
| 6              | 6,0               | 5,8               | 13,0         | 19,0         | 57,0         | 6,0               | 5          | 0,15        | 40    | 20         |
| 8              | 8,0               | 7,8               | 19,0         | 25,0         | 63,0         | 8,0               | 5          | 0,20        | 40    | 20         |
| 10             | 10,0              | 9,8               | 22,0         | 30,0         | 72,0         | 10,0              | 5          | 0,20        | 40    | 20         |
| 12             | 12,0              | 11,8              | 26,0         | 36,0         | 83,0         | 12,0              | 5          | 0,20        | 40    | 20         |
| 16             | 16,0              | 15,8              | 32,0         | 42,0         | 92,0         | 16,0              | 5          | 0,30        | 40    | 20         |
| 20             | 20,0              | 19,8              | 41,0         | 52,0         | 104,0        | 20,0              | 5          | 0,30        | 40    | 20         |



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| Dimension    | Ø6  | Ø8  | Ø10   | Ø12   | Ø16   | Ø20  |  |  |  |  |  |  |
|--------------|---|---|---|---|---|--|--|--|--|--|--|--|
| Infeed in mm | ae=0,3xD<br>ap=2xD  | ae=0,3xD<br>ap=2xD  | ae=0,3xD<br>ap=2xD  | ae=0,3xD<br>ap=2xD  | ae=0,3xD<br>ap=2xD  | ae=0,3xD<br>ap=2xD   |  |  |  |  |  |  |
| Application  |  |  |  |  |  |  |  |  |  |  |  |  |

| Material   | Strength (N/mm <sup>2</sup> ) | Feed (mm/Z) | fz  | fz    | fz    | fz    | fz    | fz    | fz   |
|------------|-------------------------------|-------------|-----|-------|-------|-------|-------|-------|------|
| <b>P</b>   |                               |             |     |       |       |       |       |       |      |
| Vc (m/min) |                               |             |     |       |       |       |       |       |      |
| 1.1        | Steel, unalloyed              | <500        | 240 | 0,045 | 0,06  | 0,07  | 0,08  | 0,09  | 0,11 |
| 1.2-1.5    | Steel, unalloyed              | <1100       | 200 | 0,04  | 0,055 | 0,065 | 0,075 | 0,085 | 0,1  |
| 2.1-2.2    | Steel, low-alloyed            | <950        | 190 | 0,04  | 0,055 | 0,065 | 0,075 | 0,085 | 0,1  |
| 2.3-2.4    | Steel, low-alloyed            | <1300       | 160 | 0,035 | 0,05  | 0,06  | 0,07  | 0,08  | 0,09 |
| 3.1-3.2    | Steel, high-alloyed           | <1100       | 180 | 0,035 | 0,05  | 0,06  | 0,07  | 0,08  | 0,09 |
| 3.3        | Steel, high-alloyed           | <1400       | 150 | 0,032 | 0,046 | 0,055 | 0,065 | 0,07  | 0,08 |
| <b>K</b>   |                               |             |     |       |       |       |       |       |      |
| Vc (m/min) |                               |             |     |       |       |       |       |       |      |
| 1.1-1.2    | Grey cast iron                | <1000       | 220 | 0,04  | 0,055 | 0,065 | 0,075 | 0,085 | 0,1  |
| 2.1-2.2    | Modular cast iron             | <850        | 180 | 0,035 | 0,05  | 0,06  | 0,07  | 0,08  | 0,09 |
| 3.1-3.2    | Malleable cast iron           | <800        | 160 | 0,035 | 0,05  | 0,06  | 0,07  | 0,08  | 0,09 |
| <b>M</b>   |                               |             |     |       |       |       |       |       |      |
| Vc (m/min) |                               |             |     |       |       |       |       |       |      |
| 1.1        | Inox, ferritic/martensitic    | <850        | 90  | 0,04  | 0,055 | 0,065 | 0,075 | 0,08  | 0,1  |
| 2.1        | Inox, austenitic              | <650        | 75  | 0,035 | 0,05  | 0,06  | 0,07  | 0,075 | 0,09 |
| 2.2        | Inox, austenitic              | <750        | 70  | 0,032 | 0,048 | 0,055 | 0,065 | 0,07  | 0,08 |
| 3.1        | Duplex steel                  | <1100       |     |       |       |       |       |       |      |

**NOTIZ** | Die in Türkis markierten Werte sind Nebenwendungen!