DORMER PRAMET

VALSET FRÆSNING

2024

PRAMET

VALSET FRÆSNING – GENERELT INDHOLD

VALSET FRÆSNING

Planfræsning		Negative skær	SON06C 16 APMX 4	SHN06C 12 APMX 3	SHN09C 12 APMX 5	SPN13 10 APMX 10			7
		Positive firkantede skær	SSD13F 4 APMX 6.4	SSE09 4 APMX 4.5	SSN12Z 4 APMX 6.5	FSB22X 4 APMX 15			25
		Positive ottekantede og runde skær	SOD05 8 APMX 2.7	SOD06D 8 APMX 3.1	SOE06Z 8 APMX 3.3				41
Hjørnefræsning		Negative skær	STN10 6 APMX 5	STN16 6 APMX 10	SLN12 4 APMX 9	SLN16 4 APMX 13	SLN12X 04 APMX 10		65
		Positive parallelogramskær (A-form)	SAD07D 2 APMX 5	SAD11E 2 APMX 9	SAD16E 2 APMX 13	SAP10D 2 APMX 9	SAP16D 2 APMX 13		89
		Positive firkantede og trekantede skær	SSO09 4 APMX 8	SSD12 4 APMX 12	FTB27X 3 APMX 18				121
Dyb hjørnefræsning		Spiralformede fræsere	J(T)-SAD11E	J(T)-SAD16E	J(T)-SSAP	J(T)-CSD12X	J(T)-SLSN		133
Kopifræsning (knapfræsere)		Rundt indsatssæde (RD.. indsatse med 15° flanke)	SRD05 a_p 1.5	SRD07 a_p 2	SRD10 a_p 2.5	SRD12 a_p 3	SRD16 a_p 4		159
		Sæde med positioneringsflader (RC.. indsatse med 7° flanke)	SRC10 8 a_p 1.46	SRC12 6 a_p 3	SRC16 8 a_p 2.3	SRC20 8 a_p 2.9			185
Profilfræsning		Kugleformet	L2-SZP	K2-SRC	K2-SLC	K2-PPH	K3-CXP		205
		Radius	SVC22C 2 APMX 16	SCN05C 4 APMX 0.5	SWN04 6 APMX 0.5				239
Fræsning med høj tiispændning		Negative skær	SBN10 4 APMX 1	SSN11 8 APMX 1.7					251
		Positive skær	SSO12 4 APMX 1.9	SPD09 5 APMX 2	SZD07 4 APMX 1	SZD09 4 APMX 1			265
Affasning		Positive skær	SSD09 4 APMX 4.5	N-SSO09 4 APMX 4.5	STC 3 APMX 8.5	2516 3 APMX 8.5	2636 3 APMX 8.5	J(T)-SXP16	291
Fræsning af spor		Skive – og T-notfræsere	S90SN	S90CN (XN)	F-SCC				313
Andre fræseindsatser									330

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Materialegrupper til arbejdsemner (WMG)		376

PRODUCT FAMILY	🕮
2	
2516	301
2636	304
F	
FSB22X	38
F-SCC	325
FTB27X	128
J(T)	
J(T)-CSD12X	150
J(T)-SAD11E	134
J(T)-SAD16E	139
J(T)-SLSN	153
J(T)-SSAP	145
J(T)-SXP16	307
K2	
K2-PPH	222
K2-SLC	218
K2-SRC	211
K3-CXP	234
L2	
L2-SZP	206
N	
N-SS009	295

PRODUCT FAMILY	🕮
S90	
S90CN(XN)	320
S90SN	314
SAD	
SAD07D	90
SAD11E	97
SAD16E	106
SAP	
SAP10D	114
SAP16D	117
SBN	
SBN10	252
SCN	
SCN05C	243
SHN	
SHN06C	13
SHN09C	17
SLN	
SLN12	75
SLN12X	85
SLN16	81
SOD	
SOD05	42
SOD06D	51

PRODUCT FAMILY	🕮
SOE	
SOE06Z	55
SON	
SON06C	8
SPD	
SPD09	270
SPN	
SPN13	21
SRC	
SRC10	186
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SRC16	194
SRC20	198
SRD	
SRD05	160
SRD07	163
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SRD12	174
SRD16	180
SSD	
SSD09	292
SSD12	125
SSD13F	26

PRODUCT FAMILY	🕮
SSE	
SSE09	31
SSN	
SSN11	258
SSN12Z	35
SSO	
SSO09	122
SSO12	266
STC	
STC	298
STN	
STN10	66
STN16	70
SVC	
SVC22C	240
SWN	
SWN04C	246
SZD	
SZD07	276
SZD09	280
SZD12	284

PRODUCT FAMILY	
A	
ADEX 07-FA	92
ADEX 07-HF	93
ADEX 11-FA	101
ADEX 11-FA	137
ADEX 11-HF	101
ADEX 16	109
ADEX 16	142
ADEX 16-FA	109
ADEX 16-FA	142
ADEX 16-HF	110
ADKT 15	330
ADKX 15	330
ADMX 07	91
ADMX 11	99
ADMX 11	135
ADMX 16	107
ADMX 16	140
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ODKT 05IM	43
ODMT 05	333
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OEHT 06	56
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OFKR 07	334
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P	
PDKT 09	272
PDKX 09	272
PDMW 09	273
PDMX 09	271
PNMQ 13	22
PNMU 13	22
PPH	224
PPHF	226
PPHT	225
R	
RC	212
RCMT 10	187
RCMT 12	191
RCMT 16	195
RCMT 20	199
RDET	334
RDGT 07	164
RDGT 10	169
RDGT 12	175
RDGT 12IM	44
RDGT 16	181
RDHT 07-FA	165
RDHT 10-FA	171
RDHT 12-FA	177
RDHT 16-FA	182
RDHX 05	161
RDHX 07	164
RDHX 10	170
RDHX 12	176
RDHX 16	182
RDHX 20	335
RDMT 10	169
RDMT 12	175
RDMT 12IM	45
RDMX 10	170
RDMX 12	176
RDMX 16	181
REHT 16	57
RPET 12	335
RPET 15	53
RPEW 12	336
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S	
SBKX 22	39
SBMR 22	39
SDET 13	27
SDEW 09	293
SDEX 09	293
SDGX 12	151
SDKT 12IM	45
SDMT 12	126
SDMT 12IM	46
SDMT 13	28
SDMX 12	151
SEEN	337
SEER	338
SEET 09	33
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SEEW 12	340
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SNGX 11	259
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SNHF	341
SNHN	341
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SNHQ TRL	317
SNKT 12	36
SNMT 12	36
SNMX 17	10
SNUN	342
SOHT 12	267
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SPET 12	147
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T	
TBMR 27	129
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TCMT	305
TCXT 16 STC	299
TNGX 10	67
TNGX 10-FA	68
TNGX 16	71
TNGX 16-FA	72
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TPKN	347
TPKR	348
TPUN	348
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XDHW	349
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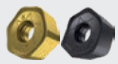
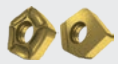
XPHT 16-FA	308
Z	
ZDCW 07	277
ZDCW 09	281
ZDEW 12	285
ZP	208

PLANFRÆSNING

FACE MILLING

	SON06C	SHN06C	SHN09C	SPN13		
	43°	45°	45°	57°		
	APMX (mm) 4.0 (7.0)	APMX (mm) 3.0	APMX (mm) 5.0	APMX (mm) 10.0		
	DC (mm) 50 – 250	DC (mm) 25 – 125	DC (mm) 50 – 315	DC (mm) 100 – 315		
Cylindrical shank						
Weldon		DC = 25, 32 (mm)				
Modular						
Shell mill		DC = 40 – 125 (mm)				
Page	8	13	17	21		
ISO	P M K S H	P M K H	P M K H	P M K S H		
Insert shape						
Inserts	ONMX 0605 SNMX 1705	HNGX 0604 XNGX 0604	HNGX 0906 XNGX 0906	PNM. 1308 XN.. 1308		
No. of cutting edges	16 / 8	12 / 1	12 / 1	10 / 1		
Face milling	■	■	■	■		
Chamfer milling	■	■	■			
Progressive plunging		■	■			
Ramping	◪	■	■			

■ Primary use ◪ Possible use

SON06C

P M K S H

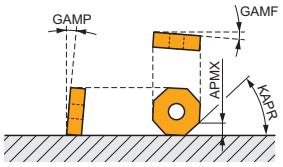
PRAMET

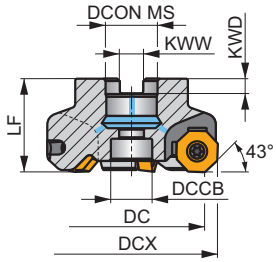
S

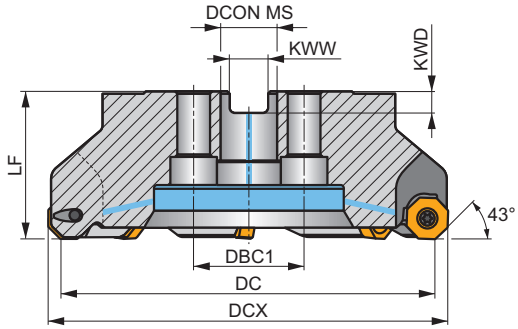
ECON ON06 43° Planfræser med dobbelt negativt design og intern kølevæske

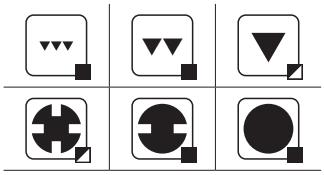
Meget økonomisk og produktiv planfræser, der anvender to typer dobbeltsidet negativØkonomiske ottekantede ON..06 skær med 16 skær og APMX på 4 mm og produktiv firkantet SN..17 skær med 8 skærekanter og APMX på 7Dorn-model fås med differentiel tandstigning.Behandlet for længere værktøjslevetid.

KAPR	43°
APMX	4.0 (7.0) mm

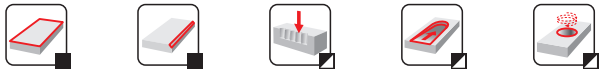








h_m 0.04 - 0.25



	Product	DC (mm)	DCX (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
	50A04R-S45ON06-C	50	60.8	22	16.5	–	40	10.4	6.3	-10	-5	4	✓	9400	✓	0.42	GI342	C0621	–
	50A05R-S45ON06-C	50	60.8	22	16.5	–	40	10.4	6.3	-10	-5	5	–	9400	✓	0.39	GI342	C0621	–
	63A05R-S45ON06-C	63	73.8	22	18.1	–	40	10.4	6.3	-10	-5	5	✓	8400	✓	0.71	GI342	C0621	–
	63A06R-S45ON06-C	63	73.8	22	18.1	–	40	10.4	6.3	-10	-5	6	✓	8400	✓	0.55	GI342	C0621	–
	80A06R-S45ON06-C	80	90.8	27	22.1	–	50	12.4	7	-10	-5	6	✓	7500	✓	1.27	GI342	C0622	–
	80A08R-S45ON06-C	80	90.8	27	22.1	–	50	12.4	7	-10	-5	8	–	7500	✓	1.19	GI342	C0622	–
	100A08R-S45ON06-C	100	110.8	32	30.1	–	50	14.4	8	-10	-5	8	✓	6700	✓	1.88	GI342	C0620	AC002
	100A10R-S45ON06-C	100	110.8	32	30.1	–	50	14.4	8	-10	-5	10	–	6700	✓	1.81	GI342	C0620	AC002
ISO 6462 DIN 8030	**125A08R-S45ON06-C**	125	135.8	40	56.1	–	63	16.4	9	-10	-5	8	✓	6000	✓	3.80	GI342	C0620	AC003
	125A10R-S45ON06-C	125	135.8	40	56.1	–	63	16.4	9	-10	-5	10	✓	6000	✓	3.65	GI342	C0620	AC003
	125A12R-S45ON06-C	125	135.8	40	56.1	–	63	16.4	9	-11	-5	12	–	6000	✓	3.70	GI342	C0620	AC003
	160C08R-S45ON06-C	160	170.8	40	–	66.7	63	16.4	9.25	-10	-5	8	✓	5700	✓	6.48	GI342	C0623	–
	160C12R-S45ON06-C	160	170.8	40	–	66.7	63	16.4	9.25	-10	-5	12	✓	5700	✓	5.74	GI342	C0623	–
	160C14R-S45ON06-C	160	170.8	40	–	66.7	63	16.4	9.25	-11	-5	14	–	5700	✓	5.65	GI342	C0623	–
	200C12R-S45ON06-C	200	210.8	60	–	101.6	63	25.8	14.25	-10	-5	12	✓	4700	✓	9.06	GI342	C0624	–
	200C16R-S45ON06-C	200	210.8	60	–	101.6	63	25.8	14.25	-10	-5	16	–	4700	✓	9.02	GI342	C0624	–
	250C14R-S45ON06-C	250	260.8	60	–	101.6	63	25.8	14.25	-10	-5	14	✓	4300	✓	15.71	GI342	C0625	–
	250C18R-S45ON06-C	250	260.8	60	–	101.6	63	25.8	14.25	-10	-5	18	–	4300	✓	15.51	GI342	C0625	–

GI342	ONMX 0605..	ONMX 0605..-W..	SNMX 1705..

C0620	US 45013A-T20P	5.0 Nm	M 5	13	SDR T20P-T	–	–	–	–

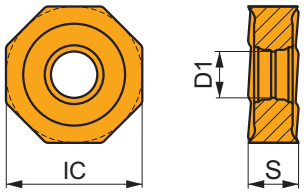
		Nm							
C0621	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1030C	–	–	–
C0622	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1230C	–	–	–
C0623	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1240C	CAC 160C	HSD 0825C	HXK 5
C0624	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1655C	CAC 200C	HSD 1025C	HXK 7
C0625	US 45013A-T20P	5.0	M 5	13	SDR T20P-T	HS 1655C	CAC 250C	HSD 1025C	HXK 7

AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

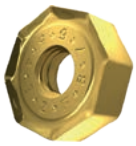
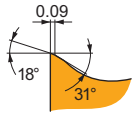
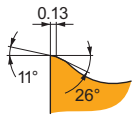
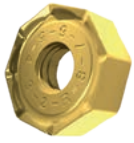
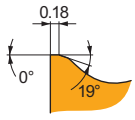
ONMX 06

PRAMET

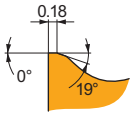
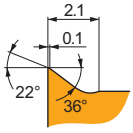
	IC (mm)	D1 (mm)	S (mm)
0605	17.000	5.70	7.08



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			**F** geometrien er skarp og bruges til efterbehandling, velegnet til store udhæng eller tyndvæggede og slanke emner.Designet med meget positiv vinkel, smal T-land og afrunding af skærkant til let bearbejdning.																	
ONMX 060508SR-F:8215	0.8	275	0.10	2.0	165	0.09	2.0	–	–	–	–	–	–	65	0.07	1.6	–	–	–
ONMX 060508SR-F:M6330	0.8	230	0.10	2.0	165	0.09	2.0	–	–	–	–	–	–	65	0.07	1.6	–	–	–
ONMX 060508SR-F:M8330	0.8	270	0.10	2.0	160	0.09	2.0	–	–	–	–	–	–	65	0.07	1.6	–	–	–
ONMX 060508SR-F:M8340	0.8	245	0.10	2.0	145	0.09	2.0	–	–	–	–	–	–	60	0.07	1.6	–	–	–
ONMX 060508SR-F:M9340	0.8	320	0.10	2.0	190	0.09	2.0	–	–	–	–	–	–	80	0.07	1.6	–	–	–
			**M** geometri er alsidig og førstevalg til en lang række arbejdsforhold.Designet med positiv vinkel, medium T-land og afrunding af skærkant til medium bearbejdning.																	
ONMX 060508SR-M:8215	0.8	230	0.20	2.0	135	0.18	2.0	–	–	–	–	–	–	55	0.14	1.6	45	0.14	1.0
ONMX 060508SR-M:M6330	0.8	195	0.20	2.0	140	0.18	2.0	–	–	–	–	–	–	55	0.14	1.6	–	–	–
ONMX 060508SR-M:M8330	0.8	230	0.20	2.0	135	0.18	2.0	–	–	–	–	–	–	55	0.14	1.6	45	0.14	1.0
ONMX 060508SR-M:M8340	0.8	210	0.20	2.0	125	0.18	2.0	–	–	–	–	–	–	50	0.14	1.6	–	–	–
ONMX 060508SR-M:M9325	0.8	285	0.20	2.0	–	–	–	–	–	–	–	–	–	–	–	–	55	0.14	1.0
ONMX 060508SR-M:M9340	0.8	255	0.20	2.0	150	0.18	2.0	–	–	–	–	–	–	60	0.14	1.6	–	–	–
			**R** geometrien er stærk og bruges til skrub og tunge arbejdsforhold.Designet med let positiv vinkel, bredt T-land og afrunding af skærkant til grov bearbejdning.																	
ONMX 060508SR-R:8215	0.8	210	0.30	2.0	–	–	–	195	0.30	2.0	–	–	–	–	–	–	40	0.21	1.0
ONMX 060508SR-R:M5315	0.8	255	0.30	2.0	–	–	–	240	0.30	2.0	–	–	–	–	–	–	50	0.21	1.0
ONMX 060508SR-R:M8330	0.8	210	0.30	2.0	–	–	–	195	0.30	2.0	–	–	–	–	–	–	40	0.21	1.0

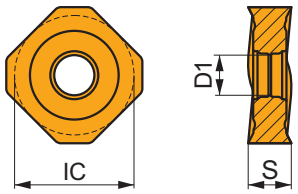
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
R geometrien er stærk og bruges til skrub og tunge arbejdsforhold.Designet med let positiv vinkel, bredt T-land og afrunding af skærkant til grov bearbejdning.																			
ONMX 060508SR-R:M8340	0.8	190	0.30	2.0	–	–	–	180	0.30	2.0	–	–	–	–	–	–	–	–	–
ONMX 060508SR-R:M9325	0.8	250	0.30	2.0	–	–	–	235	0.30	2.0	–	–	–	–	–	–	50	0.21	1.0
																			
W wiper design for forbedret overfladefinish ved bearbejdning med store fræsere og høj tilspændingshastighed.																			
ONMX 060508SR-W:8215	0.8	340	0.10	0.3	200	0.09	0.3	–	–	–	–	–	–	–	–	–	–	–	–
ONMX 060508SR-W:M8330	0.8	325	0.10	0.3	195	0.09	0.3	–	–	–	–	–	–	–	–	–	–	–	–

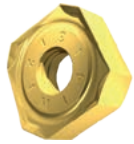
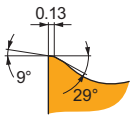
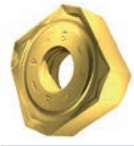
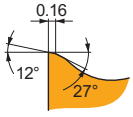
SNMX 17

PRAMET

	IC (mm)	D1 (mm)	S (mm)
1705	17.000	5.70	5.56

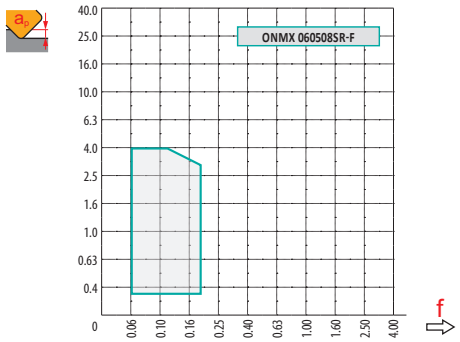


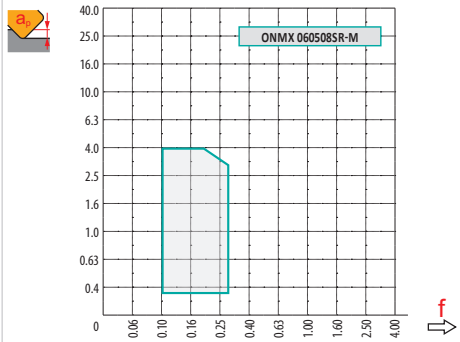
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

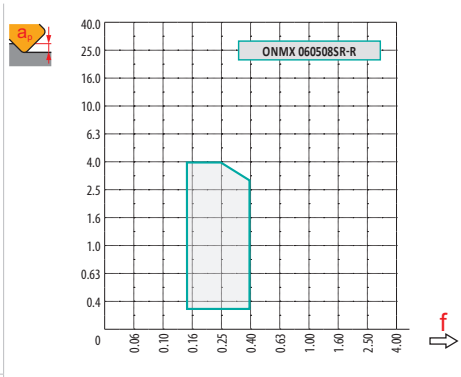
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																			
M geometri er alsidig og førstevalg til en lang række arbejdsforhold.Designet med positiv vinkel, medium T-land og afrunding af skærkant til medium bearbejdning.																			
SNMX 170508SR-M:8215	0.8	265	0.20	4.0	155	0.18	4.0	–	–	–	–	–	–	65	0.14	3.2	50	0.14	1.0
SNMX 170508SR-M:M6330	0.8	225	0.20	4.0	160	0.18	4.0	–	–	–	–	–	–	65	0.14	3.2	–	–	–
SNMX 170508SR-M:M8330	0.8	265	0.20	4.0	155	0.18	4.0	–	–	–	–	–	–	65	0.14	3.2	50	0.14	1.0
SNMX 170508SR-M:M8340	0.8	240	0.20	4.0	140	0.18	4.0	–	–	–	–	–	–	60	0.14	3.2	–	–	–
SNMX 170508SR-M:M9325	0.8	325	0.20	4.0	–	–	–	–	–	–	–	–	–	–	–	–	65	0.14	1.0
SNMX 170508SR-M:M9340	0.8	295	0.20	4.0	175	0.18	4.0	–	–	–	–	–	–	70	0.14	3.2	–	–	–
 																			
R geometrien er stærk og bruges til skrub og tunge arbejdsforhold.Designet med let positiv vinkel, bredt T-land og afrunding af skærkant til grov bearbejdning.																			
SNMX 170508SR-R:8215	0.8	240	0.30	4.0	–	–	–	225	0.30	4.0	–	–	–	–	–	–	45	0.21	1.0
SNMX 170508SR-R:M5315	0.8	300	0.30	4.0	–	–	–	285	0.30	4.0	–	–	–	–	–	–	60	0.21	1.0
SNMX 170508SR-R:M8330	0.8	240	0.30	4.0	–	–	–	225	0.30	4.0	–	–	–	–	–	–	45	0.21	1.0
SNMX 170508SR-R:M8340	0.8	220	0.30	4.0	–	–	–	205	0.30	4.0	–	–	–	–	–	–	–	–	–
SNMX 170508SR-R:M9325	0.8	290	0.30	4.0	–	–	–	275	0.30	4.0	–	–	–	–	–	–	55	0.21	1.0

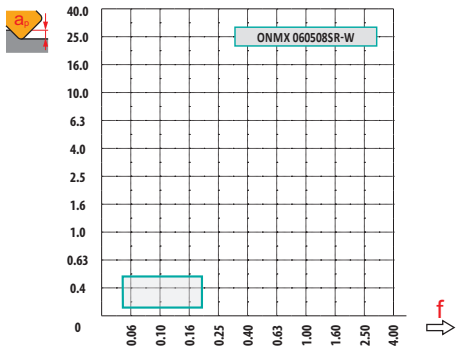
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

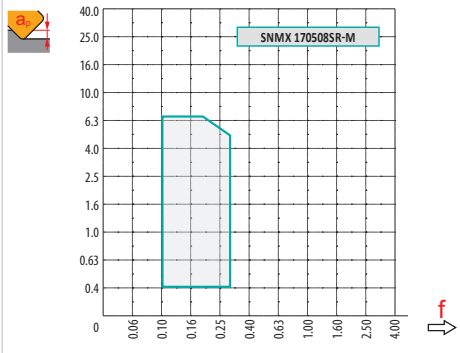
	ONMX 06-F	ONMX 06-M	ONMX 06-R	ONMX 06-W	SNMX 17-M	SNMX 17-R
RE	0.80	0.80	0.80	0.80	0.80	0.80
BS	0.75	0.75	0.75	4.30	0.70	0.70

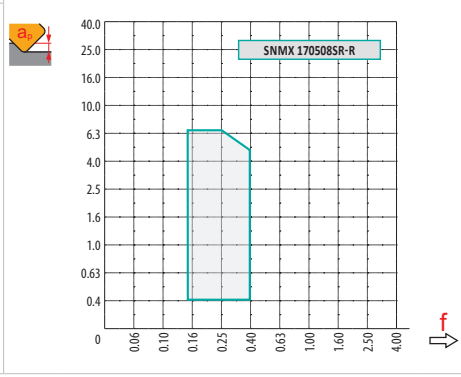










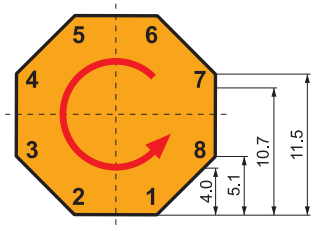


DC / a_p	0.50	1.00	1.50	2.00	2.50	3.00	3.50	4.00
50	51.06	52.11	53.19	54.27	55.35	56.43	57.51	58.59
63	64.06	65.11	66.19	67.27	68.35	69.43	70.51	71.59
80	81.06	82.11	83.19	84.27	85.35	86.43	87.51	88.59
100	101.06	102.11	103.19	104.27	105.35	106.43	107.51	108.59
125	126.06	127.11	128.19	129.27	130.35	131.43	132.51	133.59
160	161.06	162.11	163.19	164.27	165.35	166.43	167.51	168.59
200	201.06	202.11	203.19	204.27	205.35	206.43	207.51	208.59
250	251.06	252.11	253.19	254.27	255.35	256.43	257.51	258.59

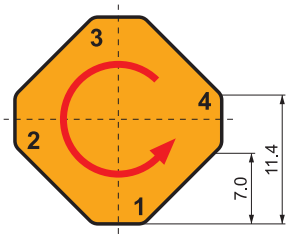
DC	a_p	0.00	1.00	2.00	3.00	4.00	5.00	6.00	7.00
		S							
50	DEF	47.24	49.40	51.56	53.73	55.90	58.06	60.23	62.40
63		60.24	62.40	64.56	66.73	68.90	71.06	73.23	75.40
80		77.24	79.40	81.56	83.73	85.90	88.06	90.23	92.40
100		97.24	99.40	101.56	103.73	105.90	108.06	110.23	112.40
125		122.24	124.40	126.56	128.73	130.90	133.06	135.23	137.40
160		157.24	159.40	161.56	163.73	165.90	168.06	170.23	172.40
200		197.24	199.40	201.56	203.73	205.90	208.06	210.23	212.40
250		247.24	249.40	251.56	253.73	255.90	258.06	260.23	262.40

DC	X.V	f_{max}
50	1.35	0.36
63	1.39	0.40
80	1.44	0.45
100	1.48	0.51
125	1.53	0.57
160	1.58	0.64
200	1.63	0.72
250	1.68	0.80

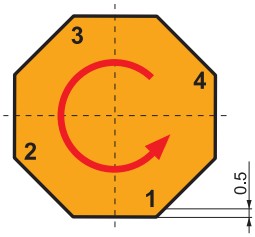
	O		S		
DC	RPMX	APMX/I	DC	RPMX	APMX/I
50	0.3	0.4/100	47.24	0.1	0.1/100
63	0.2	0.25/100	60.24	0.1	0.05/100
80	0.2	0.2/100	77.24	0.1	0.05/100
100	0.1	0.1/100			
125	0.1	0.05/100			



a_p	
-> 4.0	16
-> 5.1	14
-> 10.7	8
-> 11.5	6



a_p	
-> 7.0	8
-> 11.4	4



ONMX 06-W	
a_p	
-> 0.5	8

SHN06C

P M K H

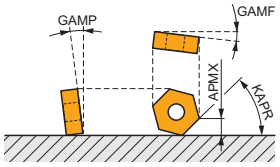
PRAMET

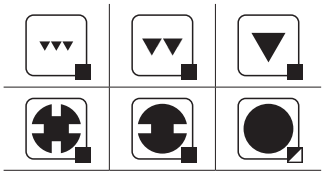
S

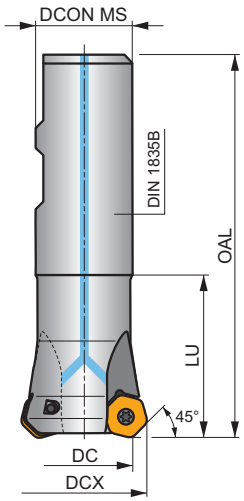
ECON HN06 45 ° planfræser med dobbelt negativt design og intern kølevæske

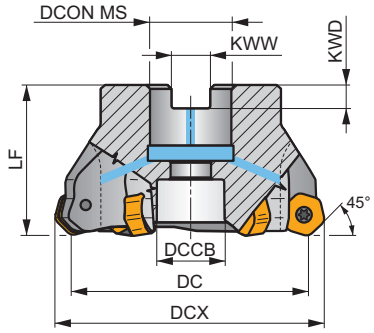
Meget produktiv 45° plan fræser med dobbeltsidet HN .. 06 skær med APMX på 3 mm. Skrub, efterbehandling og affasning. Økonomisk skær med 12 skærekanter. Differential tandstigning. Weldon, modulær og dorn type. Krop behandlet for længere værktøjslevetid.

KAPR	45°
APMX	3.0 mm









h_m	0.06 - 0.15
h_m	0.06 - 0.15

	Product	DC (mm)	DCX (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835B	**25N2R042B25-SHN06C-C**	25	32.2	99	25	–	42	–	–	–	-7	-7	2	–	17400	✓	0.35	GI204	FA010	–
	32N3R042B32-SHN06C-C	32	39.3	103	32	–	42	–	–	–	-7	-7	3	–	15400	✓	0.59	GI204	FA010	–
	40A05R-S45HN06C-C	40	47.3	–	16	14	–	40	8.4	5.6	-7	-7	5	✓	13800	✓	0.37	GI204	FA012	–
	50A04R-S45HN06C-C	50	57.3	–	22	18	–	40	10.4	6.3	-7	-7	4	✓	12300	✓	0.54	GI204	FA013	–
	50A06R-S45HN06C-C	50	57.3	–	22	18	–	40	10.4	6.3	-7	-7	6	✓	12300	✓	0.41	GI204	FA013	–
	63A06R-S45HN06C-C	63	70.3	–	22	18	–	40	10.4	6.3	-7	-7	6	✓	11000	✓	0.68	GI204	FA013	–
ISO 6462 DIN 8030	**63A08R-S45HN06C-C**	63	70.3	–	22	18	–	40	10.4	6.3	-7	-7	8	✓	11000	✓	0.68	GI204	FA013	–
	80A07R-S45HN06C-C	80	86.8	–	27	38	–	50	12.4	7	-7	-7	7	✓	9700	✓	1.10	GI204	FA011	AC001
	80A10R-S45HN06C-C	80	86.8	–	27	38	–	50	12.4	7	-7	-7	10	✓	9700	✓	1.10	GI204	FA011	AC001
	100A08R-S45HN06C-C	100	107.1	–	32	45	–	50	14.4	8	-7	-7	8	✓	8700	✓	2.00	GI204	FA011	AC002
	100A12R-S45HN06C-C	100	107.1	–	32	45	–	50	14.4	8	-7	-7	12	✓	8700	✓	1.82	GI204	FA011	AC002
	125A10R-S45HN06C-C	125	132.2	–	40	56	–	63	16.4	9	-7	-7	10	✓	7800	✓	3.53	GI204	FA011	AC003

GI204	HNGX 0604AN..	XNGX 0604AN..

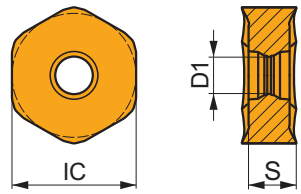
		Nm						
FA010	US 3007-T09P	2.0	M 3	7.3	–	–	Flag T09P	–
FA011	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	–
FA012	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	HS 0830C
FA013	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	HS 1030C

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

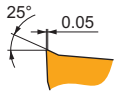
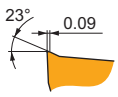
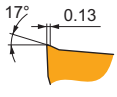
HNGX 06

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0604	10.500	3.70	4.76

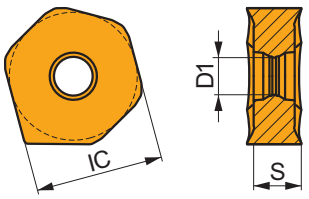


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

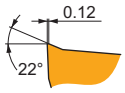
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
				**F** geometri med meget positivt design til let bearbejdning.															
HNGX 0604ANSN-F:8215	–	315	0.11	1.7	185	0.10	1.7	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-F:M6330	–	265	0.11	1.7	185	0.10	1.7	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-F:M8330	–	305	0.11	1.7	180	0.10	1.7	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-F:M8340	–	285	0.11	1.7	170	0.10	1.7	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-F:M9340	–	365	0.11	1.7	215	0.10	1.7	–	–	–	–	–	–	–	–	–	–	–	–
				**M** geometri med meget positivt design til medium bearbejdning.															
HNGX 0604ANSN-M:8215	–	300	0.13	2.0	180	0.13	2.0	285	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M5315	–	425	0.13	2.0	–	–	–	400	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M6330	–	255	0.13	2.0	180	0.13	2.0	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M8310	–	325	0.13	2.0	165	0.13	2.0	305	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M8330	–	295	0.13	2.0	175	0.13	2.0	280	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M8340	–	265	0.13	2.0	155	0.13	2.0	250	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M9315	–	410	0.13	2.0	–	–	–	385	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M9325	–	375	0.13	2.0	–	–	–	355	0.13	2.0	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-M:M9340	–	345	0.13	2.0	205	0.13	2.0	–	–	–	–	–	–	–	–	–	–	–	–
				**R** geometri med meget positivt design til medium til tung bearbejdning.															
HNGX 0604ANSN-R:8215	–	280	0.18	1.8	165	0.18	1.8	265	0.18	1.8	–	–	–	–	–	–	55	0.12	1.0
HNGX 0604ANSN-R:M5315	–	370	0.18	1.8	–	–	–	350	0.18	1.8	–	–	–	–	–	–	70	0.12	1.0
HNGX 0604ANSN-R:M8310	–	300	0.18	1.8	150	0.18	1.8	285	0.18	1.8	–	–	–	–	–	–	60	0.12	1.0
HNGX 0604ANSN-R:M8330	–	275	0.18	1.8	165	0.18	1.8	260	0.18	1.8	–	–	–	–	–	–	55	0.12	1.0
HNGX 0604ANSN-R:M8340	–	250	0.18	1.8	150	0.18	1.8	235	0.18	1.8	–	–	–	–	–	–	–	–	–
HNGX 0604ANSN-R:M9325	–	345	0.18	1.8	–	–	–	325	0.18	1.8	–	–	–	–	–	–	65	0.12	1.0

XNGX 06

	IC	D1	S
	(mm)	(mm)	(mm)
0604	10.500	3.70	4.76

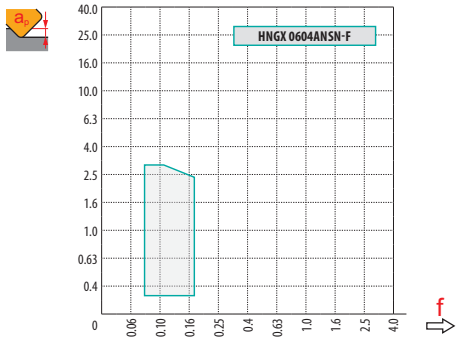


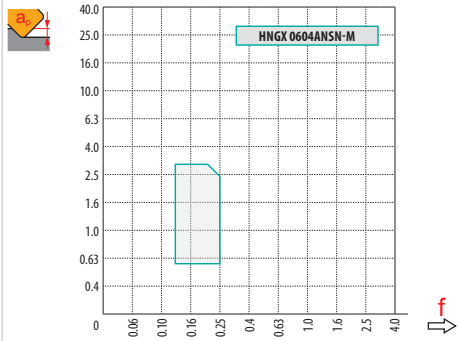
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

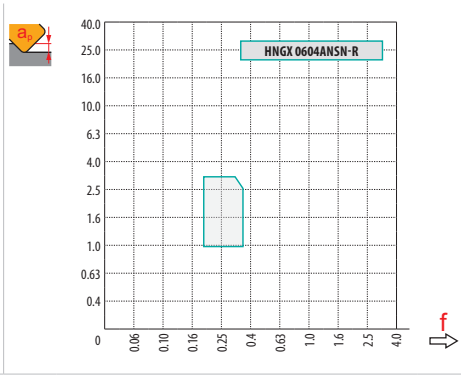
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
			**W** wiper design for forbedret overfladefinish.																	
XNGX 0604ANSN:8215		–	290	0.13	1.8	170	0.12	1.8	275	0.13	1.8	–	–	–	–	–	–	–	–	–

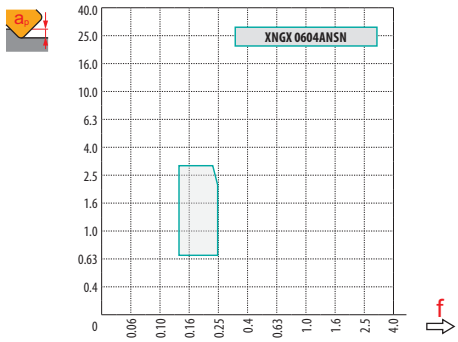
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	HNGX 06-F	HNGX 06-M	HNGX 06-R	XNGX 06
RE	–	–	–	–
BS	1.12	0.80	0.80	4.15









DC	X.V	f_{max}
25	1.31	0.24
32	1.36	0.28
40	1.40	0.31
50	1.45	0.35
63	1.49	0.39
80	1.54	0.44
100	1.59	0.49
125	1.64	0.55

DC	RPMX	APMX/I
25	2.7°	3.0/65
32	1.9°	3.0/89
40	1.5°	2.5/100
50	1.1°	1.9/100
63	0.9°	1.4/100
80	0.6°	1.0/100
100	0.5°	0.8/100
125	0.4°	0.6/100

a_p
0.9

SHN09C

P M K H

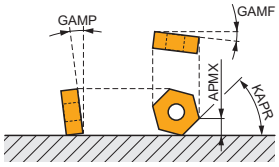
PRAMET

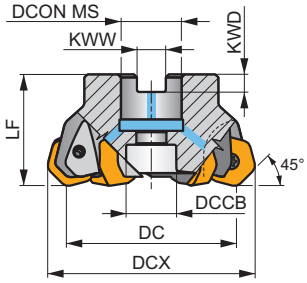
S

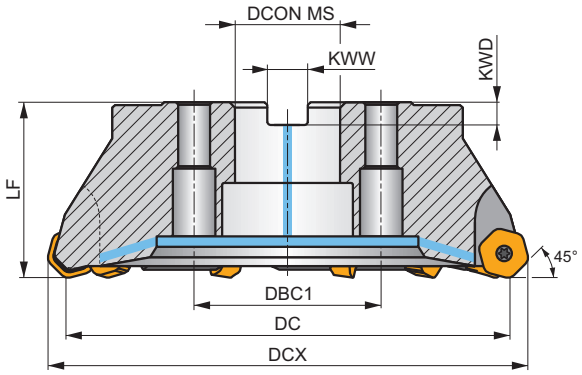
ECON HN06 45 ° planfræser med dobbelt negativt design og intern kølevæske

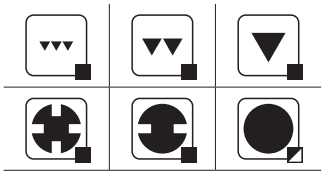
Meget produktiv 45° planfræser med dobbeltsidet HN .. 09 skær med APMX på 5 mm. Skrub, efterbehandling og affasning. Økonomisk skær med 12 skærekanter. Differential tandstigning. Dorn type. Krop behandlet for længere værktøjslevetid.

KAPR	45°
APMX	5.0 mm









h_m 0.08 - 0.25

	Product	DC	DCX	LF	DCON MS	DCCB	DBC1	KWW	KWD	GAMF	GAMP			max.		kg			
		(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)	(°)	(°)								
	50A04R-S45HN09C-CF	50	61.7	40	22	18	–	10.4	6.3	-7	-7	4	✓	7900	✓	0.38	GI252	FA023	–
	63A06R-S45HN09C-CF	63	74.7	40	22	18	–	10.4	6.3	-7	-7	6	✓	7000	✓	0.54	GI252	FA023	–
	80A06R-S45HN09C-CF	80	91.7	50	27	38	–	12.4	7	-7	-7	6	✓	6200	✓	1.06	GI252	FA021	AC001
	80A08R-S45HN09C-CF	80	91.7	50	27	38	–	12.4	7	-7	-7	8	✓	6200	✓	1.06	GI252	FA021	AC001
	100A06R-S45HN09C-CF	100	111.7	50	32	45	–	14.4	8	-7	-7	6	✓	5600	✓	1.95	GI252	FA021	AC002
	100A08R-S45HN09C-CF	100	111.7	50	32	45	–	14.4	8	-7	-7	8	✓	5600	✓	1.99	GI252	FA021	AC002
	100A10R-S45HN09C-CF	100	111.7	50	32	45	–	14.4	8	-8	-7	10	–	5600	✓	1.99	GI252	FA021	AC002
	125A06R-S45HN09C-CF	125	136.7	63	40	56	–	16.4	9	-7	-7	6	✓	5000	✓	3.36	GI252	FA021	AC003
ISO 6462 DIN 8030	**125A08R-S45HN09C-CF**	125	136.7	63	40	56	–	16.4	9	-7	-7	8	✓	4900	✓	3.66	GI252	FA021	AC003
	125A10R-S45HN09C-CF	125	136.7	63	40	56	–	16.4	9	-7	-7	10	✓	5000	✓	3.52	GI252	FA021	AC003
	125A12R-S45HN09C-CF	125	136.7	63	40	56	–	16.4	9	-8	-7	12	–	5000	✓	3.36	GI252	FA021	AC003
	160C08R-S45HN09C-CF	160	171.7	63	40	–	66.7	16.4	9	-7	-7	8	✓	4400	✓	6.24	GI252	FA026	–
	160C12R-S45HN09C-CF	160	171.7	63	40	–	66.7	16.4	9	-7	-7	12	✓	4400	✓	6.45	GI252	FA026	–
	160C14R-S45HN09C-CF	160	171.7	63	40	–	66.7	16.4	9	-7	-7	14	✓	4400	✓	6.39	GI252	FA026	–
	200C10R-S45HN09C-CF	200	211.7	63	60	–	101.6	25.7	14	-7	-7	10	✓	3900	✓	11.37	GI252	FA027	–
	250C14R-S45HN09C-CF	250	261.7	63	60	–	101.6	25.7	14	-7	-7	14	✓	3500	✓	18.50	GI252	FA028	–
	315C16R-S45HN09C-CF	315	326.7	80	60	–	101.6	25.7	14	-7	-7	16	✓	3100	✓	37.00	GI252	FA029	–

GI252	HNGX 0906AN..	XNGX 0906AN..

		Nm											
FA021	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	–	–	–	–	–	–	–
FA023	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	HS 1030C	–	–	–	–	–	–

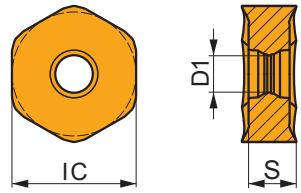
		Nm										
FA026	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	HS 1240C	CAC 160C	HSD 0825C	HXK 5	–	–
FA027	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	HS 1655C	CAC 200C	HSD 1025C	HXK 7	–	–
FA028	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	HS 1655C	CAC 250C	HSD 1025C	HXK 7	–	–
FA029	US 54511-T15P	5.0	M 4.5	11	D-T08P/T15P	FG-15	HS 1655C	CAC 315C	HSD 1035C	HXK 7	CACP 315OC	RRH 34

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

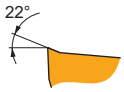
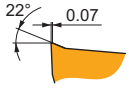
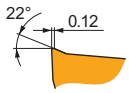
HNGX 09

PRAMET

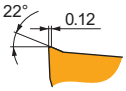
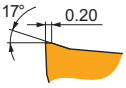
	IC (mm)	D1 (mm)	S (mm)
0906	16.500	4.90	6.35



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
FF geometri med meget positivt design til let bearbejdning.																				
HNGX 0906ANEN-FF:8215	●	–	345	0.10	1.0	205	0.09	1.0	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0906ANEN-FF:M8330	●	–	335	0.10	1.0	200	0.09	1.0	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0906ANEN-FF:M9340	●	–	405	0.10	1.0	240	0.09	1.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
F geometri med meget positivt design til let til medium bearbejdning.																				
HNGX 0906ANSN-F:8215	✱	–	300	0.12	2.1	180	0.11	2.1	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-F:M6330	✱	–	255	0.12	2.1	180	0.11	2.1	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-F:M8310	✱	–	330	0.12	2.1	165	0.11	2.1	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-F:M8330	✱	–	300	0.12	2.1	180	0.11	2.1	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-F:M8340	✱	–	270	0.12	2.1	160	0.11	2.1	–	–	–	–	–	–	–	–	–	–	–	–
																				
M geometri med meget positivt design til medium bearbejdning.																				
HNGX 0906ANSN-M:8215	✱	–	255	0.20	2.7	150	0.18	2.7	240	0.20	2.7	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M5315	✱	–	340	0.20	2.7	–	–	–	320	0.20	2.7	–	–	–	–	–	–	–	–	–

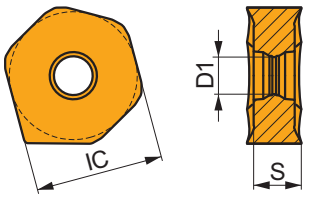
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
M geometri med meget positivt design til medium bearbejdning.																			
HNGX 0906ANSN-M:M6330	–	220	0.20	2.7	155	0.18	2.7	–	–	–	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M8310	–	280	0.20	2.7	140	0.18	2.7	265	0.20	2.7	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M8330	–	255	0.20	2.7	150	0.18	2.7	240	0.20	2.7	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M8340	–	235	0.20	2.7	140	0.18	2.7	220	0.20	2.7	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M9315	–	340	0.20	2.7	–	–	–	320	0.20	2.7	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M9325	–	315	0.20	2.7	–	–	–	295	0.20	2.7	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-M:M9340	–	290	0.20	2.7	170	0.18	2.7	–	–	–	–	–	–	–	–	–	–	–	–
																			
R geometri med positivt design til medium til tung bearbejdning.																			
HNGX 0906ANSN-R:8215	–	240	0.25	3.0	140	0.25	3.0	225	0.25	3.0	–	–	–	–	–	–	45	0.13	1.0
HNGX 0906ANSN-R:M5315	–	305	0.25	3.0	–	–	–	285	0.25	3.0	–	–	–	–	–	–	60	0.13	1.0
HNGX 0906ANSN-R:M8310	–	260	0.25	3.0	130	0.25	3.0	245	0.25	3.0	–	–	–	–	–	–	50	0.13	1.0
HNGX 0906ANSN-R:M8330	–	240	0.25	3.0	140	0.25	3.0	225	0.25	3.0	–	–	–	–	–	–	45	0.13	1.0
HNGX 0906ANSN-R:M8340	–	220	0.25	3.0	130	0.25	3.0	205	0.25	3.0	–	–	–	–	–	–	–	–	–
HNGX 0906ANSN-R:M9315	–	310	0.25	3.0	–	–	–	290	0.25	3.0	–	–	–	–	–	–	60	0.13	1.0
HNGX 0906ANSN-R:M9325	–	295	0.25	3.0	–	–	–	280	0.25	3.0	–	–	–	–	–	–	55	0.13	1.0

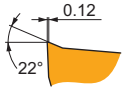
XNGX 09

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0906	16.500	4.90	6.35

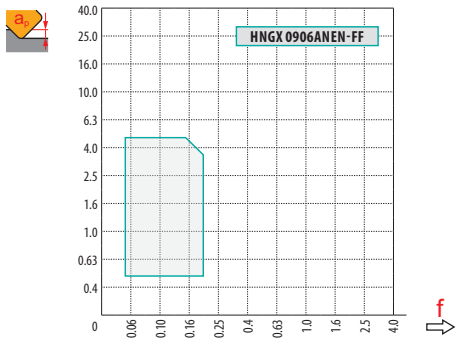


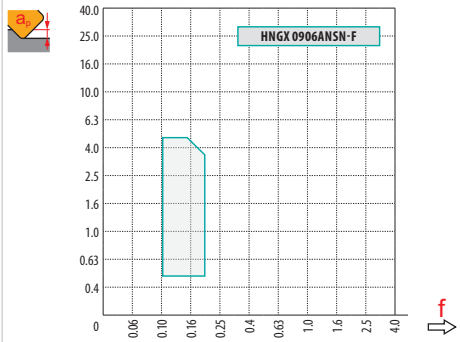
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

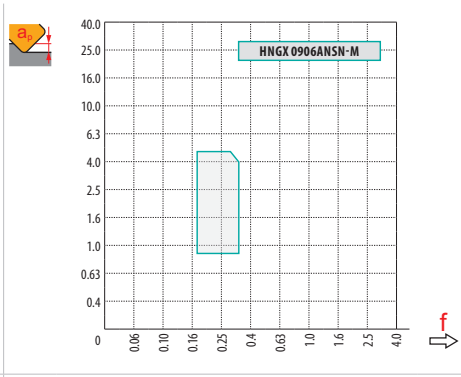
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
W wiper design for forbedret overfladefinish.																			
XNGX 0906ANSN:8215	–	245	0.20	2.7	145	0.18	2.7	230	0.20	2.7	–	–	–	–	–	–	–	–	–
XNGX 0906ANSN:M8330	–	245	0.20	2.7	145	0.18	2.7	230	0.20	2.7	–	–	–	–	–	–	–	–	–

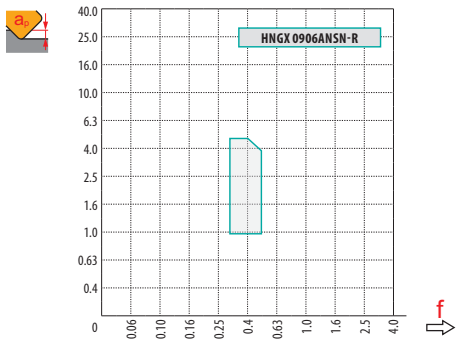
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

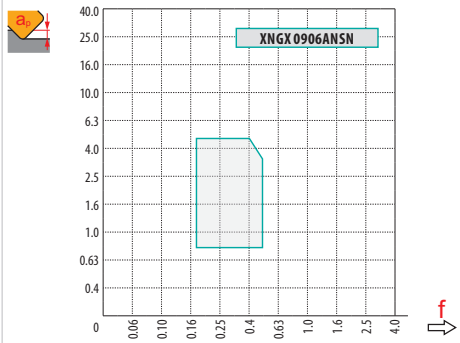
	HNGX 09-FF	HNGX 09-F	HNGX 09-M	HNGX 09-R	XNGX 09
RE	–	–	–	–	–
BS	1.50	1.17	1.17	1.17	7.53











DC	X.V	f_{max}
50	1.35	0.36
63	1.39	0.40
80	1.44	0.45
100	1.48	0.51
125	1.53	0.57
160	1.58	0.64
200	1.63	0.72
250	1.68	0.80
315	1.74	0.90

DC	RPMX	APMX/I
50	2.1°	3.5/100
63	1.5°	2.5/100
80	1.1°	1.8/100
100	0.9°	1.4/100
125	0.7°	1.1/100
160	0.5°	0.7/100

a_p
1.9

SPN13

P M K S H

PRAMET

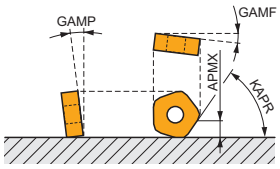
S

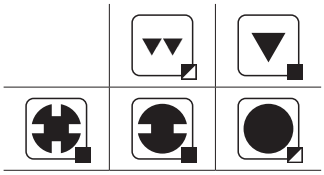
PENTA HD 57 ° planfræser med dobbelt negativt design til tung fræsning

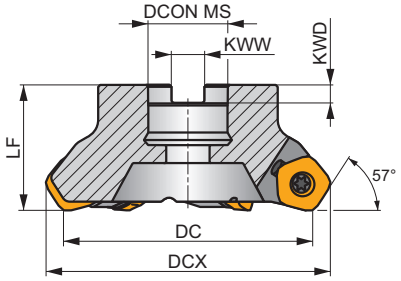
Meget produktiv 57° planfræser med dobbeltsidet PN .. 13 og XN .. 13 skær med APMX på 10 mm. Velegnet til planfræsning. Dorn type. Et indlægssæde beskyttet med et mellemlag. Krop behandlet for længere værktøjslevetid.

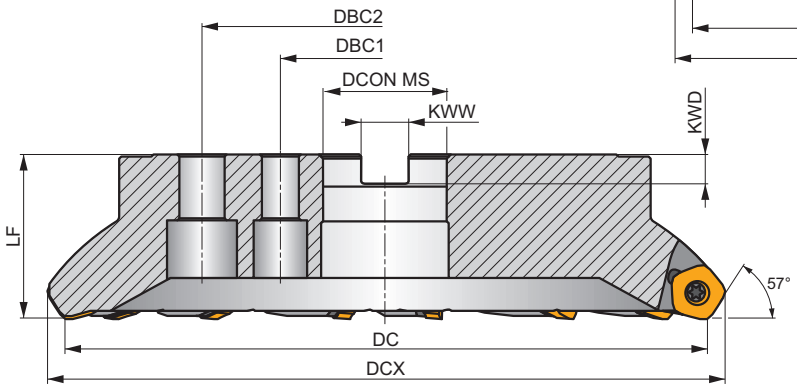
PENTA HD

KAPR	57°
APMX	10.0 mm









h_m 0.20 - 0.50

	Product	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DBC1 (mm)	DBC2 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
	100A05R-S57PN13	100	115.8	50	32	–	–	14.4	8	-8.2	-4	5	–	3400	–	1.22	GI261	FA081	AC002
	125A06R-S57PN13	125	140.8	63	40	–	–	16.4	9	-7	-4	6	–	3100	–	2.79	GI261	FA081	AC003
ISO 6462 DIN 8030	**160C08R-S57PN13**	160	175.8	63	40	66.7	–	16.4	9	-6	-4	8	–	2700	–	3.58	GI261	FA081	–
	200C10R-S57PN13	200	215.8	63	60	101.6	–	25.7	14	-5	-4	10	–	2400	–	9.17	GI261	FA081	–
	250C12R-S57PN13	250	265.8	63	60	101.6	–	25.7	14	-5	-4	12	–	2200	–	15.39	GI261	FA081	–
	315C14R-S57PN13	315	330.8	80	60	101.6	177.8	25.7	14	-5	-4	14	–	1900	–	29.17	GI261	FA081	–

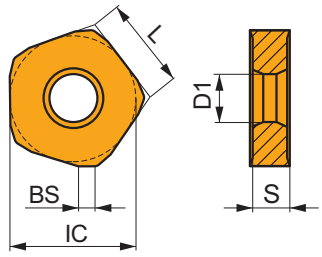
GI261	PNMU 1308DN..	XNGX 1308DNSN	PNMQ 1308DN..

FA081	SPN 13T3DN	US 64010-T15P	SDR T15P	US 68026-T30P	15.0 Nm	M 8	26	SDR T30P-T

AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

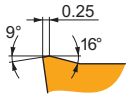
PNMU 13

	BS	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)	(mm)
1308	3.00	24.400	10.00	13.00	7.94



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

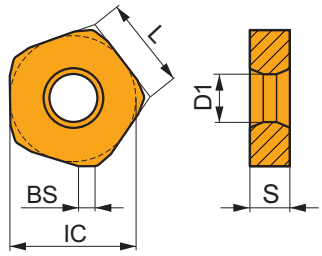
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
PNMU 1308DNSR-M:8215		–	■ 165	0.35	6.5	◪ 95	0.32	6.5	■ 155	0.35	6.5	–	–	–	◪ 40	0.28	5.2	◪ 30	0.18	2.0
PNMU 1308DNSR-M:M8330		–	■ 190	0.35	6.5	◪ 110	0.32	6.5	■ 180	0.35	6.5	–	–	–	◪ 45	0.28	5.2	◪ 35	0.18	2.0
PNMU 1308DNSR-M:M8345		–	■ 135	0.35	6.5	◪ 80	0.32	6.5	–	–	–	–	–	–	◪ 30	0.28	5.2	–	–	–
PNMU 1308DNSR-M:M9315		–	■ 210	0.35	6.5	–	–	–	■ 195	0.35	6.5	–	–	–	–	–	–	◪ 40	0.18	2.0
PNMU 1308DNSR-M:M9340		–	■ 170	0.35	6.5	◪ 100	0.32	6.5	–	–	–	–	–	–	◪ 40	0.28	5.2	–	–	–



M geometri med positivt design til hård bearbejdning.

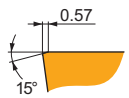
PNMQ 13

	BS	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)	(mm)
1308	3.00	24.400	10.00	13.00	7.94



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

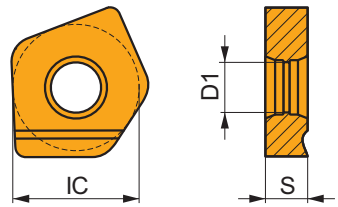
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
PNMQ 1308DNSN:M8330		–	◪ 165	0.60	6.5	–	–	–	■ 155	0.60	6.5	–	–	–	–	–	–	◪ 30	0.30	2.0
PNMQ 1308DNSN:M8345		–	◪ 120	0.60	6.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



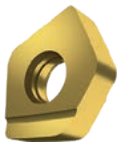
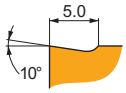
SN nul skærvinkeldesign særligt velegnet til hård bearbejdning.

XNGX 13

	IC	D1	S
	(mm)	(mm)	(mm)
1308	24.180	10.00	7.94

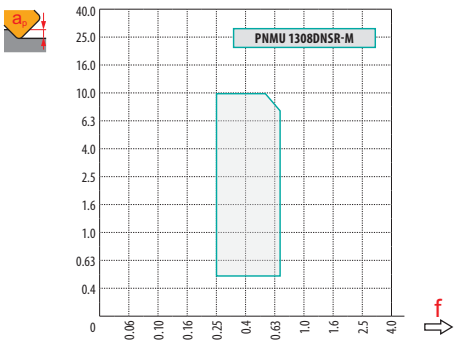


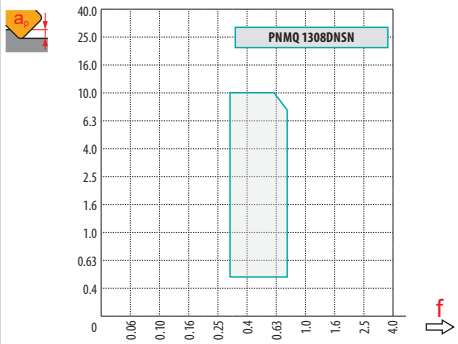
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

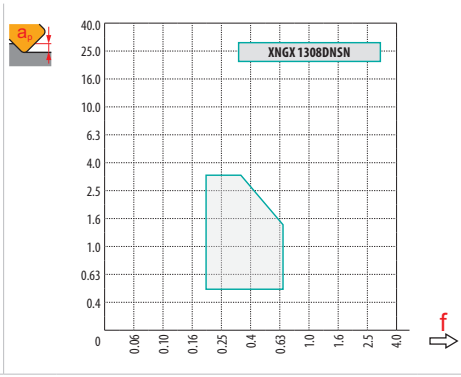
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
			**W** wiper design for forbedret overfladefinish.																	
XNGX 1308DNSN:M8330	✤	–	■ 245	0.45	2.5	–	–	–	■ 230	0.45	2.5	–	–	–	–	–	–	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

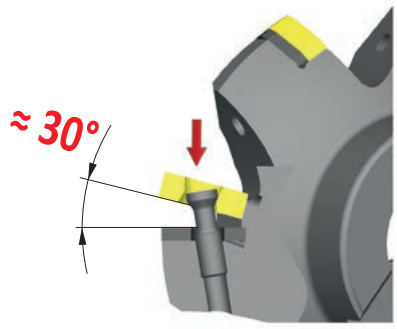
	PNMU 13-M	PNMQ 13	XNGX 13
RE	–	–	–
BS	3.00	3.00	12.71





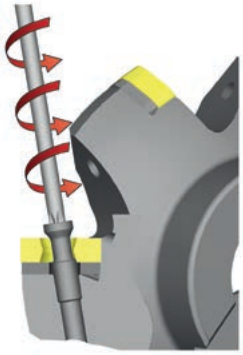


1



2

3



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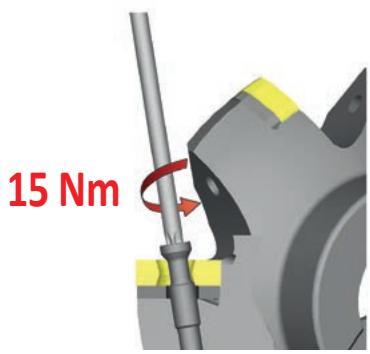


FACE MILLING

	SSD13F	SSE09	SSN12Z	FSB22X		
	45°	45°	45°	60°		
	APMX (mm) 6.4	APMX (mm) 4.5	APMX (mm) 6.5	APMX (mm) 15.0		
	DC (mm) 32 – 250	DC (mm) 20 – 160	DC (mm) 63 – 125	DC (mm) 125 – 250		
Cylindrical shank						
Weldon	DC = 32, 40 (mm)	DC = 20 – 32 (mm)				
Modular						
Shell mill	DC = 40 – 250 (mm)	DC = 32 – 160 (mm)				
Page	26	31	35	38		
ISO	P M K N S H	P M K S	P M K S	P M K		
Insert shape						
Inserts	SDET 13T3 SDMT 13T3 XDET 13T3	SE.T 09T3	SN.T 1205	SB.. 2207		
No. of cutting edges	4 / 4 / 1	4	4	4 / 1		
Face milling	■	■	■	■		
Chamfer milling	■	■	■			
Helical interpolation	◪					
Progressive plunging	◪					
Ramping	◪					

■ Primary use ◪ Possible use

SSD13F

P M K N S H

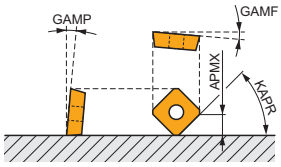
PRAMET

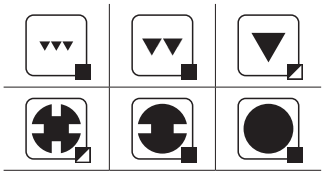
S

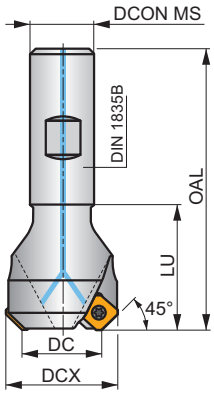
VER SD13 45° planfræser med positivt design og indvendig kølevæske

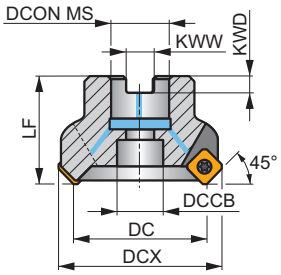
Meget alsidig 45° planfræser med enkeltsidet SD.. 13 stil indsatser med APMX på 6,4 mm.Velegnet til en bred vifte af applikationer i ethvert emnemateriale.Weldon og dorn stil tilgængelig, med differential tandstigning.Behandlet for længere værktøjslevetid, hårdmetal shims på siddepladsen for processikkerhed.

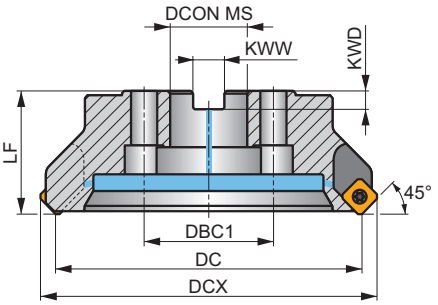
KAPR	45°
APMX	6.4 mm











h_m	0.04 - 0.28
h_m	0.04 - 0.32

	Product	DC (mm)	DCX (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LU (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835B	**32N3R045B25-SSD13F-C**	32	44.9	120	25	–	–	45	–	–	–	-15	15	3	–	16100	✓	0.43	GI341	C0610	–
	40N3R045B32-SSD13F-C	40	53.5	120	32	–	–	45	–	–	–	-7	15	3	–	14400	✓	0.72	GI341	C0610	–
	40A03R-S45SD13F-C	40	53.5	–	16	14	–	–	40	8.4	5.6	-7	15	3	–	14400	✓	0.27	GI341	C0611	–
	50A04R-S45SD13F-C	50	63.5	–	22	18	–	–	40	10.4	6.3	-7	15	4	✓	12900	✓	0.51	GI341	C0612	–
	63A05R-S45SD13F-C	63	76.4	–	22	18	–	–	40	10.4	6.3	-7	15	5	✓	11500	✓	0.53	GI341	C0612	–
	80A07R-S45SD13F-C	80	93.4	–	27	22	–	–	50	12.4	7	-7	15	7	✓	10200	✓	1.21	GI341	C0613	AC001
	100A08R-S45SD13F-C	100	112.9	–	32	45	–	–	50	14.4	8	-12	15	8	✓	9100	✓	1.83	GI341	C0613	AC002
	100A10R-S45SD13F-C	100	112.9	–	32	45	–	–	50	14.4	8	-12	15	10	–	9100	✓	1.94	GI341	C0613	AC002
ISO 6462 DIN 8030	**125A08R-S45SD13F-C**	125	137.8	–	40	56	–	–	63	16.4	9	-12	15	8	✓	8100	✓	3.41	GI341	C0613	AC003
	125A12R-S45SD13F-C	125	137.8	–	40	56	–	–	63	16.4	9	-12	15	12	–	8100	✓	3.31	GI341	C0613	AC003
	160C10R-S45SD13F-C	160	172.8	–	40	–	66.7	–	63	16.4	9	-12	15	10	✓	7200	✓	6.68	GI341	C0614	–
	160C14R-S45SD13F-C	160	172.8	–	40	–	66.7	–	63	16.4	9	-12	15	14	✓	7200	✓	6.62	GI341	C0614	–
	200C12R-S45SD13F-C	200	212.8	–	60	–	101.6	–	63	25.7	14	-12	15	12	✓	6400	✓	9.06	GI341	C0615	–
	200C16R-S45SD13F-C	200	212.8	–	60	–	101.6	–	63	25.7	14	-12	15	16	✓	6400	✓	11.85	GI341	C0615	–
	250C14R-S45SD13F-C	250	262.8	–	60	–	101.6	–	63	25.7	14	-12	15	14	✓	5700	✓	19.50	GI341	C0616	–
	250C20R-S45SD13F-C	250	262.8	–	60	–	101.6	–	63	25.7	14	-12	15	20	✓	5700	✓	19.20	GI341	C0616	–

GI341	SDET 13T3..	SDMT 13T3..	XDET 13T3..

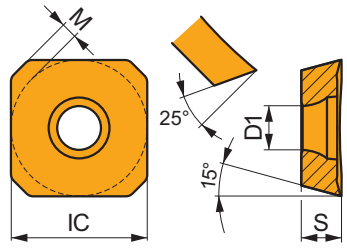
		Nm												
C0610	US 63513-T15P	3.0	M 3.5	13	Flag T15P	–	–	–	SDW 1103AF	MS 3507	HXK 3.5	–	–	–
C0611	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	HS 0830C	SDW 1103AF	MS 3507	HXK 3.5	–	–	–
C0612	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	HSD 1025C	SDW 1103AF	MS 3507	HXK 3.5	–	–	–
C0613	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	–	SDW 1103AF	MS 3507	HXK 3.5	–	–	–
C0614	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	HS 1240C	SDW 1103AF	MS 3507	HXK 3.5	CAC 160C	HSD 0825C	HXK 5
C0615	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	HS 1655C	SDW 1103AF	MS 3507	HXK 3.5	CAC 200C	HSD 1025C	HXK 7
C0616	US 63513-T15P	3.0	M 3.5	13	–	D-T08P/T15P	FG-15	HS 1655C	SDW 1103AF	MS 3507	HXK 3.5	CAC 250C	HSD 1025C	HXK 7

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

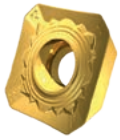
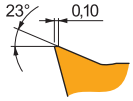
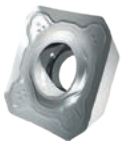
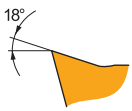
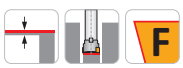
SDET 13

PRAMET

	IC (mm)	D1 (mm)	M (mm)	S (mm)
13T3	13.385	4.40	1.5	3.97

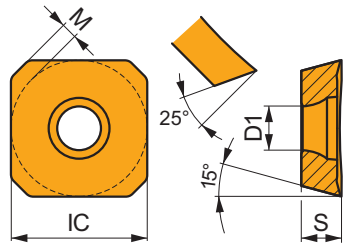


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

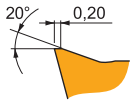
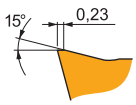
Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
F geometrien er skarp og bruges til efterbehandling, velegnet til store udhæng eller tyndvæggede og slanke emner.Designet med meget positiv vinkel, smal T-land og afrunding af skærkant til let bearbejdning.																				
SDET 13T3AFSN-F:M6330	✱	–	250	0.15	3.0	175	0.14	3.0	–	–	–	–	–	–	70	0.11	2.4	–	–	–
SDET 13T3AFSN-F:M8310	⧓	–	315	0.15	3.0	160	0.14	3.0	295	0.15	3.0	–	–	–	–	–	–	–	–	–
SDET 13T3AFSN-F:M8330	✱	–	285	0.15	3.0	170	0.14	3.0	270	0.15	3.0	855	0.18	3.0	70	0.11	2.4	–	–	–
SDET 13T3AFSN-F:M8340	✱	–	265	0.15	3.0	155	0.14	3.0	250	0.15	3.0	–	–	–	65	0.11	2.4	–	–	–
SDET 13T3AFSN-F:M9340	⧓	–	330	0.15	3.0	195	0.14	3.0	–	–	–	–	–	–	80	0.11	2.4	–	–	–
																				
FA geometrien er skarp og bruges til bearbejdning af ikke-jernholdige legeringer, velegnet til store udhæng eller tyndvæggede og slanke emner.Poleret og slebet design med meget positiv vinkel.																				
SDET 13T3AFFN-FA:HF7	⧓	–	–	–	–	–	–	–	–	–	–	360	0.12	3.0	–	–	–	–	–	–
SDET 13T3AFFN-FA:M0315	⧓	–	–	–	–	–	–	–	–	–	–	840	0.12	3.0	–	–	–	–	–	–

SDMT 13

	IC (mm)	D1 (mm)	M (mm)	S (mm)
13T3	13.385	4.40	1.5	3.97

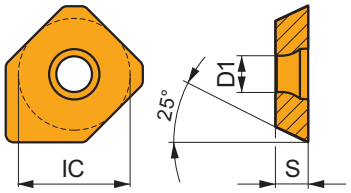


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
M geometri er alsidig og førstevalg til en lang række arbejdsforhold.Designet med positiv vinkel, medium T-land og afrunding af skærkant til medium bearbejdning.																			
SDMT 13T3AFSN-M:8215	–	245	0.30	3.0	145	0.27	3.0	230	0.30	3.0	–	–	–	60	0.24	2.4	45	0.21	1.0
SDMT 13T3AFSN-M:M6330	–	215	0.30	3.0	150	0.27	3.0	–	–	–	–	–	–	60	0.24	2.4	–	–	–
SDMT 13T3AFSN-M:M8330	–	245	0.30	3.0	145	0.27	3.0	230	0.30	3.0	–	–	–	60	0.24	2.4	45	0.21	1.0
SDMT 13T3AFSN-M:M8340	–	225	0.30	3.0	135	0.27	3.0	210	0.30	3.0	–	–	–	55	0.24	2.4	–	–	–
SDMT 13T3AFSN-M:M9325	–	295	0.30	3.0	–	–	–	280	0.30	3.0	–	–	–	–	–	–	55	0.21	1.0
SDMT 13T3AFSN-M:M9340	–	265	0.30	3.0	155	0.27	3.0	–	–	–	–	–	–	65	0.24	2.4	–	–	–
																			
R geometrien er stærk og bruges til skrub og tunge arbejdsforhold.Designet med let positiv vinkel, bredt T-land og afrunding af skærkant til grov bearbejdning.																			
SDMT 13T3AFSN-R:M5315	–	285	0.35	3.0	–	–	–	270	0.35	3.0	–	–	–	–	–	–	55	0.25	1.0
SDMT 13T3AFSN-R:M8310	–	255	0.35	3.0	130	0.32	3.0	240	0.35	3.0	–	–	–	–	–	–	50	0.25	1.0
SDMT 13T3AFSN-R:M8330	–	240	0.35	3.0	140	0.32	3.0	225	0.35	3.0	–	–	–	–	–	–	45	0.25	1.0
SDMT 13T3AFSN-R:M8340	–	220	0.35	3.0	130	0.32	3.0	205	0.35	3.0	–	–	–	–	–	–	–	–	–
SDMT 13T3AFSN-R:M9325	–	280	0.35	3.0	–	–	–	265	0.35	3.0	–	–	–	–	–	–	55	0.25	1.0

XDET 13

	IC	D1	S
	(mm)	(mm)	(mm)
13T3	13.385	4.40	3.97



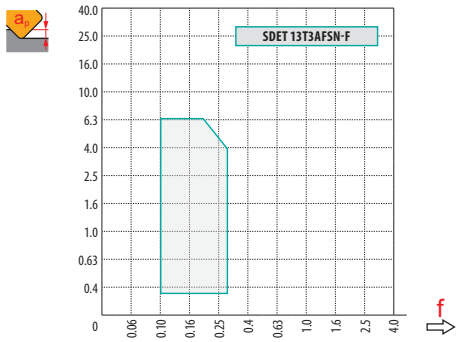
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

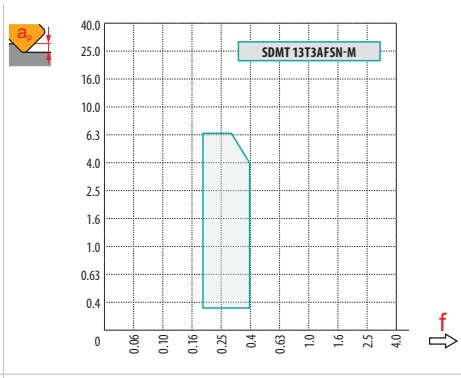
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
XDET 13T3AFER:8215		–	420	0.10	0.2	250	0.09	0.2	395	0.10	0.2	–	–	–	–	–	–	–	–	–
XDET 13T3AFER:M8330		–	395	0.10	0.2	235	0.09	0.2	375	0.10	0.2	–	–	–	–	–	–	–	–	–

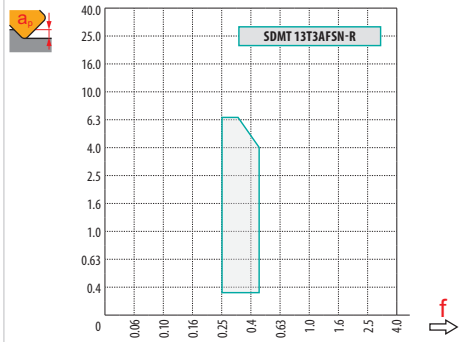
W wiper design for forbedret overfladefinish ved bearbejdning med store fræsere og høje tilspændingshastigheder.

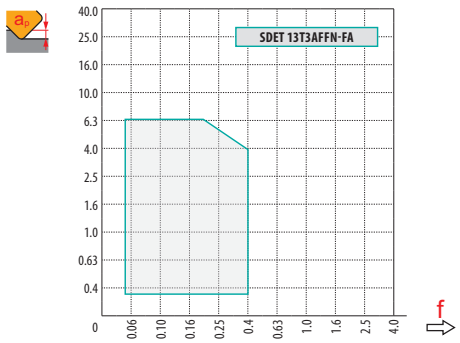
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

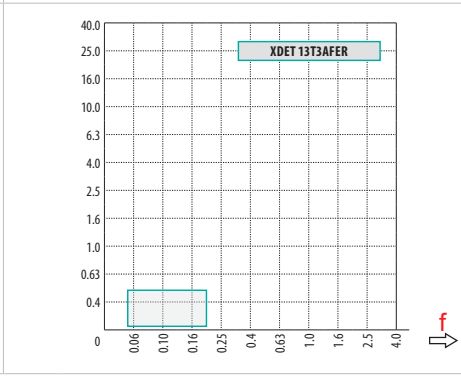
	SDET 13-F	SDMT 13-M	SDMT 13-R	SDET 13-FA	XDET 13
RE	–	–	–	–	–
BS	1.75	1.75	1.75	1.75	8.19











DC	X.V	f_{max}
32	1.22	0.15
40	1.26	0.16
50	1.30	0.18
63	1.34	0.20
80	1.39	0.22
100	1.43	0.24
125	1.48	0.26
160	1.53	0.29
200	1.58	0.33
250	1.63	0.36

DC	RPMX	APMX/I
32	14.1°	6.4/27
40	11.8°	6.4/32
50	9.8°	6.4/39
63	7.7°	6.4/49
80	5.2°	6.4/72
100	4.1°	6.4/91
125	3.2°	5.45/100
160	1.0°	1.6/100
200	0.4°	0.55/100
250	0.3°	0.4/100

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
32	60.0	89.8	1.7	1.7
40	75.0	107.0	1.7	1.7
50	94.0	127.0	1.7	1.7
63	120.0	152.8	1.7	1.7
80	155.0	186.8	1.7	1.7
100	193.0	225.8	1.7	1.7
125	245.0	275.6	1.7	1.7
160	322.0	345.6	1.7	1.7
200	405.0	425.6	1.7	1.7
250	505.0	525.6	1.7	1.7

a_p
1.5

SSE09

P M K S

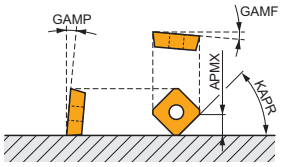
PRAMET

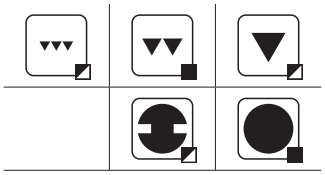
S

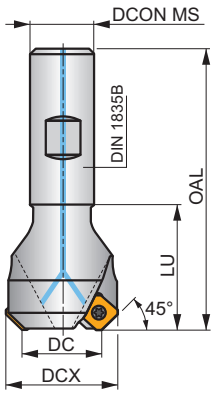
45 ° planfræser med dobbelt negativt design og intern kølevæske

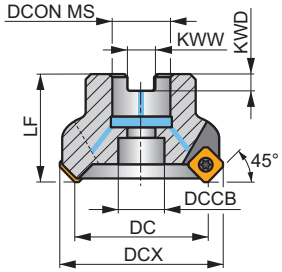
Meget produktiv 45° planfræser med enkeltsidet SE .. 09 skær med APMX på 4,5 mm. Velegnet til planfræsning og affasning. Weldon og dorn-type fås med differentieret tandhældning. Krop behandlet for længere værktøjslevetid.

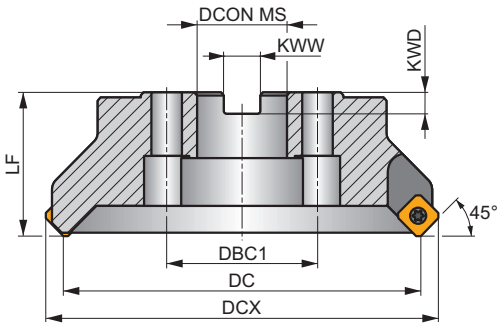
KAPR	45°
APMX	4.5 mm











h_m	0.06 - 0.18
h_m	0.06 - 0.2

	Product	DC (mm)	DCX (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LU (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835B	**20N2R032B20-SSE09-C**	20	29.8	82	20	–	–	32	–	–	–	-5	20	2	–	24600	✓	0.26	GI147	FA010	–
DIN 1835B	**25N3R042B25-SSE09-C**	25	34.8	98	25	–	–	42	–	–	–	-5	20	3	–	22000	✓	0.44	GI147	FA010	–
DIN 1835B	**32N4R042B32-SSE09-C**	32	42	102	32	–	–	42	–	–	–	-5	20	4	–	19400	✓	0.68	GI147	FA010	–
	32A04R-S45SE09F-C	32	42	–	16	14	–	–	40	8.4	6.4	-5	20	4	✓	19400	✓	0.24	GI147	FA012	–
	40A04R-S45SE09F-C	40	53.2	–	16	14	–	–	40	8.4	6.4	-5	20	4	✓	17400	✓	0.30	GI147	FA012	–
	50A05R-S45SE09F-C	50	59.6	–	22	18	–	–	40	10.4	6.4	-5	20	5	✓	15600	✓	0.55	GI147	FA013	–
	63A05R-S45SE09F-C	63	75.8	–	22	18	–	–	40	10.4	6.4	-5	20	5	✓	13900	✓	0.66	GI147	FA013	–
	63A06R-S45SE09F-C	63	75.8	–	22	18	–	–	40	10.4	6.4	-5	20	6	✓	13900	✓	0.58	GI147	FA013	–
ISO 6462 DIN 8030	**80A06R-S45SE09F-C**	80	89.6	–	27	38	–	–	50	12.4	7	-5	20	6	✓	12300	✓	1.14	GI147	FA011	AC001
ISO 6462 DIN 8030	**80A08R-S45SE09F-C**	80	89.6	–	27	38	–	–	50	12.4	7	-5	20	8	✓	12300	✓	1.13	GI147	FA011	AC001
	100A08R-S45SE09F-C	100	110	–	32	45	–	–	50	14.4	8	-5	20	8	✓	11000	✓	1.83	GI147	FA011	AC002
	100A10R-S45SE09F-C	100	110	–	32	45	–	–	50	14.4	8	-5	20	10	✓	10900	✓	1.82	GI147	FA011	AC002
	125A09R-S45SE09F-C	125	134.5	–	40	60	–	–	63	16.4	9	-5	20	9	✓	9800	✓	3.87	GI147	FA011	AC003
	125A12R-S45SE09F-C	125	134.5	–	40	60	–	–	63	16.4	9	-5	20	12	✓	9800	✓	3.87	GI147	FA011	AC003
	160C10R-S45SE09F	160	169.6	–	40	–	66.7	–	63	16.4	9	-5	20	10	✓	8700	–	6.21	GI147	FA014	–

GI147	SEET 09T3AF..	SEMT 09T3AF..

		Nm						
FA010	US 3007-T09P	2.0	M 3	7.3	–	–	Flag T09P	–
FA011	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	–
FA012	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	HS 0830C
FA013	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	HS 1030C

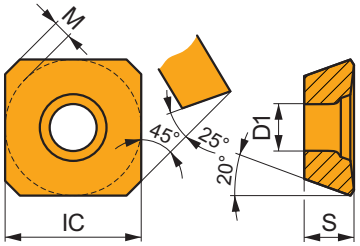
FA014	US 3007-T09P	2.0	M 3	7.3	D-T07P/T09P	FG-15	–	HS 1240C

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

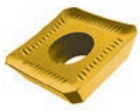
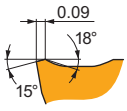
SEMT 09

PRAMET

	IC (mm)	D1 (mm)	M (mm)	S (mm)
09T3	9.525	3.50	1.2	3.97

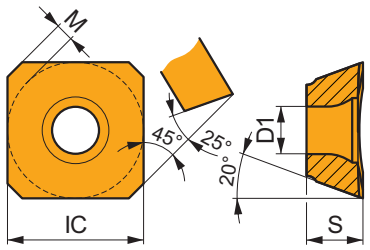


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

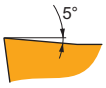
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
AFSN positivt design til let til medium bearbejdning.																			
SEMT 09T3AFSN:8215	–	295	0.18	1.8	175	0.16	1.8	280	0.18	1.8	–	–	–	–	–	–	–	–	–
SEMT 09T3AFSN:M8330	–	290	0.18	1.8	170	0.16	1.8	275	0.18	1.8	–	–	–	–	–	–	–	–	–
SEMT 09T3AFSN:M8340	–	265	0.18	1.8	155	0.16	1.8	250	0.18	1.8	–	–	–	–	–	–	–	–	–
SEMT 09T3AFSN:M9325	–	365	0.18	1.8	–	–	–	345	0.18	1.8	–	–	–	–	–	–	–	–	–

SEET 09

	IC	D1	M	S
	(mm)	(mm)	(mm)	(mm)
09T3	9.525	3.50	1.2	3.97

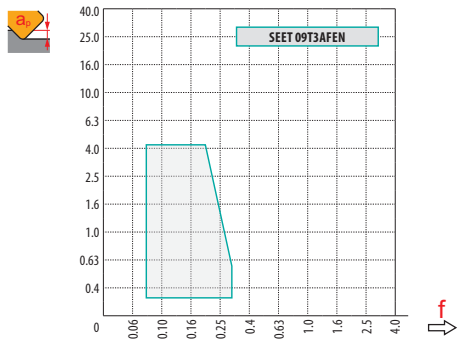


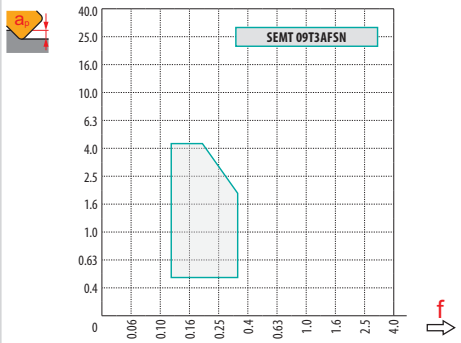
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
		**AFEN** positivt design til let til medium bearbejdning.																	
SEET 09T3AFEN:M6330	–	255	0.14	2.5	180	0.13	2.5	–	–	–	–	–	–	75	0.10	2.0	–	–	–
SEET 09T3AFEN:M8330	–	295	0.14	2.5	175	0.13	2.5	–	–	–	–	–	–	70	0.10	2.0	–	–	–
SEET 09T3AFEN:M8340	–	270	0.14	2.5	160	0.13	2.5	–	–	–	–	–	–	65	0.10	2.0	–	–	–
SEET 09T3AFEN:M9340	–	345	0.14	2.5	205	0.13	2.5	–	–	–	–	–	–	85	0.10	2.0	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SEET 09	SEMT 09
RE	–	–
BS	1.28	1.25





DC	X.V	f_{max}
20	1.20	0.18
25	1.24	0.20
32	1.29	0.23
40	1.33	0.25
50	1.37	0.28
63	1.41	0.32
80	1.46	0.36
100	1.50	0.40
125	1.55	0.45
160	1.60	0.51

SSN12Z

P M K S

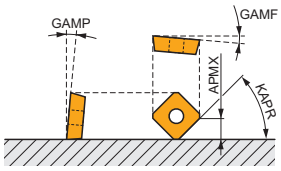
PRAMET

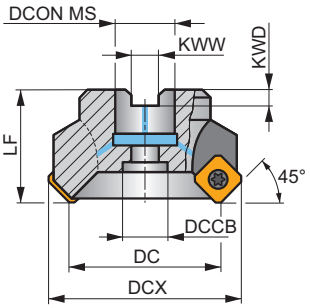
S

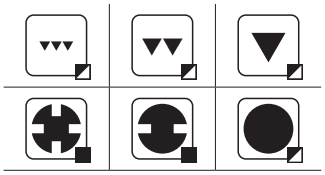
45 ° planfræser med dobbelt negativt design og intern kølevæske

Meget produktiv 45° planfræser med enkeltsidet SN .. 12 skær med APMX på 6,5 mm. Velegnet til planfræsning og affasning. Dorn type. Krop behandlet for længere værktøjslevetid.

KAPR	45°
APMX	6.5 mm







h_m 0.12 - 0.35

	Product	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	**63A05R-S45SN12Z-C**	63	78	40	22	18	–	10.4	6.3	-5.5	7.5	5	–	8600	✓	0.62	GI156	FA071	–
	80A06R-S45SN12Z-C	80	95	50	27	38	–	12.4	7	-5.5	7.5	6	–	7700	✓	1.36	GI156	FA071	AC001
	100A07R-S45SN12Z-C	100	115	50	32	45	–	14.4	8	-5.5	7.5	7	–	6900	✓	1.70	GI156	FA071	AC002
	125A08R-S45SN12Z-C	125	140	63	40	56	–	16.4	9	-5.5	7.5	8	–	6100	✓	3.42	GI156	FA071	AC003

GI156	SNKT 1205AZ..	SNMT 1205AZ..

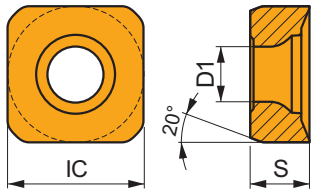
FA071	US 4511-T20	5.0 Nm	M 4.5	11	SDR T20-T

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

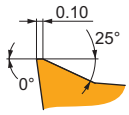
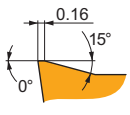
SNMT 12

PRAMET

	IC (mm)	D1 (mm)	S (mm)
1205	12.700	5.20	5.56



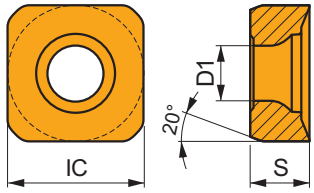
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
		**M** geometri med meget positivt design til medium bearbejdning.																	
SNMT 1205AZSR-M:8215	–	300	0.25	3.2	180	0.23	3.2	285	0.25	3.2	–	–	–	75	0.18	2.6	–	–	–
SNMT 1205AZSR-M:M8330	–	300	0.25	3.2	180	0.23	3.2	285	0.25	3.2	–	–	–	75	0.18	2.6	–	–	–
SNMT 1205AZSR-M:M8340	–	275	0.25	3.2	165	0.23	3.2	260	0.25	3.2	–	–	–	65	0.18	2.6	–	–	–
SNMT 1205AZSR-M:M9325	–	365	0.25	3.2	–	–	–	345	0.25	3.2	–	–	–	–	–	–	–	–	–
		**R** geometri med positivt design til medium til tung bearbejdning.																	
SNMT 1205AZSR-R:8215	–	290	0.27	3.5	170	0.24	3.5	275	0.27	3.5	–	–	–	70	0.22	2.8	–	–	–
SNMT 1205AZSR-R:M5315	–	365	0.27	3.5	–	–	–	345	0.27	3.5	–	–	–	–	–	–	–	–	–
SNMT 1205AZSR-R:M8330	–	290	0.27	3.5	170	0.24	3.5	275	0.27	3.5	–	–	–	70	0.22	2.8	–	–	–
SNMT 1205AZSR-R:M8340	–	270	0.27	3.5	160	0.24	3.5	255	0.27	3.5	–	–	–	65	0.22	2.8	–	–	–
SNMT 1205AZSR-R:M9325	–	355	0.27	3.5	–	–	–	335	0.27	3.5	–	–	–	–	–	–	–	–	–

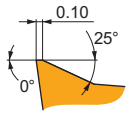
SNKT 12

PRAMET

	IC (mm)	D1 (mm)	S (mm)
1205	12.700	5.20	5.56

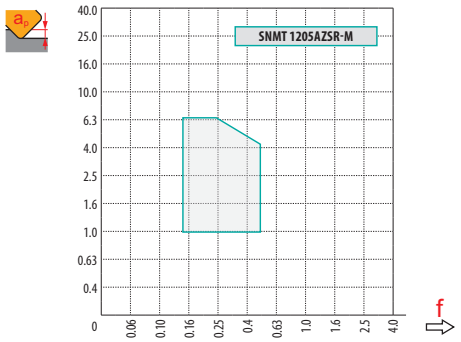


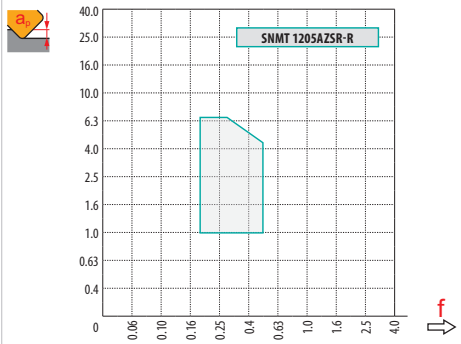
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

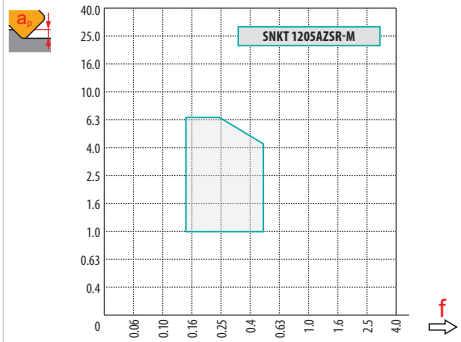
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
		**M** geometri med meget positivt design til medium bearbejdning.																	
SNKT 1205AZSR-M:M8330	–	305	0.24	3.2	180	0.22	3.2	285	0.24	3.2	–	–	–	75	0.17	2.6	–	–	–
SNKT 1205AZSR-M:M8340	–	275	0.24	3.2	165	0.22	3.2	260	0.24	3.2	–	–	–	65	0.17	2.6	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SNMT 12-M	SNMT 12-R	SNKT 12-M
RE	–	–	–
BS	0.95	1.03	1.59







DC	X.V	f_{max}
63	1.34	0.53
80	1.39	0.60
100	1.43	0.67
125	1.47	0.74

FSB22X

P M K

PRAMET

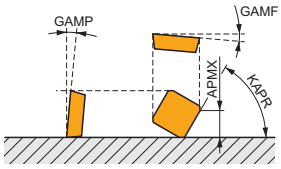
F

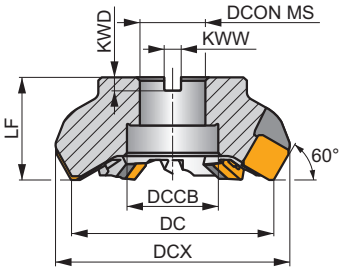
ROUGH SB 60 ° planfræser med positivt design til tung fræsning

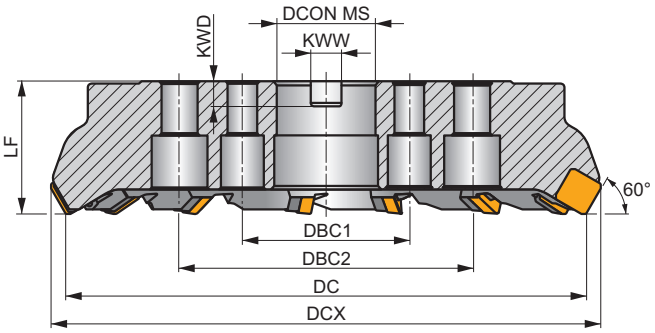
Meget produktiv 60° planfræser med enkeltsidet SB .. 22 skær med APMX på 15 mm. Optimeret til kraftig fræsning med jævn skæring. Differential tanddeling. Dorn type. Krop behandlet for længere værktøjslevetid.

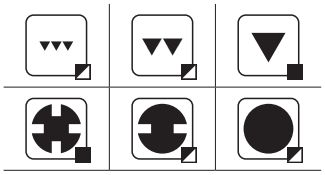
ROUGH SB

KAPR	60°
APMX	15.0 mm









h_m 0.15 - 0.5

	Product	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	DBC2 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	**125B07R-F60SB22X**	125	144.4	63	40	56	–	–	16.4	9	-9	9	7	✓	–	–	3.73	GI144	FA111	AC003
	160C08R-F60SB22X	160	178.7	63	40	–	66.7	–	16.4	9	-9	9	8	✓	–	–	6.46	GI144	FA114	–
	200C08R-F60SB22X	200	217.9	63	60	–	101.6	–	25.7	14	-9	9	8	✓	–	–	10.59	GI144	FA115	–
	250C09R-F60SB22X	250	267.4	63	60	–	101.6	–	25.7	14	-9	9	9	✓	–	–	17.54	GI144	FA115	–

GI144	SBKX 2207DZ..	SBMR 2207DZ..

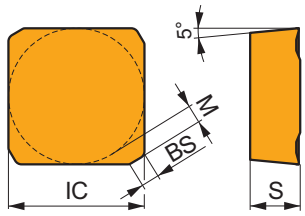
FA111	LNX 220616	US 6013-T20P	SDR T20P-T	KU SBMR 2207	DS 01Z	KL 04	–
FA114	LNX 220616	US 6013-T20P	SDR T20P-T	KU SBMR 2207	DS 01Z	KL 04	HS 1240
FA115	LNX 220616	US 6013-T20P	SDR T20P-T	KU SBMR 2207	DS 01Z	KL 04	HS 1655

AC003	KS 2040	K.FMH40

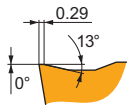
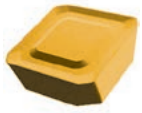
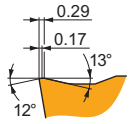
SBMR 22

PRAMET

	IC (mm)	M (mm)	S (mm)	BS (mm)
2207	22.000	2.8	8.00	1.99



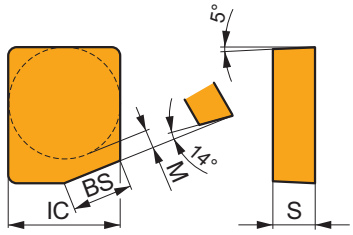
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
DZSR stabilt design til kraftig bearbejdning.																			
SBMR 2207DZSR:M8326	–	140	0.38	8.5	–	–	–	130	0.38	8.5	–	–	–	–	–	–	–	–	–
SBMR 2207DZSR:M8346	–	120	0.38	8.5	70	0.38	8.5	–	–	–	–	–	–	–	–	–	–	–	–
 																			
R geometri med stabilt design til kraftig bearbejdning.																			
SBMR 2207DZSR-R:M5326	–	160	0.44	9.8	–	–	–	150	0.44	9.8	–	–	–	–	–	–	–	–	–
SBMR 2207DZSR-R:M8326	–	135	0.44	9.8	–	–	–	125	0.44	9.8	–	–	–	–	–	–	–	–	–
SBMR 2207DZSR-R:M8346	–	115	0.44	9.8	65	0.40	9.8	–	–	–	–	–	–	–	–	–	–	–	–

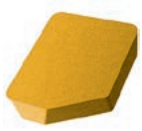
SBKX 22

PRAMET

	IC (mm)	M (mm)	S (mm)	BS (mm)
2207	22.000	3.2	8.00	11.84

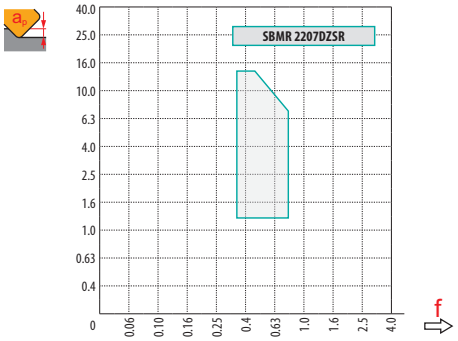


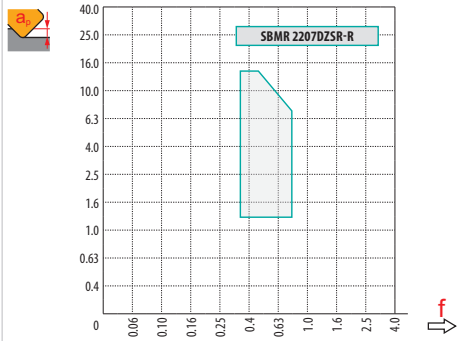
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

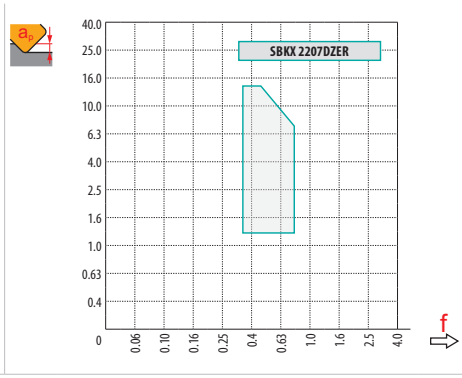
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
DZER nul skær vinkel wiper design for forbedret overfladefinish.																			
SBKX 2207DZER:M8326	–	100	0.60	8.5	–	–	–	95	0.60	8.5	–	–	–	–	–	–	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SBMR 22	SBMR 22-R	SBKX 22
RE	–	–	–
BS	1.99	1.99	11.84







FACE MILLING

	SOD05	SOD06D	SOE06Z			
	45°	45°	43°			
	APMX (mm) 2.7 (10.0)	APMX (mm) 3.1 (8.6)	APMX (mm) 3.3 (9.9)			
	DCX (mm) 32 – 125	DC (mm) 63 – 160	DC (mm) 50 – 200			
Cylindrical shank	DC = 32, 40 (mm)					
Weldon						
Modular						
Shell mill	DC = 40 – 125 (mm)					
Page	42	51	55			
ISO	P M K N	P M K S H	P M N S			
Insert shape						
Inserts	OD.. 0505 RD.. 1205 SD.. 1205	OD.. 0605 RPE. 1505	OEHT 0604 REHT 1604 XEHT 0604			
No. of cutting edges	8 / 8 / 4	8 / 8	8 / 8 / 1			
Face milling	■	■	■			
Chamfer milling	■	■	■			
Helical interpolation	■		◪			
Progressive plunging	■		◪			
Ramping	■		◪			
Shape surfaces milling (copy milling)	■		◪			
Shallow shoulder milling	■					
Shallow slot milling	■					
Plunge milling	■					

■ Primary use ◪ Possible use

SOD05

P M K N

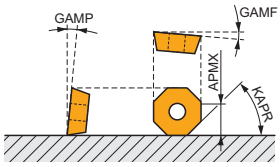
PRAMET

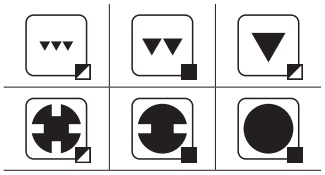
S

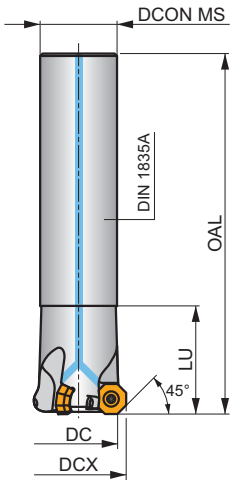
Universal planfræser med positivt design og intern kølevæske

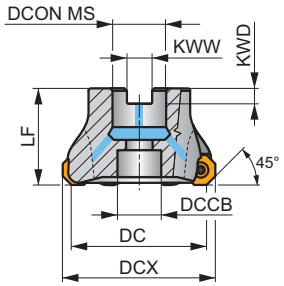
Highly productive universal face mill utilising single-sided positive inserts with APMX up to 2.7 (10) mm. Unique insert seat fits OD.. 05, RD.. 12 and SD.. 12 style inserts, suited for wide range of applications. Differential tooth pitch. Arbor and cylindrical style. Body treated for longer tool life.

KAPR	45°
APMX	2.7 (10.0) mm









h_m	0.03 - 0.15
h_m	0.03 - 0.12

	Product	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	KAPR (°)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835A	**32N3R045A25-SOD05-C**	32	24.7	130	25	–	45	–	45	–	–	-10	8	3	–	17700	✓	0.41	GI326	FA049	–
	40N3R045A32-SOD05-C	40	32.6	150	32	–	45	–	45	–	–	-7	8	3	–	15800	✓	0.86	GI326	FA040	–
	40A03R-S450D05-C	40	32.7	–	16	14	–	40	45	8.4	5.6	-10	8	3	–	15800	✓	0.18	GI326	FA042	–
	50A04R-S450D05-C	50	42.6	–	22	18	–	40	45	10.4	6.3	-7	8	4	–	14100	✓	0.28	GI326	FA043	–
	50A05R-S450D05-C	50	42.6	–	22	18	–	40	45	10.4	6.3	-7	8	5	–	14100	✓	0.28	GI326	FA043	–
ISO 6462 DIN 8030	**63A05R-S450D05-C**	63	55.6	–	22	18	–	40	45	10.4	6.3	-7	8	5	✓	12600	✓	0.39	GI326	FA043	–
	63A06R-S450D05-C	63	55.6	–	22	18	–	40	45	10.4	6.3	-7	8	6	✓	12600	✓	0.50	GI326	FA043	–
	80A06R-S450D05-C	80	72.6	–	27	38	–	50	45	12.4	7	-7	8	6	✓	11100	✓	0.73	GI326	FA041	AC001
	80A08R-S450D05-C	80	72.6	–	27	38	–	50	45	12.4	7	-7	8	8	✓	11100	✓	0.66	GI326	FA041	AC001
	100A07R-S450D05-C	100	92.6	–	32	45	–	50	45	14.4	8	-7	8	7	✓	10000	✓	1.09	GI326	FA041	AC002
	125A08R-S450D05-C	125	117.6	–	40	56	–	63	45	16.4	9	-7	8	8	✓	8900	✓	2.20	GI326	FA041	AC003

GI326	OD.. 0505..	RD.. 1205..	SDKT 1205..	SDMT 1205..SN

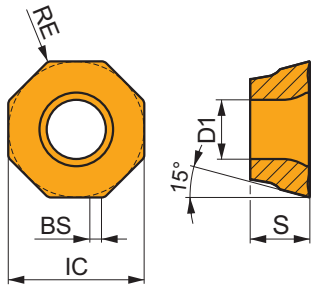
		Nm					
FA040	US 45014-T20P	5.0	M 5	13	Flag T20P	–	–
FA041	US 45014-T20P	5.0	M 5	13	–	SDR T20P-T	–
FA042	US 45014-T20P	5.0	M 5	13	–	SDR T20P-T	HS 90835
FA043	US 45014-T20P	5.0	M 5	13	–	SDR T20P-T	HS 1030C
FA049	US 45011-T20P	5.0	M 5	11	Flag T20P	–	–

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

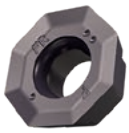
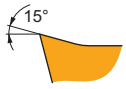
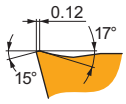
ODKT 05IM

PRAMET

	IC (mm)	D1 (mm)	S (mm)	BS (mm)
0505	12.700	5.50	5.56	1.00



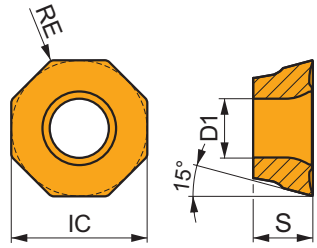
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
F geometri, 45 ° fræser med meget positivt design til let bearbejdning.																				
ODKT 0505ADFR-F:M8310	●	0.8	275	0.15	2.5	140	0.14	2.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
FM geometri, 45 ° fræser med positivt design til let til medium bearbejdning.																				
ODKT 0505ADSR-FM:M6330	⧓	0.8	190	0.25	2.5	135	0.23	2.5	–	–	–	–	–	–	–	–	–	–	–	–
ODKT 0505ADSR-FM:M8310	⧓	0.8	240	0.25	2.5	120	0.23	2.5	225	0.25	2.5	–	–	–	–	–	–	–	–	–
ODKT 0505ADSR-FM:M8330	⧓	0.8	225	0.25	2.5	135	0.23	2.5	210	0.25	2.5	–	–	–	–	–	–	–	–	–
ODKT 0505ADSR-FM:M8345	⧓	0.8	160	0.25	2.5	95	0.23	2.5	–	–	–	–	–	–	–	–	–	–	–	–
ODKT 0505ADSR-FM:M9340	⧓	0.8	245	0.25	2.5	145	0.23	2.5	–	–	–	–	–	–	–	–	–	–	–	–

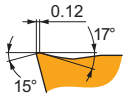
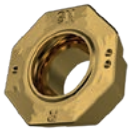
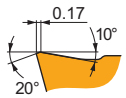
ODMT 05IM

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0505	12.700	5.50	5.56



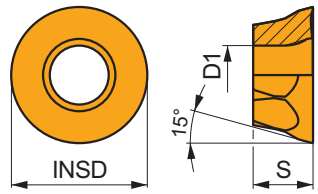
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
FM geometri, 45 ° fræser med positivt design til let til medium bearbejdning.																				
ODMT 0505ADSR-FM:M8340	●	0.8	200	0.25	2.5	120	0.23	2.5	190	0.25	2.5	–	–	–	–	–	–	–	–	–
ODMT 0505ADSR-FM:M9340	●	0.8	245	0.25	2.5	145	0.23	2.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
R geometri, 45 ° planfræser med positivt design for ustabile skæreforhold.																				
ODMT 050508SN-R:M8330	✱	0.8	190	0.25	2.5	–	–	–	180	0.25	2.5	–	–	–	–	–	–	–	–	–
ODMT 050508SN-R:M9340	●	0.8	210	0.25	2.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

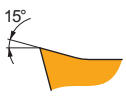
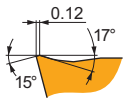
RDGT 12IM

PRAMET

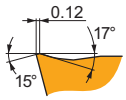
	INSD (mm)	D1 (mm)	S (mm)
1205	12.700	5.50	5.56



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
F geometri med meget positivt design til let bearbejdning.																				
RDGT 120500FN-F:M8310	●	–	210	0.20	1.5	105	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
																				
FM geometri med positivt design til let til medium bearbejdning.																				
RDGT 120500SN-FM:M8330	●	–	190	0.20	1.5	110	0.18	1.5	180	0.20	1.5	–	–	–	–	–	–	–	–	–

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

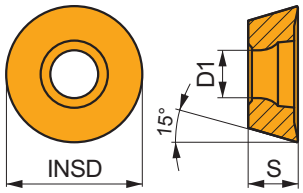
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
RDGT 120500SN-FM:M8345	●	–	■	140	0.20	1.5	◪	80	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–

FM geometri med positivt design til let til medium bearbejdning.

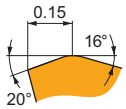
RDMT 12IM

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1205	12.700	5.50	5.56



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

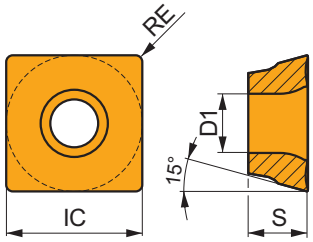
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
RDMT 120500SN-R:M8330	●	–	■	175	0.30	1.5	–	–	–	■	165	0.30	1.5	–	–	–	–	–	–	–	–	–
RDMT 120500SN-R:M8340	●	–	■	160	0.30	1.5	–	–	–	◪	150	0.30	1.5	–	–	–	–	–	–	–	–	–

R geometri, kopi- og profilfræser med positivt design til ustabile skæreforhold.

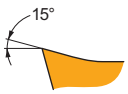
SDKT 12IM

PRAMET

	IC (mm)	D1 (mm)	S (mm)
1205	12.700	5.50	5.56

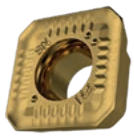
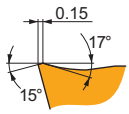


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
SDKT 1205PDFR-F:8215	●	0.8	■	285	0.10	4.0	◪	170	0.09	4.0	–	–	–	◪	855	0.12	4.0	–	–	–	–	–

F geometri, 90 ° hjørnefræser, med meget positivt design til let bearbejdning.

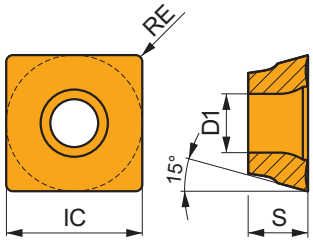
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)
																				
FM geometri, 90 ° hjørnefræser, med positivt design til let til medium bearbejdning.																				
SDKT 1205AESN-FM:M8330		–	280	0.15	4.0	165	0.15	4.0	265	0.15	4.0	–	–	–	–	–	–	–	–	–
SDKT 1205AESN-FM:M8345		–	205	0.15	4.0	120	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–
SDKT 1205PDSR-FM:M8330		0.8	255	0.15	4.0	150	0.15	4.0	240	0.15	4.0	–	–	–	–	–	–	–	–	–
SDKT 1205PDSR-FM:M8345		0.8	185	0.15	4.0	110	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–

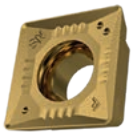
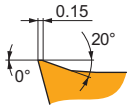
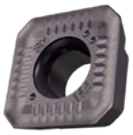
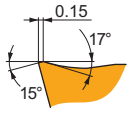
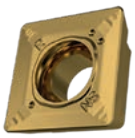
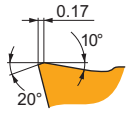
SDMT 12IM

PRAMET

	IC (mm)	D1 (mm)	S (mm)
1205	12.700	5.50	5.56



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

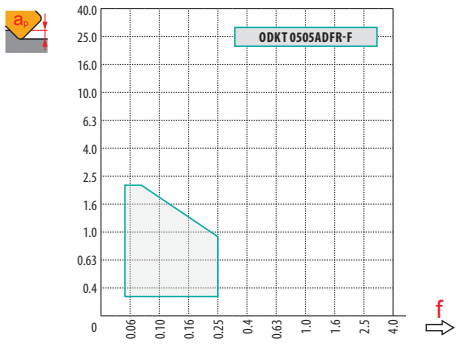
Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)
																				
F geometri, 90 ° hjørnefræser, med positivt design til let til medium bearbejdning.																				
SDMT 120508SN-F:M8310		0.8	265	0.15	4.0	135	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–
SDMT 120508SN-F:M8330		0.8	245	0.15	4.0	145	0.15	4.0	–	–	–	735	0.18	4.0	–	–	–	–	–	–
																				
FM geometri, 90 ° hjørnefræser, med positivt design til medium bearbejdning.																				
SDMT 120508SN-FM:M8345		0.8	175	0.15	4.0	105	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
R geometri, 90 ° hjørnefræser, med positivt design for ustabile skæreforhold.																				
SDMT 120508SN-R:M8330		0.8	225	0.20	4.0	–	–	–	210	0.20	4.0	–	–	–	–	–	–	–	–	–
SDMT 120508SN-R:M8345		0.8	165	0.20	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SDMT 1205AESN-R:M8330		–	265	0.20	4.0	–	–	–	250	0.20	4.0	–	–	–	–	–	–	–	–	–
SDMT 1205AESN-R:M8340		–	240	0.20	4.0	–	–	–	225	0.20	4.0	–	–	–	–	–	–	–	–	–

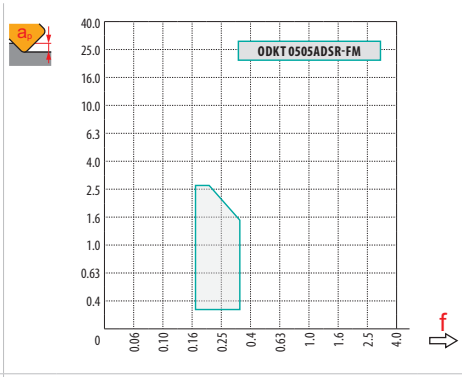
a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

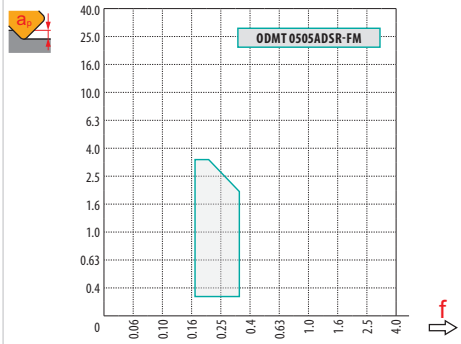
	ODKT 05-F	ODKT 05-FM	ODMT 05-FM	ODMT 05-R
RE	0.4	0.8	0.8	0.8
BS	1.00	1.00	–	–

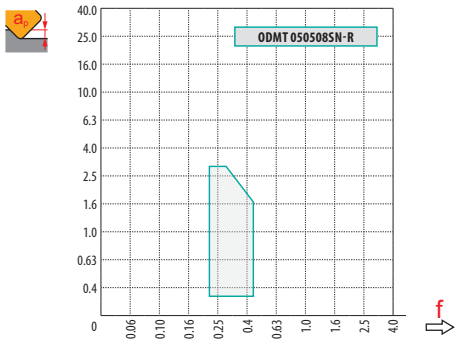
	RDGT 12-F	RDGT 12-FM	RDGT 12-R
RE	6.35	6.35	6.35
BS	–	–	–

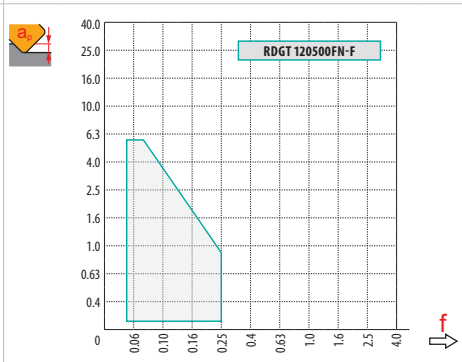
	SDKT 12-F	SDKT 12-FM	SDMT 12-F	SDMT 12-R
RE	0.8	0.8	0.8	0.8
BS	2.30	2.30	–	–

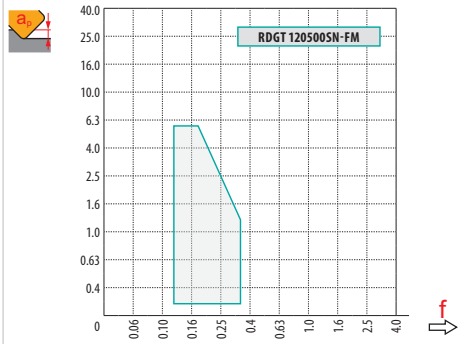


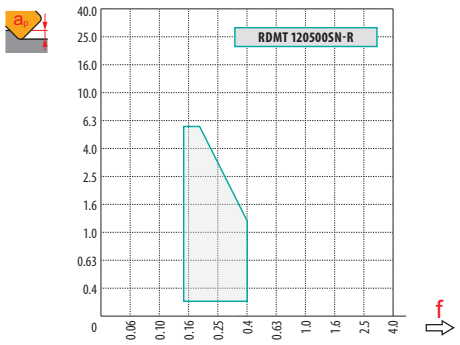


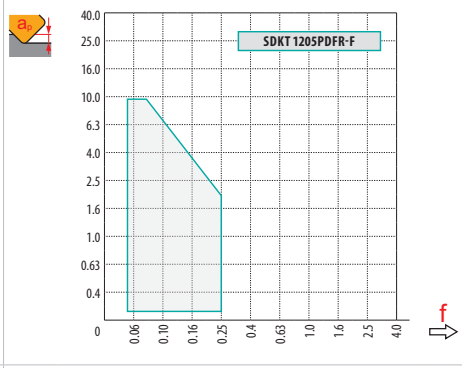


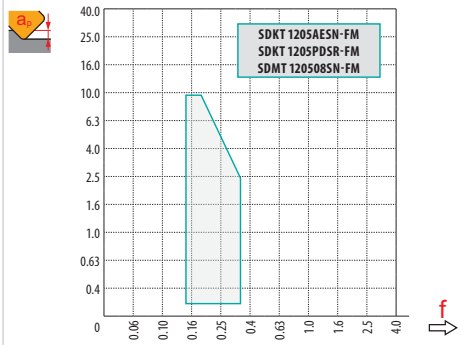


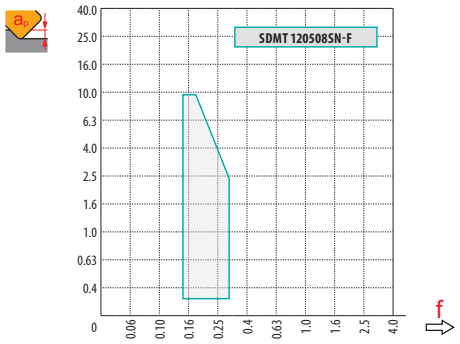


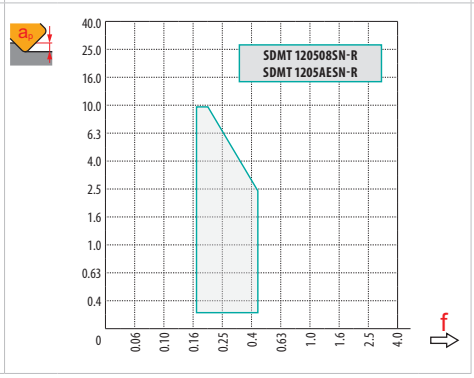












DCX	a_p	0.25	0.50	0.60	0.70	0.80	1.00	1.25	1.50	2.00	3.00	4.00	5.00	6.00
		R												
32		23.43	24.80	25.23	25.62	25.99	26.63	27.33	27.94	28.94	30.39	31.31	31.83	32.00
40		31.43	32.80	33.23	33.62	33.99	34.63	35.33	35.94	36.94	38.39	39.31	39.83	40.00
50	DEF	41.43	42.80	43.23	43.62	43.99	44.63	45.33	45.94	46.94	48.39	49.31	49.83	50.00
63		54.43	55.80	56.23	56.62	56.99	57.63	58.33	58.94	59.94	61.39	62.31	62.83	63.00
80		71.43	72.80	73.23	73.62	73.99	74.63	75.33	75.94	76.94	78.39	79.31	79.83	80.00
100		91.43	92.80	93.23	93.62	93.99	94.63	95.33	95.94	96.94	98.39	99.31	99.83	100.00
125		116.43	117.80	118.23	118.62	118.99	119.63	120.33	120.94	121.94	123.39	124.31	124.83	125.00

DCX	X.V	f_{max}
32	1.36	0.28
40	1.40	0.31
50	1.43	0.33
63	1.47	0.37
80	1.52	0.42
100	1.57	0.47
125	1.62	0.52

S

a_{emax}
10.0

S

a_p	1.0	5.0	10.0
f	0.35	0.21	0.15

O

DCX	RPMX	APMX/I
50	4.1°	7.05/100
63	2.7°	4.6/100
80	1.8°	3/100
100	1.7°	2.85/100
125	0.7°	1.1/100

R

DCX	RPMX	APMX/I
50	3.8°	6.2/95
63	2.5°	4.25/100
80	1.7°	2.85/100
100	1.6°	2.65/100
125	0.3°	0.4/100

O

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
50	78.0	100.0	4.5	4.5
63	105.0	126.0	4.5	4.5
80	138.0	160.0	4.5	4.5
100	178.0	200.0	4.5	4.5
125	229.0	250.0	4.0	4.5

R

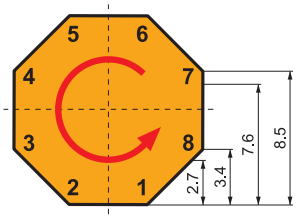
DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
50	78.0	100.0	4.5	4.5
63	105.0	126.0	4.5	4.5
80	138.0	160.0	4.5	4.5
100	178.0	200.0	4.5	4.5
125	230.0	250.0	4.0	4.5

	O	R
a_p	2.4	2.3

DCX	µm	R 3	5	10	15	20	30	40	50	60	80	100
32	FE	0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
125		1.225	1.581	2.236	2.739	3.162	3.873	4.472	5.000	5.477	6.325	7.071

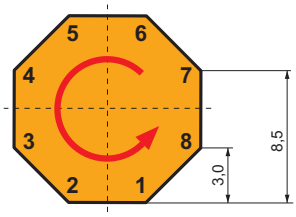
RE	µm	3	5	10	15	20	30	40	50	60	80	100
6.0	FE	0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191

ODKT 05



a_p	
–> 2.7	8
–> 3.4	7
–> 7.6	4
–> 8.5	2

ODMT 05



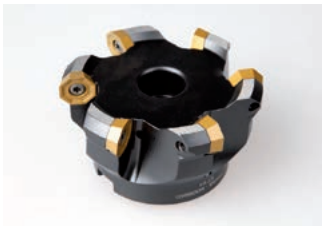
a_p	
–> 3.0	8
–> 8.5	4

SOD06D

P M K S H

PRAMET

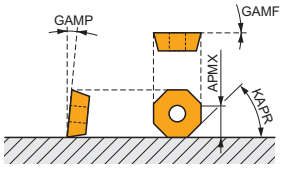
S

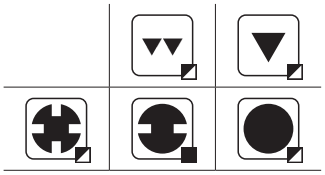


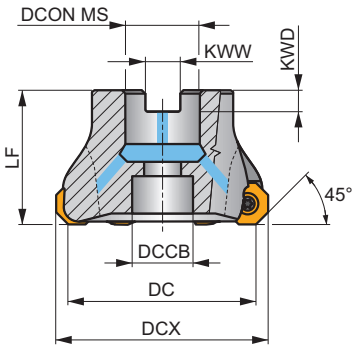
Universal planfræser med positivt design og intern kølevæske

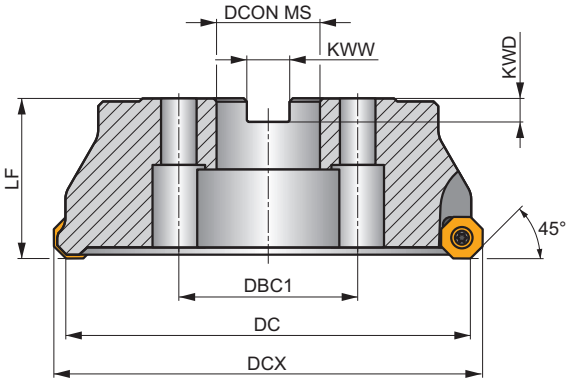
Highly productive universal face mill utilising single sided positive inserts with APMX of up to 3.1 (8.6) mm. Unique insert seat fits OD.. 06 and RP.. 15 style inserts, suited for face milling and chamfering. Arbor style only with differential tooth pitch. Body treated for longer tool life.

KAPR	45°
APMX	3.1 (8.6) mm









h_m 0.12 - 0.22

	Product	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
ISO 6462 DIN 8030	**63A05R-S450D06D**	63	72.5	40	22	18	–	10.4	6.3	0	5	5	✓	8800	✓	0.55	GI059	FA071
	80A06R-S450D06D	80	89.5	50	27	20	–	12.4	7	0	5	6	✓	7800	✓	1.19	GI059	FA071
	100A07R-S450D06D	100	109.5	50	32	27	–	14.4	8	0	5	7	✓	7000	✓	2.07	GI059	FA071
	125A08R-S450D06D	125	134.5	63	40	33	–	16.4	9	0	5	8	✓	6300	✓	4.05	GI059	FA071
	160C09R-S450D06D	160	169.5	63	40	56	66.7	16.4	9	0	5	9	✓	5500	–	6.49	GI059	FA071

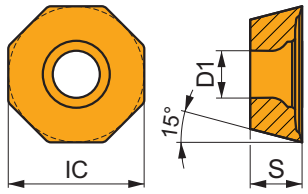
GI059	OD.. 0605ZZ..	RP.. 1505M0..

FA071	US 4511-T20	5.0 Nm	M 4.5	11	SDR T20-T

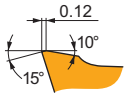
ODMT 06

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0605	15.875	5.50	5.56



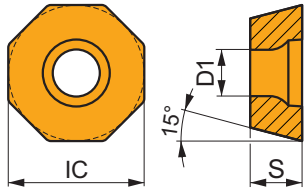
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
ZZN lidt positivt design, 45 ° fræser til medium bearbejdning.																			
ODMT 0605ZZN:M5315	–	255	0.24	3.0	–	–	–	240	0.24	3.0	–	–	–	–	–	–	–	–	–
ODMT 0605ZZN:M8330	–	200	0.24	3.0	–	–	–	190	0.24	3.0	–	–	–	–	–	–	–	–	–
ODMT 0605ZZN:M8340	–	185	0.24	3.0	–	–	–	175	0.24	3.0	–	–	–	–	–	–	–	–	–
ODMT 0605ZZN:M9325	–	245	0.24	3.0	–	–	–	230	0.24	3.0	–	–	–	–	–	–	–	–	–

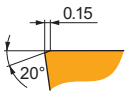
ODEW 06

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0605	15.875	5.50	5.56

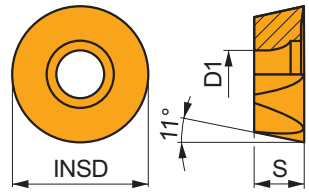


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

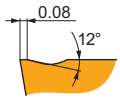
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
ZZN nul skærvinkeldesign, 45 ° fræser, til medium bearbejdning.																			
ODEW 0605ZZN:M8330	–	210	0.26	2.5	–	–	–	195	0.26	2.5	–	–	–	–	–	–	40	0.13	1.0

RPET 15

	INSD	D1	S
	(mm)	(mm)	(mm)
1505	15.785	5.50	5.56



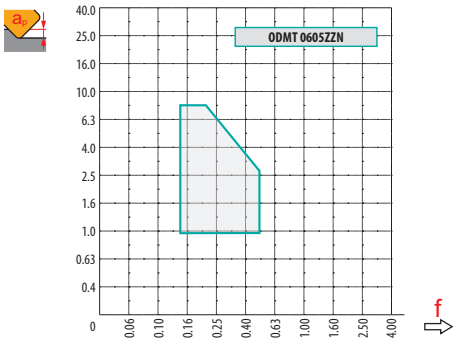
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

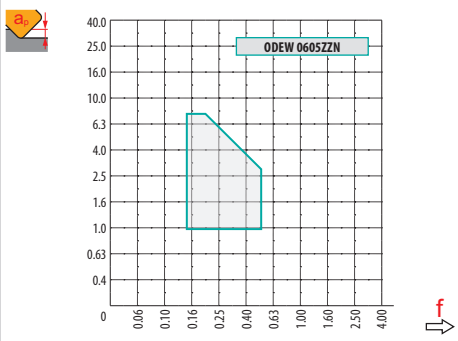
Product		RE	**P**			**M**			**K**			**N**			**S**			**H**		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				
RPET 1505MOS-M:M8330	✱	–	■	230	0.40	1.0	◪	135	0.36	1.0	◪	215	0.40	1.0		–	–	–	◪	55	0.28	0.8		–	–	–

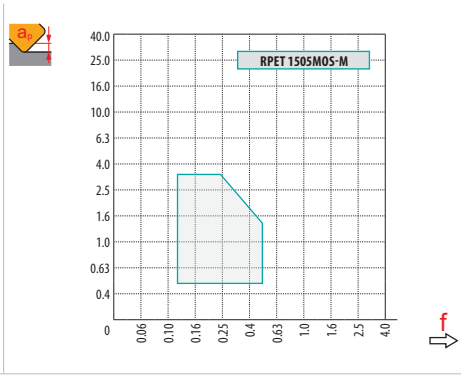
M geometri, kopi- og profilfræsning med positivt design til let til grov bearbejdning.

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ODMT 06	ODEW 06	RPET 15-M
RE	–	–	7.89
BS	1.73	5.92	–

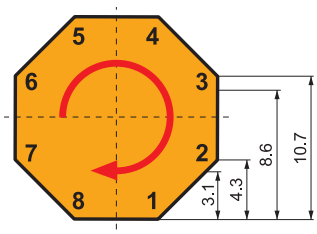






DC	a_p	0.00	0.50	0.75	1.25	1.50	2.00	2.50	3.00	4.00
63	DEF	56.63	62.17	63.36	65.18	65.91	67.16	68.19	69.05	70.41
80		73.63	79.17	80.36	82.18	82.91	84.16	85.19	86.05	87.41
100		93.63	99.17	100.36	102.18	102.91	104.16	105.19	106.05	107.41
125		118.63	124.17	125.36	127.18	127.91	129.16	130.19	131.05	132.41
160		153.63	159.17	160.36	162.18	162.91	164.16	165.19	166.05	167.41

DC	X.V	f_{max}
63	1.49	0.78
80	1.54	0.88
100	1.59	0.98
125	1.64	1.10
160	1.70	1.24



a_p	
–> 3.1	8
–> 4.3	7
–> 8.6	4
–> 10.7	2

SOE06Z

P M N S

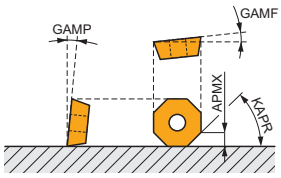
PRAMET

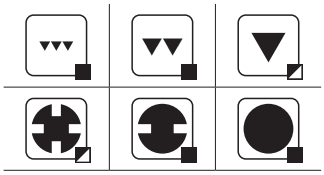
S

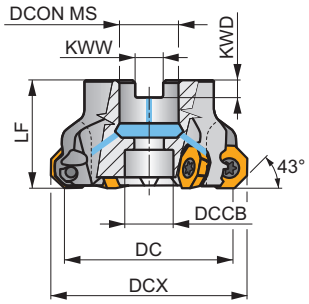
Universal planfræser med positivt design og intern kølevæske

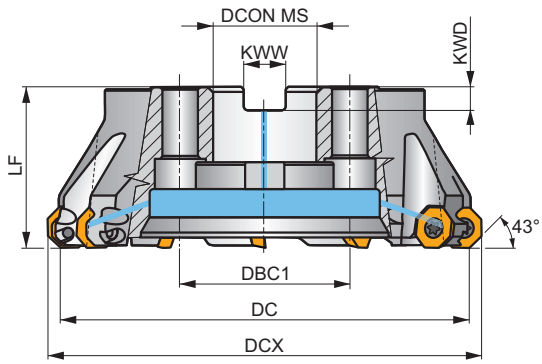
Højproduktiv universal planfræser med positive ensidige skær med APMX på 4 mm til RE .. 16. Unikt skær sæde passer til OE .. 06, RE .. 16 og XE .. 06 skær, der er velegnet til en bred vifte af applikationer. Dorn type med differentieret tanddeling. Krop behandlet for længere værktøjslevetid.

KAPR	43°
APMX	3.3 (9.9) mm









h_m 0.06 - 0.20

	Product	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
	50A04R-S45OE06Z-C	50	60.2	40	22	18	–	10.4	6.3	6	10	4	✓	10700	✓	0.47	GI283	FA053	–
	50A05R-S45OE06Z-C	50	60	40	22	18	–	10.4	6.3	1	10	5	✓	10700	✓	0.47	GI283	FA053	–
	56A05R-S45OE06Z-C	56	66	40	22	18	–	10.4	6.3	6	10	5	✓	10100	✓	0.52	GI283	FA053	–
	63A04R-S45OE06Z-C	63	73.2	40	22	18	–	10.4	6.3	6	10	4	✓	9600	✓	0.58	GI283	FA053	–
	63A06R-S45OE06Z-C	63	73	40	22	18	–	10.4	6.3	1	10	6	✓	9600	✓	0.60	GI283	FA053	–
	70A06R-S45OE06Z-C	70	80	40	22	18	–	10.4	6.3	6	10	6	✓	9100	✓	0.69	GI283	FA053	–
	80A05R-S45OE06Z-C	80	90.2	50	27	38	–	12.4	7	6	10	5	✓	8500	✓	1.02	GI283	FA051	AC001
	80A06R-S45OE06Z-C	80	90.2	50	27	38	–	12.4	7	6	10	6	✓	8500	✓	1.03	GI283	FA051	AC001
ISO 6462 DIN 8030	**90A07R-S45OE06Z-C**	90	100	50	32	45	–	14.4	8	6	10	7	✓	8000	✓	1.59	GI283	FA051	AC002
	100A06R-S45OE06Z-C	100	110.2	50	32	45	–	14.4	8	6	10	6	✓	7600	✓	1.85	GI283	FA051	AC002
	100A08R-S45OE06Z-C	100	109.9	50	32	45	–	14.4	8	1	10	8	✓	7600	✓	1.87	GI283	FA051	AC002
	125A07R-S45OE06Z-C	125	135.2	63	40	56	–	16.4	9	6	10	7	✓	6800	✓	3.31	GI283	FA051	AC003
	125A09R-S45OE06Z-C	125	134.9	63	40	56	–	16.4	9	1	10	9	✓	6800	✓	3.35	GI283	FA051	AC003
	160C09R-S45OE06Z-C	160	170.2	63	40	–	66.7	16.4	9	6	10	9	✓	6000	✓	6.08	GI283	FA056	–
	160C12R-S45OE06Z-C	160	169.9	63	40	–	66.7	16.4	9	1	10	12	✓	6000	✓	7.06	GI283	FA056	–
	200C11R-S45OE06Z-C	200	210.2	63	60	–	101.6	25.7	14	6	10	11	✓	5300	✓	10.80	GI283	FA057	–
	200C14R-S45OE06Z-C	200	209.9	63	60	–	101.6	25.7	14	1	10	14	✓	5300	✓	11.15	GI283	FA057	–

GI283	OEHT 0604AE..	REHT 1604M0..	XEHT 0604AE..

		Nm							
FA051	US 5011-T20P	5.0	M 5	11	SDR T20P-T	–	–	–	–
FA053	US 5011-T20P	5.0	M 5	11	SDR T20P-T	HS 1030C	–	–	–

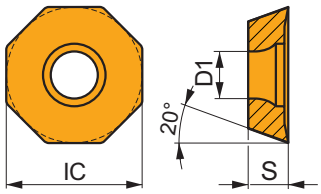
		Nm							
FA056	US 5011-T20P	5.0	M 5	11	SDR T20P-T	HS 1240C	CAC 160C	HSD 0825C	HXK 5
FA057	US 5011-T20P	5.0	M 5	11	SDR T20P-T	HS 1655C	CAC 200C	HSD 1025C	HXK 7

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

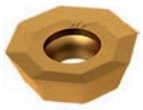
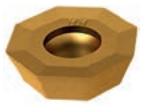
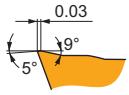
OEHT 06

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0604	16.050	5.50	4.76



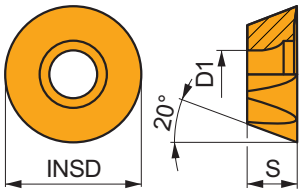
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
MF geometri, 45 ° fræser med skarpt positivt design til let til medium og potentielt færdigbearbejdning.																				
OEHT 0604AEER-MF:M6330		–	255	0.12	2.2	180	0.11	2.2	–	–	–	–	–	–	75	0.10	1.8	–	–	–
OEHT 0604AEER-MF:M8330		–	295	0.12	2.2	175	0.11	2.2	–	–	–	885	0.14	2.2	70	0.10	1.8	–	–	–
OEHT 0604AEER-MF:M8340		–	275	0.12	2.2	165	0.11	2.2	–	–	–	–	–	–	65	0.10	1.8	–	–	–
																				
MM geometri, 45 ° fræser med skarpt positivt design til let til medium bearbejdning.																				
OEHT 0604AEER-MM:M6330		–	245	0.16	2.2	170	0.14	2.2	–	–	–	–	–	–	70	0.11	1.8	–	–	–
OEHT 0604AEER-MM:M8330		–	280	0.16	2.2	165	0.14	2.2	–	–	–	840	0.19	2.2	70	0.11	1.8	–	–	–
OEHT 0604AEER-MM:M8340		–	255	0.16	2.2	150	0.14	2.2	–	–	–	–	–	–	60	0.11	1.8	–	–	–
OEHT 0604AEER-MM:M8345		–	205	0.16	2.2	120	0.14	2.2	–	–	–	–	–	–	50	0.11	1.8	–	–	–
OEHT 0604AEER-MM:M9340		–	320	0.16	2.2	190	0.14	2.2	–	–	–	–	–	–	80	0.11	1.8	–	–	–
																				
M geometri, 45 ° fræser med let positivt design til let til medium bearbejdning.																				
OEHT 0604AESR-M:M6330		–	210	0.24	3.2	150	0.22	3.2	–	–	–	–	–	–	60	0.17	2.6	–	–	–
OEHT 0604AESR-M:M8310		–	265	0.24	3.2	135	0.22	3.2	–	–	–	–	–	–	–	–	–	–	–	–
OEHT 0604AESR-M:M8330		–	245	0.24	3.2	145	0.22	3.2	–	–	–	–	–	–	60	0.17	2.6	–	–	–
OEHT 0604AESR-M:M8340		–	220	0.24	3.2	130	0.22	3.2	–	–	–	–	–	–	55	0.17	2.6	–	–	–
OEHT 0604AESR-M:M9325		–	295	0.24	3.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

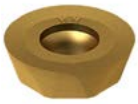
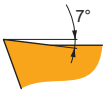
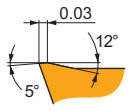
REHT 16

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1604	16.000	5.50	4.76



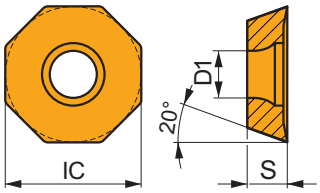
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
  E																			
MM geometri, kopi og profilfræsning med let positivt design til let til medium bearbejdning.																			
REHT 1604M0EN-MM:M6330	–	255	0.20	2.0	180	0.18	2.0	–	–	–	–	–	–	75	0.14	1.6	–	–	–
REHT 1604M0EN-MM:M8340	–	270	0.20	2.0	160	0.18	2.0	–	–	–	–	–	–	65	0.14	1.6	–	–	–
REHT 1604M0EN-MM:M9340	–	330	0.20	2.0	195	0.18	2.0	–	–	–	–	–	–	80	0.14	1.6	–	–	–
 S																			
M geometri, kopi og profilfræser med positivt design til let til medium bearbejdning.																			
REHT 1604M0SN-M:M8310	–	285	0.30	2.0	145	0.27	2.0	–	–	–	–	–	–	–	–	–	–	–	–
REHT 1604M0SN-M:M8330	–	270	0.30	2.0	160	0.27	2.0	–	–	–	–	–	–	65	0.21	1.6	–	–	–
REHT 1604M0SN-M:M8340	–	245	0.30	2.0	145	0.27	2.0	–	–	–	–	–	–	60	0.21	1.6	–	–	–

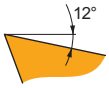
OEHT 06-FA

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0604	16.050	5.50	4.76

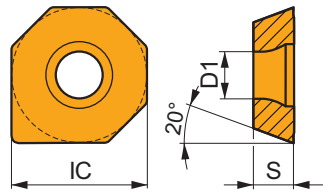


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 1 F																			
FA geometri, 45 ° fræser med yderst positivt design til finbearbejdning til medium bearbejdning.																			
OEHT 0604AEFR-FA:HF7	–	–	–	–	–	–	–	–	–	–	330	0.18	2.0	–	–	–	–	–	–
OEHT 0604AEFR-FA:M0315	–	–	–	–	–	–	–	–	–	–	765	0.18	2.0	–	–	–	–	–	–

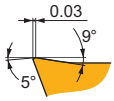
XEHT 06

	IC	D1	S
	(mm)	(mm)	(mm)
0604	16.050	5.50	4.76



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)

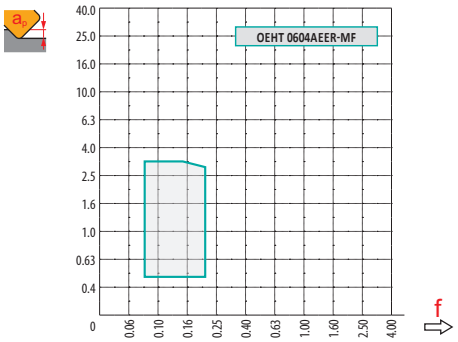


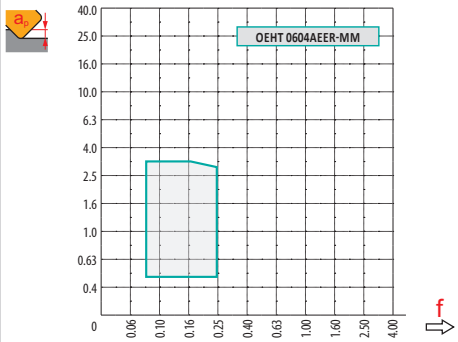
W lidt positivt wiper design for forbedret overfladefinish.

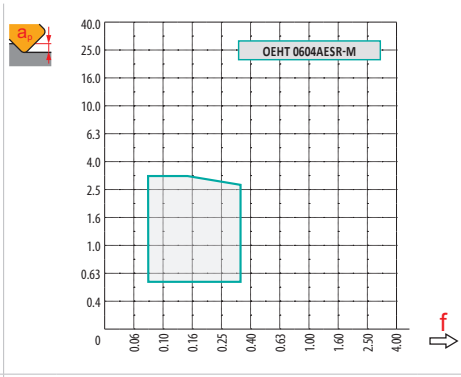
XEHT 0604AESR:M8310		–	■	265	0.24	3.2	◪	135	0.22	3.2	–	–	–	–	–	–	–	–	–	–	–	–
XEHT 0604AESR:M8330		–	■	245	0.24	3.2	◪	145	0.22	3.2	–	–	–	–	–	–	–	–	–	–	–	–

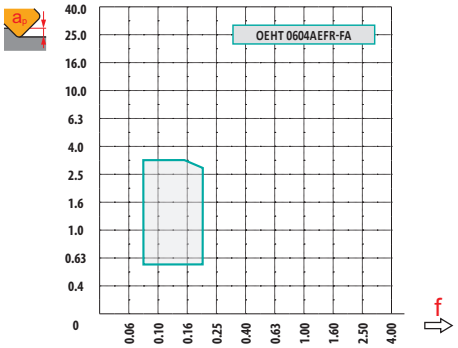
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

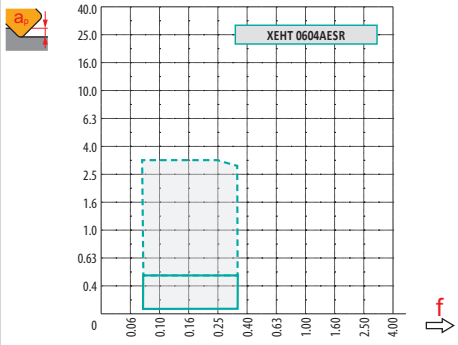
	OEHT 06-MF	OEHT 06-MM	OEHT 06-M	OEHT 06-FA	XEHT 06	REHT 16-MM	REHT 16-M
RE	–	–	–	–	–	8.00	8.00
BS	1.36	1.36	1.36	1.36	9.91	–	–

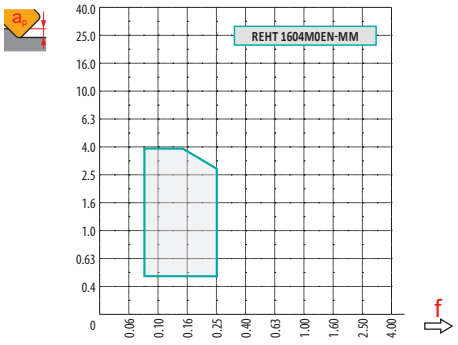


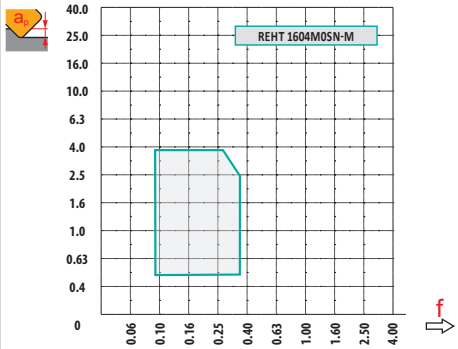












DC	R								
	a_p	0.00	0.50	0.75	1.25	1.50	2.00	2.50	3.00	4.00
50		43.90	49.47	50.66	52.49	53.23	54.48	55.52	56.39	57.76
56		49.80	55.37	56.56	58.39	59.13	60.38	61.42	62.29	63.66
63		56.90	62.47	63.66	65.49	66.23	67.48	68.52	69.39	70.76
70		63.80	69.37	70.56	72.39	73.13	74.38	75.42	76.29	77.66
80	DEF	73.90	79.47	80.66	82.49	83.23	84.48	85.52	86.39	87.76
90		83.80	89.37	90.56	92.39	93.13	94.38	95.42	96.29	97.66
100		93.90	99.47	100.66	102.49	103.23	104.48	105.52	106.39	107.76
125		118.90	124.47	125.66	127.49	128.23	129.48	130.52	131.39	132.76
160		153.90	159.47	160.66	162.49	163.23	164.48	165.52	166.39	167.76
200		193.90	199.47	200.66	202.49	203.23	204.48	205.52	206.39	207.76

DC	X.V	f_{max}
50	1.43	0.33
56	1.45	0.35
63	1.47	0.37
70	1.49	0.39
80	1.52	0.42
90	1.55	0.44
100	1.57	0.47
125	1.62	0.52
160	1.68	0.59
200	1.73	0.66

O		
DC	RPMX	APMX/I
50	4.9°	8.4/100
56	4.2°	7.2/100
63	3.6°	6.1/100
70	3.1°	5.3/100
80	2.6°	4.4/100
90	2.3°	3.9/100
100	2.0°	3.3/100
125	1.5°	2.5/100

R		
DCX	RPMX	APMX/I
59.9	4.6°	7.9/100
65.8	4.0°	6.8/100
72.9	3.0°	5.1/100
79.8	2.7°	4.6/100
89.9	2.2°	3.7/100
99.8	2.0°	3.3/100
109.9	1.8°	3.0/100
134.9	1.3°	2.1/100

O				
DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
50	91.5	120.0	5.9	5.9
56	103.2	131.5	5.9	5.9
63	117.4	146.0	5.9	5.9
70	131.2	159.5	5.9	5.9
80	151.4	180.0	5.9	5.9
90	171.2	199.5	5.9	5.9
100	191.4	220.0	5.9	5.9
125	241.3	270.0	5.9	5.9

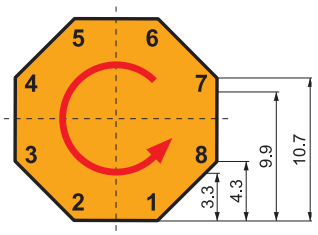
R				
DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
59.9	91.5	119.5	5.9	5.9
65.8	103.5	131.0	5.9	5.9
72.9	118.0	145.5	5.9	5.9
79.8	131.5	159.0	5.9	5.9
89.9	151.5	179.5	5.9	5.9
99.8	171.5	199.0	5.9	5.9
109.9	191.5	219.5	5.9	5.9
134.9	241.5	269.5	5.9	5.9

	O	R
a_p	3.1	3.0

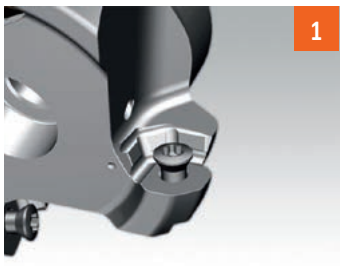
R

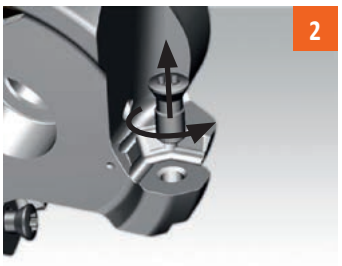
DCX	µm	3	5	10	15	20	30	40	50	60	80	100
59.9	FE	0.848	1.095	1.548	1.896	2.189	2.681	3.096	3.461	3.792	4.378	4.895
65.8		0.889	1.147	1.622	1.987	2.294	2.810	3.245	3.628	3.974	4.589	5.130
72.9		0.935	1.207	1.708	2.091	2.415	2.958	3.415	3.818	4.183	4.830	5.400
79.8		0.979	1.263	1.787	2.188	2.527	3.095	3.573	3.995	4.376	5.053	5.650
89.9		1.039	1.341	1.896	2.322	2.682	3.285	3.793	4.240	4.645	5.364	5.997
99.8		1.094	1.413	1.998	2.447	2.826	3.461	3.996	4.468	4.894	5.651	6.318

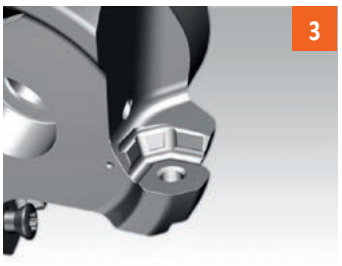
RE	µm	3	5	10	15	20	30	40	50	60	80	100
8.0	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530

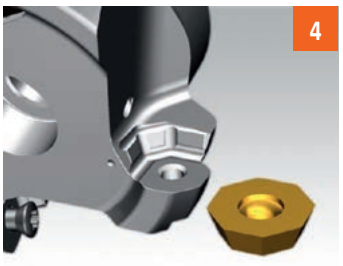


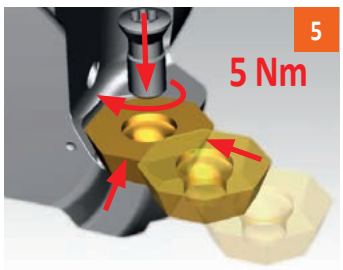
a_p	
–> 3.3	8
–> 4.3	7
–> 9.9	4
–> 10.7	2

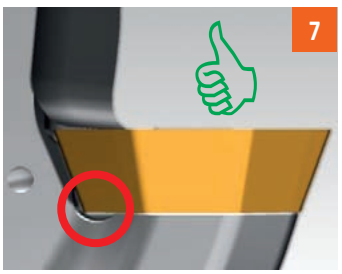


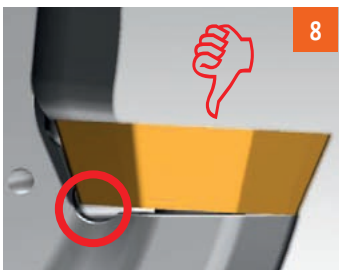












HJØRNEFRÆSNING

FACE MILLING

	STN10	STN16	SLN12	SLN16	SLN12X
	90°	90°	90°	90°	90°
	APMX (mm) 5.0	APMX (mm) 10.0	APMX (mm) 9.0	APMX (mm) 13.0	APMX (mm) 10.0
	DC (mm) 18 – 80	DC (mm) 25 – 175	DC (mm) 25 – 125	DC (mm) 63 – 175	DC (mm) 25 – 125
Cylindrical shank	DC = 18 – 35 (mm)	DC = 25 – 35 (mm)	DC = 25, 32 (mm)		DC = 25 – 40 (mm)
Weldon	DC = 20 – 32 (mm)	DC = 25 – 40 (mm)	DC = 25 – 40 (mm)		DC = 25 – 40 (mm)
Modular	DC = 20 – 32 (mm)	DC = 25 – 40 (mm)	DC = 25 – 40 (mm)		
Shell mill	DC = 40 – 80 (mm)	DC = 40 – 175 (mm)	DC = 40 – 125 (mm)		DC = 40 – 125 (mm)
Page	66	70	75	81	85
ISO	P M K N	P M K N	P M K N	P K N H	P M K H
Insert shape					
Inserts	TNGX 1004	TNGX 1606	LNG. 1205	LN.U 1607	LNEX 1210
No. of cutting edges	6	6	4	4	4
Face milling	■	■	■	■	■
Chamfer milling	◪	◪	◪		◪
Helical interpolation	■	■	■	■	■
Progressive plunging	◪		■	■	■
Ramping	◪		◪		
Shape surfaces milling (copy milling)	◪		◪		◪
Shallow shoulder milling	■	■	◪		■
Shallow slot milling			◪	◪	

■ Primary use ◪ Possible use

STN10

P M K N S

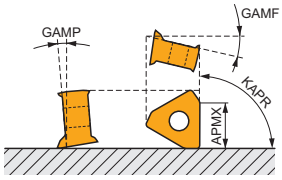
PRAMET

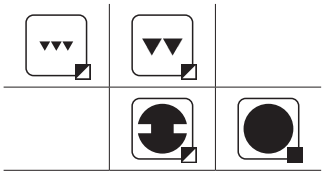
S

ECON TN10 skaftfræser med indvendig kølevæske

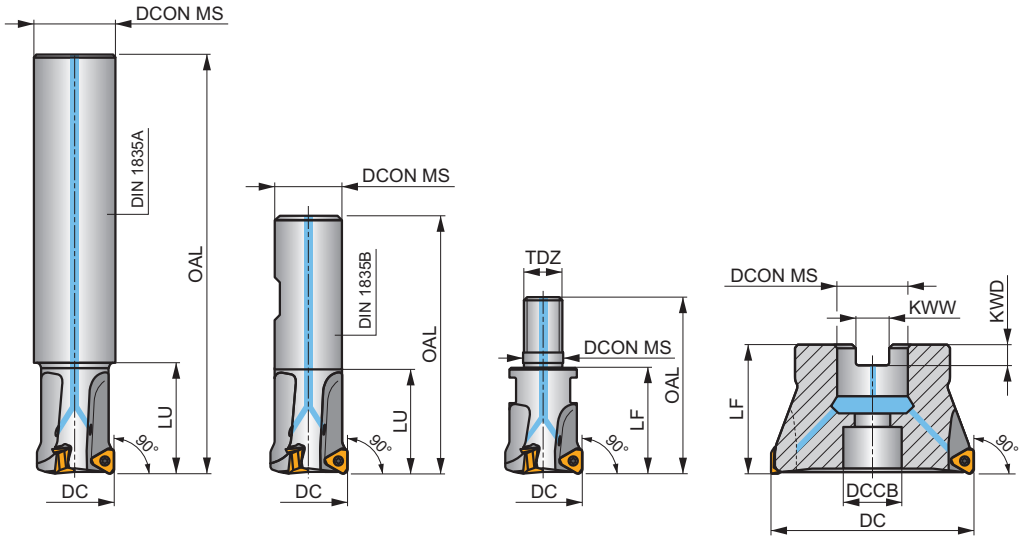
90° ende- og skaftfræser med dobbeltsidet TNGX 10-skær med 6 skærekanter og APMX på 5 mm. Velegnet til en lang række applikationer. Fås i cylindrisk, weldon, modulær og dorn-stil, med eller uden differentieret tandafstand. Krop behandlet for længere levetid på værktøjet.

KAPR	90°
APMX	5.0 mm





ECON TN



h_m	0.03 - 0.06
h_m	0.03 - 0.08

	Product	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
	18A2R050A20-STN10-C	18	180	20	–	50	–	–	–	–	-17.1	-11	2	–	29100	✓	0.39	GI292	SQ300	–
	20A2R029A20-STN10-C	20	150	20	–	29	–	–	–	–	-16.5	-11	2	–	27600	✓	0.35	GI292	SQ300	–
	20A3R029A20-STN10-C	20	150	20	–	29	–	–	–	–	-16.5	-11	3	–	27600	✓	0.34	GI292	SQ300	–
	22A3R050A25-STN10-C	22	180	25	–	50	–	–	–	–	-16.5	-11	3	–	26300	✓	0.58	GI292	SQ300	–
DIN 1835A	**25A3R034A25-STN10-C**	25	170	25	–	34	–	–	–	–	-16	-11	3	–	24700	✓	0.58	GI292	SQ300	–
	25A4R034A25-STN10-C	25	170	25	–	34	–	–	–	–	-16	-11	4	✓	24700	✓	0.58	GI292	SQ300	–
	30A4R050A32-STN10-C	30	200	32	–	50	–	–	–	–	-16	-11	4	✓	22500	✓	1.06	GI292	SQ300	–
	32A4R037A32-STN10-C	32	195	32	–	37	–	–	–	–	-16	-11	4	✓	21800	✓	1.08	GI292	SQ300	–
	32A5R037A32-STN10-C	32	195	32	–	37	–	–	–	–	-16	-11	5	✓	21800	✓	1.08	GI292	SQ300	–
	35A5R080A32-STN10-C	35	200	32	–	80	–	–	–	–	-16	-11	5	✓	20800	✓	1.07	GI292	SQ300	–
	20A2R032B20-STN10-C	20	90	20	–	32	–	–	–	–	-16.5	-11	2	–	27600	✓	0.20	GI292	SQ300	–
	20A3R032B20-STN10-C	20	90	20	–	32	–	–	–	–	-16.5	-11	3	–	27600	✓	0.19	GI292	SQ300	–
DIN 1835B	**25A3R042B25-STN10-C**	25	100	25	–	42	–	–	–	–	-16	-11	3	–	24700	✓	0.31	GI292	SQ300	–
	25A4R042B25-STN10-C	25	100	25	–	42	–	–	–	–	-16	-11	4	✓	24700	✓	0.31	GI292	SQ300	–
	32A4R042B32-STN10-C	32	110	32	–	42	–	–	–	–	-16	-11	4	✓	21800	✓	0.57	GI292	SQ300	–
	32A5R042B32-STN10-C	32	110	32	–	42	–	–	–	–	-16	-11	5	✓	21800	✓	0.56	GI292	SQ300	–
	20A2R026M10-STN10-C	20	45	10.5	–	–	26	M10	–	–	-16.5	-11	2	–	–	✓	0.06	GI292	SQ300	–
	20A3R026M10-STN10-C	20	45	10.5	–	–	26	M10	–	–	-16.5	-11	3	–	–	✓	0.06	GI292	SQ300	–
MODULAR	**25A3R033M12-STN10-C**	25	55	12.5	–	–	33	M12	–	–	-16	-11	3	–	–	✓	0.10	GI292	SQ300	–
	25A4R033M12-STN10-C	25	55	12.5	–	–	33	M12	–	–	-16	-11	4	✓	–	✓	0.10	GI292	SQ300	–
	32A4R043M16-STN10-C	32	66	17	–	–	43	M16	–	–	-16	-11	4	✓	–	✓	0.21	GI292	SQ300	–
	32A5R043M16-STN10-C	32	66	17	–	–	43	M16	–	–	-16	-11	5	✓	–	✓	0.21	GI292	SQ300	–
	40A04R-S90TN10-C	40	–	16	14	–	40	–	8.4	5.6	-15	-11	4	✓	19500	✓	0.34	GI292	SQ302	–
	40A06R-S90TN10-C	40	–	16	14	–	40	–	8.4	5.6	-15	-11	6	✓	19500	✓	0.34	GI292	SQ302	–
ISO 6462 DIN 8030	**50A05R-S90TN10-C**	50	–	22	18	–	40	–	10.4	6.3	-15	-11	5	✓	17400	✓	0.48	GI292	SQ303	–
	50A07R-S90TN10-C	50	–	22	18	–	40	–	10.4	6.3	-15	-11	7	✓	17400	✓	0.49	GI292	SQ303	–
	63A06R-S90TN10-C	63	–	22	18	–	40	–	10.4	6.3	-15	-11	6	✓	15500	✓	0.63	GI292	SQ303	–

	Product	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	**63A09R-S90TN10-C**	63	–	22	18	–	40	–	10.4	6.3	-15	-11	9	✓	15500	✓	0.63	GI292	SQ303	–
	80A10R-S90TN10-C	80	–	27	38	–	50	–	12.4	7	-15	-11	10	✓	13800	✓	1.03	GI292	SQ301	AC001

GI292	TNGX 1004..

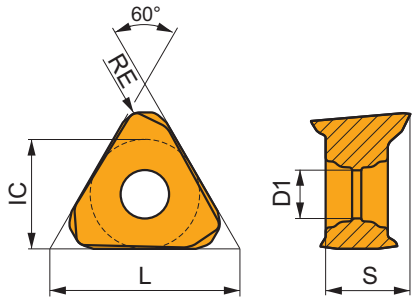
		Nm						
SQ300	US 52506-T07P	0.8	M 2.5	6	–	–	Flag T07P	–
SQ301	US 52506-T07P	0.8	M 2.5	6	D-T07P/T09P	FG-15	–	–
SQ302	US 52506-T07P	0.8	M 2.5	6	D-T07P/T09P	FG-15	–	HS 0830C
SQ303	US 52506-T07P	0.8	M 2.5	6	D-T07P/T09P	FG-15	–	HS 1030C

AC001	KS 1230	K.FMH27

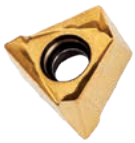
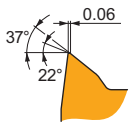
TNGX 10

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1004	6.000	2.80	10.39	4.69

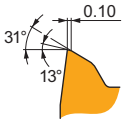


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
TNGX 100402SR-F:M8330	●	0.2	205	0.09	2.0	120	0.08	2.0	190	0.09	2.0	–	–	–	–	–	–	–	–	–
TNGX 100402SR-F:M8340	●	0.2	190	0.09	2.0	110	0.08	2.0	180	0.09	2.0	–	–	–	–	–	–	–	–	–
TNGX 100404SR-F:8215	●	0.4	225	0.09	2.0	135	0.08	2.0	210	0.09	2.0	–	–	–	–	–	–	–	–	–
TNGX 100404SR-F:M6330	●	0.4	190	0.09	2.0	135	0.08	2.0	–	–	–	–	–	–	–	–	–	–	–	–
TNGX 100404SR-F:M8330	●	0.4	220	0.09	2.0	130	0.08	2.0	205	0.09	2.0	–	–	–	–	–	–	–	–	–
TNGX 100404SR-F:M8340	●	0.4	200	0.09	2.0	120	0.08	2.0	190	0.09	2.0	–	–	–	–	–	–	–	–	–
TNGX 100404SR-F:M9340	●	0.4	270	0.09	2.0	160	0.08	2.0	–	–	–	–	–	–	–	–	–	–	–	–
TNGX 100408SR-F:8215	●	0.8	270	0.09	2.0	160	0.08	2.0	255	0.09	2.0	–	–	–	–	–	–	–	–	–
TNGX 100408SR-F:M6330	●	0.8	225	0.09	2.0	160	0.08	2.0	–	–	–	–	–	–	–	–	–	–	–	–
TNGX 100408SR-F:M8330	●	0.8	260	0.09	2.0	155	0.08	2.0	245	0.09	2.0	–	–	–	–	–	–	–	–	–
TNGX 100408SR-F:M8340	●	0.8	240	0.09	2.0	140	0.08	2.0	225	0.09	2.0	–	–	–	–	–	–	–	–	–
TNGX 100408SR-F:M9340	●	0.8	320	0.09	2.0	190	0.08	2.0	–	–	–	–	–	–	–	–	–	–	–	–

F geometri med meget positivt design til let bearbejdning.

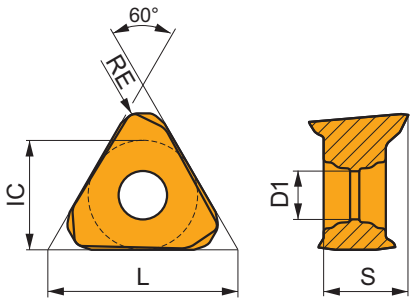
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				
M geometri med positivt design til let til medium bearbejdning.																				
TNGX 100404SR-M:8215	●	0.4	205	0.13	2.0	120	0.12	2.0	190	0.13	2.0	–	–	–	50	0.09	1.6	–	–	–
TNGX 100404SR-M:M6330	●	0.4	175	0.13	2.0	125	0.12	2.0	–	–	–	–	–	–	50	0.09	1.6	–	–	–
TNGX 100404SR-M:M8330	●	0.4	205	0.13	2.0	120	0.12	2.0	190	0.13	2.0	–	–	–	50	0.09	1.6	–	–	–
TNGX 100404SR-M:M8340	●	0.4	185	0.13	2.0	110	0.12	2.0	175	0.13	2.0	–	–	–	45	0.09	1.6	–	–	–
TNGX 100404SR-M:M9340	●	0.4	240	0.13	2.0	140	0.12	2.0	–	–	–	–	–	–	60	0.09	1.6	–	–	–
TNGX 100408SR-M:8215	●	0.8	245	0.13	2.0	145	0.12	2.0	230	0.13	2.0	–	–	–	60	0.09	1.6	–	–	–
TNGX 100408SR-M:M6330	●	0.8	210	0.13	2.0	150	0.12	2.0	–	–	–	–	–	–	60	0.09	1.6	–	–	–
TNGX 100408SR-M:M8310	●	0.8	270	0.13	2.0	135	0.12	2.0	255	0.13	2.0	–	–	–	–	–	–	–	–	–
TNGX 100408SR-M:M8330	●	0.8	245	0.13	2.0	145	0.12	2.0	230	0.13	2.0	–	–	–	60	0.09	1.6	–	–	–
TNGX 100408SR-M:M8340	●	0.8	220	0.13	2.0	130	0.12	2.0	205	0.13	2.0	–	–	–	55	0.09	1.6	–	–	–
TNGX 100408SR-M:M8345	●	0.8	180	0.13	2.0	105	0.12	2.0	–	–	–	–	–	–	45	0.09	1.6	–	–	–
TNGX 100408SR-M:M9340	●	0.8	285	0.13	2.0	170	0.12	2.0	–	–	–	–	–	–	70	0.09	1.6	–	–	–
TNGX 100412SR-M:M8330	●	1.2	255	0.13	2.0	150	0.12	2.0	240	0.13	2.0	–	–	–	60	0.09	1.6	–	–	–
TNGX 100412SR-M:M8340	●	1.2	230	0.13	2.0	135	0.12	2.0	215	0.13	2.0	–	–	–	55	0.09	1.6	–	–	–
TNGX 100416SR-M:M8310	●	1.6	300	0.13	2.0	150	0.12	2.0	285	0.13	2.0	–	–	–	–	–	–	–	–	–
TNGX 100416SR-M:M8330	●	1.6	270	0.13	2.0	160	0.12	2.0	255	0.13	2.0	–	–	–	65	0.09	1.6	–	–	–
TNGX 100416SR-M:M8340	●	1.6	245	0.13	2.0	145	0.12	2.0	230	0.13	2.0	–	–	–	60	0.09	1.6	–	–	–

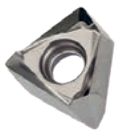
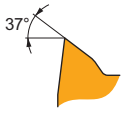
TNGX 10-FA

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1004	6.000	2.80	10.39	4.69

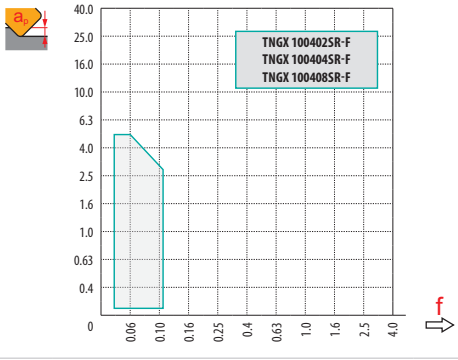


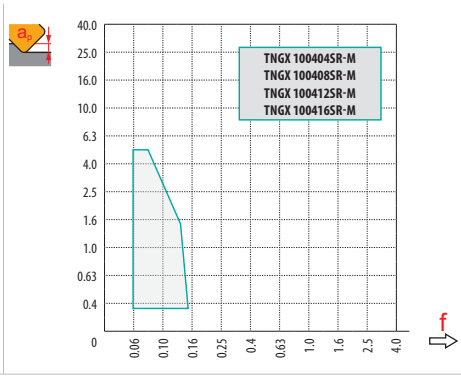
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

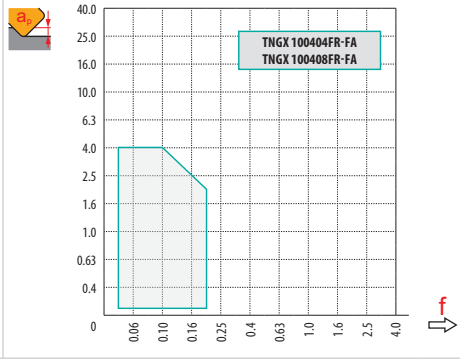
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				
FA geometri med meget positivt design til finbearbejdning til medium bearbejdning.																				
TNGX 100404FR-FA:HF7	●	0.4	–	–	–	–	–	–	–	–	–	345	0.10	1.5	–	–	–	–	–	–
TNGX 100404FR-FA:M0315	●	0.4	–	–	–	–	–	–	–	–	–	780	0.10	1.5	–	–	–	–	–	–
TNGX 100408FR-FA:HF7	●	0.8	–	–	–	–	–	–	–	–	–	345	0.10	1.5	–	–	–	–	–	–
TNGX 100408FR-FA:M0315	●	0.8	–	–	–	–	–	–	–	–	–	780	0.10	1.5	–	–	–	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	TNGX 10-F			TNGX 10-M				TNGX 10-FA	
RE	0.2	0.4	0.8	0.4	0.8	1.2	1.6	0.4	0.8
BS	1.53	1.34	0.92	1.34	0.92			1.33	0.93







max 1.5

a_p	1.0	3.0	5.0
f	0.10	0.08	0.04

a_p 0.2

DC	RPMX	APMX/I
18	1.80°	3.05/100
20	1.60°	2.70/100
22	1.20°	2.00/100
25	1.00°	1.70/100
30	0.90°	1.45/100
32	0.80°	1.30/100
35	0.65°	1.00/100
40	0.60°	0.90/100
50	0.50°	0.70/100
63	0.40°	0.50/100
80	0.25°	0.30/100

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
18	33	36	1.2	1.2
20	37	40	1.2	1.2
22	41	44	1.0	1.0
25	47	50	1.0	1.0
30	57	60	1.0	1.0
32	61	64	1.0	1.0
35	67	70	0.9	0.9
40	77	80	0.9	0.9
50	97	100	0.9	0.9
63	123	126	0.9	0.9
80	157	160	0.9	0.9

STN16

P M K N S

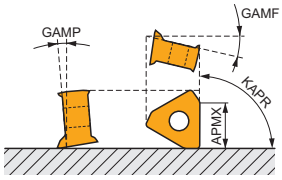
PRAMET

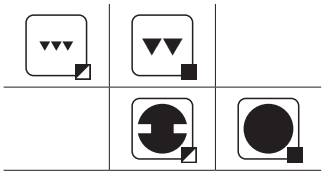
S

ECON TN16 skaftfræser med indvendig kølevæske

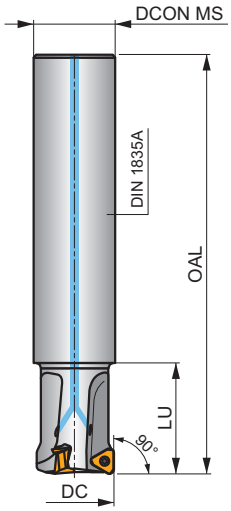
90° ende- og planfræser, der bruger dobbeltsidede TNGX 16-skær med 6 skærekanter og APMX på 10 mm. Velegnet til en lang række applikationer. Fås i cylindrisk, weldon, modulær og dorn (med differentiel tanddeling) i Ø25 op til Ø175 mm. Krop behandlet for længere værktøjslevetid.

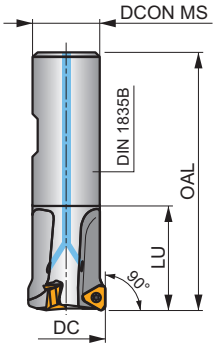
KAPR	90°
APMX	10.0 mm

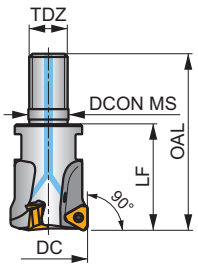


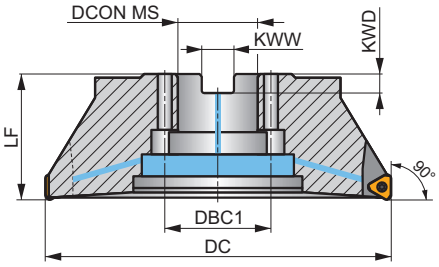


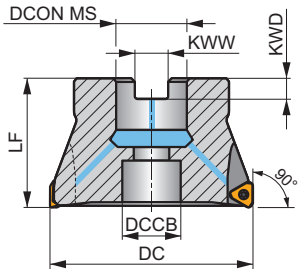
ECON TN











h_m	0.03 - 0.13
h_m	0.03 - 0.15

	Product	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)	max.	kg		
	25A2R034A25-STN16-C	25	170	25	–	–	34	–	–	–	–	-18.5	-9.5	20000	0.54	GI340	C0382
	32A2R034A32-STN16-C	32	195	32	–	–	34	–	–	–	–	-16	-9.5	17500	1.05	GI340	C0382
DIN 1835A	25A2R080A25-STN16-C	25	170	25	–	–	80	–	–	–	–	-18.5	-9.5	20000	0.48	GI340	C0382
DIN 1835A	32A2R080A32-STN16-C	32	195	32	–	–	80	–	–	–	–	-16	-9.5	17500	0.96	GI340	C0382
	32A3R034A32-STN16-C	32	195	32	–	–	34	–	–	–	–	-16	-9.5	17500	1.04	GI340	C0382
	35A3R034A32-STN16-C	35	195	32	–	–	34	–	–	–	–	-16	-9.5	17000	1.07	GI340	C0382
DIN 1835B	25A2R042B25-STN16-C	25	110	25	–	–	42	–	–	–	–	-18.5	-9.5	20000	0.29	GI340	C0382
DIN 1835B	32A3R042B32-STN16-C	32	110	32	–	–	42	–	–	–	–	-16	-9.5	17500	0.52	GI340	C0382
DIN 1835B	40A4R050B32-STN16-C	40	120	32	–	–	50	–	–	–	–	-16	-9.5	16000	0.68	GI340	C0382
	25A2R033M12-STN16-C	25	55	12.5	–	–	–	33	M12	–	–	-18.5	-9.5	20000	0.10	GI340	C0382
MODULAR	32A2R043M16-STN16-C	32	66	17	–	–	–	43	M16	–	–	-16	-9.5	17500	0.18	GI340	C0382
MODULAR	32A3R043M16-STN16-C	32	66	17	–	–	–	43	M16	–	–	-16	-9.5	17500	0.17	GI340	C0382
MODULAR	40A3R043M16-STN16-C	40	66	17	–	–	–	43	M16	–	–	-16	-9.5	16000	0.20	GI340	C0382
MODULAR	40A4R043M16-STN16-C	40	66	17	–	–	–	43	M16	–	–	-16	-9.5	16000	0.21	GI340	C0382
	40A03R-S90TN16-C	40	40	16	12.4	–	–	40	–	8.4	5.6	-16	-9.5	16000	0.32	GI340	C0384
	40A04R-S90TN16-C	40	40	16	12.4	–	–	40	–	8.4	5.6	-16	-9.5	16000	0.31	GI340	C0384
	50A04R-S90TN16-C	50	40	22	18.1	–	–	40	–	10.4	6.3	-16	-9.5	14000	0.34	GI340	C0386
	50A05R-S90TN16-C	50	40	22	18.1	–	–	40	–	10.4	6.3	-16	-9.5	14000	0.32	GI340	C0386
	63A04R-S90TN16-C	63	40	22	18.1	–	–	40	–	10.4	6.3	-16	-9.5	12500	0.47	GI340	C0386
	63A06R-S90TN16-C	63	40	22	18.1	–	–	40	–	10.4	6.3	-16	-9.5	12500	0.48	GI340	C0386
ISO 6462 DIN 8030	80A05R-S90TN16-C	80	50	27	22.1	–	–	50	–	12.4	7	-16	-9.5	11000	1.15	GI340	C0388
ISO 6462 DIN 8030	80A07R-S90TN16-C	80	50	27	22.1	–	–	50	–	12.4	7	-16	-9.5	11000	1.17	GI340	C0388
	100A06R-S90TN16-C	100	50	32	45.1	–	–	50	–	14.4	8	-16	-9.5	10000	1.79	GI340	C0390
	100A08R-S90TN16-C	100	50	32	45.1	–	–	50	–	14.4	8	-16	-9.5	10000	1.66	GI340	C0390
	115A06R-S90TN16-C	115	50	32	45.1	–	–	50	–	14.4	8	-16	-9.5	9500	2.21	GI340	C0390
	125A07R-S90TN16-C	125	63	40	56.1	–	–	63	–	16.4	9	-16	-9.5	9000	3.05	GI340	C0390
	125A09R-S90TN16-C	125	63	40	56.1	–	–	63	–	16.4	9	-16	-9.5	9000	3.14	GI340	C0390

	Product	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
ISO 6462 DIN 8030	**140A08R-S90TN16-C**	140	63	40	56.1	–	–	63	–	16.4	9	-16	-9.5	8	✓	8500	✓	3.69	GI340	C0390
	160C10R-S90TN16-C	160	63	40	–	66.7	–	63	–	16.4	9.2	-16	-9.5	10	✓	8000	✓	5.16	GI340	C0394
	175C10R-S90TN16-C	175	63	40	–	66.7	–	63	–	16.4	9.2	-16	-9.5	10	✓	7500	✓	6.89	GI340	C0394

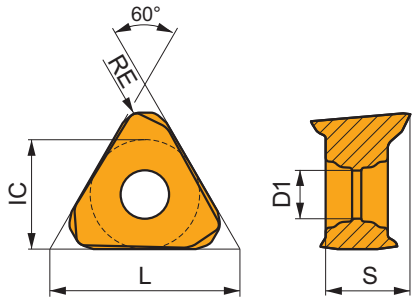
GI340	TNGX 1606..

		Nm									
C0382	US 44010-T15P	3.5	M 4	10	–	–	Flag T15P	–	–	–
C0384	US 44010-T15P	3.5	M 4	10	D-T08P/T15P	FG-15	–	HS 90835	–	–
C0386	US 44010-T15P	3.5	M 4	10	D-T08P/T15P	FG-15	–	HS 1030C	–	–
C0388	US 44010-T15P	3.5	M 4	10	D-T08P/T15P	FG-15	–	HS 1230C	–	–
C0390	US 44010-T15P	3.5	M 4	10	D-T08P/T15P	FG-15	–	–	–	–
C0394	US 44010-T15P	3.5	M 4	10	D-T08P/T15P	FG-15	–	HS 1240C	HSD 0825C	CAC 160C

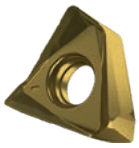
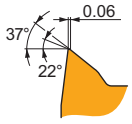
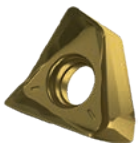
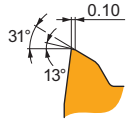
TNGX 16

PRAMET

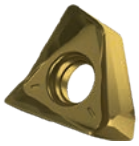
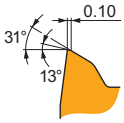
	IC (mm)	D1 (mm)	L (mm)	S (mm)
1606	9.525	4.40	16.50	6.58



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
F geometri med meget positivt design til let bearbejdning.																				
TNGX 160604SR-F:M8330	●	0.4	205	0.10	3.0	120	0.09	3.0	190	0.10	3.0	–	–	–	–	–	–	–	–	–
TNGX 160604SR-F:M8340	●	0.4	190	0.10	3.0	110	0.09	3.0	180	0.10	3.0	–	–	–	–	–	–	–	–	–
TNGX 160608SR-F:8215	●	0.8	250	0.10	3.0	150	0.09	3.0	235	0.10	3.0	–	–	–	–	–	–	–	–	–
TNGX 160608SR-F:M6330	●	0.8	215	0.10	3.0	150	0.09	3.0	–	–	–	–	–	–	–	–	–	–	–	–
TNGX 160608SR-F:M8310	●	0.8	280	0.10	3.0	140	0.09	3.0	265	0.10	3.0	–	–	–	–	–	–	–	–	–
TNGX 160608SR-F:M8330	●	0.8	245	0.10	3.0	145	0.09	3.0	230	0.10	3.0	–	–	–	–	–	–	–	–	–
TNGX 160608SR-F:M8340	●	0.8	225	0.10	3.0	135	0.09	3.0	210	0.10	3.0	–	–	–	–	–	–	–	–	–
																				
M geometri med positivt design til let til medium bearbejdning.																				
TNGX 160604SR-M:8215	●	0.4	180	0.18	3.0	105	0.16	3.0	170	0.18	3.0	–	–	–	45	0.13	2.4	–	–	–
TNGX 160604SR-M:M6330	●	0.4	155	0.18	3.0	110	0.16	3.0	–	–	–	–	–	–	45	0.13	2.4	–	–	–
TNGX 160604SR-M:M8310	●	0.4	205	0.15	3.0	100	0.14	3.0	190	0.15	3.0	–	–	–	–	–	–	–	–	–
TNGX 160604SR-M:M8330	●	0.4	180	0.18	3.0	105	0.16	3.0	170	0.18	3.0	–	–	–	45	0.13	2.4	–	–	–

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

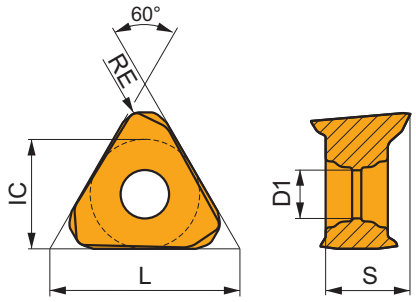
Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)
																				
TNGX 160604SR-M:M8340	●	0.4	165	0.18	3.0	95	0.16	3.0	155	0.18	3.0	–	–	–	40	0.13	2.4	–	–	–
TNGX 160608SR-M:8215	⁂	0.8	215	0.18	3.0	125	0.16	3.0	200	0.18	3.0	–	–	–	50	0.13	2.4	–	–	–
TNGX 160608SR-M:M6330	⁂	0.8	185	0.18	3.0	130	0.16	3.0	–	–	–	–	–	–	55	0.13	2.4	–	–	–
TNGX 160608SR-M:M8310	●	0.8	245	0.15	3.0	120	0.14	3.0	230	0.15	3.0	–	–	–	–	–	–	–	–	–
TNGX 160608SR-M:M8330	⁂	0.8	215	0.18	3.0	125	0.16	3.0	200	0.18	3.0	–	–	–	50	0.13	2.4	–	–	–
TNGX 160608SR-M:M8340	⁂	0.8	195	0.18	3.0	115	0.16	3.0	185	0.18	3.0	–	–	–	45	0.13	2.4	–	–	–
TNGX 160608SR-M:M8345	⁂	0.8	155	0.18	3.0	90	0.16	3.0	–	–	–	–	–	–	35	0.13	2.4	–	–	–
TNGX 160608SR-M:M9325	●	0.8	285	0.15	3.0	–	–	–	270	0.15	3.0	–	–	–	–	–	–	–	–	–
TNGX 160608SR-M:M9340	⁂	0.8	245	0.18	3.0	145	0.16	3.0	–	–	–	–	–	–	60	0.13	2.4	–	–	–
TNGX 160612SR-M:M8330	⁂	1.2	230	0.18	3.0	135	0.16	3.0	215	0.18	3.0	–	–	–	55	0.13	2.4	–	–	–
TNGX 160612SR-M:M8340	⁂	1.2	205	0.18	3.0	120	0.16	3.0	190	0.18	3.0	–	–	–	50	0.13	2.4	–	–	–
TNGX 160616SR-M:M8310	⁂	1.6	275	0.15	3.0	140	0.14	3.0	260	0.15	3.0	–	–	–	–	–	–	–	–	–
TNGX 160616SR-M:M8330	⁂	1.6	240	0.18	3.0	140	0.16	3.0	225	0.18	3.0	–	–	–	60	0.13	2.4	–	–	–
TNGX 160616SR-M:M8340	⁂	1.6	220	0.18	3.0	130	0.16	3.0	205	0.18	3.0	–	–	–	55	0.13	2.4	–	–	–

M geometri med positivt design til let til medium bearbejdning.

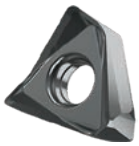
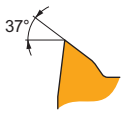
TNGX 16-FA

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1606	9.525	4.40	16.50	6.58



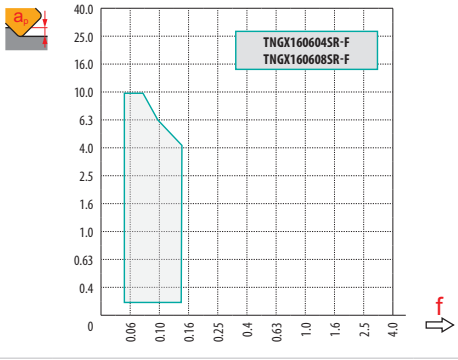
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

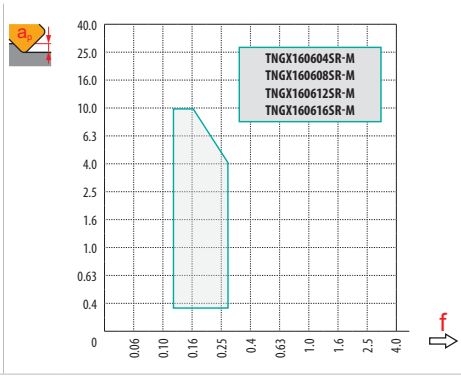
Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)
																				
TNGX 160604FR-FA:HF7	●	0.4	–	–	–	–	–	–	–	–	–	255	0.14	2.0	–	–	–	–	–	–
TNGX 160604FR-FA:M0315	●	0.4	–	–	–	–	–	–	–	–	–	585	0.14	2.0	–	–	–	–	–	–
TNGX 160608FR-FA:HF7	●	0.8	–	–	–	–	–	–	–	–	–	300	0.14	2.0	–	–	–	–	–	–
TNGX 160608FR-FA:M0315	●	0.8	–	–	–	–	–	–	–	–	–	690	0.14	2.0	–	–	–	–	–	–

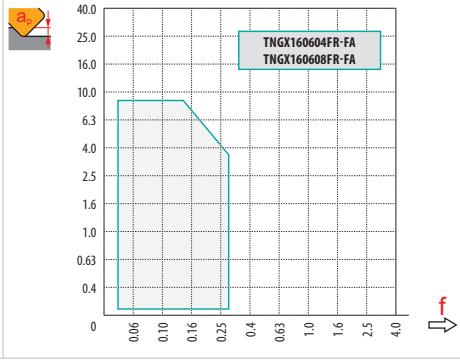
FA geometri med meget positivt design til finbearbejdning til medium bearbejdning.

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	TNGX 16-F		TNGX 16-M				TNGX 16-FA	
RE	0.4	0.8	0.4	0.8	1.2	1.6	0.4	0.8
BS	2.10	1.9	2.10	1.90	1.73	1.14	2.10	1.90

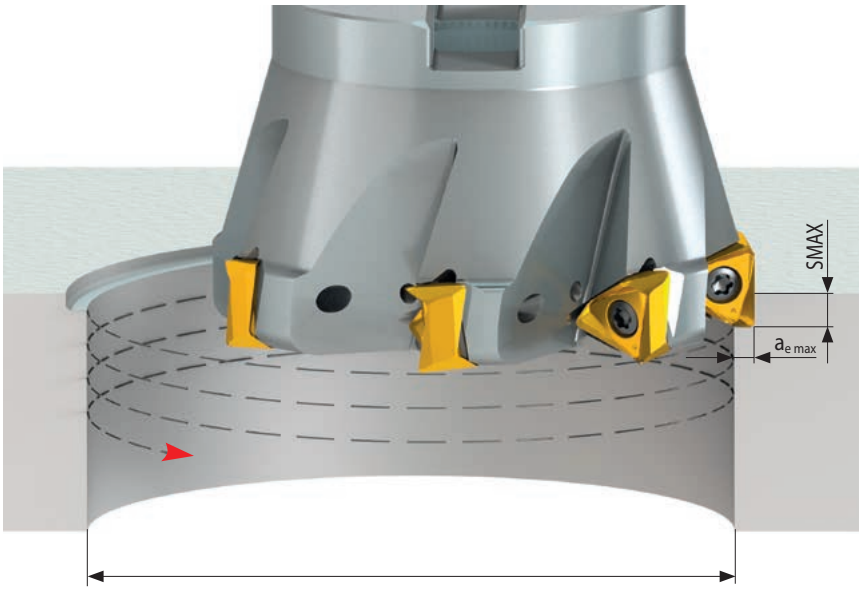






a_p	3.0	4.5	6.0
1 f	0.18	0.14	0.10

DC	d_{min} = DC *			d = 1.25 DC			d = 1.5 DC			d = 1.75 DC			d ≥ 2 DC	
	min	SMAX	$a_{e\,max}$	SMAX	$a_{e\,max}$		SMAX	$a_{e\,max}$		SMAX	$a_{e\,max}$		SMAX	$a_{e\,max}$
25	25	0.14	1.3	31	0.22	2.2	38	0.33	3.0	44	0.60	4.0	50	0.70	5.0
32	32	0.16	1.5	40	0.33	2.8	48	0.44	4.0	56	0.70	5.0	64	0.90	6.5
40	40	0.22	2.0	50	0.38	3.5	60	0.55	5.0	70	0.90	6.5	80	1.15	8.0
50	50	0.27	2.5	63	0.50	4.5	75	0.70	6.5	88	1.00	8.0	100	1.40	10.0
63	63	0.33	3.2	80	0.60	5.5	95	0.90	8.0	110	1.45	10.0	125	1.80	12.5
80	80	0.55	4.0	100	1.00	7.0	120	1.45	10.0	140	2.15	13.0	160	2.60	16.0
100	100	0.70	5.0	125	1.20	9.0	150	1.80	12.5	175	2.70	16.5	200	3.30	20.0
115	115	0.85	6.0	145	1.50	10.0	175	1.90	14.5	200	2.80	19.0	230	3.80	23.0
125	125	0.90	6.5	155	1.60	11.0	190	2.30	15.5	220	3.10	20.0	250	4.10	25.0
140	140	1.00	7.0	175	1.80	12.5	210	2.60	17.5	245	3.70	23.0	280	4.60	28.0
160	160	1.20	8.0	200	2.00	14.0	240	2.90	20.0	280	4.30	26.0	320	5.30	32.0
175	175	1.30	8.8	220	2.20	15.5	265	3.20	22.0	305	4.70	29.0	350	5.80	35.0



SLN12

P M K N

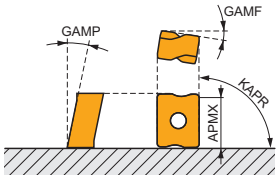
PRAMET

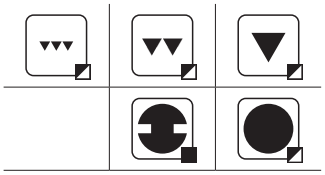
S

ECON LN12 skaftfræser med indvendig kølevæske

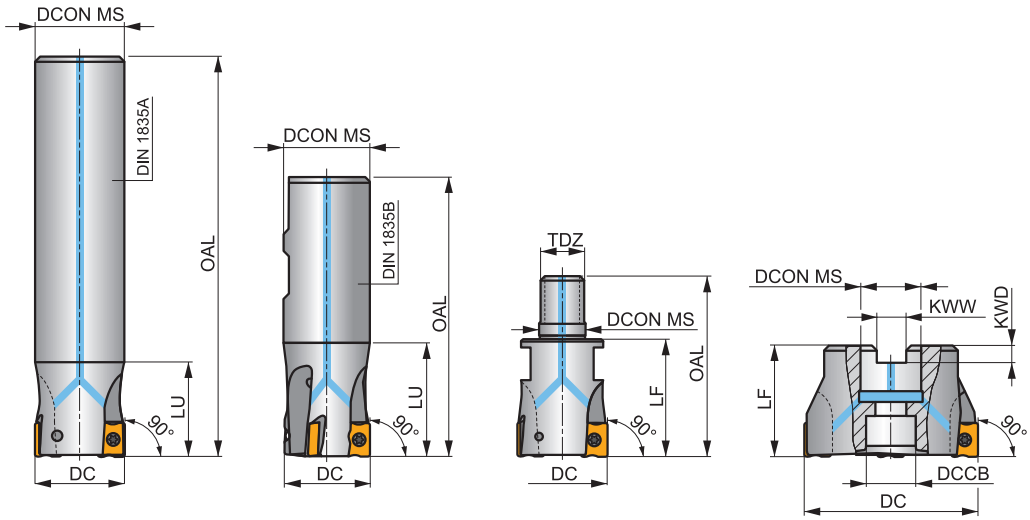
90° ende- og skaftfræser, der anvender dobbeltsidet LN .. 12 skær med APMX på 9 mm. Velegnet til en lang række applikationer. Fås i cylindrisk, svejset, modulær og dorn (med differentieret tandhøjde) Krop behandlet for længere levetid på værktøjet.

KAPR	90°
APMX	9.0 mm





ECON LN



h_m	0.06 - 0.15
h_m	0.06 - 0.13

	Product	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835A	**25A2R034A25-SLN12-C**	25	170	25	–	34	–	–	–	–	-23	-8	2	–	19500	✓	0.58	GI205	SQ340	–
	25A2R080A25-SLN12-C	25	170	25	–	80	–	–	–	–	-23	-8	2	–	19500	✓	0.54	GI205	SQ340	–
	32A2R034A32-SLN12-C	32	195	32	–	34	–	–	–	–	-15	-6	2	–	17300	✓	1.05	GI205	SQ340	–
	32A2R090A32-SLN12-C	32	195	32	–	90	–	–	–	–	-15	-6	2	–	17300	✓	0.98	GI205	SQ340	–
DIN 1835B	**25A2R042B25-SLN12-C**	25	99	25	–	42	–	–	–	–	-23	-8	2	–	19500	✓	0.30	GI205	SQ340	–
	32A3R042B32-SLN12-C	32	103	32	–	42	–	–	–	–	-15	-6	3	–	17300	✓	0.50	GI205	SQ340	–
	40A4R050B32-SLN12-C	40	111	32	–	50	–	–	–	–	-15	-6	4	✓	15500	✓	0.62	GI205	SQ340	–
MODULAR	**25A2R033M12-SLN12-C**	25	55	12.5	–	–	33	–	–	–	-22	-6	2	–	–	✓	0.11	GI205	SQ340	–
	32A2R043M16-SLN12-C	32	66	17	–	–	43	–	–	–	-15	-6	2	–	–	✓	0.22	GI205	SQ340	–
	32A3R043M16-SLN12-C	32	66	17	–	–	43	–	–	–	-15	-6	3	–	–	✓	0.22	GI205	SQ340	–
	40A3R043M16-SLN12-C	40	66	17	–	–	43	–	–	–	-15	-6	3	–	–	✓	0.28	GI205	SQ340	–
	40A04R-S90LN12-C	40	–	16	14	–	40	–	8.4	5.6	-15	-6	4	✓	15500	✓	0.33	GI205	SQ342	–
	50A04R-S90LN12-C	50	–	22	18	–	40	–	10.4	6.3	-14.5	-6	4	✓	13800	✓	0.47	GI205	SQ343	–
	50A05R-S90LN12-C	50	–	22	18	–	40	–	10.4	6.3	-14.5	-6	5	✓	13800	✓	0.40	GI205	SQ343	–
	63A04R-S90LN12-C	63	–	22	18	–	40	–	10.4	6.3	-14	-6	4	✓	12300	✓	0.55	GI205	SQ343	–
	63A06R-S90LN12-C	63	–	22	18	–	40	–	10.4	6.3	-14	-6	6	✓	12300	✓	0.50	GI205	SQ343	–
ISO 6462 DIN 8030	**80A05R-S90LN12-C**	80	–	27	38	–	50	–	12.4	7	-14	-6	5	✓	10900	✓	1.16	GI205	SQ341	AC001
	80A07R-S90LN12-C	80	–	27	38	–	50	–	12.4	7	-14	-6	7	✓	10900	✓	1.11	GI205	SQ341	AC001
	100A06R-S90LN12-C	100	–	32	45	–	50	–	14.4	8	-14	-6	6	✓	9800	✓	1.78	GI205	SQ341	AC002
	100A08R-S90LN12-C	100	–	32	45	–	50	–	14.4	8	-14	-6	8	✓	9800	✓	1.93	GI205	SQ341	AC002
	110A06R-S90LN12-C	110	–	32	45	–	50	–	14.4	8	-14	-6	6	✓	9300	✓	2.09	GI205	SQ341	AC002
	125A07R-S90LN12-C	125	–	40	56	–	63	–	16.4	9	-14	-6	7	✓	8700	✓	3.40	GI205	SQ341	AC003
	125A09R-S90LN12-C	125	–	40	56	–	63	–	16.4	9	-14	-6	9	✓	8700	✓	3.35	GI205	SQ341	AC003

GI205	LNGX 1205..	LNGU 1205..

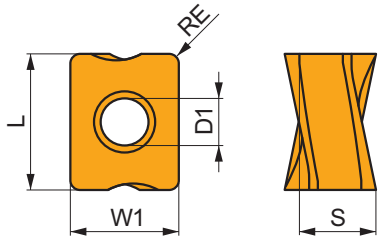
		Nm						
SQ340	US 44012-T15P	3.5	M 4	12	–	–	Flag T15P	–
SQ341	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	–
SQ342	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	HS 0830C
SQ343	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	HS 1030C

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

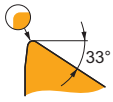
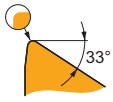
LNGX 12

PRAMET

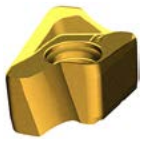
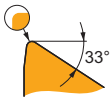
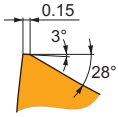
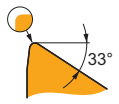
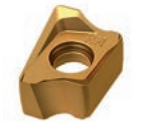
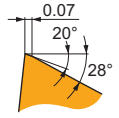
	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1205	9.500	4.50	12.00	5.96



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
F geometri med meget positivt design til let bearbejdning.																				
LNGX 120504ER-F:8215	●	0.4	200	0.15	1.5	–	–	–	190	0.15	1.5	–	–	–	–	–	–	–	–	–
LNGX 120504ER-F:M8330	●	0.4	200	0.15	1.5	–	–	–	190	0.15	1.5	–	–	–	–	–	–	–	–	–
LNGX 120504ER-F:M8340	●	0.4	180	0.15	1.5	–	–	–	170	0.15	1.5	–	–	–	–	–	–	–	–	–
LNGX 120508ER-F:8215	●●	0.8	240	0.15	1.5	–	–	–	225	0.15	1.5	–	–	–	–	–	–	–	–	–
LNGX 120508ER-F:M8310	●●	0.8	260	0.15	1.5	–	–	–	245	0.15	1.5	–	–	–	–	–	–	–	–	–
LNGX 120508ER-F:M8330	●●	0.8	235	0.15	1.5	–	–	–	220	0.15	1.5	–	–	–	–	–	–	–	–	–
LNGX 120508ER-F:M8340	●●	0.8	215	0.15	1.5	–	–	–	200	0.15	1.5	–	–	–	–	–	–	–	–	–
																				
M geometri med positivt design til let til medium bearbejdning.																				
LNGX 120504ER-M:M8330	●	0.4	185	0.15	3.0	–	–	–	175	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120504ER-M:M8340	●●	0.4	170	0.15	3.0	–	–	–	160	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120508ER-M:8215	●●	0.8	220	0.15	3.0	–	–	–	205	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120508ER-M:M8310	●●	0.8	240	0.15	3.0	–	–	–	225	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120508ER-M:M8330	●●	0.8	220	0.15	3.0	–	–	–	205	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120508ER-M:M8340	●●	0.8	200	0.15	3.0	–	–	–	190	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120508ER-M:M9315	●●	0.8	300	0.15	3.0	–	–	–	285	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120508ER-M:M9325	●●	0.8	280	0.15	3.0	–	–	–	265	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120508ER-M:M9340	●●	0.8	250	0.15	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
LNGX 120510ER-M:M8330	●●	1.0	230	0.15	3.0	–	–	–	215	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120512ER-M:M8330	●●	1.2	230	0.15	3.0	–	–	–	215	0.15	3.0	–	–	–	–	–	–	–	–	–

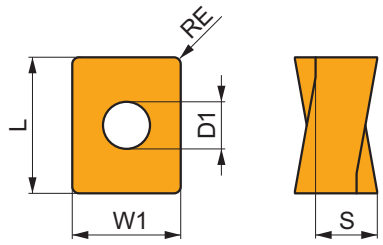
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)
																				
M geometri med positivt design til let til medium bearbejdning.																				
LNGX 120512ER-M:M8340	✱	1.2	210	0.15	3.0	–	–	–	195	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120516ER-M:M8330	⬢	1.6	240	0.15	3.0	–	–	–	225	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120516ER-M:M8340	✱	1.6	220	0.15	3.0	–	–	–	205	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120520ER-M:M8310	⬢	2.0	280	0.15	3.0	–	–	–	265	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120520ER-M:M8330	✱	2.0	255	0.15	3.0	–	–	–	240	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGX 120520ER-M:M8340	✱	2.0	230	0.15	3.0	–	–	–	215	0.15	3.0	–	–	–	–	–	–	–	–	–
																				
R geometri med positivt design til ustabile skæreforhold.																				
LNGX 120508SR-R:8215	⬢	0.8	205	0.20	3.5	–	–	–	190	0.20	3.5	–	–	–	–	–	–	–	–	–
LNGX 120508SR-R:M5315	⬢	0.8	265	0.20	3.5	–	–	–	250	0.20	3.5	–	–	–	–	–	–	–	–	–
LNGX 120508SR-R:M8310	⬢	0.8	220	0.20	3.5	–	–	–	205	0.20	3.5	–	–	–	–	–	–	–	–	–
LNGX 120508SR-R:M8330	⬢	0.8	205	0.20	3.5	–	–	–	190	0.20	3.5	–	–	–	–	–	–	–	–	–
LNGX 120508SR-R:M8340	✱	0.8	185	0.20	3.5	–	–	–	175	0.20	3.5	–	–	–	–	–	–	–	–	–
LNGX 120508SR-R:M9315	⬢	0.8	265	0.20	3.5	–	–	–	250	0.20	3.5	–	–	–	–	–	–	–	–	–
LNGX 120508SR-R:M9325	⬢	0.8	250	0.20	3.5	–	–	–	235	0.20	3.5	–	–	–	–	–	–	–	–	–
LNGX 120508SR-R:M9340	⬢	0.8	225	0.20	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
LNGX 120516SR-R:8215	✱	1.6	225	0.20	3.5	–	–	–	210	0.20	3.5	–	–	–	–	–	–	–	–	–
LNGX 120516SR-R:M8330	✱	1.6	225	0.20	3.5	–	–	–	210	0.20	3.5	–	–	–	–	–	–	–	–	–
LNGX 120516SR-R:M8340	✱	1.6	205	0.20	3.5	–	–	–	190	0.20	3.5	–	–	–	–	–	–	–	–	–
LNGX 120516SR-R:M9325	⬢	1.6	275	0.20	3.5	–	–	–	260	0.20	3.5	–	–	–	–	–	–	–	–	–
																				
MF geometri med meget positivt design til let bearbejdning.																				
LNGX 120504ER-MF:M6330	●	0.4	175	0.15	1.0	125	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
LNGX 120504ER-MF:M9340	●	0.4	240	0.15	1.0	140	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
LNGX 120508ER-MF:M6330	⬢	0.8	210	0.15	1.0	150	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
LNGX 120508ER-MF:M8340	⬢	0.8	225	0.15	1.0	135	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
LNGX 120508ER-MF:M9340	⬢	0.8	285	0.15	1.0	170	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
																				
MM geometri med positivt design til let til medium bearbejdning.																				
LNGX 120508SR-MM:M6330	✱	0.8	190	0.15	2.8	135	0.14	2.8	–	–	–	–	–	–	–	–	–	–	–	–
LNGX 120508SR-MM:M8340	✱	0.8	200	0.15	2.8	120	0.14	2.8	–	–	–	–	–	–	–	–	–	–	–	–
LNGX 120508SR-MM:M8345	✱	0.8	160	0.15	2.8	95	0.14	2.8	–	–	–	–	–	–	–	–	–	–	–	–
LNGX 120508SR-MM:M9340	⬢	0.8	255	0.15	2.8	150	0.14	2.8	–	–	–	–	–	–	–	–	–	–	–	–

LNGU 12

PRAMET

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1205	9.500	4.50	12.00	5.96



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)

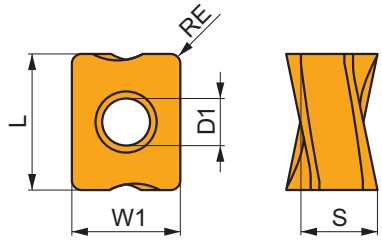
M geometri med positivt design til medium bearbejdning.

LNGU 120525ER-M:M8330	✱	2.5	■	255	0.15	3.0	–	–	–	■	240	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGU 120525ER-M:M8340	✱	2.5	■	230	0.15	3.0	–	–	–	◪	215	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGU 120530ER-M:M8330	✱	3.0	■	255	0.15	3.0	–	–	–	■	240	0.15	3.0	–	–	–	–	–	–	–	–	–
LNGU 120530ER-M:M8340	✱	3.0	■	230	0.15	3.0	–	–	–	◪	215	0.15	3.0	–	–	–	–	–	–	–	–	–

LNGX 12-FA

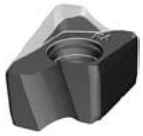
PRAMET

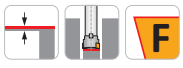
	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1205	9.500	4.50	12.00	5.96



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)





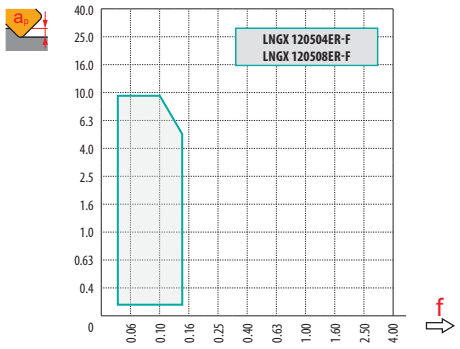
FA geometri med meget positivt design til finbearbejdning til medium bearbejdning.

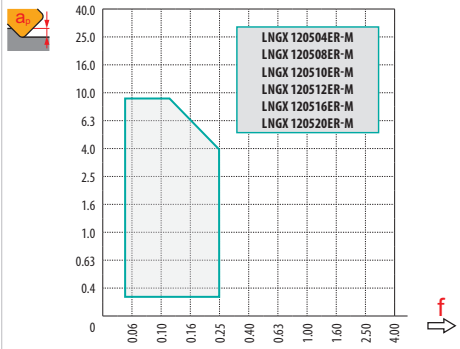
LNGX 120504FR-FA:HF7	●	0.4	–	–	–	–	–	–	–	–	–	–	–	■	270	0.30	2.0	–	–	–	–	–	–
LNGX 120508FR-FA:HF7	●	0.8	–	–	–	–	–	–	–	–	–	–	–	■	315	0.30	2.0	–	–	–	–	–	–
LNGX 120508FR-FA:M0315	●	0.8	–	–	–	–	–	–	–	–	–	–	–	■	720	0.30	2.0	–	–	–	–	–	–

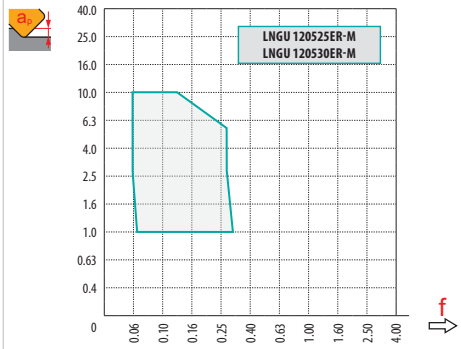
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

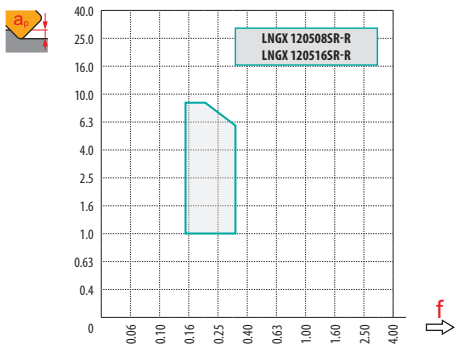
	LNGX 12-F		LNGX 12-M						LNGU 12-M	
RE	0.4	0.8	0.4	0.8	1.0	1.2	1.6	2.0	2.5	3.0
BS	2.29	1.89	2.29	1.89	1.69	1.49	1.09	0.68	0.87	0.36

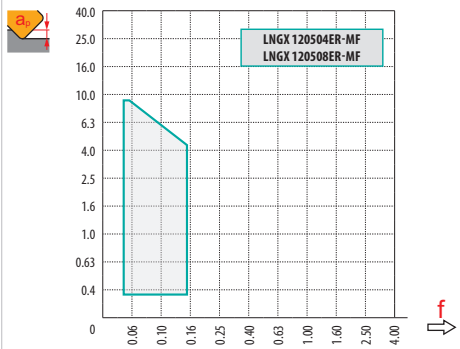
	LNGX 12-R		LNGX 12-MF		LNGX 12-MM	LNGX 12-FA	
RE	0.8	1.6	0.4	0.8	0.8	0.4	0.8
BS	1.88	1.08	2.28	1.88	1.88	2.30	1.89

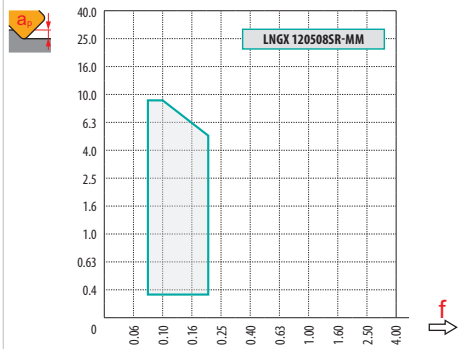


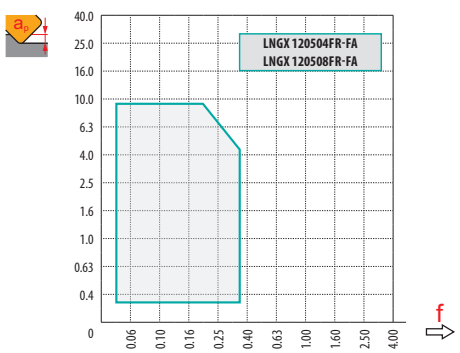


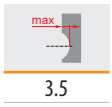












3.5

a_p	1.0	5.0	9.0
f	0.19	0.13	0.08

LNGX 12

DC	RPMX	APMX/I
25	1.3°	2.1/100
32	0.7°	1.1/100
40	0.5°	0.7/100
50	0.4°	0.5/100
63	0.2°	0.3/100
80	0.2°	0.2/100

LNGX 12

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
25	35.0	50.0	0.7	1.7
32	49.0	64.0	0.6	1.2
40	65.0	80.0	0.6	1.0
50	85.0	100.0	0.7	1.0
63	111.0	126.0	0.6	0.8
80	145.0	160.0	0.7	0.8

0.2

DC	µm	3	5	10	15	20	30	40	50	60	80	100
25	FE	0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657

RE	µm	3	5	10	15	20	30	40	50	60	80	100
1.6	FE	0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
2.5		0.245	0.316	0.447	0.548	0.632	0.775	0.894	1.000	1.095	1.265	1.414
3.0		0.268	0.346	0.490	0.600	0.693	0.849	0.980	1.095	1.200	1.386	1.549

SLN16

P K N H

PRAMET

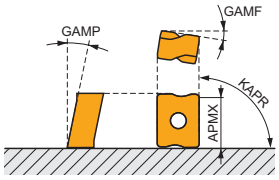
S

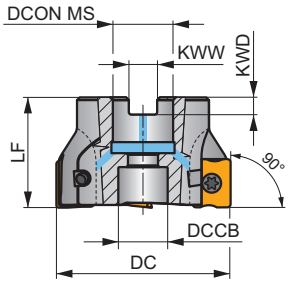
ECON LN16 hjørnefræser med intern kølevæske

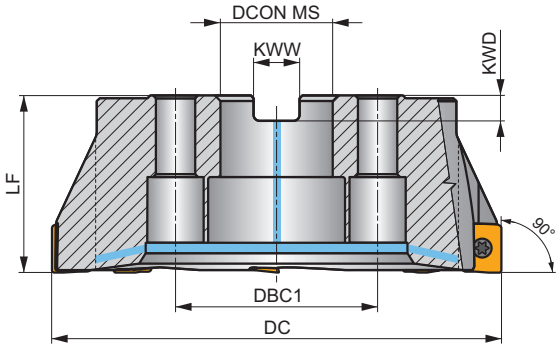
90° hjørnefræser med dobbeltsidet LN .. 16 skær med APMX på 13 mm. Velegnet til en lang række applikationer. Fås i dorn med differentieret tanddeling. Krop behandlet for længere værktøjslevetid.

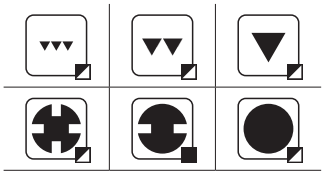
ECON LN

KAPR	90°
APMX	13.0 mm









h_m 0.08 - 0.2

	Product	DC (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	**63A04R-S90LN16-C**	63	40	22	18	–	10.4	6.3	-10.5	-6	4	✓	7600	✓	0.46	GI207	SQ353	–
	63A05R-S90LN16-C	63	40	22	18	–	10.4	6.3	-10.5	-6	5	✓	7600	✓	0.46	GI207	SQ353	–
	80A04R-S90LN16-C	80	50	27	38	–	12.4	7	-10.5	-6	4	✓	6800	✓	0.98	GI207	SQ351	AC001
	80A06R-S90LN16-C	80	50	27	38	–	12.4	7	-10.5	-6	6	✓	6800	✓	0.89	GI207	SQ351	AC001
	100A05R-S90LN16-C	100	50	32	45	–	14.4	8	-10.5	-6	5	✓	6100	✓	0.98	GI207	SQ351	AC002
	100A07R-S90LN16-C	100	50	32	45	–	14.4	8	-10.5	-6	7	✓	6100	✓	1.78	GI207	SQ351	AC002
	125A06R-S90LN16-C	125	63	40	56	–	16.4	9	-10.5	-6	6	✓	5400	✓	3.39	GI207	SQ351	AC003
	125A08R-S90LN16-C	125	63	40	56	–	16.4	9	-10.5	-6	8	✓	5400	✓	3.28	GI207	SQ351	AC003
	140A06R-S90LN16-C	140	63	40	56	–	16.4	9	-10.5	-6	6	✓	5100	✓	3.91	GI207	SQ351	AC003
	160C08R-S90LN16-C	160	63	40	–	66.7	16.4	9	-10.5	-6	8	✓	4700	✓	6.19	GI207	SQ356	–
	175C08R-S90LN16-C	175	63	40	–	66.7	16.4	9	-10.5	-6	8	✓	4500	✓	7.11	GI207	SQ356	–

GI207	LNMU 1607..	LNGU 1607..

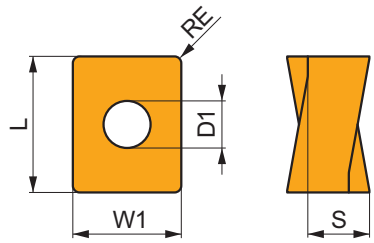
		Nm							
SQ351	US 45012-T20P	5.0	M 5	12	SDR T20P-T	–	–	–	–
SQ353	US 45012-T20P	5.0	M 5	12	SDR T20P-T	HS 1030C	–	–	–
SQ356	US 45012-T20P	5.0	M 5	12	SDR T20P-T	HS 1240C	CAC 160C	HSD 0825C	HXK 5

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

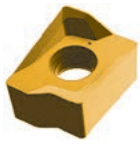
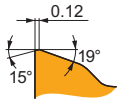
LNGU 16

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1607	13.200	5.70	16.60	7.50



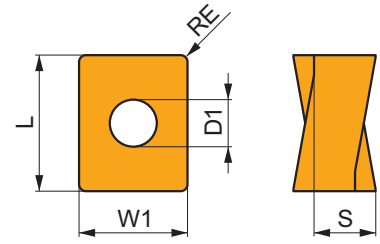
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																			
M geometri med meget positivt design til medium bearbejdning.																			
LNGU 160708SR-M:8215	0.8	200	0.18	5.0	–	–	–	190	0.18	5.0	–	–	–	–	–	–	40	0.12	1.0
LNGU 160708SR-M:M8340	0.8	180	0.18	5.0	–	–	–	170	0.18	5.0	–	–	–	–	–	–	–	–	–
LNGU 160708SR-M:M9315	0.8	265	0.18	5.0	–	–	–	250	0.18	5.0	–	–	–	–	–	–	50	0.12	1.0
LNGU 160708SR-M:M9325	0.8	250	0.18	5.0	–	–	–	235	0.18	5.0	–	–	–	–	–	–	50	0.12	1.0

LNMU 16

PRAMET

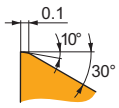
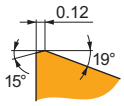
	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1607	13.200	5.70	16.60	7.50



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
F geometri med meget positivt design til let bearbejdning.																			
LNMU 160708ER-F:M8330	0.8	230	0.16	1.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
LNMU 160708ER-F:M8340	0.8	210	0.16	1.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

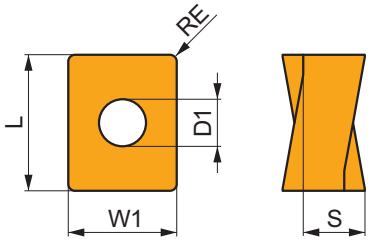
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
M geometri med positivt design til medium bearbejdning.																			
LNMU 160708SR-M:8215	0.8	■ 200	0.18	5.0	–	–	–	■ 190	0.18	5.0	–	–	–	–	–	–	–	–	–
LNMU 160708SR-M:M6330	0.8	■ 170	0.18	5.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
LNMU 160708SR-M:M8330	0.8	■ 200	0.18	5.0	–	–	–	■ 190	0.18	5.0	–	–	–	–	–	–	–	–	–
LNMU 160708SR-M:M8340	0.8	■ 180	0.18	5.0	–	–	–	◪ 170	0.18	5.0	–	–	–	–	–	–	–	–	–
LNMU 160708SR-M:M9325	0.8	■ 250	0.18	5.0	–	–	–	■ 235	0.18	5.0	–	–	–	–	–	–	–	–	–
LNMU 160720SR-M:M8330	2.0	■ 230	0.18	5.0	–	–	–	■ 215	0.18	5.0	–	–	–	–	–	–	–	–	–
LNMU 160720SR-M:M8340	2.0	■ 210	0.18	5.0	–	–	–	◪ 195	0.18	5.0	–	–	–	–	–	–	–	–	–
LNMU 160730SR-M:M8330	3.0	■ 230	0.18	5.0	–	–	–	■ 215	0.18	5.0	–	–	–	–	–	–	–	–	–
LNMU 160730SR-M:M8340	3.0	■ 210	0.18	5.0	–	–	–	◪ 195	0.18	5.0	–	–	–	–	–	–	–	–	–
LNMU 160740SR-M:M8340	4.0	■ 210	0.18	5.0	–	–	–	◪ 195	0.18	5.0	–	–	–	–	–	–	–	–	–
																			
R geometri med positivt stabilt design til medium bearbejdning.																			
LNMU 160708SR-R:M5315	0.8	◪ 265	0.18	6.3	–	–	–	■ 250	0.18	6.3	–	–	–	–	–	–	◪ 50	0.12	1.0
LNMU 160708SR-R:M8330	0.8	■ 195	0.18	6.3	–	–	–	■ 185	0.18	6.3	–	–	–	–	–	–	◪ 35	0.12	1.0
LNMU 160708SR-R:M8340	0.8	■ 175	0.18	6.3	–	–	–	◪ 165	0.18	6.3	–	–	–	–	–	–	–	–	–
LNMU 160708SR-R:M9315	0.8	■ 260	0.18	6.3	–	–	–	■ 245	0.18	6.3	–	–	–	–	–	–	◪ 50	0.12	1.0
LNMU 160708SR-R:M9325	0.8	■ 240	0.18	6.3	–	–	–	■ 225	0.18	6.3	–	–	–	–	–	–	◪ 45	0.12	1.0
LNMU 160716SR-R:M8330	1.6	■ 215	0.18	6.3	–	–	–	■ 200	0.18	6.3	–	–	–	–	–	–	◪ 40	0.12	1.1
LNMU 160716SR-R:M8340	1.6	■ 195	0.18	6.3	–	–	–	◪ 185	0.18	6.3	–	–	–	–	–	–	–	–	–
LNMU 160716SR-R:M9315	1.6	■ 285	0.18	6.3	–	–	–	■ 270	0.18	6.3	–	–	–	–	–	–	◪ 55	0.12	1.1
LNMU 160716SR-R:M9325	1.6	■ 265	0.18	6.3	–	–	–	■ 250	0.18	6.3	–	–	–	–	–	–	◪ 50	0.12	1.1

LNGU 16-FA

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1607	13.200	5.70	16.60	7.50

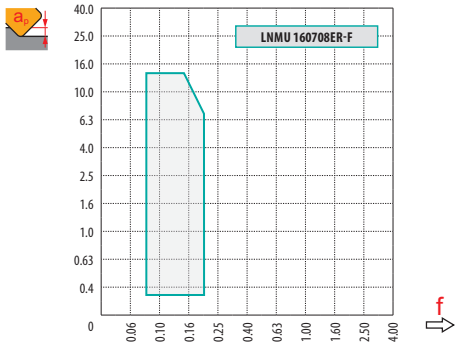


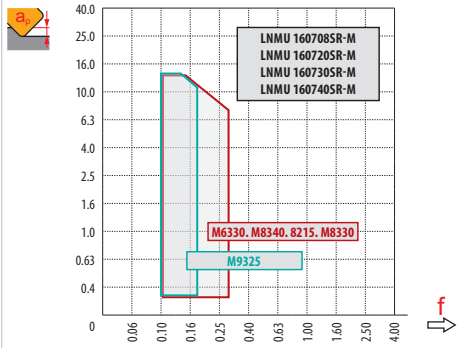
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

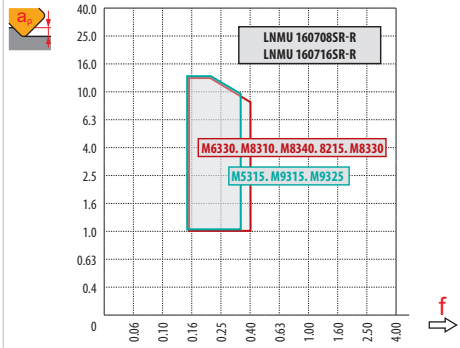
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
FA geometri med meget positivt design til finbearbejdning til medium bearbejdning.																			
LNGU 160708FR-FA:HF7	● 0.8	–	–	–	–	–	–	–	–	–	■ 300	0.30	3.0	–	–	–	–	–	–

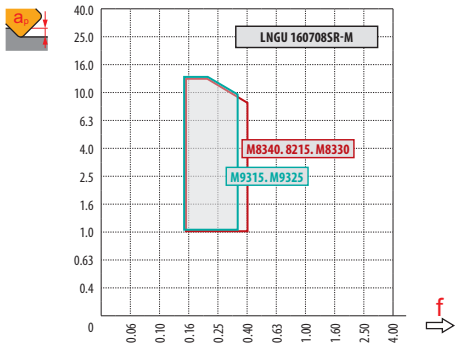
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

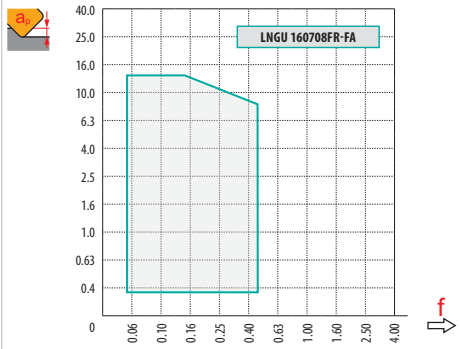
	LNMU 16-F	LNMU 16-M				LNMU 16-R		LNGU 16-M	LNGU 16-FA
RE	0.8	0.8	2.0	3.0	4.0	0.8	1.6	0.8	0.8
BS	3.30	3.30	2.11	1.12	0.10	3.30	2.50	3.24	3.30











max
7.0

a_p	1.0	6.0	13.0
1 f	0.31	0.24	0.13

SLN12X

P K H

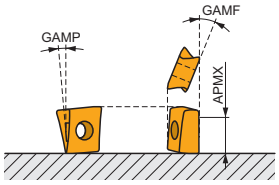
PRAMET

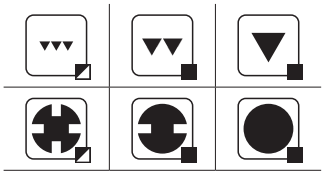
S

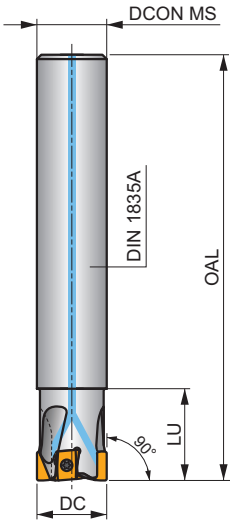
PROD LN12 90° Tangentiel firkantet fræser med intern kølevæske

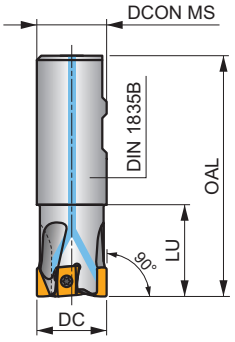
Yderst produktive 90° hjørnefræsere med tangentiel LNEX 12 skær med 4 skærekanter og APMX på 10 mm.Velegnet til en bred vifte af applikationer.Fås i cylindrisk, weldon- og dorn-type.Robust skærekrop understøtter lang værktøjslevetid og fremragende brudmodstand.

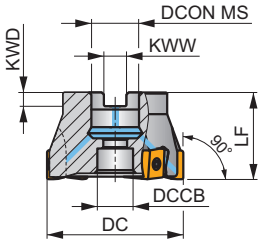
KAPR	90°
APMX	10.0 mm











h_m	0.06 - 0.18
h_m	0.06 - 0.20

	Product	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	25A2R042A25-SLN12X-C	25	170	25	–	42	–	–	–	-30	-5	2	–	17300	✓	0.55	GI206	C0382
	25A2R080A25-SLN12X-C	25	170	25	–	80	–	–	–	-30	-5	2	–	17300	✓	0.50	GI206	C0382
	32A3R042A32-SLN12X-C	32	195	32	–	42	–	–	–	-22.5	-5	3	–	15300	✓	1.08	GI206	SQ340
	32A3R090A32-SLN12X-C	32	195	32	–	90	–	–	–	-22.5	-5	3	–	15300	✓	1.02	GI206	SQ340
	40A4R050A32-SLN12X-C	40	195	32	–	50	–	–	–	-22.5	-5	4	–	13700	✓	1.17	GI206	SQ340
DIN 1835B	25A2R042B25-SLN12X-C	25	100	25	–	42	–	–	–	-30	-5	2	–	17300	✓	0.29	GI206	C0382
	32A3R042B32-SLN12X-C	32	110	32	–	42	–	–	–	-22.5	-5	3	–	15300	✓	0.58	GI206	SQ340
	40A4R050B32-SLN12X-C	40	120	32	–	50	–	–	–	-22.5	-5	4	–	13700	✓	0.73	GI206	SQ340
ISO 6462 DIN 8030	40A03R-S90LN12X-C	40	–	16	12.4	–	40	8.4	5.6	-22.5	-5	3	–	13700	✓	0.15	GI206	SQ345
	40A04R-S90LN12X-C	40	–	16	12.4	–	40	8.4	5.6	-22.5	-5	4	✓	13700	✓	0.23	GI206	SQ345
	50A05R-S90LN12X-C	50	–	22	16.5	–	40	10.4	6.3	-19.5	-5	5	–	12300	✓	0.34	GI206	SQ343
	50A06R-S90LN12X-C	50	–	22	16.5	–	40	10.4	6.3	-19.5	-5	6	–	12300	✓	0.34	GI206	SQ343
	52A05R-S90LN12X-C	52	–	22	16.5	–	40	10.4	6.3	-19.5	-5	5	–	12300	✓	0.37	GI206	SQ343
	63A06R-S90LN12X-C	63	–	22	16.5	–	40	10.4	6.3	-19.5	-5	6	✓	10900	✓	0.61	GI206	SQ343
	63A08R-S90LN12X-C	63	–	22	16.5	–	40	10.4	6.3	-19.5	-5	8	–	10900	✓	0.50	GI206	SQ343
	66A06R-S90LN12X-C	66	–	22	16.5	–	40	10.4	6.3	-19.5	-5	6	✓	10900	✓	0.54	GI206	SQ343
	80A07R-S90LN12X-C	80	–	27	38.1	–	50	12.4	7	-19.5	-5	7	✓	9700	✓	1.00	GI206	SQ341
	80A10R-S90LN12X-C	80	–	27	38.1	–	50	12.4	7	-19.5	-5	10	–	9700	✓	0.98	GI206	SQ341
	100A08R-S90LN12X-C	100	–	32	45.1	–	50	14.4	8	-17.5	-5	8	✓	8700	✓	1.90	GI206	SQ341
	100A11R-S90LN12X-C	100	–	32	45.1	–	50	14.4	8	-17.5	-5	11	–	8700	✓	1.88	GI206	SQ341
	125A12R-S90LN12X-C	125	–	40	56.1	–	63	16.4	9	-17.5	-5	12	✓	7800	✓	3.39	GI206	SQ341

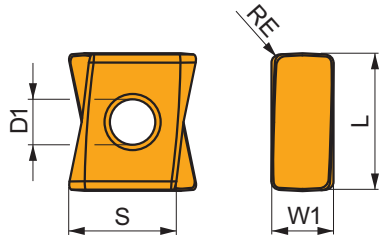
GI206	LNEX 1210..

		Nm						
C0382	US 44010-T15P	3.5	M 4	10	–	–	Flag T15P	–
SQ340	US 44012-T15P	3.5	M 4	12	–	–	Flag T15P	–
SQ341	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	–
SQ343	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	HS 1030C
SQ345	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	HS 90835

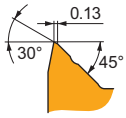
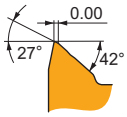
LNEX 12

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1210	6.000	4.40	13.30	10.26

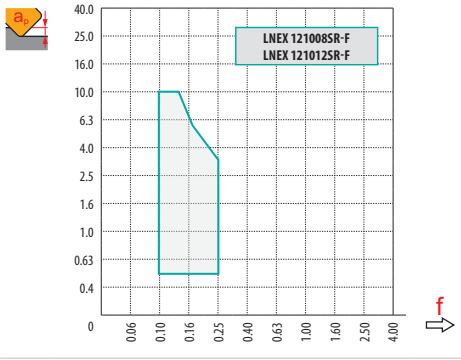


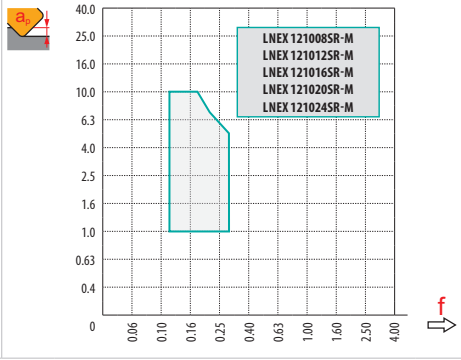
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
F geometrien er skarp og bruges til let og mellemstor bearbejdning, velegnet til store udhængsapplikationer. Designet med meget positiv vinkel, smal T-land og afrunding af skærkant til let til medium bearbejdning.																				
LNEX 121008SR-F:M6330		0.8	220	0.17	3.0	155	0.15	3.0	–	–	–	–	–	–	–	–	–	–	–	–
LNEX 121008SR-F:M8310		0.8	280	0.17	3.0	140	0.15	3.0	265	0.17	3.0	–	–	–	–	–	–	55	0.11	1.0
LNEX 121008SR-F:M8330		0.8	260	0.17	3.0	155	0.15	3.0	245	0.17	3.0	–	–	–	–	–	–	50	0.11	1.0
LNEX 121008SR-F:M8340		0.8	235	0.17	3.0	140	0.15	3.0	220	0.17	3.0	–	–	–	–	–	–	–	–	–
LNEX 121012SR-F:M6330		1.2	230	0.17	3.0	165	0.15	3.0	–	–	–	–	–	–	–	–	–	–	–	–
LNEX 121012SR-F:M8310		1.2	295	0.17	3.0	150	0.15	3.0	280	0.17	3.0	–	–	–	–	–	–	55	0.11	1.0
LNEX 121012SR-F:M8330		1.2	270	0.17	3.0	160	0.15	3.0	255	0.17	3.0	–	–	–	–	–	–	50	0.11	1.0
																				
M geometri er alsidig og førstevalg til en lang række arbejdsforhold.Designet med positiv vinkel, medium T-land og afrunding af skærekant til medium op til semi-skrubbearbejdning.																				
LNEX 121008SR-M:M6330		0.8	210	0.20	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
LNEX 121008SR-M:M8310		0.8	265	0.20	3.5	–	–	–	250	0.20	3.5	–	–	–	–	–	–	50	0.16	1.0
LNEX 121008SR-M:M8330		0.8	245	0.20	3.5	–	–	–	230	0.20	3.5	–	–	–	–	–	–	45	0.16	1.0
LNEX 121008SR-M:M8340		0.8	220	0.20	3.5	–	–	–	205	0.20	3.5	–	–	–	–	–	–	–	–	–
LNEX 121008SR-M:M9315		0.8	320	0.20	3.5	–	–	–	300	0.20	3.5	–	–	–	–	–	–	60	0.16	1.0
LNEX 121008SR-M:M9325		0.8	300	0.20	3.5	–	–	–	285	0.20	3.5	–	–	–	–	–	–	60	0.16	1.0
LNEX 121008SR-M:M9340		0.8	270	0.20	3.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
LNEX 121012SR-M:M8310		1.2	280	0.20	3.5	–	–	–	265	0.20	3.5	–	–	–	–	–	–	55	0.16	1.0
LNEX 121012SR-M:M8330		1.2	255	0.20	3.5	–	–	–	240	0.20	3.5	–	–	–	–	–	–	50	0.16	1.0
LNEX 121012SR-M:M8340		1.2	235	0.20	3.5	–	–	–	220	0.20	3.5	–	–	–	–	–	–	–	–	–
LNEX 121016SR-M:M8310		1.6	295	0.20	3.5	–	–	–	280	0.20	3.5	–	–	–	–	–	–	55	0.16	1.0
LNEX 121016SR-M:M8330		1.6	270	0.20	3.5	–	–	–	255	0.20	3.5	–	–	–	–	–	–	50	0.16	1.0
LNEX 121016SR-M:M8340		1.6	245	0.20	3.5	–	–	–	230	0.20	3.5	–	–	–	–	–	–	–	–	–
LNEX 121020SR-M:M8330		2.0	285	0.20	3.5	–	–	–	270	0.20	3.5	–	–	–	–	–	–	55	0.16	1.0
LNEX 121020SR-M:M8340		2.0	255	0.20	3.5	–	–	–	240	0.20	3.5	–	–	–	–	–	–	–	–	–
LNEX 121024SR-M:M8330		2.4	285	0.20	3.5	–	–	–	270	0.20	3.5	–	–	–	–	–	–	55	0.16	1.0
LNEX 121024SR-M:M8340		2.4	255	0.20	3.5	–	–	–	240	0.20	3.5	–	–	–	–	–	–	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	LNEX 12-F		LNEX 12-M				
RE	0.8	1.2	0.8	1.2	1.6	2.0	2.4
BS	2.25	1.73	2.25	1.73	1.33	1.15	0.79





max
2.5

a_p	2.0	3.0	4.0	5.0
1 f	0.30	0.20	0.20	0.15

DC	RPMX	APMX/I
25	0.80°	1.40/100
32	0.60°	1.00/100
40	0.35°	0.60/100
50	0.30°	0.50/100
52	0.30°	0.50/100
63	0.20°	0.35/100

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
25	44.0	48.0	0.6	0.7
32	58.0	62.0	0.8	1.0
40	74.0	78.0	0.7	0.8
50	94.0	98.0	0.7	0.8
52	98.0	102.0	0.7	0.8
63	120.0	124.0	0.3	0.4

DC	µm	3	5	10	15	20	30	40	50	60	80	100
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
63		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657

RE	µm	3	5	10	15	20	30	40	50	60	80	100
0.8		0.155	0.200	0.283	0.346	0.400	0.490	0.566	0.632	0.693	0.800	0.894
1.2		0.170	0.219	0.310	0.379	0.438	0.537	0.620	0.693	0.759	0.876	0.980
1.6		0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
2.4		0.245	0.316	0.447	0.548	0.632	0.775	0.894	1.000	1.095	1.265	1.414

FACE MILLING

	SAD07D	SAD11E	SAD16E	SAP10D	SAP16D
	90°	90°	90°	90°	90°
	APMX (mm) 5.0	APMX (mm) 9.0	APMX (mm) 13.0	APMX (mm) 9.0	APMX (mm) 13.0
	DC (mm) 10 – 32	DC (mm) 16 – 125	DC (mm) 25 – 175	DC (mm) 10 – 25	DC (mm) 25 – 125
Cylindrical shank	DC = 10 – 25 (mm)	DC = 16 – 35 (mm)	DC = 25, 32 (mm)		
Weldon		DC = 16 – 32 (mm)	DC = 25 – 40 (mm)	DC = 10 – 25 (mm)	DC = 25 – 40 (mm)
Modular	DC = 12 – 32 (mm)	DC = 16 – 40 (mm)	DC = 32, 40 (mm)		
Shell mill		DC = 40 – 125 (mm)	DC = 40 – 175 (mm)		DC = 40 – 125 (mm)
Page	90	97	106	114	117
ISO	P M K N S	P M K N S H	P M K N S H	P M K N S	P M K N S
Insert shape					
Inserts	AD.X 0702	AD.X 11T3	AD.X 1606	APKT 1003	AP.T 1604
No. of cutting edges	2	2	2	2	2
Face milling	■	■	■	■	■
Chamfer milling	■	■	■	■	■
Helical interpolation	■	■	■	■	■
Progressive plunging	■	■	■	■	■
Ramping	■	■	■	■	■
Shape surfaces milling (copy milling)	■	■	■	■	■
Shallow shoulder milling	◪	◪	◪	◪	◪
Shallow slot milling	◪	■	■		

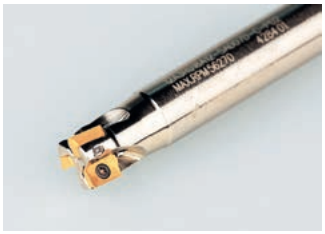
■ Primary use ◪ Possible use

SAD07D

P M K N S

PRAMET

S

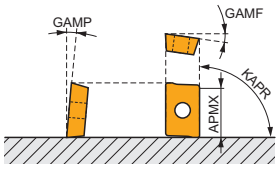


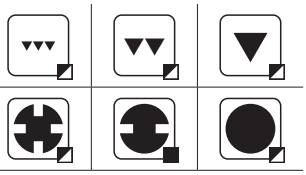
FORCE AD07 fræser med intern kølevæske

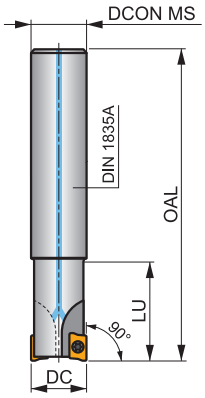
90° endefræser med positiv AD .. 07 skær med APMX på 5 mm. Velegnet til applikationer, herunder plan, hjørne, spor,spiralinterpolation , trochoidal, ramping og lommefræsning. Fås i cylindrisk og modulær stil og med differentieret tandafstand. Krop behandlet for længere værktøjslevetid.

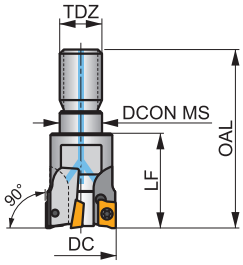
FORCE AD

KAPR	90°
APMX	5.0 mm









h_m 0.03 - 0.08

	Product	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	TDZ	GAMF (°)	GAMP (°)			max.		kg		
	10A2R016A08-SAD07D-C	10	100	8	16	–	–	-12	8	2	–	61600	✓	0.05	GI276	SQ010
	10A2R016A10-SAD07D-C	10	80	10	16	–	–	-12	8	2	–	61600	✓	0.05	GI276	SQ010
	10A2R018A08-SAD07D-CF	10	100	8	18	–	–	-12	8	2	–	61600	✓	0.06	GI276	SQ010
	10A2R018A10-SAD07D-CF	10	80	10	18	–	–	-12	8	2	–	61600	✓	0.05	GI276	SQ010
	12A2R018A10-SAD07D-C	12	120	10	18	–	–	-10	8	2	–	56300	✓	0.09	GI276	SQ010
	12A2R018A12-SAD07D-C	12	90	12	18	–	–	-10	8	2	–	56300	✓	0.09	GI276	SQ010
	12A3R018A12-SAD07D-C	12	90	12	18	–	–	-10	8	3	–	56200	✓	0.09	GI276	SQ010
	12A3R020A12-SAD07D-CF	12	90	12	20	–	–	-10	8	3	–	56200	✓	0.09	GI276	SQ010
	14A3R018A12-SAD07D-C	14	140	12	18	–	–	-9	8	3	–	52100	✓	0.13	GI276	SQ010
	14A3R018A14-SAD07D-C	14	90	14	18	–	–	-9	8	3	–	52100	✓	0.11	GI276	SQ010
DIN 1835A	14A3R020A12-SAD07D-CF	14	140	12	20	–	–	-9	8	3	–	52100	✓	0.14	GI276	SQ010
DIN 1835A	14A3R020A14-SAD07D-CF	14	90	14	20	–	–	-9	8	3	–	52100	✓	0.11	GI276	SQ010
	16A3R019A14-SAD07D-C	16	160	14	19	–	–	-8	8	3	–	48700	✓	0.21	GI276	SQ011
	16A3R019A16-SAD07D-C	16	110	16	19	–	–	-8	8	3	–	48700	✓	0.18	GI276	SQ011
	16A4R019A16-SAD07D-C	16	110	16	19	–	–	-8	8	4	–	48700	✓	0.18	GI276	SQ011
	18A4R019A16-SAD07D-C	18	180	16	19	–	–	-7.5	8	4	✓	45900	✓	0.28	GI276	SQ011
	18A4R019A18-SAD07D-C	18	110	18	19	–	–	-7.5	8	4	✓	45900	✓	0.22	GI276	SQ011
	20A4R020A18-SAD07D-C	20	200	18	20	–	–	-7	8	4	✓	43600	✓	0.37	GI276	SQ011
	20A4R020A20-SAD07D-C	20	125	20	20	–	–	-7	8	4	✓	43600	✓	0.29	GI276	SQ011
	20A5R020A20-SAD07D-C	20	125	20	20	–	–	-7	8	5	✓	43600	✓	0.30	GI276	SQ011
	25A5R024A25-SAD07D-C	25	140	25	24	–	–	-6.5	8	5	✓	39000	✓	0.51	GI276	SQ011
	25A6R024A25-SAD07D-C	25	140	25	24	–	–	-6.5	8	6	✓	39000	✓	0.51	GI276	SQ011
	12A2R020M06-SAD07D-C	12	35	6.5	–	20	M6	-10	8	2	–	–	✓	0.04	GI276	SQ010
MODULAR	14A3R020M08-SAD07D-C	14	38	8.5	–	20	M8	-9	8	3	–	–	✓	0.04	GI276	SQ010
MODULAR	14A3R023M08-SAD07D-CF	14	41	8.5	–	23	M8	-9	8	3	–	–	✓	0.05	GI276	SQ010
	16A4R023M08-SAD07D-C	16	41	8.5	–	23	M8	-8	8	4	✓	–	✓	0.05	GI276	SQ011
	20A5R030M10-SAD07D-C	20	49	10.5	–	30	M10	-7	8	5	✓	–	✓	0.08	GI276	SQ011

	Product	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	TDZ	GAMF (°)	GAMP (°)			max.		kg		
MODULAR	**25A6R035M12-SAD07D-C**	25	57	12.5	–	35	M12	-6.5	8	6	✓	–	✓	0.13	GI276	SQ011
MODULAR	**32A8R043M16-SAD07D-C**	32	66	17	–	43	M16	-6	8	8	✓	–	✓	0.24	GI276	SQ011

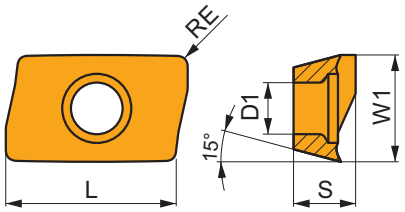
GI276	ADMX 0702..	ADEX 0702..

		Nm			
SQ010	US 62003A-T06P	0.6	M 2	3	Flag T06P
SQ011	US 62004A-T06P	0.6	M 2	4	Flag T06P

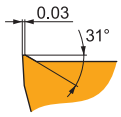
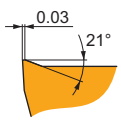
ADMX 07

PRAMET

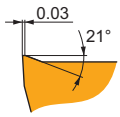
	W1 (mm)	D1 (mm)	L (mm)	S (mm)
0702	4.482	2.20	6.95	2.48



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
			F geometri med meget skarpt positivt design til let bearbejdning.																	
ADMX 070202SR-F:M8330	●	0.2	220	0.07	2.0	130	0.06	2.0	–	–	–	660	0.08	2.0	55	0.05	1.6	–	–	–
ADMX 070204SR-F:M6330	●	0.4	200	0.07	2.0	140	0.06	2.0	–	–	–	–	–	–	60	0.05	1.6	–	–	–
ADMX 070204SR-F:M8330	●	0.4	235	0.07	2.0	140	0.06	2.0	–	–	–	705	0.08	2.0	55	0.05	1.6	–	–	–
ADMX 070204SR-F:M8340	●	0.4	215	0.07	2.0	125	0.06	2.0	–	–	–	–	–	–	50	0.05	1.6	–	–	–
ADMX 070208SR-F:M8310	⧓	0.8	320	0.07	2.0	160	0.06	2.0	–	–	–	–	–	–	–	–	–	–	–	–
ADMX 070208SR-F:M8330	⧓	0.8	280	0.07	2.0	165	0.06	2.0	–	–	–	840	0.08	2.0	70	0.05	1.6	–	–	–
ADMX 070208SR-F:M8340	⧓	0.8	255	0.07	2.0	150	0.06	2.0	–	–	–	–	–	–	60	0.05	1.6	–	–	–
																				
			M geometri med positivt design til let til medium bearbejdning.																	
ADMX 070202SR-M:M8330	●	0.2	205	0.09	2.2	120	0.08	2.2	190	0.09	2.2	615	0.11	2.2	50	0.06	1.8	–	–	–
ADMX 070202SR-M:M8340	●	0.2	185	0.09	2.2	110	0.08	2.2	175	0.09	2.2	–	–	–	45	0.06	1.8	–	–	–
ADMX 070204SR-M:8215	●	0.4	225	0.09	2.2	135	0.08	2.2	210	0.09	2.2	675	0.11	2.2	55	0.06	1.8	–	–	–
ADMX 070204SR-M:M6330	●	0.4	190	0.09	2.2	135	0.08	2.2	–	–	–	–	–	–	55	0.06	1.8	–	–	–
ADMX 070204SR-M:M8310	●	0.4	245	0.09	2.2	120	0.08	2.2	230	0.09	2.2	–	–	–	–	–	–	–	–	–
ADMX 070204SR-M:M8330	●	0.4	220	0.09	2.2	130	0.08	2.2	205	0.09	2.2	660	0.11	2.2	55	0.06	1.8	–	–	–
ADMX 070204SR-M:M8340	●	0.4	200	0.09	2.2	120	0.08	2.2	190	0.09	2.2	–	–	–	50	0.06	1.8	–	–	–
ADMX 070204SR-M:M9340	●	0.4	265	0.09	2.2	155	0.08	2.2	–	–	–	–	–	–	65	0.06	1.8	–	–	–
ADMX 070208SR-M:8215	⧓	0.8	270	0.09	2.2	160	0.08	2.2	255	0.09	2.2	810	0.11	2.2	65	0.06	1.8	–	–	–

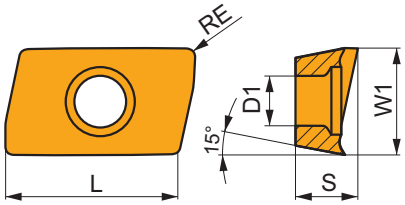
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
M geometri med positivt design til let til medium bearbejdning.																			
ADMX 070208SR-M:M6330	0.8	225	0.09	2.2	160	0.08	2.2	–	–	–	–	–	–	65	0.06	1.8	–	–	–
ADMX 070208SR-M:M8310	0.8	290	0.09	2.2	145	0.08	2.2	275	0.09	2.2	–	–	–	–	–	–	–	–	–
ADMX 070208SR-M:M8330	0.8	260	0.09	2.2	155	0.08	2.2	245	0.09	2.2	780	0.11	2.2	65	0.06	1.8	–	–	–
ADMX 070208SR-M:M8340	0.8	240	0.09	2.2	140	0.08	2.2	225	0.09	2.2	–	–	–	60	0.06	1.8	–	–	–
ADMX 070208SR-M:M9340	0.8	315	0.09	2.2	185	0.08	2.2	–	–	–	–	–	–	75	0.06	1.8	–	–	–
ADMX 070216SR-M:M8330	1.6	290	0.09	2.2	170	0.08	2.2	275	0.09	2.2	870	0.11	2.2	70	0.06	1.8	–	–	–
ADMX 070220SR-M:M8310	2.0	340	0.09	2.2	170	0.08	2.2	320	0.09	2.2	–	–	–	–	–	–	–	–	–
ADMX 070220SR-M:M8330	2.0	300	0.09	2.2	180	0.08	2.2	285	0.09	2.2	900	0.11	2.2	75	0.06	1.8	–	–	–
ADMX 070220SR-M:M8340	2.0	275	0.09	2.2	165	0.08	2.2	260	0.09	2.2	–	–	–	65	0.06	1.8	–	–	–

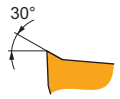
ADEX 07-FA

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
0702	4.497	2.20	6.95	2.48

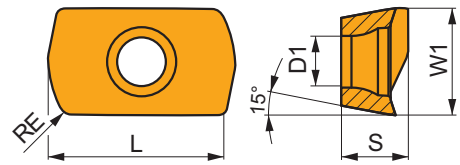


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

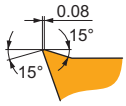
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
FA geometri med meget positivt design til finbearbejdning til medium bearbejdning.																			
ADEX 070204FR-FA:HF7	0.4	–	–	–	–	–	–	–	–	–	240	0.18	3.0	–	–	–	–	–	–
ADEX 070204FR-FA:M0315	0.4	–	–	–	–	–	–	–	–	–	555	0.18	3.0	–	–	–	–	–	–
ADEX 070208FR-FA:HF7	0.8	–	–	–	–	–	–	–	–	–	285	0.18	3.0	–	–	–	–	–	–

ADEX 07-HF

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0702	4.439	2.20	6.45	2.48

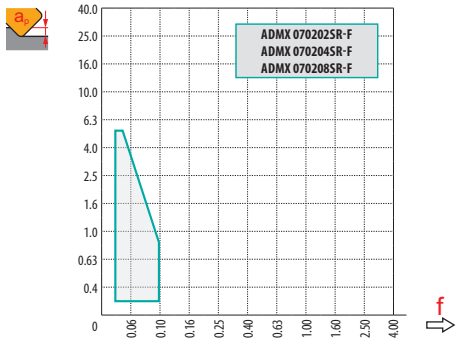


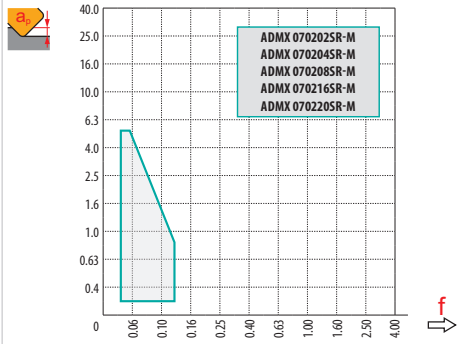
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

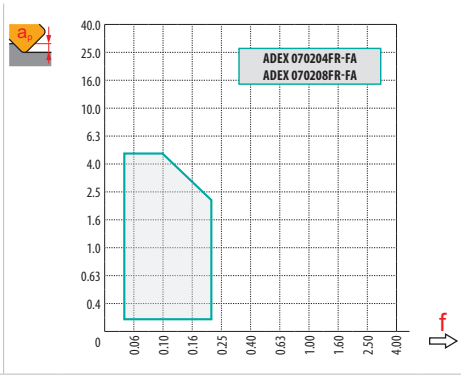
Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
		HFC S																	
HF geometri med meget positivt design til high feed bearbejdning.																			
ADEX 070206SR-HF:M6330	0.6	200	0.60	0.3	140	0.54	0.3	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 070206SR-HF:M8330	0.6	225	0.60	0.3	135	0.54	0.3	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 070206SR-HF:M8340	0.6	215	0.60	0.3	125	0.54	0.3	–	–	–	–	–	–	–	–	–	–	–	–

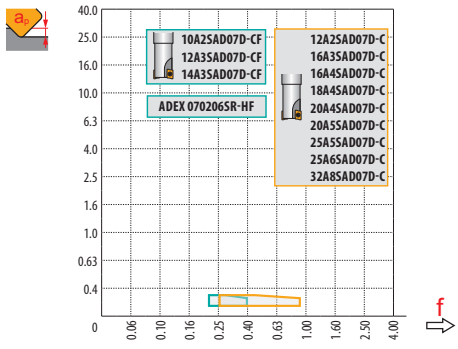
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ADMX 07-F			ADMX 07-M					ADEX 07-HF	ADEX 07-FA	
RE	0.2	0.4	0.8	0.2	0.4	0.8	1.6	2.0	0.6	0.4	0.8
BS	1.38	0.89	0.54	1.38	0.89	0.54	0.7	0.33	–	0.94	0.55









ADEX 07-HF				
DC	a_p	0	0.1	0.2	0.3
10	DEF	5.6	7.8	8.7	9.4
12		7.6	9.8	10.7	11.4
14		9.6	11.8	12.7	13.4
16		11.6	13.8	14.7	15.4
18		13.6	15.8	16.7	17.4
20		15.6	17.8	18.7	19.4
25		20.6	22.8	23.7	24.4
32		27.6	29.8	30.7	31.4

HFC			
a_p	0.1	0.2	0.3
1 f	0.9	0.8	0.6

max
3.0

a_p	1.0	3.0	5.0
1 f	0.13	0.08	0.05

	HFC		
a_p	0.1	0.2	0.3
1 f	0.7	0.6	0.4

DC	RPMX	APMX/I
10	5.2°	5.0/56
12	3.4°	5.0/86
14	2.5°	4.2/100
16	1.9°	3.2/100
18	1.7°	2.8/100
20	1.5°	2.5/100
25	1.1°	1.8/100
32	0.8°	1.2/100

	HFC	
DC	RPMX	APMX/I
10	3.5°	0.3/6
12	2.2°	0.3/9
14	1.6°	0.3/12
16	1.3°	0.3/15
18	1.1°	0.3/17
20	0.9°	0.3/21
25	0.7°	0.3/26
32	0.5°	0.3/36

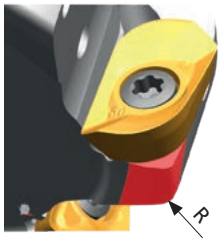
DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
10	12.0	20.0	0.5	2.8
12	16.0	24.0	0.7	2.2
14	20.0	28.0	0.8	1.9
16	24.0	32.0	0.8	1.6
18	28.0	36.0	0.9	1.6
20	32.0	40.0	0.9	1.6
25	42.0	50.0	1.0	1.5
32	56.0	64.0	1.0	1.4

	HFC			
DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
10	12	20	0.30	0.30
12	16	24	0.30	0.30
14	20	28	0.30	0.30
16	24	32	0.30	0.30
18	28	36	0.30	0.30
20	32	40	0.30	0.30
25	42	50	0.30	0.30
32	56	64	0.30	0.30

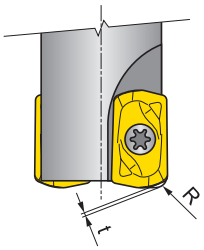
a_p
0.5

a_p	HFC
	0.3

DC	µm	3	5	10	15	20	30	40	50	60	80	100
10		0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
12		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
14		0.410	0.529	0.748	0.917	1.058	1.296	1.497	1.673	1.833	2.117	2.366
16	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
18		0.465	0.600	0.849	1.039	1.200	1.470	1.697	1.897	2.078	2.400	2.683
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578



ADMX 07	R
ADMX 070216SR-M	1
ADMX 070220SR-M	1.5
ADEX 070206SR-HF	1



ADEX 07	R	t
ADEX 070206SR-HF	0.8	0.18

SAD11E

P M K N S H

PRAMET

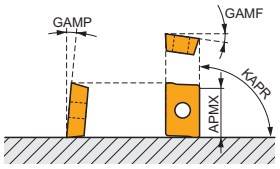
S

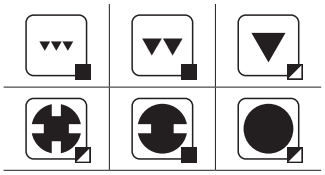
FORCE AD11 skaftfræser med indvendig kølevæske

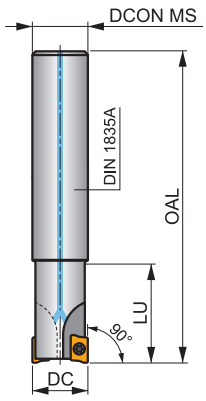
90° ende- og planfræser med positiv AD .. 11 skær med APMX på 9 mm. Velegnet til plan, hjørne, spor,spiralinterpolation , trochoidal, ramping og lommefræsning. Fås i cylindrisk, weldon, morse konisk, modulær og dorn (med differentieret tanddeling) Krop behandlet for længere værktøjslevetid.

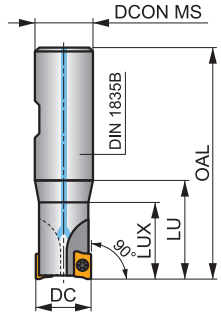
FORCE AD

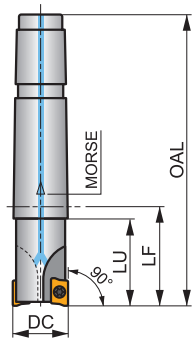
KAPR	90°
APMX	9.0 mm

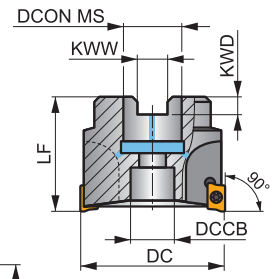


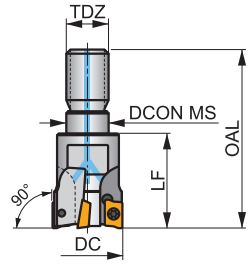












h_m	0.06 – 0.13
h_m	0.08 – 0.16

	Product	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	CZC MS	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)	max.	kg	
	16A2R024A14-SAD11E-C	16	160	14	–	24	–	–	–	–	–	–	-12.8	4	2	–	30100	✓	0.19	GI169 SQ025	–
	16A2R024A16-SAD11E-C	16	135	16	–	24	–	–	–	–	–	–	-12.8	4	2	–	30100	✓	0.19	GI169 SQ025	–
	16A2R050A16-SAD11E-C	16	135	16	–	50	–	–	–	–	–	–	-12.8	4	2	–	30100	✓	0.20	GI169 SQ025	–
	18A2R029A20-SAD11E-C	18	150	20	–	29	–	–	–	–	–	–	-12	4.5	2	–	28400	✓	0.35	GI169 SQ025	–
	20A2R029A20-SAD11E-C	20	150	20	–	29	–	–	–	–	–	–	-11.5	5	2	–	27000	✓	0.33	GI169 SQ020	–
	20A2R070A20-SAD11E-C	20	150	20	–	70	–	–	–	–	–	–	-11.5	5	2	–	27000	✓	0.32	GI169 SQ020	–
	20A3R029A18-SAD11E-C	20	200	18	–	29	–	–	–	–	–	–	-11.5	5	3	–	27000	✓	0.36	GI169 SQ025	–
	20A3R029A20-SAD11E-C	20	150	20	–	29	–	–	–	–	–	–	-11.5	5	3	–	27000	✓	0.31	GI169 SQ025	–
DIN 1835A	**22A3R029A20-SAD11E-C**	22	200	20	–	29	–	–	–	–	–	–	-11.5	5	3	–	25600	✓	0.45	GI169 SQ025	–
	25A3R034A25-SAD11E-C	25	170	25	–	34	–	–	–	–	–	–	-10.2	5	3	–	24100	✓	0.42	GI169 SQ020	–
	25A3R080A25-SAD11E-C	25	170	25	–	80	–	–	–	–	–	–	-10.2	5	3	–	24100	✓	0.52	GI169 SQ020	–
	25A4R034A25-SAD11E-C	25	170	25	–	34	–	–	–	–	–	–	-10.2	5	4	–	24100	✓	0.56	GI169 SQ025	–
	25A4R040A25-SAD11E-C	25	250	25	–	40	–	–	–	–	–	–	-10.2	5	4	–	24100	✓	0.85	GI169 SQ025	–
	30A3R080A32-SAD11E-C	30	200	32	–	80	–	–	–	–	–	–	-9.3	7	3	–	22000	✓	0.98	GI169 SQ020	–
	32A3R090A32-SAD11E-C	32	195	32	–	90	–	–	–	–	–	–	-9	5	3	–	21300	✓	0.99	GI169 SQ020	–
	32A5R034A32-SAD11E-C	32	195	32	–	34	–	–	–	–	–	–	-9	8	5	–	21300	✓	1.03	GI169 SQ025	–
	35A5R025A32-SAD11E-C	35	200	32	–	25	–	–	–	–	–	–	-9	8	5	–	20300	✓	1.11	GI169 SQ020	–
	16A2R027B16-SAD11E-C	16	75	16	–	–	27	–	–	–	–	–	-12.8	4	2	–	30100	✓	0.11	GI169 SQ025	–
	20A2R032B20-SAD11E-C	20	82	20	–	–	32	–	–	–	–	–	-11.5	5	2	–	27000	✓	0.13	GI169 SQ020	–
	20A3R032B20-SAD11E-C	20	82	20	–	–	32	–	–	–	–	–	-11.5	5	3	–	27000	✓	0.13	GI169 SQ025	–
DIN 1835B	**25A3R042B25-SAD11E-C**	25	98	25	–	–	42	–	–	–	–	–	-10.2	5	3	–	24100	✓	0.29	GI169 SQ020	–
	25A4R042B25-SAD11E-C	25	98	25	–	–	42	–	–	–	–	–	-10.2	5	4	–	24100	✓	0.31	GI169 SQ025	–
	32A4R042B32-SAD11E-C	32	102	32	–	–	42	–	–	–	–	–	-9	8	4	–	21300	✓	0.27	GI169 SQ020	–
	32A5R042B32-SAD11E-C	32	102	32	–	–	42	–	–	–	–	–	-9	8	5	–	21300	✓	0.32	GI169 SQ025	–
	16A2R030E02-SAD11E-C	16	94	–	–	25	–	30	–	2	–	–	-12.8	4	2	–	30100	✓	0.13	GI169 SQ025	–
DIN 228A	**20A3R035E03-SAD11E-C**	20	116	–	–	30	–	35	–	3	–	–	-11.5	5	3	–	27000	✓	0.27	GI169 SQ025	–
	25A4R043E03-SAD11E-C	25	124	–	–	38	–	43	–	3	–	–	-10.2	5	4	–	24100	✓	0.31	GI169 SQ025	–

	Product	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	CZC MS	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)					kg			
MODULAR	**16A2R024M08-SAD11E-C**	16	38	8.5	–	–	–	24	M8	–	–	–	-12.8	4	2	–	–	✓	0.04	GI169	SQ025	–
	20A2R026M10-SAD11E-C	20	45	11	–	–	–	26	M10	–	–	–	-11.5	5	2	–	–	✓	0.06	GI169	SQ020	–
	20A3R026M10-SAD11E-C	20	45	10.5	–	–	–	26	M10	–	–	–	-11.5	5	3	–	–	✓	0.06	GI169	SQ025	–
	25A3R033M12-SAD11E-C	25	55	12.5	–	–	–	33	M12	–	–	–	-10.2	5	3	–	–	✓	0.10	GI169	SQ020	–
	25A4R033M12-SAD11E-C	25	55	12.5	–	–	–	33	M12	–	–	–	-10.2	5	4	–	–	✓	0.09	GI169	SQ025	–
	32A4R043M16-SAD11E-C	32	66	17	–	–	–	43	M16	–	–	–	-9	8	4	–	–	✓	0.20	GI169	SQ020	–
	32A5R043M16-SAD11E-C	32	66	17	–	–	–	43	M16	–	–	–	-9	8	5	–	–	✓	0.20	GI169	SQ025	–
	40A4R043M16-SAD11E-C	40	66	17	–	–	–	43	M16	–	–	–	-8.1	11	4	–	–	✓	0.27	GI169	SQ020	–
	40A6R043M16-SAD11E-C	40	66	17	–	–	–	43	M16	–	–	–	-8.1	11	6	–	–	✓	0.21	GI169	SQ020	–
ISO 6462 DIN 8030	**40A04R-S90AD11E-C**	40	–	16	14	–	–	40	–	–	8.4	5.6	-8.1	11	4	✓	19100	✓	0.16	GI169	SQ022	–
	40A05R-S90AD11E-C	40	–	16	14	–	–	40	–	–	8.4	5.6	-8.1	11	5	✓	19000	✓	0.31	GI169	SQ022	–
	40A06R-S90AD11E-C	40	–	16	14	–	–	40	–	–	8.4	5.6	-8.1	11	6	✓	19100	✓	0.20	GI169	SQ022	–
	50A05R-S90AD11E-C	50	–	22	18	–	–	40	–	–	10.4	6.3	-7.2	12	5	✓	17000	✓	0.31	GI169	SQ023	–
	50A07R-S90AD11E-C	50	–	22	18	–	–	40	–	–	10.4	6.3	-7.2	12	7	✓	17000	✓	0.44	GI169	SQ023	–
	63A06R-S90AD11E-C	63	–	22	18	–	–	40	–	–	10.4	6.3	-6.5	12	6	✓	15200	✓	0.54	GI169	SQ023	–
	63A09R-S90AD11E-C	63	–	22	18	–	–	40	–	–	10.4	6.3	-6.5	12	9	✓	15200	✓	0.61	GI169	SQ023	–
	80A10R-S90AD11E-C	80	–	27	38	–	–	50	–	–	12.4	7	-6	12	10	✓	13500	✓	1.04	GI169	SQ021	AC001
	100A11R-S90AD11E-C	100	–	32	45	–	–	50	–	–	14.4	8	-5.5	12	11	✓	12100	✓	1.89	GI169	SQ021	AC002
	125A12R-S90AD11E-C	125	–	40	56	–	–	63	–	–	16.4	9	-5.2	12	12	✓	10800	✓	2.97	GI169	SQ021	AC003

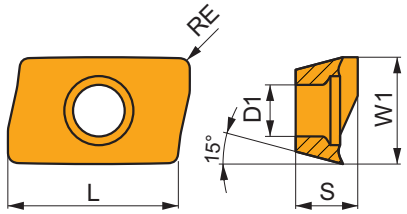
GI169	ADMX 11T3..	ADEX 11T3..

		Nm						
SQ020	US 62506-T07P	1.2	M 2.5	6	–	–	Flag T07P	–
SQ021	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	–	–
SQ022	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	–	HS 0830C
SQ023	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	–	HS 1030C
SQ025	US 62505-T07P	1.2	M 2.5	5	–	–	Flag T07P	–

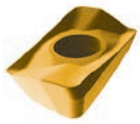
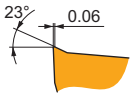
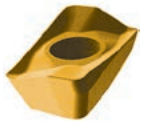
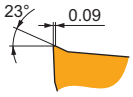
AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

ADMX 11

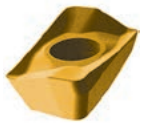
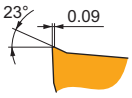
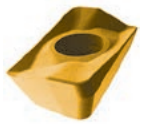
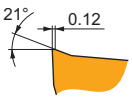
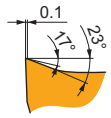
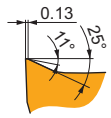
	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
11T3	6.530	2.90	11.00	3.97



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
			**F** geometri med meget skarpt positivt design til let bearbejdning.																	
ADMX 11T304SR-F:8215	●	0.4	245	0.10	2.0	145	0.09	2.0	230	0.10	2.0	735	0.12	2.0	60	0.08	1.6	–	–	–
ADMX 11T304SR-F:M8330	●	0.4	240	0.10	2.0	140	0.09	2.0	225	0.10	2.0	720	0.12	2.0	60	0.08	1.6	–	–	–
ADMX 11T304SR-F:M8340	●	0.4	220	0.10	2.0	130	0.09	2.0	205	0.10	2.0	–	–	–	55	0.08	1.6	–	–	–
ADMX 11T304SR-F:M9340	●	0.4	285	0.10	2.0	170	0.09	2.0	–	–	–	–	–	–	70	0.08	1.6	–	–	–
ADMX 11T308SR-F:8215	⬢	0.8	290	0.10	2.0	170	0.09	2.0	275	0.10	2.0	870	0.12	2.0	70	0.08	1.6	–	–	–
ADMX 11T308SR-F:M8330	⬢	0.8	285	0.10	2.0	170	0.09	2.0	270	0.10	2.0	855	0.12	2.0	70	0.08	1.6	–	–	–
ADMX 11T308SR-F:M8340	⬢	0.8	260	0.10	2.0	155	0.09	2.0	245	0.10	2.0	–	–	–	65	0.08	1.6	–	–	–
ADMX 11T308SR-F:M9340	⬢	0.8	340	0.10	2.0	200	0.09	2.0	–	–	–	–	–	–	85	0.08	1.6	–	–	–
			**M** geometri med positivt design til let til medium bearbejdning.																	
ADMX 11T302SR-M:M8330	●	0.2	190	0.15	4.0	110	0.14	4.0	180	0.15	4.0	–	–	–	45	0.12	3.2	–	–	–
ADMX 11T302SR-M:M8340	⬢	0.2	170	0.15	4.0	100	0.14	4.0	160	0.15	4.0	–	–	–	40	0.12	3.2	–	–	–
ADMX 11T304SR-M:8215	●	0.4	205	0.15	4.0	120	0.14	4.0	190	0.15	4.0	–	–	–	50	0.12	3.2	–	–	–
ADMX 11T304SR-M:M8310	●	0.4	220	0.15	4.0	110	0.14	4.0	205	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T304SR-M:M8330	⬢	0.4	205	0.15	4.0	120	0.14	4.0	190	0.15	4.0	–	–	–	50	0.12	3.2	–	–	–
ADMX 11T304SR-M:M8340	⬢	0.4	185	0.15	4.0	110	0.14	4.0	175	0.15	4.0	–	–	–	45	0.12	3.2	–	–	–
ADMX 11T304SR-M:M9325	●	0.4	255	0.15	4.0	–	–	–	240	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T304SR-M:M9340	●	0.4	235	0.15	4.0	140	0.14	4.0	–	–	–	–	–	–	55	0.12	3.2	–	–	–
ADMX 11T308SR-M:8215	⬢	0.8	245	0.15	4.0	145	0.14	4.0	230	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T308SR-M:M5315	⬢	0.8	335	0.15	4.0	–	–	–	315	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T308SR-M:M8310	⬢	0.8	265	0.15	4.0	135	0.14	4.0	250	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T308SR-M:M8330	⬢	0.8	245	0.15	4.0	145	0.14	4.0	230	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T308SR-M:M8340	⬢	0.8	220	0.15	4.0	130	0.14	4.0	205	0.15	4.0	–	–	–	55	0.12	3.2	–	–	–
ADMX 11T308SR-M:M9315	⬢	0.8	330	0.15	4.0	–	–	–	310	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T308SR-M:M9325	⬢	0.8	305	0.15	4.0	–	–	–	285	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T308SR-M:M9340	⬢	0.8	275	0.15	4.0	165	0.14	4.0	–	–	–	–	–	–	65	0.12	3.2	–	–	–
ADMX 11T310SR-M:M8330	⬢	1.0	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T310SR-M:M8340	✱	1.0	230	0.15	4.0	135	0.14	4.0	215	0.15	4.0	–	–	–	55	0.12	3.2	–	–	–
ADMX 11T312SR-M:8215	⬢	1.2	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T312SR-M:M8330	✱	1.2	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T312SR-M:M8340	✱	1.2	230	0.15	4.0	135	0.14	4.0	215	0.15	4.0	–	–	–	55	0.12	3.2	–	–	–
ADMX 11T316SR-M:8215	⬢	1.6	270	0.15	4.0	160	0.14	4.0	255	0.15	4.0	–	–	–	65	0.12	3.2	–	–	–
ADMX 11T316SR-M:M6330	✱	1.6	230	0.15	4.0	165	0.14	4.0	–	–	–	–	–	–	65	0.12	3.2	–	–	–
ADMX 11T316SR-M:M8310	⬢	1.6	295	0.15	4.0	150	0.14	4.0	280	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T316SR-M:M8330	✱	1.6	270	0.15	4.0	160	0.14	4.0	255	0.15	4.0	–	–	–	65	0.12	3.2	–	–	–
ADMX 11T316SR-M:M8340	✱	1.6	240	0.15	4.0	140	0.14	4.0	225	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T320SR-M:M6330	✱	2.0	240	0.15	4.0	170	0.14	4.0	–	–	–	–	–	–	70	0.12	3.2	–	–	–
ADMX 11T320SR-M:M8330	✱	2.0	280	0.15	4.0	165	0.14	4.0	265	0.15	4.0	–	–	–	70	0.12	3.2	–	–	–
ADMX 11T320SR-M:M8340	✱	2.0	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–

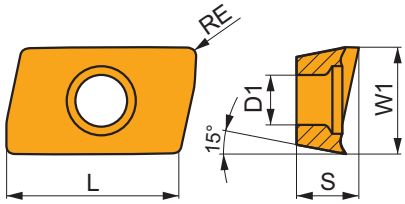
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
  **M** geometri med positivt design til let til medium bearbejdning.																			
ADMX 11T325SR-M:M6330	2.5	240	0.15	4.0	170	0.14	4.0	–	–	–	–	–	–	70	0.12	3.2	–	–	–
ADMX 11T325SR-M:M8340	2.5	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T330SR-M:M6330	3.0	240	0.15	4.0	170	0.14	4.0	–	–	–	–	–	–	70	0.12	3.2	–	–	–
ADMX 11T330SR-M:M8330	3.0	280	0.15	4.0	165	0.14	4.0	265	0.15	4.0	–	–	–	70	0.12	3.2	–	–	–
ADMX 11T330SR-M:M8340	3.0	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
  **R** geometri med positivt design til bearbejdningsforhold under mindre stabile forhold.																			
ADMX 11T308PR-R:8215	0.8	230	0.18	4.0	135	0.16	4.0	215	0.18	4.0	–	–	–	55	0.16	3.2	45	0.12	0.7
ADMX 11T308PR-R:M5315	0.8	310	0.18	4.0	–	–	–	290	0.18	4.0	–	–	–	–	–	–	60	0.13	0.7
ADMX 11T308PR-R:M8310	0.8	250	0.18	4.0	125	0.16	4.0	235	0.18	4.0	–	–	–	–	–	–	50	0.12	0.7
ADMX 11T308PR-R:M8330	0.8	230	0.18	4.0	135	0.16	4.0	215	0.18	4.0	–	–	–	55	0.16	3.2	45	0.12	0.7
ADMX 11T308PR-R:M8340	0.8	210	0.18	4.0	125	0.16	4.0	195	0.18	4.0	–	–	–	50	0.16	3.2	–	–	–
ADMX 11T308PR-R:M9315	0.8	310	0.18	4.0	–	–	–	290	0.18	4.0	–	–	–	–	–	–	60	0.13	0.7
ADMX 11T308PR-R:M9325	0.8	290	0.18	4.0	–	–	–	275	0.18	4.0	–	–	–	–	–	–	55	0.13	0.7
ADMX 11T316PR-R:8215	1.6	255	0.18	4.0	150	0.16	4.0	240	0.18	4.0	–	–	–	60	0.16	3.2	50	0.12	0.7
ADMX 11T316PR-R:M8330	1.6	255	0.18	4.0	150	0.16	4.0	240	0.18	4.0	–	–	–	60	0.16	3.2	50	0.12	0.7
ADMX 11T316PR-R:M9325	1.6	320	0.18	4.0	–	–	–	300	0.18	4.0	–	–	–	–	–	–	60	0.12	0.7
 **MF** geometri med meget positivt design til letbearbejdning.																			
ADMX 11T304SR-MF:M6330	0.4	215	0.08	2.5	150	0.07	2.5	–	–	–	–	–	–	60	0.06	2.0	–	–	–
ADMX 11T304SR-MF:M8340	0.4	220	0.08	2.5	130	0.07	2.5	–	–	–	–	–	–	55	0.06	2.0	–	–	–
ADMX 11T308SR-MF:M6330	0.8	255	0.08	2.5	180	0.07	2.5	–	–	–	–	–	–	75	0.06	2.0	–	–	–
ADMX 11T308SR-MF:M8340	0.8	265	0.08	2.5	155	0.07	2.5	–	–	–	–	–	–	65	0.06	2.0	–	–	–
 **MM** geometri med meget positivt design til let til medium bearbejdning.																			
ADMX 11T304SR-MM:M6330	0.4	185	0.14	2.5	130	0.13	2.5	–	–	–	–	–	–	55	0.11	2.0	–	–	–
ADMX 11T304SR-MM:M8340	0.4	195	0.14	2.5	115	0.13	2.5	–	–	–	–	–	–	45	0.11	2.0	–	–	–
ADMX 11T308SR-MM:M6330	0.8	225	0.14	2.5	155	0.13	2.5	–	–	–	–	–	–	65	0.11	2.0	–	–	–
ADMX 11T308SR-MM:M8340	0.8	235	0.14	2.5	140	0.13	2.5	–	–	–	–	–	–	55	0.11	2.0	–	–	–
ADMX 11T308SR-MM:M8345	0.8	190	0.14	2.5	110	0.13	2.5	–	–	–	–	–	–	45	0.11	2.0	–	–	–
ADMX 11T308SR-MM:M9340	0.8	300	0.14	2.5	180	0.13	2.5	–	–	–	–	–	–	75	0.11	2.0	–	–	–
ADMX 11T312SR-MM:M6330	1.2	235	0.14	2.5	165	0.13	2.5	–	–	–	–	–	–	70	0.11	2.0	–	–	–
ADMX 11T312SR-MM:M8340	1.2	245	0.14	2.5	145	0.13	2.5	–	–	–	–	–	–	60	0.11	2.0	–	–	–

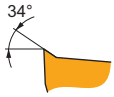
ADEX 11-FA

PRAMET

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
11T3	6.450	2.90	9.70	3.91



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

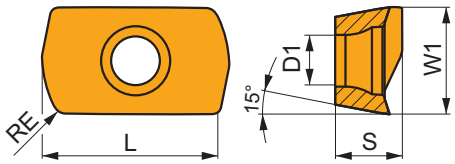
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				
ADEX 11T304FR-FA:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 210	0.30	5.0	–	–	–	–	–	–
ADEX 11T304FR-FA:M0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 480	0.30	5.0	–	–	–	–	–	–
ADEX 11T308FR-FA:HF7	●	0.8	–	–	–	–	–	–	–	–	–	■ 240	0.30	5.0	–	–	–	–	–	–
ADEX 11T308FR-FA:M0315	●	0.8	–	–	–	–	–	–	–	–	–	■ 570	0.30	5.0	–	–	–	–	–	–
ADEX 11T312FR-FA:HF7	●	1.2	–	–	–	–	–	–	–	–	–	■ 255	0.30	5.0	–	–	–	–	–	–
ADEX 11T316FR-FA:HF7	●	1.6	–	–	–	–	–	–	–	–	–	■ 270	0.18	5.0	–	–	–	–	–	–

FA geometri med meget positivt design til finbearbejdning til medium bearbejdning.

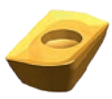
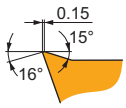
ADEX 11-HF

PRAMET

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
11T3	6.450	2.90	10.67	3.82

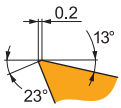


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				
ADEX 11T308SR-HF:8215	●	0.8	■ 215	0.68	0.4	◪ 125	0.61	0.4	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 11T308SR-HF:M6330	●	0.8	■ 185	0.68	0.4	◪ 130	0.61	0.4	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 11T308SR-HF:M8310	●	0.8	■ 220	0.68	0.4	◪ 110	0.52	0.4	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 11T308SR-HF:M8330	●	0.8	■ 215	0.68	0.4	◪ 125	0.61	0.4	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 11T308SR-HF:M8340	●	0.8	■ 200	0.68	0.4	◪ 120	0.61	0.4	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 11T308SR-HF:M9340	●	0.8	■ 220	0.68	0.4	◪ 130	0.61	0.4	–	–	–	–	–	–	–	–	–	–	–	–

HF geometri med meget positivt design til high feed bearbejdning.

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

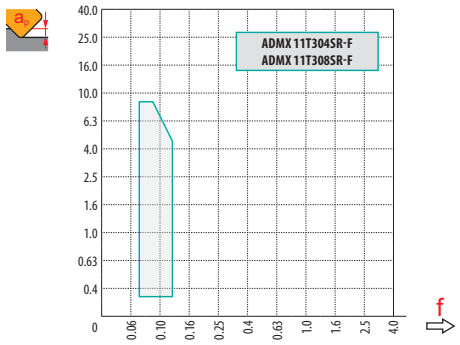
Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)
																				
ADEX 11T308SR-HF2:M8310		0.8	■ 220	0.68	0.4	◪ 110	0.61	0.4	◪ 205	0.68	0.4	–	–	–	–	–	–	◪ 40	0.48	0.3
ADEX 11T308SR-HF2:M8330		0.8	■ 215	0.68	0.4	◪ 125	0.61	0.4	◪ 200	0.68	0.4	–	–	–	◪ 50	0.48	0.3	◪ 40	0.48	0.3
ADEX 11T308SR-HF2:M8340		0.8	■ 200	0.68	0.4	◪ 120	0.61	0.4	◪ 190	0.68	0.4	–	–	–	◪ 50	0.48	0.3	–	–	–
ADEX 11T308SR-HF2:M9325		0.8	■ 250	0.68	0.4	–	–	–	◪ 235	0.68	0.4	–	–	–	–	–	–	◪ 50	0.48	0.3

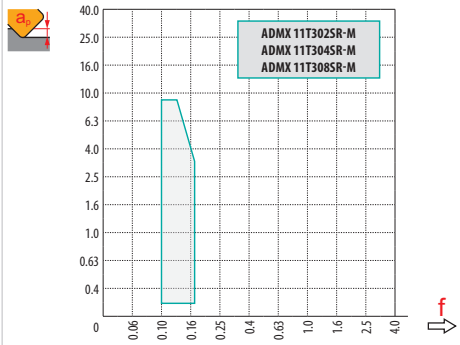
HF2 geometri med positivt design til high feed bearbejdning.

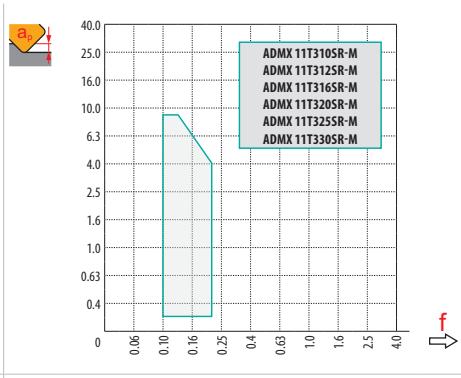
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

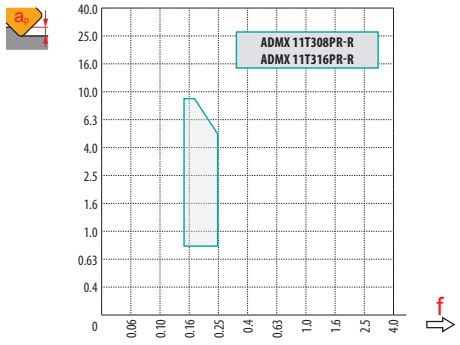
	ADMX 11-F		ADMX 11-M									ADMX 11-R		ADMX 11-MF	
RE	0.4	0.8	0.2	0.4	0.8	1.0	1.2	1.6	2.0	2.5	3.0	0.8	1.6	0.4	0.8
BS	1.89	1.48	2.09	1.89	1.48	1.27	1.08	0.68	1.61	1.13	0.66	1.48	0.68	1.89	1.48

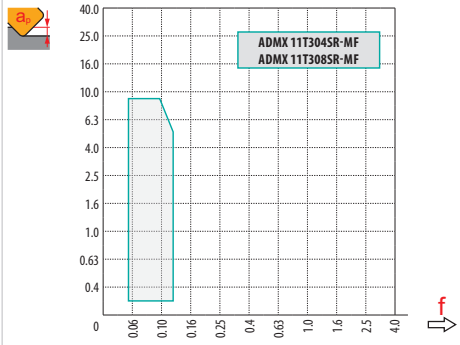
	ADMX 11-MM			ADEX 11-HF	ADEX 11-HF2	ADEX 11-FA			
RE	0.4	0.8	1.2	0.8	0.8	0.4	0.8	1.2	1.6
BS	1.89	1.48	1.08	0.17	0.17	1.77	1.39	1.0	0.62

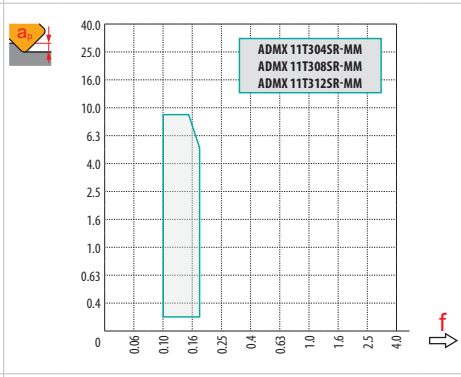


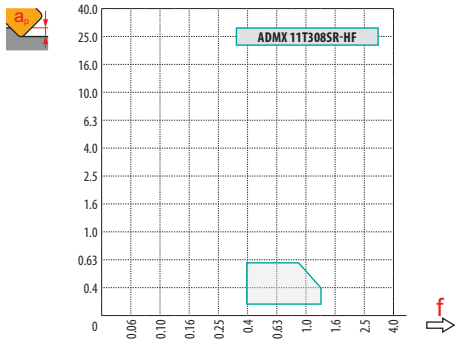


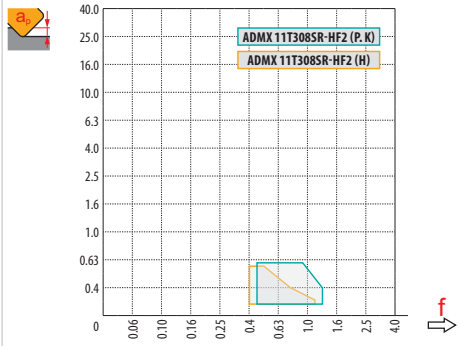


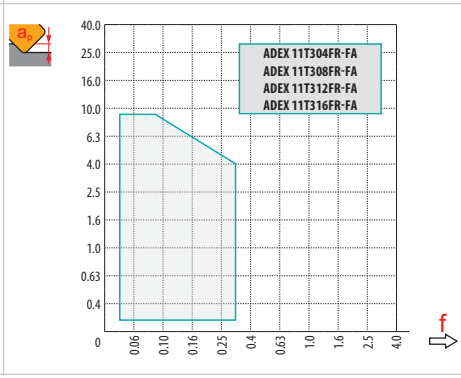












max 4.5

a_p	1.0	5.0	9.0
f	0.20	0.13	0.10

DC	RPMX	APMX/I
16	13.5°	9.0/40
18	10.0°	9.0/53
20	9.0°	9.0/59
25	6.0°	9.0/87
32	5.3°	9.0/99
40	3.8°	6.5/100
50	2.8°	4.7/100
63	1.8°	3.0/100
80	1.6°	2.6/100

HFC

DC	RPMX *	RPMX **	APMX/I
16	4.1°	5.7°	0.6/8
18	2.8°	4.5°	0.6/12
20	2.3°	4.3°	0.6/15
25	1.3°	6.7°	0.6/26
32	0.7°	4.3°	0.6/49
40	0.3°	2.9°	0.6/100
50	0.1°	2.1°	0.6/100
63	–	–	–
80	–	–	–

* HFC milling
** Conventional milling

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
16	27.0	32.0	8.3	9.0
18	32.0	36.0	7.5	9.0
20	35.0	40.0	7.5	9.0
25	45.0	50.0	6.5	7.5
32	59.0	64.0	4.0	4.5
40	75.0	80.0	1.5	2.0
50	–	–	–	–

HFC

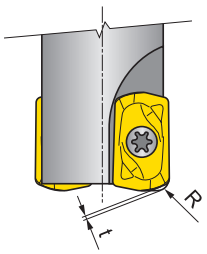
DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
16	21.0	32.0	0.6	0.6
18	29.0	36.0	0.6	0.6
20	29.0	40.0	0.6	0.6
25	39.0	50.0	0.6	0.6
32	53.0	64.0	0.6	0.6
40	68.5	80.0	0.6	0.6
50	88.5	100.0	0.6	0.6

a_p
1.7

DC	µm	3	5	10	15	20	30	40	50	60	80	100
16	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
18		0.465	0.600	0.849	1.039	1.200	1.470	1.697	1.897	2.078	2.400	2.683
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657

RE	µm	3	5	10	15	20	30	40	50	60	80	100
1.0	FE	0.155	0.200	0.283	0.346	0.400	0.490	0.566	0.632	0.693	0.800	0.894
1.2		0.170	0.219	0.310	0.379	0.438	0.537	0.620	0.693	0.759	0.876	0.980
1.6		0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
2.5		0.245	0.316	0.447	0.548	0.632	0.775	0.894	1.000	1.095	1.265	1.414
3.0		0.268	0.346	0.490	0.600	0.693	0.849	0.980	1.095	1.200	1.386	1.549

ADMX/ADEX 11	R
ADMX 11T320SR-M	1.0
ADMX 11T325SR-M	1.8
ADMX 11T330SR-M	1.8
ADEX 11T308SR-HF	1.4
ADEX 11T308SR-HF2	1.4



ADEX 11	R	t
ADEX 11T308SR-HF	1.42	0.35
ADEX 11T308SR-HF2	1.34	0.38

SAD16E

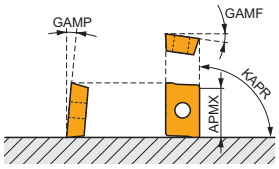
P M K N S H

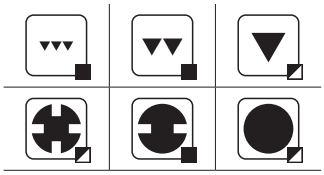
PRAMET S

FORCE AD16 skaftfræser med indvendig kølevæske

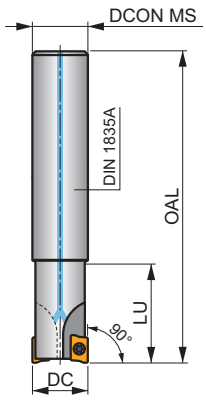
90° ende- og planfræser med positiv AD .. 16 skær med APMX på 13 mm. Velegnet til plan, hjørne, spor,spiralinterpolation , trochoidal, ramping og lommefræsning. Fås i cylindrisk, weldon, morse konisk, modulær og dorn (med differentieret tanddeling) Krop behandlet for længere værktøjslevetid.

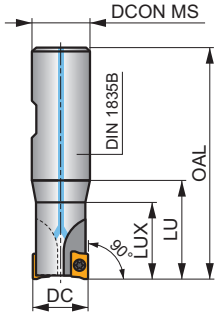
KAPR	90°
APMX	13.0 mm

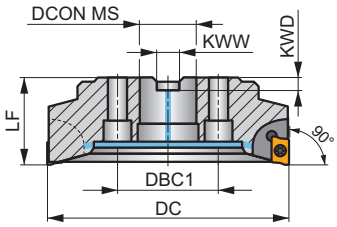


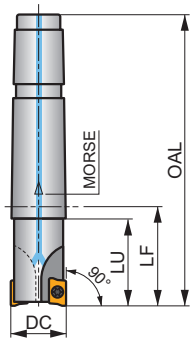


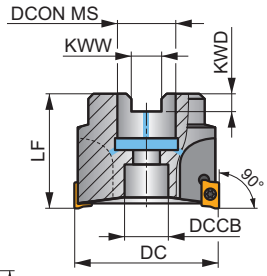
FORCE AD

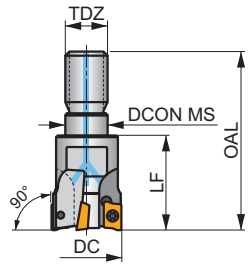












h_m	0.06 - 0.18
h_m	0.08 - 0.22

	Product	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	CZC MS	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)	max.	kg	
DIN 1835A	25A2R033A25-SAD16E-C	25	165	25	–	–	33	–	–	–	–	–	–	-13	5	2	–	18700	✓	0.52 GI165 SQ030 –
	25A2R038A25-SAD16E-C	25	200	25	–	–	38	–	–	–	–	–	–	-13	5	2	–	18700	✓	0.66 GI165 SQ030 –
	32A3R033A32-SAD16E-C	32	195	32	–	–	33	–	–	–	–	–	–	-12	7	3	–	16500	✓	1.03 GI165 SQ030 –
	32A3R048A32-SAD16E-C	32	250	32	–	–	48	–	–	–	–	–	–	-12	7	3	–	16500	✓	1.35 GI165 SQ030 –
DIN 1835B	25A2R042B25-SAD16E-C	25	98	25	–	–	–	42	–	–	–	–	–	-13	5	2	–	18700	✓	0.29 GI165 SQ030 –
	32A3R040B32-SAD16E-C	32	100	32	–	–	–	40	–	–	–	–	–	-12	7	3	–	16500	✓	0.51 GI165 SQ030 –
	40A3R050B32-SAD16E-C	40	110	32	–	–	–	50	–	–	–	–	–	-8.2	10.5	3	–	14800	✓	0.51 GI165 SQ030 –
	40A4R050B32-SAD16E-C	40	110	32	–	–	–	50	–	–	–	–	–	-8.2	10.5	4	–	14800	✓	0.64 GI165 SQ030 –
DIN 228A	25A2R043E03-SAD16E-C	25	98	–	–	–	38	–	43	–	3	–	–	-13	5	2	–	18600	✓	0.31 GI165 SQ030 –
	32A3R043E03-SAD16E-C	32	100	–	–	–	38	–	43	–	3	–	–	-12	7	3	–	16500	✓	0.33 GI165 SQ030 –
	40A3R054E04-SAD16E-C	40	110	–	–	–	48	–	54	–	4	–	–	-8.2	10.5	3	–	14700	✓	0.74 GI165 SQ030 –
	40A4R054E04-SAD16E-C	40	110	–	–	–	48	–	54	–	4	–	–	-8.2	10.5	4	–	14700	✓	0.70 GI165 SQ030 –
MODULAR	32A3R043M16-SAD16E-C	32	66	17	–	–	–	–	43	M16	–	–	–	-12	7	3	–	–	✓	0.20 GI165 SQ030 –
	40A4R043M16-SAD16E-C	40	66	17	–	–	–	–	43	M16	–	–	–	-8.2	10.5	4	–	–	✓	0.26 GI165 SQ030 –
ISO 6462 DIN 8030	40A04R-S90AD16E-C	40	–	16	14	–	–	–	40	–	–	8.4	5.6	-8.2	10.5	4	–	14700	✓	0.21 GI165 SQ032 –
	50A03R-S90AD16E-C	50	–	22	18	–	–	–	40	–	–	10.4	6.3	-7	11	3	–	13200	✓	0.43 GI165 SQ033 –
	50A05R-S90AD16E-C	50	–	22	18	–	–	–	40	–	–	10.4	6.3	-7	11	5	✓	13200	✓	0.40 GI165 SQ033 –
	63A04R-S90AD16E-C	63	–	22	18	–	–	–	40	–	–	10.4	6.3	-6	12	4	✓	11800	✓	0.60 GI165 SQ033 –
	63A06R-S90AD16E-C	63	–	22	18	–	–	–	40	–	–	10.4	6.3	-6	12	6	✓	11800	✓	0.59 GI165 SQ033 –
	80A05R-S90AD16E-C	80	–	27	38	–	–	–	50	–	–	12.4	7	-5	12	5	✓	10400	✓	1.09 GI165 SQ031 AC001
	80A07R-S90AD16E-C	80	–	27	38	–	–	–	50	–	–	12.4	7	-5	13	7	✓	10400	✓	0.97 GI165 SQ031 AC001
	100A06R-S90AD16E-C	100	–	32	45	–	–	–	50	–	–	14.4	8	-4	12	6	✓	9300	✓	1.85 GI165 SQ031 AC002
	100A08R-S90AD16E-C	100	–	32	45	–	–	–	50	–	–	14.4	8	-4	12	8	✓	9300	✓	1.89 GI165 SQ031 AC002
	125A09R-S90AD16E-C	125	–	40	56	–	–	–	63	–	–	16.4	9	-3.8	12	9	✓	8400	✓	3.65 GI165 SQ031 AC003
	140A08R-S90AD16E-C	140	–	40	56	–	–	–	63	–	–	16.4	9	-3.8	12	8	✓	7900	✓	4.06 GI165 SQ031 –
	160C10R-S90AD16E-C	160	–	40	–	66.7	–	–	63	–	–	16.4	9.2	-3.8	10	10	✓	7300	✓	6.04 GI165 SQ036 –
	175C10R-S90AD16E-C	175	–	40	–	66.7	–	–	63	–	–	16.4	9.2	-3.8	12	10	✓	7000	✓	6.86 GI165 SQ036 –

GI165	ADMX 1606..	ADEX 1606..

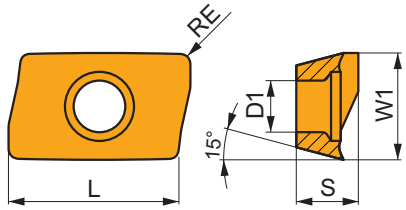
SQ030	US 4008-T15P	3.5	M 4	8	–	–	Flag T15P	–	–	–	–
SQ031	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	–	–	–	–	–
SQ032	US 4008-T15P	3.5	M 4	8	D-T08P/T15P	FG-15	–	HS 0830C	–	–	–
SQ033	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	–	HS 1030C	–	–	–
SQ036	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	–	HS 1240C	CAC 160C	HSD 0825C	HXK 5

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

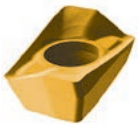
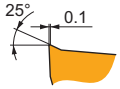
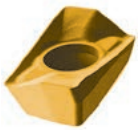
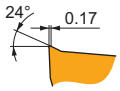
ADMX 16

PRAMET

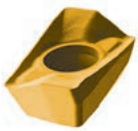
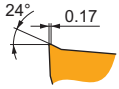
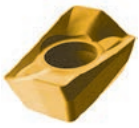
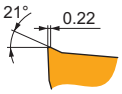
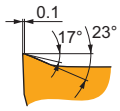
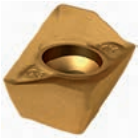
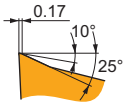
	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1606	9.950	4.50	16.00	6.25



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																			
F geometri med meget positivt design til let til medium bearbejdning.																			
ADMX 160608SR-F:8215	0.8	290	0.10	2.0	170	0.09	2.0	275	0.10	2.0	870	0.12	2.0	70	0.07	1.6	–	–	–
ADMX 160608SR-F:M8310	0.8	320	0.10	2.0	160	0.09	2.0	300	0.10	2.0	–	–	–	–	–	–	–	–	–
ADMX 160608SR-F:M8330	0.8	285	0.10	2.0	170	0.09	2.0	270	0.10	2.0	855	0.12	2.0	70	0.07	1.6	–	–	–
ADMX 160608SR-F:M8340	0.8	260	0.10	2.0	155	0.09	2.0	245	0.10	2.0	–	–	–	65	0.07	1.6	–	–	–
ADMX 160608SR-F:M9340	0.8	340	0.10	2.0	200	0.09	2.0	–	–	–	–	–	–	85	0.07	1.6	–	–	–
 																			
M geometri med positivt design til let til medium bearbejdning.																			
ADMX 160604SR-M:8215	0.4	190	0.18	5.0	110	0.16	5.0	180	0.18	5.0	–	–	–	45	0.13	4.0	–	–	–
ADMX 160604SR-M:M8330	0.4	190	0.18	5.0	110	0.16	5.0	180	0.18	5.0	–	–	–	45	0.13	4.0	–	–	–
ADMX 160604SR-M:M8340	0.4	170	0.18	5.0	100	0.16	5.0	160	0.18	5.0	–	–	–	40	0.13	4.0	–	–	–
ADMX 160608SR-M:8215	0.8	225	0.18	5.0	135	0.16	5.0	210	0.18	5.0	–	–	–	55	0.13	4.0	–	–	–
ADMX 160608SR-M:M5315	0.8	305	0.18	5.0	–	–	–	285	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160608SR-M:M8310	0.8	250	0.18	5.0	125	0.16	5.0	235	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160608SR-M:M8330	0.8	225	0.18	5.0	135	0.16	5.0	210	0.18	5.0	–	–	–	55	0.13	4.0	–	–	–
ADMX 160608SR-M:M8340	0.8	205	0.18	5.0	120	0.16	5.0	190	0.18	5.0	–	–	–	50	0.13	4.0	–	–	–
ADMX 160608SR-M:M9315	0.8	305	0.18	5.0	–	–	–	285	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160608SR-M:M9325	0.8	280	0.18	5.0	–	–	–	265	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160608SR-M:M9340	0.8	255	0.18	5.0	150	0.16	5.0	–	–	–	–	–	–	60	0.13	4.0	–	–	–

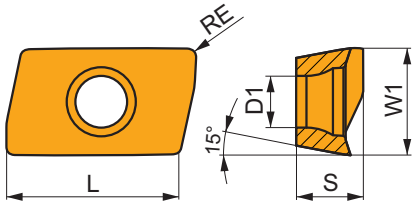
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
		(mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)
																				
M geometri med positivt design til let til medium bearbejdning.																				
ADMX 160616SR-M:8215		1.6	250	0.18	5.0	150	0.16	5.0	235	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–
ADMX 160616SR-M:M8310		1.6	275	0.18	5.0	140	0.16	5.0	260	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160616SR-M:M8330		1.6	250	0.18	5.0	150	0.16	5.0	235	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–
ADMX 160616SR-M:M8340		1.6	225	0.18	5.0	135	0.16	5.0	210	0.18	5.0	–	–	–	55	0.13	4.0	–	–	–
ADMX 160616SR-M:M9325		1.6	310	0.18	5.0	–	–	–	290	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160620SR-M:M8330		2.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	–	–	–	65	0.13	4.0	–	–	–
ADMX 160620SR-M:M8340		2.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–
ADMX 160630SR-M:M8330		3.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	–	–	–	65	0.13	4.0	–	–	–
ADMX 160630SR-M:M8340		3.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–
ADMX 160632SR-M:M6330		3.2	225	0.18	5.0	155	0.16	5.0	–	–	–	–	–	–	65	0.13	4.0	–	–	–
ADMX 160632SR-M:M8330		3.2	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	–	–	–	65	0.13	4.0	–	–	–
ADMX 160632SR-M:M8340		3.2	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–
ADMX 160632SR-M:M9325		3.2	325	0.18	5.0	–	–	–	305	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160640SR-M:M8330		4.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	–	–	–	65	0.13	4.0	–	–	–
ADMX 160640SR-M:M8340		4.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–
ADMX 160650SR-M:M8330		5.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	–	–	–	65	0.13	4.0	–	–	–
ADMX 160650SR-M:M8340		5.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–
																				
R geometri med positivt design til mellemstore til mindre stabile bearbejdningsforhold.																				
ADMX 160608PR-R:8215		0.8	205	0.25	6.0	120	0.23	6.0	190	0.25	6.0	–	–	–	50	0.20	4.8	40	0.16	1.1
ADMX 160608PR-R:M5315		0.8	260	0.25	6.0	–	–	–	245	0.25	6.0	–	–	–	–	–	–	50	0.16	1.1
ADMX 160608PR-R:M8310		0.8	220	0.25	6.0	110	0.23	6.0	205	0.25	6.0	–	–	–	–	–	–	40	0.16	1.1
ADMX 160608PR-R:M8330		0.8	205	0.25	6.0	120	0.23	6.0	190	0.25	6.0	–	–	–	50	0.20	4.8	40	0.16	1.1
ADMX 160608PR-R:M8340		0.8	190	0.25	6.0	110	0.23	6.0	180	0.25	6.0	–	–	–	45	0.20	4.8	–	–	–
ADMX 160608PR-R:M9315		0.8	265	0.25	6.0	–	–	–	250	0.25	6.0	–	–	–	–	–	–	50	0.16	1.1
ADMX 160608PR-R:M9325		0.8	250	0.25	6.0	–	–	–	235	0.25	6.0	–	–	–	–	–	–	50	0.16	1.1
ADMX 160616PR-R:M8330		1.6	225	0.25	6.0	135	0.23	6.0	210	0.25	6.0	–	–	–	55	0.20	4.8	45	0.16	1.1
ADMX 160616PR-R:M8340		1.6	210	0.25	6.0	125	0.23	6.0	195	0.25	6.0	–	–	–	50	0.20	4.8	–	–	–
ADMX 160616PR-R:M9315		1.6	295	0.25	6.0	–	–	–	280	0.25	6.0	–	–	–	–	–	–	55	0.16	1.1
																				
MF geometri med meget positivt design til færdigbearbejdning.																				
ADMX 160608SR-MF:M6330		0.8	215	0.08	4.0	150	0.07	4.0	–	–	–	–	–	–	60	0.06	3.2	–	–	–
ADMX 160608SR-MF:M8340		0.8	225	0.08	4.0	135	0.07	4.0	–	–	–	–	–	–	55	0.06	3.2	–	–	–
ADMX 160608SR-MF:M9340		0.8	305	0.08	4.0	180	0.07	4.0	–	–	–	–	–	–	75	0.06	3.2	–	–	–
																				
MM geometri med meget positivt design til let til medium bearbejdning.																				
ADMX 160604SR-MM:M6330		0.4	145	0.18	4.0	105	0.16	4.0	–	–	–	–	–	–	40	0.14	3.2	–	–	–
ADMX 160604SR-MM:M8340		0.4	160	0.18	4.0	95	0.16	4.0	–	–	–	–	–	–	40	0.14	3.2	–	–	–
ADMX 160608SR-MM:M6330		0.8	175	0.18	4.0	125	0.16	4.0	–	–	–	–	–	–	50	0.14	3.2	–	–	–
ADMX 160608SR-MM:M8340		0.8	190	0.18	4.0	110	0.16	4.0	–	–	–	–	–	–	45	0.14	3.2	–	–	–
ADMX 160608SR-MM:M8345		0.8	150	0.18	4.0	90	0.16	4.0	–	–	–	–	–	–	35	0.14	3.2	–	–	–
ADMX 160608SR-MM:M9340		0.8	235	0.18	4.0	140	0.16	4.0	–	–	–	–	–	–	55	0.14	3.2	–	–	–
ADMX 160616SR-MM:M6330		1.6	195	0.18	4.0	140	0.16	4.0	–	–	–	–	–	–	55	0.14	3.2	–	–	–
ADMX 160616SR-MM:M8340		1.6	210	0.18	4.0	125	0.16	4.0	–	–	–	–	–	–	50	0.14	3.2	–	–	–
ADMX 160616SR-MM:M8345		1.6	165	0.18	4.0	95	0.16	4.0	–	–	–	–	–	–	40	0.14	3.2	–	–	–
ADMX 160616SR-MM:M9340		1.6	260	0.18	4.0	155	0.16	4.0	–	–	–	–	–	–	65	0.14	3.2	–	–	–

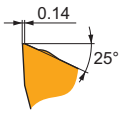
ADEX 16

PRAMET

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1606	9.950	4.50	16.00	6.25



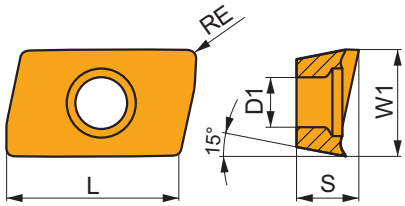
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																			
FM geometri med meget positivt design til medium bearbejdning.																			
ADEX 160608SR-FM:8215	0.8	260	0.16	2.0	155	0.14	2.0	245	0.16	2.0	–	–	–	65	0.11	1.6	–	–	–
ADEX 160608SR-FM:M8330	0.8	255	0.16	2.0	150	0.14	2.0	240	0.16	2.0	–	–	–	60	0.11	1.6	–	–	–
ADEX 160608SR-FM:M8340	0.8	235	0.16	2.0	140	0.14	2.0	220	0.16	2.0	–	–	–	55	0.11	1.6	–	–	–

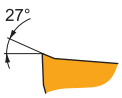
ADEX 16-FA

PRAMET

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1606	9.950	4.50	16.00	6.17

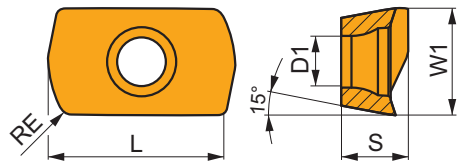


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

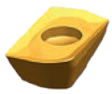
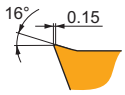
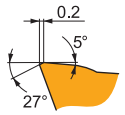
Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																			
FA geometri med meget positivt design til finbearbejdning til medium bearbejdning.																			
ADEX 160604FR-FA:HF7	0.4	–	–	–	–	–	–	–	–	–	195	0.28	6.0	–	–	–	–	–	–
ADEX 160604FR-FA:M0315	0.4	–	–	–	–	–	–	–	–	–	480	0.28	6.0	–	–	–	–	–	–
ADEX 160608FR-FA:HF7	0.8	–	–	–	–	–	–	–	–	–	240	0.28	6.0	–	–	–	–	–	–
ADEX 160608FR-FA:M0315	0.8	–	–	–	–	–	–	–	–	–	570	0.28	6.0	–	–	–	–	–	–
ADEX 160616FR-FA:HF7	1.6	–	–	–	–	–	–	–	–	–	255	0.28	6.0	–	–	–	–	–	–
ADEX 160616FR-FA:M0315	1.6	–	–	–	–	–	–	–	–	–	630	0.28	6.0	–	–	–	–	–	–
ADEX 160630FR-FA:HF7	3.0	–	–	–	–	–	–	–	–	–	270	0.28	6.0	–	–	–	–	–	–

ADEX 16-HF

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1606	9.950	4.50	16.00	5.88



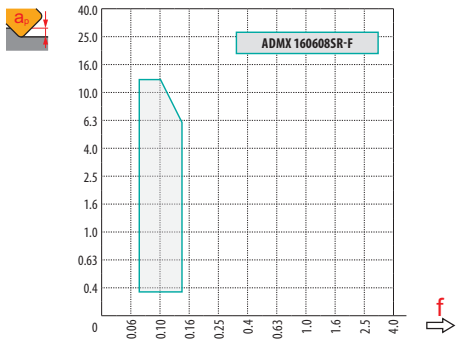
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

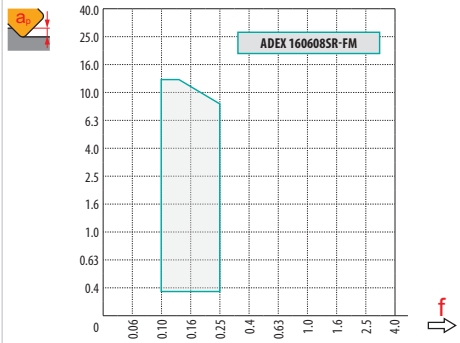
Product	RE	P			M			K			N			S			H		
		vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)
	(mm)																		
		**HF** geometri med meget positivt design til high feed bearbejdning.																	
ADEX 160612SR-HF:8215	1.2	195	1.00	0.6	115	0.90	0.6	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 160612SR-HF:M8310	1.2	205	1.00	0.6	100	0.77	0.6	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 160612SR-HF:M8330	1.2	200	1.00	0.6	120	0.90	0.6	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 160612SR-HF:M8340	1.2	185	1.00	0.6	110	0.90	0.6	–	–	–	–	–	–	–	–	–	–	–	–
ADEX 160612SR-HF:M9340	1.2	195	1.00	0.6	115	0.90	0.6	–	–	–	–	–	–	–	–	–	–	–	–
		**HF2** geometri med positivt design til high feed bearbejdning.																	
ADEX 160612SR-HF2:M8310	1.2	205	0.90	0.6	100	0.81	0.6	190	0.90	0.6	–	–	–	–	–	–	40	0.63	0.5
ADEX 160612SR-HF2:M8330	1.2	205	0.90	0.6	120	0.81	0.6	190	0.90	0.6	–	–	–	50	0.81	0.5	40	0.63	0.5
ADEX 160612SR-HF2:M8340	1.2	190	0.90	0.6	110	0.81	0.6	180	0.90	0.6	–	–	–	45	0.81	0.5	–	–	–
ADEX 160612SR-HF2:M9325	1.2	230	0.90	0.6	–	–	–	215	0.90	0.6	–	–	–	–	–	–	45	0.63	0.5

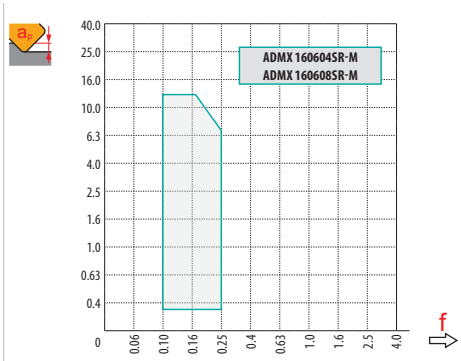
a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

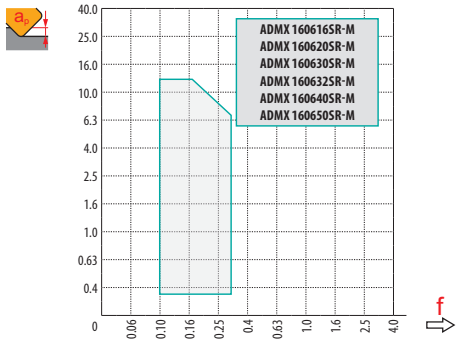
	ADMX 16-F	ADEX 16-FM	ADMX 16-M								ADMX 16-R	
RE	0.8	0.8	0.4	0.8	1.6	2.0	3.0	3.2	4.0	5.0	0.8	1.6
BS	2.99	2.18	3.39	2.99	1.62	1.23	0.28	0.09	2.69	1.52	2.99	1.62

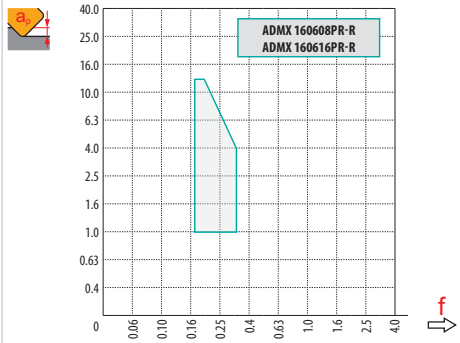
	ADMX 16-MF	ADMX 16-MM			ADEX 16-HF	ADEX 16-HF2	ADEX 16-FA			
RE	0.8	0.4	0.8	1.6	1.2	1.2	0.4	0.8	1.6	3.0
BS	2.99	3.39	2.99	1.62	0.52	0.52	2.84	2.44	1.65	0.69

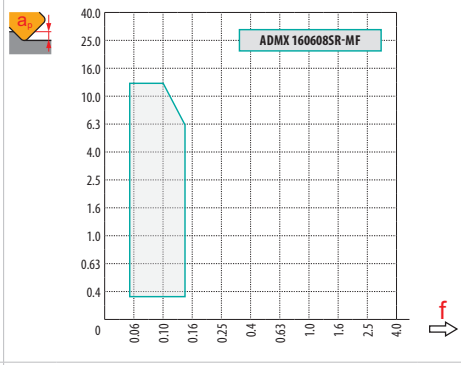


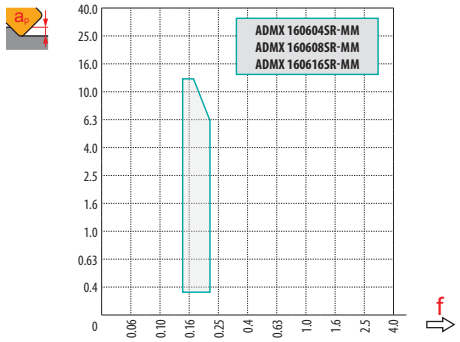


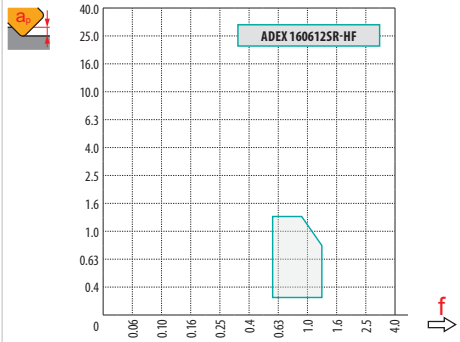


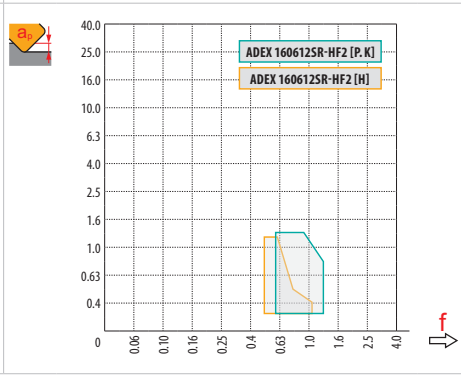


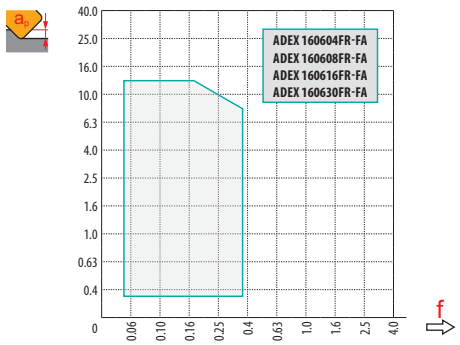












max

7.5

a_p	1.0	6.0	13.0
f	0.28	0.19	0.10

DC	RPMX	APMX/l
25	12.5°	13.0/60
32	7.5°	13.0/100
40	5.0°	8.6/100
50	3.5°	6.0/100
63	2.5°	4.2/100
80	2.0°	3.3/100

HFC

DC	RPMX *	RPMX **	APMX/l
25	4.0°	8.0°	1.3/19
32	2.0°	7.5°	1.3/38
40	1.2°	4.5°	1.3/65
50	0.8°	3.0°	1.3/100
63	0.5°	2.0°	0.8/100
80	0.4°	1.5°	0.6/100

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
25	42.0	50.0	10.0	12.5
32	55.0	64.0	6.5	9.0
40	72.0	80.0	5.0	8.0
50	92.0	100.0	4.5	6.0
63	118.0	126.0	4.0	5.0
80	136.0	160.0	1.5	2.0

HFC

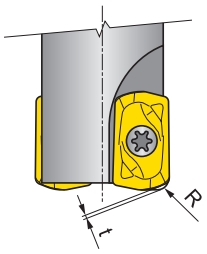
DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
25	42.0	50.0	1.3	1.3
32	55.0	64.0	1.3	1.3
40	72.0	80.0	1.3	1.3
50	92.0	100.0	1.3	1.3
63	118.0	126.0	1.3	1.3
80	136.0	160.0	1.3	1.3

a_p
2.5

DC	µm	3	5	10	15	20	30	40	50	60	80	100
25	FE	0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657

RE	µm	3	5	10	15	20	30	40	50	60	80	100
1.6	FE	0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
3.0		0.268	0.346	0.490	0.600	0.693	0.849	0.980	1.095	1.200	1.386	1.549
3.2		0.277	0.358	0.506	0.620	0.716	0.876	1.012	1.131	1.239	1.431	1.600
4.0		0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789
5.0		0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000

ADMX/ADEX 16	R
ADMX 160630SR-M	2.5
ADMX 160632SR-M	2.5
ADMX 160640SR-M	4.0
ADMX 160650SR-M	4.5
ADEX 160612SR-HF	3.0
ADEX 160612SR-HF2	3.0



ADEX 16	R	t
ADEX 160612SR-HF	2.59	0.56
ADEX 160612SR-HF2	2.48	0.57

SAP10D

P M K N S

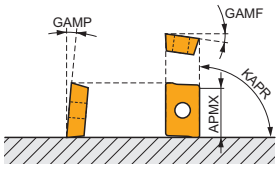
PRAMET

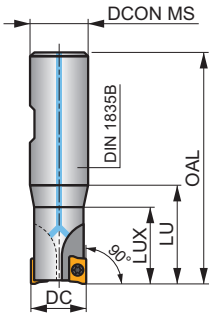
S

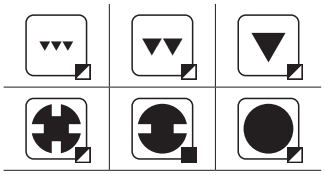
Firkantet hjørnefræser til APKT 10 skær med intern køleværske

90° ende- og planfræser, der anvender positiv APKT 10-skær med APMX på 9 mm. Velegnet til plan, hjørne, spor, spiralinterpolation, trochoidal, ramping og lommefræsning. Fås i weldon og dorn (med differentieret tanddeling) Krop behandlet for længere værktøjslevetid.

KAPR	90°
APMX	9.0 mm







h_m	0.06 - 0.13
h_m	0.08 - 0.16

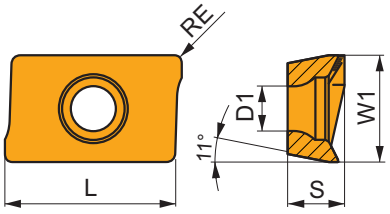
	Product	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LUX (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835B	**10A1R020B16-SAP10D-C**	10	78	16	–	30	20	–	–	–	12	2	1	–	39000	✓	0.09	GI081	SQ215
	12A1R027B16-SAP10D-C	12	75	16	–	27	–	–	–	–	12	2	1	–	35600	✓	0.10	GI081	SQ210
	16A2R032B16-SAP10D-C	16	80	16	–	32	–	–	–	–	12	4	2	–	30800	✓	0.12	GI081	SQ210
	20A3R032B20-SAP10D-C	20	82	20	–	32	–	–	–	–	12	4	3	–	27600	✓	0.13	GI081	SQ210
	25A3R042B25-SAP10D-C	25	98	25	–	42	–	–	–	–	12	4	3	–	24700	✓	0.36	GI081	SQ210

GI081	APKT 1003..

		Nm			
SQ210	US 2506-T07P	1.2	M 2.5	6.3	Flag T07P
SQ215	US 2505-T07P	1.2	M 2.5	5.2	Flag T07P

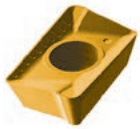
APKT 10

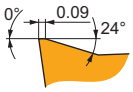
	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1003	6.700	2.88	11.00	3.50



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
APKT 1003PDER-M:8215	⬢	0.5	285	0.12	4.0	170	0.11	4.0	270	0.12	4.0	–	–	–	70	0.11	3.2	–	–	–
APKT 1003PDER-M:M8330	⬢	0.5	285	0.12	4.0	170	0.11	4.0	270	0.12	4.0	–	–	–	70	0.11	3.2	–	–	–
APKT 1003PDER-M:M8340	⬢	0.5	255	0.12	4.0	150	0.11	4.0	240	0.12	4.0	–	–	–	60	0.11	3.2	–	–	–
APKT 1003PDER-M:M9325	●	0.5	360	0.12	4.0	–	–	–	340	0.12	4.0	–	–	–	–	–	–	–	–	–
APKT 1003PDER-M:M9340	⬢	0.5	335	0.12	4.0	200	0.11	4.0	–	–	–	–	–	–	80	0.11	3.2	–	–	–

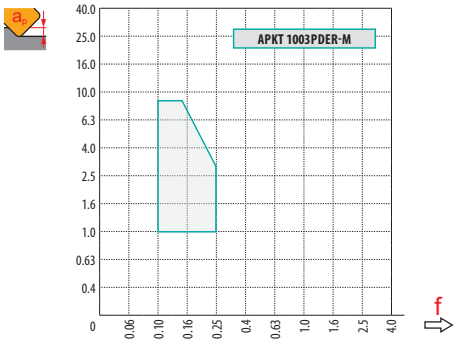




M geometri med meget positivt design til let til medium bearbejdning.

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	APKT 10-M
RE	0.5
BS	0.84



max.
4.5

a_p	1.0	3.0	5.0
1 ⇨ f	0.20	0.13	0.10

DC	RPMX	APMX/I
10	7.3°	9.0/72
12	6.2°	9.0/84
16	2.4°	4.0/100
20	2.2°	3.7/100
25	2.2°	3.7/100

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
10	11.0	20.0	0.4	3.8
12	13.0	24.0	0.3	3.9
16	20.5	32.0	0.6	2.0
20	27.2	40.0	0.9	2.4
25	37.9	50.0	1.6	3.0

a_p
0.3

SAP16D

P M K N S

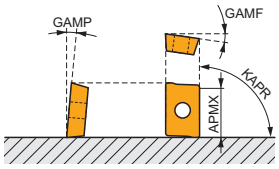
PRAMET

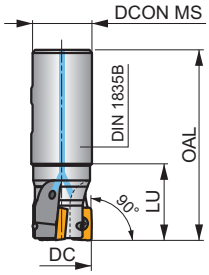
S

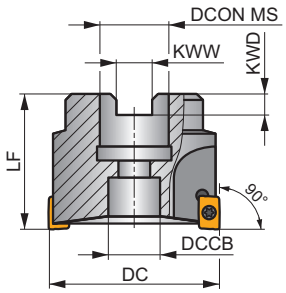
Firkantet hjørnefræser til APKT 16 skær med intern kølevæske

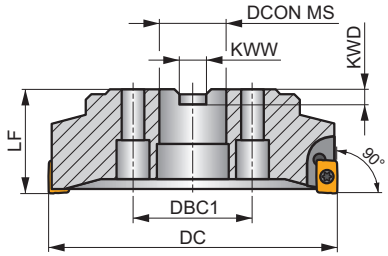
90° ende- og planfræser, der anvender positiv APKT 16-skær med APMX på 9 mm. Velegnet til plan, hjørne, spor, spiralinterpolation, trochoidal, ramping og lommefræsning. Fås i weldon og dorn (med differentieret tanddeling) Krop behandlet for længere værktøjslevetid.

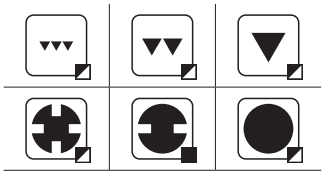
KAPR	90°
APMX	13.0 mm











h_m	0.06 - 0.18
h_m	0.10 - 0.22

	Product	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LU (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835B	**25A2R042B25-SAP16D-C**	25	98	25	–	–	42	–	–	–	0	6	2	–	16800	✓	0.31	GI080	SQ030	–
DIN 1835B	**32A3R040B32-SAP16D-C**	32	100	32	–	–	50	–	–	–	0	8	3	–	14800	✓	0.51	GI080	SQ220	–
DIN 1835B	**40A4R050B32-SAP16D-C**	40	110	32	–	–	50	–	–	–	0	8	4	–	13200	✓	0.67	GI080	SQ220	–
	40A4R-S90AP16D	40	40	16	11	–	–	40	8.4	5.6	0	6	4	✓	13200	–	0.23	GI080	SQ031	–
	50A5R-S90AP16D	50	40	22	18	–	–	40	10.4	6.3	0	6	5	✓	11800	–	0.35	GI080	SQ031	–
	63A6R-S90AP16D	63	40	22	18	–	–	40	10.4	6.3	0	6	6	✓	10600	–	0.50	GI080	SQ031	–
ISO 6462 DIN 8030	**80B5R-S90AP16D**	80	50	27	38	–	–	50	12.4	7	0	6	5	✓	9400	–	0.97	GI080	SQ031	AC001
ISO 6462 DIN 8030	**80B7R-S90AP16D**	80	50	27	38	–	–	50	12.4	7	0	6	7	✓	9400	–	0.99	GI080	SQ031	AC001
ISO 6462 DIN 8030	**100B8R-S90AP16D**	100	50	32	45	–	–	50	14.4	8	0	6	8	✓	8400	–	1.50	GI080	SQ031	AC002
ISO 6462 DIN 8030	**125B9R-S90AP16D**	125	63	40	56	–	–	63	16.4	9	0	6	9	✓	7500	–	2.80	GI080	SQ031	AC003

GI080	APKT 1604..	APET 1604..

		Nm					
SQ030	US 4008-T15P	3.5	M 4	8	–	–	Flag T15P
SQ031	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	–
SQ220	US 4011-T15P	3.5	M 4	10.6	–	–	Flag T15P

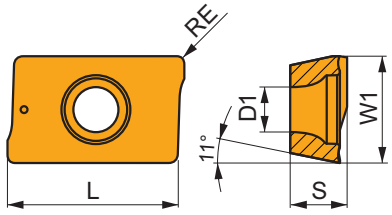
AC001	KS 1230	K.FMH27

AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

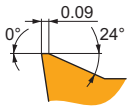
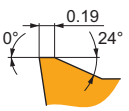
APKT 16

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1604	9.440	4.60	17.00	5.67

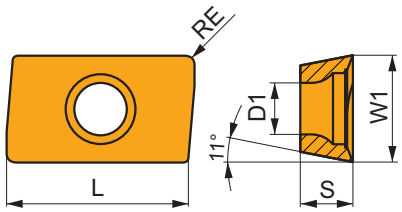


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

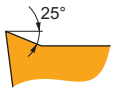
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
GM geometri med meget positivt design til let til medium bearbejdning.																			
APKT 1604PDR-GM:M8330	0.8	235	0.20	8.0	140	0.18	8.0	220	0.20	8.0	–	–	–	55	0.16	6.4	–	–	–
APKT 1604PDR-GM:M8340	0.8	210	0.20	8.0	125	0.18	8.0	195	0.20	8.0	–	–	–	50	0.16	6.4	–	–	–
APKT 1604PDR-GM:M9315	0.8	310	0.20	8.0	–	–	–	290	0.20	8.0	–	–	–	–	–	–	–	–	–
APKT 1604PDR-GM:M9325	0.8	285	0.20	8.0	–	–	–	270	0.20	8.0	–	–	–	–	–	–	–	–	–
APKT 1604PDR-GM:M9340	0.8	260	0.20	8.0	155	0.18	8.0	–	–	–	–	–	–	65	0.16	6.4	–	–	–
																			
HM geometri med meget positivt design til mellemstore og mindre stabile bearbejdningsforhold.																			
APKT 160404-HM:M8340	0.4	160	0.30	6.0	95	0.27	6.0	150	0.30	6.0	–	–	–	40	0.24	4.8	–	–	–
APKT 160416-HM:M8340	1.6	210	0.30	6.0	125	0.27	6.0	195	0.30	6.0	–	–	–	50	0.24	4.8	–	–	–
APKT 160431-HM:M8340	3.1	220	0.30	6.0	130	0.27	6.0	205	0.30	6.0	–	–	–	55	0.24	4.8	–	–	–
APKT 1604PDR-HM:8215	0.8	220	0.30	6.0	130	0.27	6.0	205	0.30	6.0	–	–	–	55	0.24	4.8	–	–	–
APKT 1604PDR-HM:M5315	0.8	270	0.30	6.0	–	–	–	255	0.30	6.0	–	–	–	–	–	–	–	–	–
APKT 1604PDR-HM:M8330	0.8	220	0.30	6.0	130	0.27	6.0	205	0.30	6.0	–	–	–	55	0.24	4.8	–	–	–
APKT 1604PDR-HM:M8340	0.8	200	0.30	6.0	120	0.27	6.0	190	0.30	6.0	–	–	–	50	0.24	4.8	–	–	–
APKT 1604PDR-HM:M9325	0.8	260	0.30	6.0	–	–	–	245	0.30	6.0	–	–	–	–	–	–	–	–	–

APET 16-FA

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.600	4.50	17.00	4.76



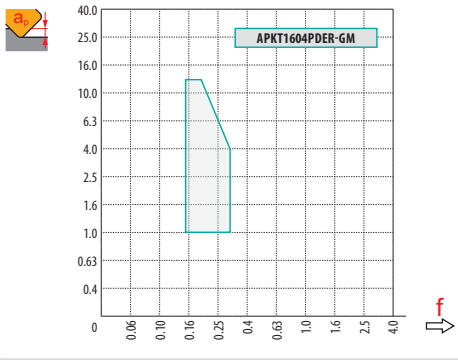
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

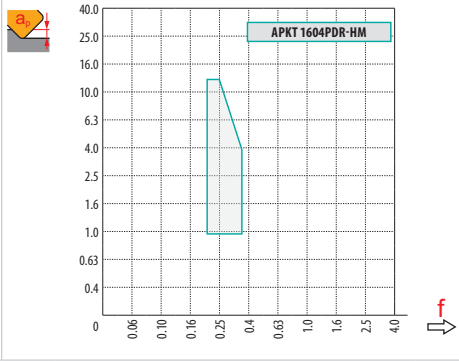
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																					
APET 160408FR-FA:HF7	●	0.8	–	–	–	–	–	–	–	–	–	255	0.24	8.0	–	–	–	–	–	–

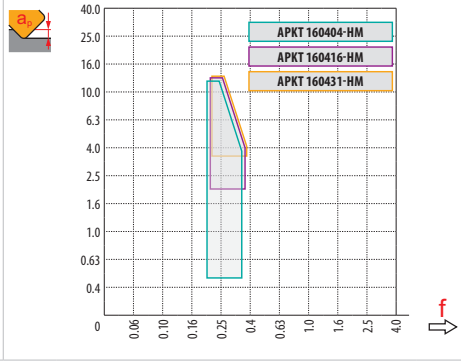
FA geometri med meget positivt design til finbearbejdning til medium bearbejdning.

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	APKT 16-GM	APKT 16-HM			
RE	0.8	0.4	0.8	1.6	3.1
BS	1.39	1.87	1.48	0.64	1.30







max

7.4

a_p	1.0	6.0	13.0
f	0.28	0.19	0.13

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
25	34.7	50.0	1.2	3.1
32	48.5	64.0	0.9	1.7
40	63.5	80.0	1.3	2.2
50	83.5	100.0	0.9	1.4
63	110.0	126.0	1.0	1.4
80	144.0	160.0	1.1	1.3

DC	RPMX	APMX/I
25	2.3	3.9/100
32	1.0	1.6/100
40	1.0	1.6/100
50	0.5	0.7/100
63	0.4	0.5/100
80	0.3	0.4/100

a_p
0.2

FACE MILLING

	SSO09	SSD12	FTB27X			
	90°	90°	90°			
	APMX (mm) 8.0	APMX (mm) 10.0	APMX (mm) 18.0			
	DC (mm) 20 – 80	DC (mm) 50 – 160	DC (mm) 175, 260			
Cylindrical shank						
Weldon	DC = 20 – 32 (mm)					
Modular						
Shell mill	DC = 40 – 80 (mm)					
Page	122	125	128			
ISO	P M K S	P M K N S	P M K			
Insert shape						
Inserts	SOMT 09T3	SDMT 1205	TBMR 2707			
No. of cutting edges	4	4	3			
Shallow shoulder milling	■	■	■			
Shallow slot milling	■	■	◪			
Plunge milling	■	■				
Face milling	◪	◪	◪			

■ Primary use ◪ Possible use

SSO09

P M K S

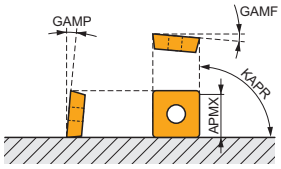
PRAMET

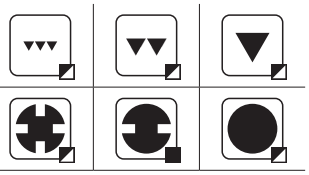
S

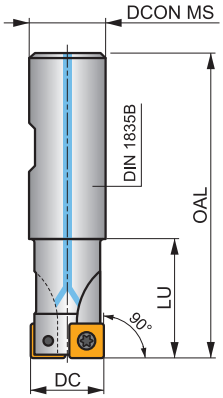
90 ° hjørnefræser til SOMT 09 skær med intern kølevæske

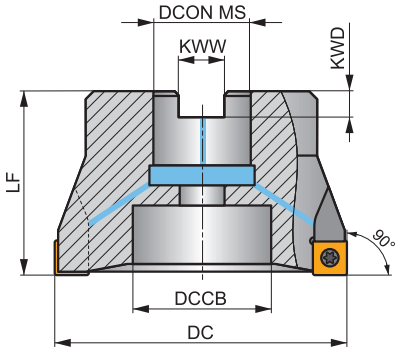
90° ende- og planfræser, der bruger positive SOMT 09-skær med APMX på 8 mm. Velegnet til plan, hjørne, spor og lommefræsning. Fås i cylindrisk, weldontype og dorn-stil og med differentieret tanddeling. Krop behandlet for længere værktøjslevetid.

KAPR	90°
APMX	8.0 mm









h_m	0.07 - 0.18
h_m	0.07 - 0.22

	Product	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835B	**20A2R032B20-SSO09-C**	20	82	20	–	32	–	–	–	-12	6	2	–	23800	✓	0.21	GI146	SQ400	–
	25A3R042B25-SSO09-C	25	98	25	–	42	–	–	–	-12	6	3	–	21300	✓	0.31	GI146	SQ400	–
	32A4R042B32-SSO09-C	32	102	32	–	42	–	–	–	-10	10	4	✓	18800	✓	0.55	GI146	SQ400	–
ISO 6462 DIN 8030	**40A05R-S90SO09-C**	40	–	16	14	–	40	8.4	5.6	-9.1	10	5	–	16800	✓	0.29	GI146	SQ402	–
	50A06R-S90SO09-C	50	–	22	18	–	40	10.4	6.4	-8.8	10	6	–	15100	✓	0.33	GI146	SQ403	–
	63A07R-S90SO09-C	63	–	22	18	–	40	10.4	6.4	-8.6	10	7	–	13400	✓	0.62	GI146	SQ403	–
	80A09R-S90SO09-C	80	–	27	38	–	50	12.4	7	-8.1	10	9	–	11900	✓	1.03	GI146	SQ401	AC001

GI146	SOMT 09T3..

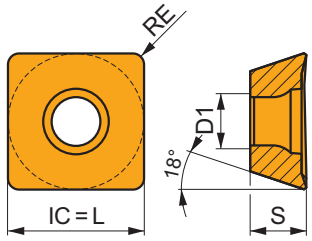
		Nm						
SQ400	US 3006-T09P	2.0	M 3	6	–	–	Flag T09P	–
SQ401	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	–	–
SQ402	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	–	HS 0830C
SQ403	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	–	HS 1030C

AC001	KS 1230	K.FMH27

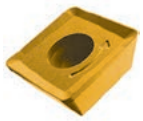
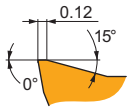
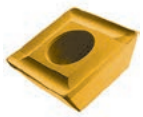
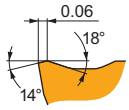
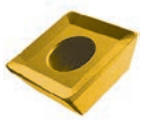
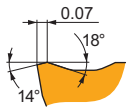
SOMT 09

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
09T3	9.550	3.50	9.55	3.97

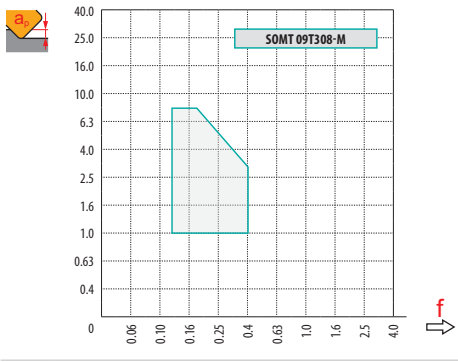


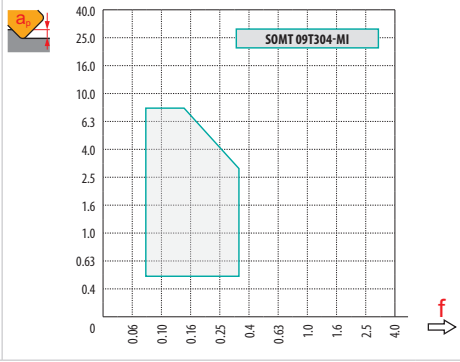
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Betingelserne gælder for indstillingsvinkel 90 °. Se vores app til bearbejdning af yderligere beregninger.

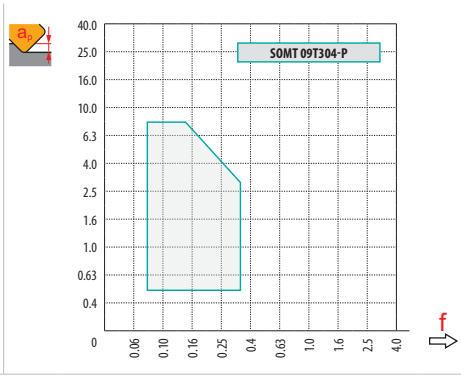
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
			**M** geometri med positivt design til medium bearbejdning.																	
SOMT 09T308-M:8215		0.8	275	0.14	2.5	165	0.13	2.5	260	0.14	2.5	–	–	–	65	0.13	2.0	–	–	–
SOMT 09T308-M:M5315		0.8	390	0.14	2.5	–	–	–	370	0.14	2.5	–	–	–	–	–	–	–	–	–
SOMT 09T308-M:M8330		0.8	270	0.14	2.5	160	0.13	2.5	255	0.14	2.5	–	–	–	65	0.13	2.0	–	–	–
SOMT 09T308-M:M8340		0.8	250	0.14	2.5	150	0.13	2.5	235	0.14	2.5	–	–	–	60	0.13	2.0	–	–	–
SOMT 09T308-M:M9315		0.8	380	0.14	2.5	–	–	–	360	0.14	2.5	–	–	–	–	–	–	–	–	–
			**MI** geometri med stabilt positivt design til medium bearbejdning.																	
SOMT 09T304-MI:8215		0.4	230	0.14	2.5	135	0.13	2.5	215	0.14	2.5	–	–	–	55	0.10	2.0	–	–	–
SOMT 09T304-MI:M8310		0.4	255	0.14	2.5	130	0.13	2.5	240	0.14	2.5	–	–	–	–	–	–	–	–	–
SOMT 09T304-MI:M8330		0.4	230	0.14	2.5	135	0.13	2.5	215	0.14	2.5	–	–	–	55	0.10	2.0	–	–	–
SOMT 09T304-MI:M8340		0.4	210	0.14	2.5	125	0.13	2.5	195	0.14	2.5	–	–	–	50	0.10	2.0	–	–	–
SOMT 09T304-MI:M9315		0.4	320	0.14	2.5	–	–	–	300	0.14	2.5	–	–	–	–	–	–	–	–	–
SOMT 09T304-MI:M9340		0.4	265	0.14	2.5	155	0.13	2.5	–	–	–	–	–	–	65	0.10	2.0	–	–	–
			**P** geometri med meget positivt design til medium bearbejdning.																	
SOMT 09T304-P:M8330		0.4	250	0.14	2.5	150	0.13	2.5	235	0.14	2.5	–	–	–	60	0.10	2.0	–	–	–
SOMT 09T304-P:M8340		0.4	230	0.14	2.5	135	0.13	2.5	215	0.14	2.5	–	–	–	55	0.10	2.0	–	–	–
SOMT 09T304-P:M9325		0.4	320	0.14	2.5	–	–	–	300	0.14	2.5	–	–	–	–	–	–	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SOMT 09-M	SOMT 09-MI	SOMT 09-P
RE	0.8	0.4	0.4
BS	0.90	1.30	1.30







max

6.0

a_p	1.0	4.0	8.0
f	0.28	0.19	0.09

SSD12

P M K N S

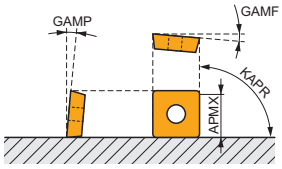
PRAMET

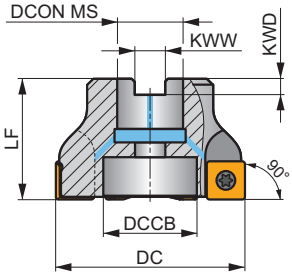
S

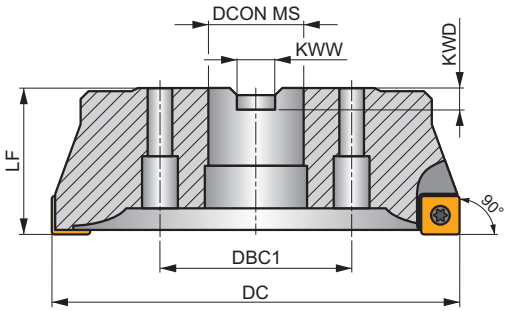
90 ° hjørnefræser til SDMT 12 skær med intern kølevæske

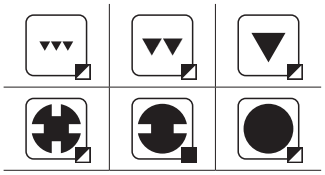
90° hjørnefræser med positive SDMT 12 skær med APMX på 10 mm. Velegnet til plan, hjørne, spor og lommefræsning. Fås kun med dorn. Krop behandlet for længere værktøjslevetid.

KAPR	90°
APMX	10.0 mm









h_m 0.09 - 0.25

	Product	DC (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	**50A05R-S90SD12-C**	50	40	22	18	–	10.4	6.3	-5	8	5	–	13000	✓	0.34	GI057	SQ413	–
	63A06R-S90SD12-C	63	40	22	18	–	10.4	6.3	-5	8	6	–	11600	✓	0.53	GI057	SQ413	–
	80A06R-S90SD12-C	80	50	27	38	–	12.4	7	-5	8	6	–	10300	✓	1.16	GI057	SQ411	AC001
	100A08R-S90SD12-C	100	50	32	45	–	14.4	8	-5	8	8	–	9200	✓	1.69	GI057	SQ411	AC002
	125A09R-S90SD12-C	125	63	40	56	–	16.4	9	-5	8	9	–	8300	✓	3.19	GI057	SQ411	AC003
	160C12R-S90SD12	160	63	40	–	66.7	16.4	9	-5	8	12	–	7300	–	5.70	GI057	SQ411	–

GI057	SDMT 1205..

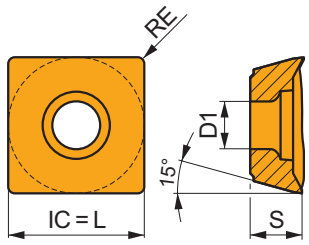
					Nm					
SQ411	SSN 100312	MS 3510	HXK 3.5	US 3511-T15	3.0	M 3.5	11	D-T07/T15	FG-15	–
SQ413	–	–	–	US 3511-T15	3.0	M 3.5	11	D-T07/T15	FG-15	HS 1030C

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

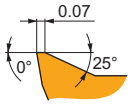
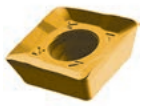
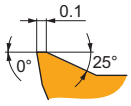
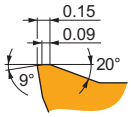
SDMT 12

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
1205	12.700	4.40	12.70	5.00

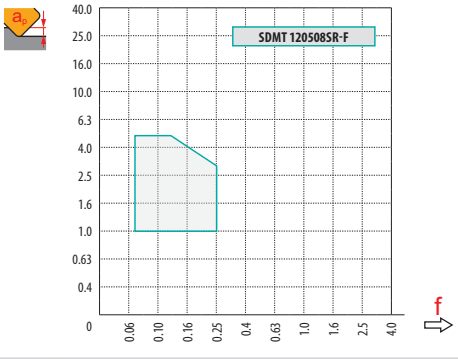


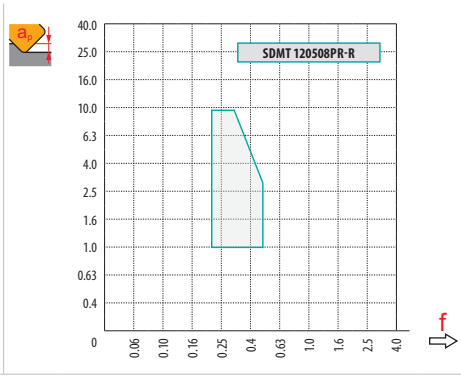
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			**F** geometri med positivt design til let til medium bearbejdning.																	
SDMT 120508SR-F:M8330		0.8	275	0.10	3.0	165	0.09	3.0	260	0.10	3.0	825	0.12	3.0	65	0.08	2.4	–	–	–
SDMT 120508SR-F:M8340		0.8	250	0.10	3.0	150	0.09	3.0	235	0.10	3.0	–	–	–	60	0.08	2.4	–	–	–
			**M** geometri med positivt design til let til medium bearbejdning.																	
SDMT 120508SR-M:8215		0.8	245	0.16	3.5	145	0.14	3.5	230	0.16	3.5	–	–	–	60	0.11	2.8	–	–	–
SDMT 120508SR-M:M8330		0.8	240	0.16	3.5	140	0.14	3.5	225	0.16	3.5	–	–	–	60	0.11	2.8	–	–	–
SDMT 120508SR-M:M8340		0.8	220	0.16	3.5	130	0.14	3.5	205	0.16	3.5	–	–	–	55	0.11	2.8	–	–	–
SDMT 120508SR-M:M9325		0.8	305	0.16	3.5	–	–	–	285	0.16	3.5	–	–	–	–	–	–	–	–	–
			**R** geometri med stabilt positivt design til medium bearbejdning.																	
SDMT 120508PR-R:M8330		0.8	220	0.25	3.5	130	0.23	3.5	205	0.25	3.5	–	–	–	55	0.23	2.8	–	–	–
SDMT 120508PR-R:M8340		0.8	195	0.25	3.5	115	0.23	3.5	185	0.25	3.5	–	–	–	45	0.23	2.8	–	–	–
SDMT 120508PR-R:M9315		0.8	280	0.25	3.5	–	–	–	265	0.25	3.5	–	–	–	–	–	–	–	–	–
SDMT 120508PR-R:M9325		0.8	265	0.25	3.5	–	–	–	250	0.25	3.5	–	–	–	–	–	–	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SDMT 12-F	SDMT 12-M	SDMT 12-R
RE	0.8	0.8	0.8
BS	–	–	–





max.

8.0

a_p	1.0	5.0	10.0
f	0.39	0.25	0.14

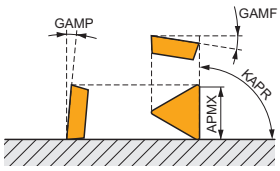
FTB27X

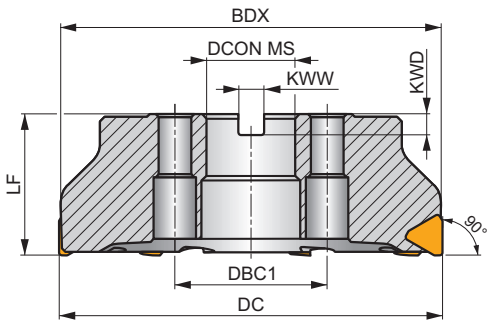
ROUGH TB hjørnefræser til TBMR 27 skær til kraftig fræsning

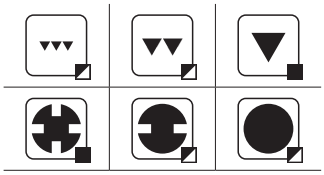
90° hjørnefræser med positive TBMR 27 skær med APMX på 18 mm. Velegnet til kraftig fræsning i plan, hjørne og spor Fås kun med dorn og med differentieret tanddeling. Krop behandlet for længere værktøjslevetid.

ROUGH TB

KAPR	90°
APMX	18.0 mm







h_m 0.15 - 0.38

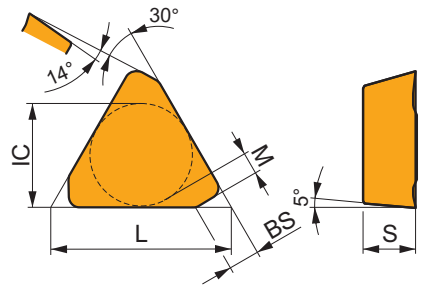
	Product	DC (mm)	BDX (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	**175C08R-F90TB27X**	175	169.6	63	40	–	66.7	16.4	16.4	-9	9	8	✓	–	–	7.59	GI163	SQ424	–
	260C12R-F90TB27X	260	253.4	63	60	–	101.6	25.7	25.7	-9	9	12	✓	–	–	18.21	GI163	SQ425	–

GI163	TBMR 2707PZ..

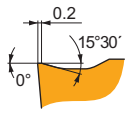
SQ424	LNK 220616	US 6013-T20P	SDR T20P-T	KU TBMR 2707	DS 01Z	KL 04	HS 1240
SQ425	LNK 220616	US 6013-T20P	SDR T20P-T	KU TBMR 2707	DS 01Z	KL 04	HS 1655

TBMR 27

	BS	IC	L	M	S
	(mm)	(mm)	(mm)	(mm)	(mm)
2707	4.61	15.875	27.50	3.2	7.94

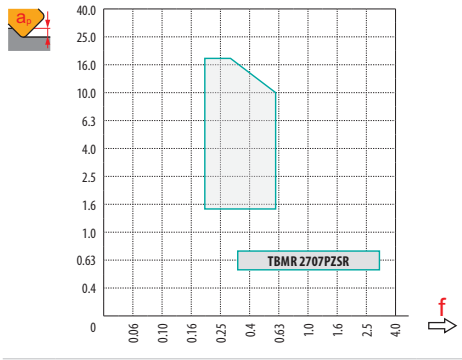


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
			**PZSR** stærkt design til kraftig bearbejdning.																	
TBMR 2707PZSR:M8326		–	130	0.20	11.0	–	–	–	120	0.20	11.0	–	–	–	–	–	–	–	–	–
TBMR 2707PZSR:M8346		–	110	0.20	11.0	65	0.20	11.0	–	–	–	–	–	–	–	–	–	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	TBMR 27
RE	–
BS	2.70



a_e	1.5	8.0	18.0
f	0.60	0.39	0.24

DYB HJØRNEFRÆSNING

FACE MILLING

	J(T)-SAD11E	J(T)-SAD16E	J(T)-SSAP	J(T)-CSD12X	J(T)-SLSN
	90°	90°	90°	90°	90°
	APMX (mm) 37.0 – 56.0	APMX (mm) 40.0 – 108.0	APMX (mm) 58.0 – 95.0	APMX (mm) 44.1 – 87.3	APMX (mm) 104.0 – 134.0
	DC (mm) 25 – 50	DC (mm) 50 – 100	DC (mm) 50 – 80	DC (mm) 40 – 80	DC (mm) 63, 80
Cylindrical shank	DC = 25 – 40 (mm)				
Weldon	DC = 25 – 40 (mm)			DC = 50 (mm)	
Modular		DC = 50 – 80 (mm)		DC = 40 – 63 (mm)	
Shell mill	DC = 50 (mm)	DC = 50 – 100 (mm)		DC = 50 – 80 (mm)	
Page	134	139	145	150	153
ISO	P M K N S H	P M K N S H	P M K N S H	P M S	P K
Insert shape					
Inserts	AD 11T3	AD.. 1606	APE. 150412 SPE. 1204	SD.X 1205	LNET 1606 SN.. 1305
No. of cutting edges	2	2	2 / 4	4	2 / 8
Dyb hjørne fræsning	■	■	■	■	■
Fræsning med dyb spor	■	■	■	■	■
Planfræsning	◪	◪	◪	◪	◪
Dykfræsning	◪	◪	◪		◪

■ Primary use ◪ Possible use

J(T)-SAD11E

P M K N S

PRAMET

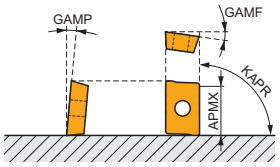
S

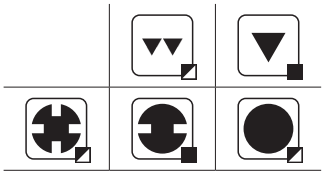
HELISK AD11 Langfræser med intern kølevæske

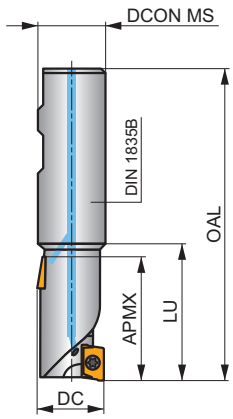
90° langskærsfræse med positiv ADMX 11 skær med APMX på 36 op til 56 mm med indvendigt kølevæske. Velegnet til hjørner-, spor-, plan- eller lommefræsning. Fås i weldon, MK eller dorn. Krop behandlet for længere værktøjslevetid.

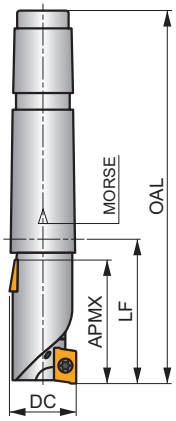
FORCE AD

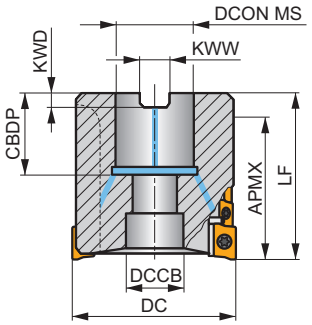
KAPR	90°
APMX	37.0 - 56.0 mm











h_m	0.05 - 0.08
h_m	0.05 - 0.08

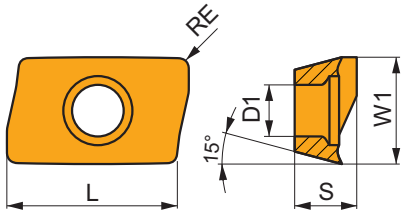
	Product	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	APMX (mm)	CBDP (mm)	CZC MS	GAMF (°)	GAMP (°)	NOF			max.		kg		
DIN 1835B	**25J2R50B25-SAD11E38-C**	25	106	25	–	50	–	38.00	–	–	-10.5	5	2	8	–	24100	✓	0.32	GI184	SQ210
	32J2R60B32-SAD11E47-C	32	120	32	–	60	–	47.00	–	–	-9	8	2	10	–	21300	✓	0.60	GI184	SQ210
	40J2R60B40-SAD11E47-C	40	130	40	–	60	–	47.00	–	–	-8.1	11	2	10	–	19100	✓	1.07	GI184	SQ210
	40J3R70B32-SAD11E56-C	40	130	32	–	70	–	56.00	–	–	-8.1	11	3	18	–	19100	✓	0.76	GI184	SQ210
	40J3R70B40-SAD11E56-C	40	140	40	–	70	–	56.00	–	–	-8.1	11	3	18	–	19100	✓	1.07	GI184	SQ210
DIN 228A	**25J2R55E03-SAD11E38-C**	25	136	–	–	–	55	38.00	–	3	-10.5	5	2	8	–	24100	✓	0.32	GI184	SQ210
	32J2R65E04-SAD11E47-C	32	167.5	–	–	–	65	47.00	–	4	-9	8	2	10	–	21300	✓	0.71	GI184	SQ210
	40J3R75E04-SAD11E56-C	40	177.5	–	–	–	75	56.00	–	4	-8.1	11	3	18	–	19100	✓	0.85	GI184	SQ210
ISO 6462 DIN 8030	**50T03R-S90AD11E37-C**	50	–	22	18	–	58	37.00	21	–	-7.2	12	3	12	–	17000	✓	0.66	GI184	SQ903

GI184	ADMX 11T3..	ADEX 11T3..-FA

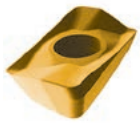
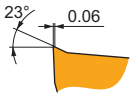
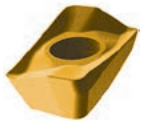
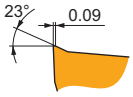
		Nm						
SQ210	US 2506-T07P	1.2	M 2.5	6.3	–	–	Flag T07P	–
SQ903	US 2506-T07P	1.2	M 2.5	6.3	D-T07P/T09P	FG-15	–	HS 1030C

ADMX 11

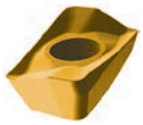
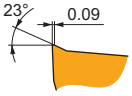
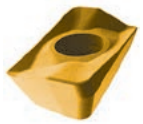
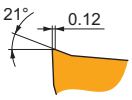
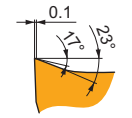
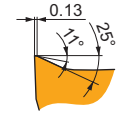
	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
11T3	6.530	2.90	11.00	3.97



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

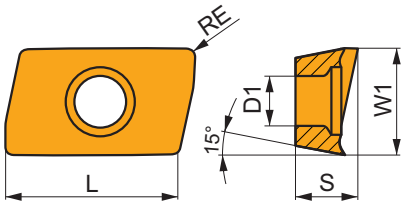
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
			**F** geometri med meget skarpt positivt design til let bearbejdning.																	
ADMX 11T304SR-F:8215	●	0.4	245	0.10	2.0	145	0.09	2.0	230	0.10	2.0	735	0.12	2.0	60	0.08	1.6	–	–	–
ADMX 11T304SR-F:M8330	●	0.4	240	0.10	2.0	140	0.09	2.0	225	0.10	2.0	720	0.12	2.0	60	0.08	1.6	–	–	–
ADMX 11T304SR-F:M8340	●	0.4	220	0.10	2.0	130	0.09	2.0	205	0.10	2.0	–	–	–	55	0.08	1.6	–	–	–
ADMX 11T304SR-F:M9340	●	0.4	285	0.10	2.0	170	0.09	2.0	–	–	–	–	–	–	70	0.08	1.6	–	–	–
ADMX 11T308SR-F:8215	⬢	0.8	290	0.10	2.0	170	0.09	2.0	275	0.10	2.0	870	0.12	2.0	70	0.08	1.6	–	–	–
ADMX 11T308SR-F:M8330	⬢	0.8	285	0.10	2.0	170	0.09	2.0	270	0.10	2.0	855	0.12	2.0	70	0.08	1.6	–	–	–
ADMX 11T308SR-F:M8340	⬢	0.8	260	0.10	2.0	155	0.09	2.0	245	0.10	2.0	–	–	–	65	0.08	1.6	–	–	–
ADMX 11T308SR-F:M9340	⬢	0.8	340	0.10	2.0	200	0.09	2.0	–	–	–	–	–	–	85	0.08	1.6	–	–	–
			**M** geometri med positivt design til let til medium bearbejdning.																	
ADMX 11T302SR-M:M8330	●	0.2	190	0.15	4.0	110	0.14	4.0	180	0.15	4.0	–	–	–	45	0.12	3.2	–	–	–
ADMX 11T302SR-M:M8340	⬢	0.2	170	0.15	4.0	100	0.14	4.0	160	0.15	4.0	–	–	–	40	0.12	3.2	–	–	–
ADMX 11T304SR-M:8215	●	0.4	205	0.15	4.0	120	0.14	4.0	190	0.15	4.0	–	–	–	50	0.12	3.2	–	–	–
ADMX 11T304SR-M:M8310	●	0.4	220	0.15	4.0	110	0.14	4.0	205	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T304SR-M:M8330	⬢	0.4	205	0.15	4.0	120	0.14	4.0	190	0.15	4.0	–	–	–	50	0.12	3.2	–	–	–
ADMX 11T304SR-M:M8340	⬢	0.4	185	0.15	4.0	110	0.14	4.0	175	0.15	4.0	–	–	–	45	0.12	3.2	–	–	–
ADMX 11T304SR-M:M9325	●	0.4	255	0.15	4.0	–	–	–	240	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T304SR-M:M9340	●	0.4	235	0.15	4.0	140	0.14	4.0	–	–	–	–	–	–	55	0.12	3.2	–	–	–
ADMX 11T308SR-M:8215	⬢	0.8	245	0.15	4.0	145	0.14	4.0	230	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T308SR-M:M5315	⬢	0.8	335	0.15	4.0	–	–	–	315	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T308SR-M:M8310	⬢	0.8	265	0.15	4.0	135	0.14	4.0	250	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T308SR-M:M8330	⬢	0.8	245	0.15	4.0	145	0.14	4.0	230	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T308SR-M:M8340	⬢	0.8	220	0.15	4.0	130	0.14	4.0	205	0.15	4.0	–	–	–	55	0.12	3.2	–	–	–
ADMX 11T308SR-M:M9315	⬢	0.8	330	0.15	4.0	–	–	–	310	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T308SR-M:M9325	⬢	0.8	305	0.15	4.0	–	–	–	285	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T308SR-M:M9340	⬢	0.8	275	0.15	4.0	165	0.14	4.0	–	–	–	–	–	–	65	0.12	3.2	–	–	–
ADMX 11T310SR-M:M8330	⬢	1.0	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T310SR-M:M8340	✱	1.0	230	0.15	4.0	135	0.14	4.0	215	0.15	4.0	–	–	–	55	0.12	3.2	–	–	–
ADMX 11T312SR-M:8215	⬢	1.2	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T312SR-M:M8330	✱	1.2	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T312SR-M:M8340	✱	1.2	230	0.15	4.0	135	0.14	4.0	215	0.15	4.0	–	–	–	55	0.12	3.2	–	–	–
ADMX 11T316SR-M:8215	⬢	1.6	270	0.15	4.0	160	0.14	4.0	255	0.15	4.0	–	–	–	65	0.12	3.2	–	–	–
ADMX 11T316SR-M:M6330	✱	1.6	230	0.15	4.0	165	0.14	4.0	–	–	–	–	–	–	65	0.12	3.2	–	–	–
ADMX 11T316SR-M:M8310	⬢	1.6	295	0.15	4.0	150	0.14	4.0	280	0.15	4.0	–	–	–	–	–	–	–	–	–
ADMX 11T316SR-M:M8330	✱	1.6	270	0.15	4.0	160	0.14	4.0	255	0.15	4.0	–	–	–	65	0.12	3.2	–	–	–
ADMX 11T316SR-M:M8340	✱	1.6	240	0.15	4.0	140	0.14	4.0	225	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T320SR-M:M6330	✱	2.0	240	0.15	4.0	170	0.14	4.0	–	–	–	–	–	–	70	0.12	3.2	–	–	–
ADMX 11T320SR-M:M8330	✱	2.0	280	0.15	4.0	165	0.14	4.0	265	0.15	4.0	–	–	–	70	0.12	3.2	–	–	–
ADMX 11T320SR-M:M8340	✱	2.0	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
  **M** geometri med positivt design til let til medium bearbejdning.																			
ADMX 11T325SR-M:M6330	2.5	240	0.15	4.0	170	0.14	4.0	–	–	–	–	–	–	70	0.12	3.2	–	–	–
ADMX 11T325SR-M:M8340	2.5	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
ADMX 11T330SR-M:M6330	3.0	240	0.15	4.0	170	0.14	4.0	–	–	–	–	–	–	70	0.12	3.2	–	–	–
ADMX 11T330SR-M:M8330	3.0	280	0.15	4.0	165	0.14	4.0	265	0.15	4.0	–	–	–	70	0.12	3.2	–	–	–
ADMX 11T330SR-M:M8340	3.0	255	0.15	4.0	150	0.14	4.0	240	0.15	4.0	–	–	–	60	0.12	3.2	–	–	–
  **R** geometri med positivt design til bearbejdningsforhold under mindre stabile forhold.																			
ADMX 11T308PR-R:8215	0.8	230	0.18	4.0	135	0.16	4.0	215	0.18	4.0	–	–	–	55	0.16	3.2	45	0.12	0.7
ADMX 11T308PR-R:M5315	0.8	310	0.18	4.0	–	–	–	290	0.18	4.0	–	–	–	–	–	–	60	0.13	0.7
ADMX 11T308PR-R:M8310	0.8	250	0.18	4.0	125	0.16	4.0	235	0.18	4.0	–	–	–	–	–	–	50	0.12	0.7
ADMX 11T308PR-R:M8330	0.8	230	0.18	4.0	135	0.16	4.0	215	0.18	4.0	–	–	–	55	0.16	3.2	45	0.12	0.7
ADMX 11T308PR-R:M8340	0.8	210	0.18	4.0	125	0.16	4.0	195	0.18	4.0	–	–	–	50	0.16	3.2	–	–	–
ADMX 11T308PR-R:M9315	0.8	310	0.18	4.0	–	–	–	290	0.18	4.0	–	–	–	–	–	–	60	0.13	0.7
ADMX 11T308PR-R:M9325	0.8	290	0.18	4.0	–	–	–	275	0.18	4.0	–	–	–	–	–	–	55	0.13	0.7
ADMX 11T316PR-R:8215	1.6	255	0.18	4.0	150	0.16	4.0	240	0.18	4.0	–	–	–	60	0.16	3.2	50	0.12	0.7
ADMX 11T316PR-R:M8330	1.6	255	0.18	4.0	150	0.16	4.0	240	0.18	4.0	–	–	–	60	0.16	3.2	50	0.12	0.7
ADMX 11T316PR-R:M9325	1.6	320	0.18	4.0	–	–	–	300	0.18	4.0	–	–	–	–	–	–	60	0.12	0.7
 **MF** geometri med meget positivt design til letbearbejdning.																			
ADMX 11T304SR-MF:M6330	0.4	215	0.08	2.5	150	0.07	2.5	–	–	–	–	–	–	60	0.06	2.0	–	–	–
ADMX 11T304SR-MF:M8340	0.4	220	0.08	2.5	130	0.07	2.5	–	–	–	–	–	–	55	0.06	2.0	–	–	–
ADMX 11T308SR-MF:M6330	0.8	255	0.08	2.5	180	0.07	2.5	–	–	–	–	–	–	75	0.06	2.0	–	–	–
ADMX 11T308SR-MF:M8340	0.8	265	0.08	2.5	155	0.07	2.5	–	–	–	–	–	–	65	0.06	2.0	–	–	–
 **MM** geometri med meget positivt design til let til medium bearbejdning.																			
ADMX 11T304SR-MM:M6330	0.4	185	0.14	2.5	130	0.13	2.5	–	–	–	–	–	–	55	0.11	2.0	–	–	–
ADMX 11T304SR-MM:M8340	0.4	195	0.14	2.5	115	0.13	2.5	–	–	–	–	–	–	45	0.11	2.0	–	–	–
ADMX 11T308SR-MM:M6330	0.8	225	0.14	2.5	155	0.13	2.5	–	–	–	–	–	–	65	0.11	2.0	–	–	–
ADMX 11T308SR-MM:M8340	0.8	235	0.14	2.5	140	0.13	2.5	–	–	–	–	–	–	55	0.11	2.0	–	–	–
ADMX 11T308SR-MM:M8345	0.8	190	0.14	2.5	110	0.13	2.5	–	–	–	–	–	–	45	0.11	2.0	–	–	–
ADMX 11T308SR-MM:M9340	0.8	300	0.14	2.5	180	0.13	2.5	–	–	–	–	–	–	75	0.11	2.0	–	–	–
ADMX 11T312SR-MM:M6330	1.2	235	0.14	2.5	165	0.13	2.5	–	–	–	–	–	–	70	0.11	2.0	–	–	–
ADMX 11T312SR-MM:M8340	1.2	245	0.14	2.5	145	0.13	2.5	–	–	–	–	–	–	60	0.11	2.0	–	–	–

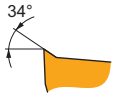
ADEX 11-FA

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
11T3	6.450	2.90	9.70	3.91



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



FA geometri med meget positivt design til finbearbejdning til medium bearbejdning.

ADEX 11T304FR-FA:HF7	●	0.4	–	–	–	–	–	–	–	–	–	■ 210	0.30	5.0	–	–	–	–	–	–
ADEX 11T304FR-FA:M0315	●	0.4	–	–	–	–	–	–	–	–	–	■ 480	0.30	5.0	–	–	–	–	–	–
ADEX 11T308FR-FA:HF7	●	0.8	–	–	–	–	–	–	–	–	–	■ 240	0.30	5.0	–	–	–	–	–	–
ADEX 11T308FR-FA:M0315	●	0.8	–	–	–	–	–	–	–	–	–	■ 570	0.30	5.0	–	–	–	–	–	–
ADEX 11T312FR-FA:HF7	●	1.2	–	–	–	–	–	–	–	–	–	■ 255	0.30	5.0	–	–	–	–	–	–
ADEX 11T316FR-FA:HF7	●	1.6	–	–	–	–	–	–	–	–	–	■ 270	0.18	5.0	–	–	–	–	–	–

a_e/DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	0.89	0.81	0.76	0.73	0.71	0.70	0.67	0.65	0.63	0.62	0.60	0.60	0.60	0.45

$a_{e\,max}$ / DC	1		2.5		5		7.5		10		15		20	
	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨
25	0.25	0.40	0.16	0.26	0.12	0.19	0.10	0.15	0.09	0.14	0.07	0.12	0.07	0.11
32	0.28	0.45	0.18	0.29	0.13	0.21	0.11	0.17	0.09	0.15	0.08	0.13	0.07	0.12
40	0.32	0.51	0.20	0.32	0.14	0.23	0.12	0.19	0.10	0.17	0.09	0.14	0.08	0.13
50	0.35	0.57	0.23	0.36	0.16	0.26	0.13	0.21	0.12	0.19	0.10	0.15	0.09	0.14

$a_{e\,max}$ / DC	25		32		40		50	
	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨
25	0.08	0.13	–	–	–	–	–	–
32	0.07	0.11	0.08	0.13	–	–	–	–
40	0.07	0.12	0.07	0.11	0.08	0.13	–	–
50	0.08	0.13	0.07	0.12	0.07	0.11	0.08	0.13

	ADMX 11-F		ADMX 11-M									ADMX 11-R		ADMX 11-MF		ADMX 11-MM			ADEX 11-FA			
RE	0.4	0.8	0.2	0.4	0.8	1.0	1.2	1.6	2.0	2.5	3.0	0.8	1.6	0.4	0.8	0.4	0.8	1.2	0.4	0.8	1.2	1.6
BS	1.89	1.48	2.09	1.89	1.48	1.27	1.08	0.68	1.61	1.13	0.66	1.48	0.68	1.89	1.48	1.89	1.48	1.08	1.77	1.39	1.0	0.62

ISO	DC		APMX	a_p
25J2R50B25-SAD11E38-C	25	2	38	34.5
32J2R60B32-SAD11E47-C	32	2	47	43.5
40J2R60B40-SAD11E47-C	40	2	47	43.5
40J3R70B32-SAD11E56-C	40	3	56	52.5
40J3R70B40-SAD11E56-C	40	3	56	52.5
25J2R55E03-SAD11E38-C	25	2	38	34.5
32J2R65E04-SAD11E47-C	32	2	47	43.5
40J3R75E04-SAD11E56-C	40	3	56	52.5
50T03R-S90AD11E37-C	50	3	37	33.5

ADMX/ADEX 11	R
ADMX 11T320SR-M	1.0
ADMX 11T325SR-M	1.8
ADMX 11T330SR-M	1.8

max

4.5

J(T)-SAD16E

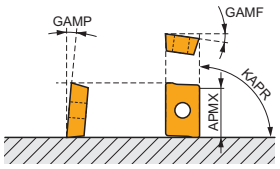
PRAMET

S

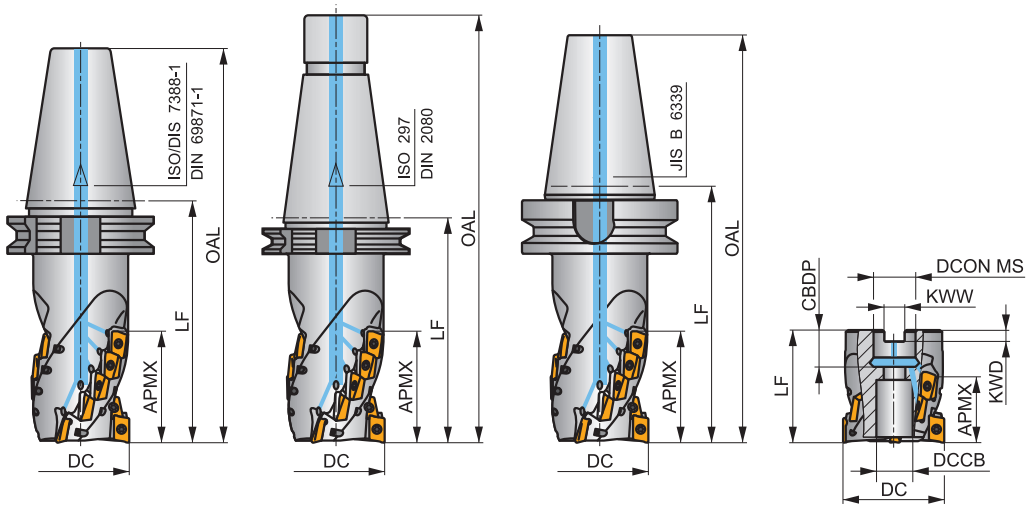
HELISK AD16 Langfræser med intern kølevæske

90° langskærsfræse med positiv AD .. 16 skær med APMX på 40 op til 108 mm med indvendigt kølevæske. Velegnet til hjørner-, spor-, plan- eller lommefræsning. Fås i dorn, DIN 69871, BT og DIN 2080 konisk stil, med eller uden differentieret tandafstand. Krop behandlet for længere værktøjslevetid.

KAPR	90°
APMX	40.0 - 108.0 mm



FORCE AD



h_m	0.08 - 0.1
h_m	0.08 - 0.1

	Product	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LF (mm)	APMX (mm)	CBDP (mm)	CZC MS	GAMF (°)	GAMP (°)	NOF			max.		kg		
	50J3R100H50-SAD16E54-C	50	202	–	–	100	54.00	–	50	-6	12	3	12	–	13200	✓	4.08	GI282	SQ031
	50J3R140H50-SAD16E80-C	50	242	–	–	140	80.00	–	50	-6	12	3	18	–	13200	✓	4.38	GI282	SQ031
ISO/DIS 7388-1	63J3R140H50-SAD16E68-C	63	242	–	–	140	68.00	–	50	-6	12	3	15	–	11700	✓	5.34	GI282	SQ031
	63J3R155H50-SAD16E95-C	63	257	–	–	155	95.00	–	50	-6	12	3	21	–	11700	✓	5.43	GI282	SQ031
	80J4R165H50-SAD16E108-C	80	257	–	–	165	108.00	–	50	-6	12	4	32	✓	10400	✓	7.37	GI282	SQ031
	50J3R140G50-SAD16E80-C	50	267	–	–	140	80.00	–	50	-6	12	3	18	–	13200	✓	4.48	GI282	SQ031
ISO 297	63J3R155G50-SAD16E95-C	63	282	–	–	155	95.00	–	50	-6	12	3	21	–	11700	✓	5.52	GI282	SQ031
	80J4R165G50-SAD16E108-C	80	292	–	–	165	108.00	–	50	-6	12	4	32	✓	10400	✓	7.51	GI282	SQ031
	50J3R140X50-SAD16E68-C	50	242	–	–	140	68.00	–	50	-6	12	3	15	–	13200	✓	5.28	GI282	SQ031
JIS B 6339	63J3R155X50-SAD16E80-C	63	257	–	–	155	80.00	–	50	-6	12	3	18	–	11700	✓	6.19	GI282	SQ031
	80J4R165X50-SAD16E95-C	80	267	–	–	165	95.00	–	50	-6	12	4	28	✓	10400	✓	7.84	GI282	SQ031
	50T03R-S90AD16E40-C	50	–	22	18	70	40.00	21	–	-6	12	3	9	–	13200	✓	0.63	GI282	SQ913
	63T04R-S90AD16E40-C	63	–	27	22	70	40.00	22	–	-6	12	4	12	✓	11700	✓	1.14	GI282	SQ914
ISO 6462 DIN 8030	63T04R-S90AD16E68-C	63	–	27	22	100	68.00	22	–	-6	12	4	20	✓	11700	✓	1.86	GI282	SQ914
	80T04R-S90AD16E55-C	80	–	32	30	85	55.00	25	–	-6	12	4	16	✓	10400	✓	2.56	GI282	SQ915
	80T04R-S90AD16E80-C	80	–	32	30	115	80.00	25	–	-6	12	4	24	✓	10400	✓	3.17	GI282	SQ915
	100T05R-S90AD16E80-C	100	–	40	36	120	80.00	30	–	-6	12	5	30	✓	9300	✓	5.31	GI282	SQ916

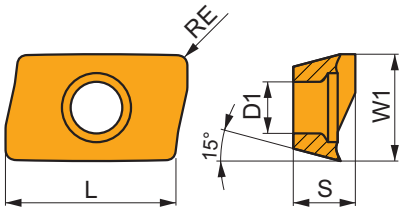
GI282	ADMX 1606..	ADEX 1606..-FA	ADEX 1606..-FM

SQ031	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	–
SQ913	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	HS 1030C
SQ914	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	HS 1230C
SQ915	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	HS 1630C
SQ916	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	HS 2040C

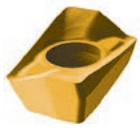
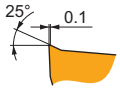
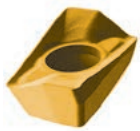
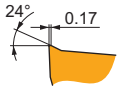
ADMX 16

PRAMET

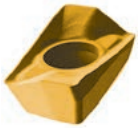
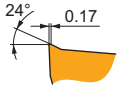
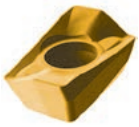
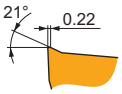
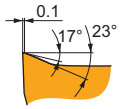
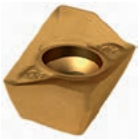
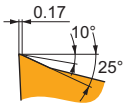
	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1606	9.950	4.50	16.00	6.25



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			**F** geometri med meget positivt design til let til medium bearbejdning.																	
ADMX 160608SR-F:8215	●	0.8	290	0.10	2.0	170	0.09	2.0	275	0.10	2.0	870	0.12	2.0	70	0.07	1.6	–	–	–
ADMX 160608SR-F:M8310	●	0.8	320	0.10	2.0	160	0.09	2.0	300	0.10	2.0	–	–	–	–	–	–	–	–	–
ADMX 160608SR-F:M8330	●	0.8	285	0.10	2.0	170	0.09	2.0	270	0.10	2.0	855	0.12	2.0	70	0.07	1.6	–	–	–
ADMX 160608SR-F:M8340	●	0.8	260	0.10	2.0	155	0.09	2.0	245	0.10	2.0	–	–	–	65	0.07	1.6	–	–	–
ADMX 160608SR-F:M9340	●	0.8	340	0.10	2.0	200	0.09	2.0	–	–	–	–	–	–	85	0.07	1.6	–	–	–
			**M** geometri med positivt design til let til medium bearbejdning.																	
ADMX 160604SR-M:8215	●	0.4	190	0.18	5.0	110	0.16	5.0	180	0.18	5.0	–	–	–	45	0.13	4.0	–	–	–
ADMX 160604SR-M:M8330	●	0.4	190	0.18	5.0	110	0.16	5.0	180	0.18	5.0	–	–	–	45	0.13	4.0	–	–	–
ADMX 160604SR-M:M8340	●	0.4	170	0.18	5.0	100	0.16	5.0	160	0.18	5.0	–	–	–	40	0.13	4.0	–	–	–
ADMX 160608SR-M:8215	●	0.8	225	0.18	5.0	135	0.16	5.0	210	0.18	5.0	–	–	–	55	0.13	4.0	–	–	–
ADMX 160608SR-M:M5315	●	0.8	305	0.18	5.0	–	–	–	285	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160608SR-M:M8310	●	0.8	250	0.18	5.0	125	0.16	5.0	235	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160608SR-M:M8330	●	0.8	225	0.18	5.0	135	0.16	5.0	210	0.18	5.0	–	–	–	55	0.13	4.0	–	–	–
ADMX 160608SR-M:M8340	●	0.8	205	0.18	5.0	120	0.16	5.0	190	0.18	5.0	–	–	–	50	0.13	4.0	–	–	–
ADMX 160608SR-M:M9315	●	0.8	305	0.18	5.0	–	–	–	285	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160608SR-M:M9325	●	0.8	280	0.18	5.0	–	–	–	265	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160608SR-M:M9340	●	0.8	255	0.18	5.0	150	0.16	5.0	–	–	–	–	–	–	60	0.13	4.0	–	–	–
ADMX 160616SR-M:8215	●	1.6	250	0.18	5.0	150	0.16	5.0	235	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–
ADMX 160616SR-M:M8310	●	1.6	275	0.18	5.0	140	0.16	5.0	260	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160616SR-M:M8330	✱	1.6	250	0.18	5.0	150	0.16	5.0	235	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–
ADMX 160616SR-M:M8340	✱	1.6	225	0.18	5.0	135	0.16	5.0	210	0.18	5.0	–	–	–	55	0.13	4.0	–	–	–
ADMX 160616SR-M:M9325	●	1.6	310	0.18	5.0	–	–	–	290	0.18	5.0	–	–	–	–	–	–	–	–	–
ADMX 160620SR-M:M8330	✱	2.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	–	–	–	65	0.13	4.0	–	–	–
ADMX 160620SR-M:M8340	✱	2.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–
ADMX 160630SR-M:M8330	✱	3.0	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	–	–	–	65	0.13	4.0	–	–	–
ADMX 160630SR-M:M8340	✱	3.0	240	0.18	5.0	140	0.16	5.0	225	0.18	5.0	–	–	–	60	0.13	4.0	–	–	–
ADMX 160632SR-M:M6330	✱	3.2	225	0.18	5.0	155	0.16	5.0	–	–	–	–	–	–	65	0.13	4.0	–	–	–
ADMX 160632SR-M:M8330	✱	3.2	265	0.18	5.0	155	0.16	5.0	250	0.18	5.0	–	–	–	65	0.13	4.0	–	–	–

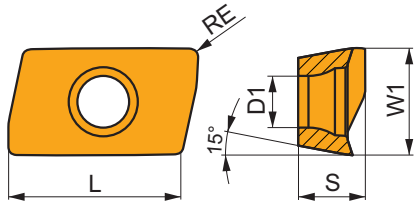
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)	vc (m/min)	f (mm/tooth)	ap (mm)
																				
M geometri med positivt design til let til medium bearbejdning.																				
ADMX 160632SR-M:M8340	✱	3.2	■	240	0.18	5.0	■	140	0.16	5.0	◪	225	0.18	5.0	–	–	–	◪	60	0.13	4.0	–	–	–
ADMX 160632SR-M:M9325	❖	3.2	■	325	0.18	5.0		–	–	–	■	305	0.18	5.0	–	–	–		–	–	–	–	–	–
ADMX 160640SR-M:M8330	✱	4.0	■	265	0.18	5.0	■	155	0.16	5.0	■	250	0.18	5.0	–	–	–	◪	65	0.13	4.0	–	–	–
ADMX 160640SR-M:M8340	✱	4.0	■	240	0.18	5.0	■	140	0.16	5.0	◪	225	0.18	5.0	–	–	–	◪	60	0.13	4.0	–	–	–
ADMX 160650SR-M:M8330	✱	5.0	■	265	0.18	5.0	■	155	0.16	5.0	■	250	0.18	5.0	–	–	–	◪	65	0.13	4.0	–	–	–
ADMX 160650SR-M:M8340	✱	5.0	■	240	0.18	5.0	■	140	0.16	5.0	◪	225	0.18	5.0	–	–	–	◪	60	0.13	4.0	–	–	–
																				
R geometri med positivt design til mellemstore til mindre stabile bearbejdningsforhold.																				
ADMX 160608PR-R:8215	✱	0.8	■	205	0.25	6.0	◪	120	0.23	6.0	■	190	0.25	6.0	–	–	–	◪	50	0.20	4.8	◪	40	0.16	1.1
ADMX 160608PR-R:M5315	✱	0.8	◪	260	0.25	6.0		–	–	–	■	245	0.25	6.0	–	–	–		–	–	–	◪	50	0.16	1.1
ADMX 160608PR-R:M8310	✱	0.8	■	220	0.25	6.0	◪	110	0.23	6.0	■	205	0.25	6.0	–	–	–		–	–	–	◪	40	0.16	1.1
ADMX 160608PR-R:M8330	✱	0.8	■	205	0.25	6.0	◪	120	0.23	6.0	■	190	0.25	6.0	–	–	–	◪	50	0.20	4.8	◪	40	0.16	1.1
ADMX 160608PR-R:M8340	✱	0.8	■	190	0.25	6.0	◪	110	0.23	6.0	◪	180	0.25	6.0	–	–	–	◪	45	0.20	4.8		–	–	–
ADMX 160608PR-R:M9315	✱	0.8	■	265	0.25	6.0		–	–	–	■	250	0.25	6.0	–	–	–		–	–	–	◪	50	0.16	1.1
ADMX 160608PR-R:M9325	✱	0.8	■	250	0.25	6.0		–	–	–	■	235	0.25	6.0	–	–	–		–	–	–	◪	50	0.16	1.1
ADMX 160616PR-R:M8330	✱	1.6	■	225	0.25	6.0	◪	135	0.23	6.0	■	210	0.25	6.0	–	–	–	◪	55	0.20	4.8	◪	45	0.16	1.1
ADMX 160616PR-R:M8340	✱	1.6	■	210	0.25	6.0	◪	125	0.23	6.0	◪	195	0.25	6.0	–	–	–	◪	50	0.20	4.8		–	–	–
ADMX 160616PR-R:M9315	✱	1.6	■	295	0.25	6.0		–	–	–	■	280	0.25	6.0	–	–	–		–	–	–	◪	55	0.16	1.1
																				
MF geometri med meget positivt design til færdigbearbejdning.																				
ADMX 160608SR-MF:M6330	❖	0.8	■	215	0.08	4.0	■	150	0.07	4.0		–	–	–	–	–	–	■	60	0.06	3.2	–	–	–
ADMX 160608SR-MF:M8340	❖	0.8	■	225	0.08	4.0	■	135	0.07	4.0		–	–	–	–	–	–	■	55	0.06	3.2	–	–	–
ADMX 160608SR-MF:M9340	❖	0.8	■	305	0.08	4.0	■	180	0.07	4.0		–	–	–	–	–	–	■	75	0.06	3.2	–	–	–
																				
MM geometri med meget positivt design til let til medium bearbejdning.																				
ADMX 160604SR-MM:M6330	❖	0.4	■	145	0.18	4.0	■	105	0.16	4.0		–	–	–	–	–	–	■	40	0.14	3.2	–	–	–
ADMX 160604SR-MM:M8340	❖	0.4	■	160	0.18	4.0	■	95	0.16	4.0		–	–	–	–	–	–	■	40	0.14	3.2	–	–	–
ADMX 160608SR-MM:M6330	❖	0.8	■	175	0.18	4.0	■	125	0.16	4.0		–	–	–	–	–	–	■	50	0.14	3.2	–	–	–
ADMX 160608SR-MM:M8340	❖	0.8	■	190	0.18	4.0	■	110	0.16	4.0		–	–	–	–	–	–	■	45	0.14	3.2	–	–	–
ADMX 160608SR-MM:M8345	❖	0.8	■	150	0.18	4.0	■	90	0.16	4.0		–	–	–	–	–	–	■	35	0.14	3.2	–	–	–
ADMX 160608SR-MM:M9340	❖	0.8	■	235	0.18	4.0	■	140	0.16	4.0		–	–	–	–	–	–	■	55	0.14	3.2	–	–	–
ADMX 160616SR-MM:M6330	✱	1.6	■	195	0.18	4.0	■	140	0.16	4.0		–	–	–	–	–	–	■	55	0.14	3.2	–	–	–
ADMX 160616SR-MM:M8340	✱	1.6	■	210	0.18	4.0	■	125	0.16	4.0		–	–	–	–	–	–	■	50	0.14	3.2	–	–	–
ADMX 160616SR-MM:M8345	✱	1.6	■	165	0.18	4.0	■	95	0.16	4.0		–	–	–	–	–	–	■	40	0.14	3.2	–	–	–
ADMX 160616SR-MM:M9340	❖	1.6	■	260	0.18	4.0	■	155	0.16	4.0		–	–	–	–	–	–	■	65	0.14	3.2	–	–	–

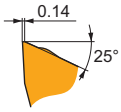
ADEX 16

PRAMET

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1606	9.950	4.50	16.00	6.25



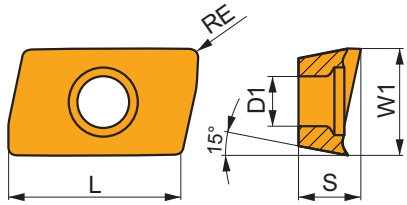
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 **FM** geometri med meget positivt design til medium bearbejdning.																			
ADEX 160608SR-FM:8215	0.8	260	0.16	2.0	155	0.14	2.0	245	0.16	2.0	–	–	–	65	0.11	1.6	–	–	–
ADEX 160608SR-FM:M8330	0.8	255	0.16	2.0	150	0.14	2.0	240	0.16	2.0	–	–	–	60	0.11	1.6	–	–	–
ADEX 160608SR-FM:M8340	0.8	235	0.16	2.0	140	0.14	2.0	220	0.16	2.0	–	–	–	55	0.11	1.6	–	–	–

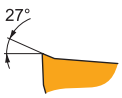
ADEX 16-FA

PRAMET

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1606	9.950	4.50	16.00	6.17



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 **FA** geometri med meget positivt design til finbearbejdning til medium bearbejdning.																			
ADEX 160604FR-FA:HF7	0.4	–	–	–	–	–	–	–	–	–	195	0.28	6.0	–	–	–	–	–	–
ADEX 160604FR-FA:M0315	0.4	–	–	–	–	–	–	–	–	–	480	0.28	6.0	–	–	–	–	–	–
ADEX 160608FR-FA:HF7	0.8	–	–	–	–	–	–	–	–	–	240	0.28	6.0	–	–	–	–	–	–
ADEX 160608FR-FA:M0315	0.8	–	–	–	–	–	–	–	–	–	570	0.28	6.0	–	–	–	–	–	–
ADEX 160616FR-FA:HF7	1.6	–	–	–	–	–	–	–	–	–	255	0.28	6.0	–	–	–	–	–	–
ADEX 160616FR-FA:M0315	1.6	–	–	–	–	–	–	–	–	–	630	0.28	6.0	–	–	–	–	–	–
ADEX 160630FR-FA:HF7	3.0	–	–	–	–	–	–	–	–	–	270	0.28	6.0	–	–	–	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	0.89	0.81	0.76	0.73	0.71	0.70	0.66	0.65	0.63	0.62	0.60	0.60	0.60	0.45

$a_{e\,max}$	1		2.5		5		7.5		10		15		20	
DC	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹
50	0.57	0.71	0.36	0.45	0.26	0.32	0.21	0.27	0.19	0.23	0.15	0.19	0.14	0.17
63	0.64	0.80	0.40	0.51	0.29	0.36	0.24	0.30	0.21	0.26	0.17	0.21	0.15	0.19
80	0.72	0.90	0.45	0.57	0.32	0.40	0.27	0.33	0.23	0.29	0.19	0.24	0.17	0.21
100	0.80	1.00	0.51	0.64	0.36	0.45	0.30	0.37	0.26	0.32	0.21	0.27	0.19	0.23

$a_{e\,max}$	25		32		40		50		63		80		100	
DC	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹
50	0.13	0.16	0.12	0.14	0.11	0.14	0.13	0.16	–	–	–	–	–	–
63	0.14	0.17	0.12	0.16	0.12	0.15	0.11	0.14	0.13	0.16	–	–	–	–
80	0.15	0.19	0.14	0.17	0.13	0.16	0.12	0.15	0.11	0.14	0.13	0.16	–	–
100	0.17	0.21	0.15	0.19	0.14	0.17	0.13	0.16	0.12	0.15	0.11	0.14	0.13	0.16

	ADMX 16-F	ADEX 16-FM	ADMX 16-M								ADMX 16-R	
RE	0.8	0.8	0.4	0.8	1.6	2.0	3.0	3.2	4.0	5.0	0.8	1.6
BS	2.99	2.18	3.39	2.99	1.62	1.23	0.28	0.09	2.69	1.52	2.99	1.62

	ADMX 16-MF	ADMX 16-MM			ADEX 16-FA			
RE	0.8	0.4	0.8	1.6	0.4	0.8	1.6	3.0
BS	2.99	3.39	2.99	1.62	2.84	2.44	1.65	0.69

ISO	DC		APMX	a_p
50J3R100H50-SAD16E54-C	50	3	54	50.5
50J3R140H50-SAD16E80-C	50	3	80	76.5
63J3R140H50-SAD16E68-C	63	3	68	64.5
63J3R155H50-SAD16E95-C	63	3	95	91.5
80J4R165H50-SAD16E108-C	80	4	108	104.5
50J3R140G50-SAD16E80-C	50	3	80	76.5
63J3R155G50-SAD16E95-C	63	3	95	91.5
80J4R165G50-SAD16E108-C	80	4	108	104.5
50J3R140X50-SAD16E68-C	50	3	68	64.5
63J3R155X50-SAD16E80-C	63	3	80	76.5
80J4R165X50-SAD16E95-C	80	4	95	91.5
50T03R-S90AD16E40-C	50	3	40	36.5
63T04R-S90AD16E40-C	63	4	40	36.5
63T04R-S90AD16E68-C	63	4	68	64.5
80T04R-S90AD16E55-C	80	4	55	51.5
80T04R-S90AD16E80-C	80	4	80	76.5
100T05R-S90AD16E80-C	100	5	80	76.5

max
7.5

ADMX/ADEX 16	R
ADMX 160630SR-M	2.5
ADMX 160632SR-M	2.5
ADMX 160640SR-M	4.0
ADMX 160650SR-M	4.5

J(T)-SSAP

P M K S

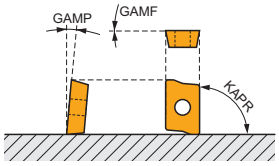
PRAMET

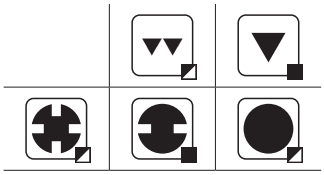
S

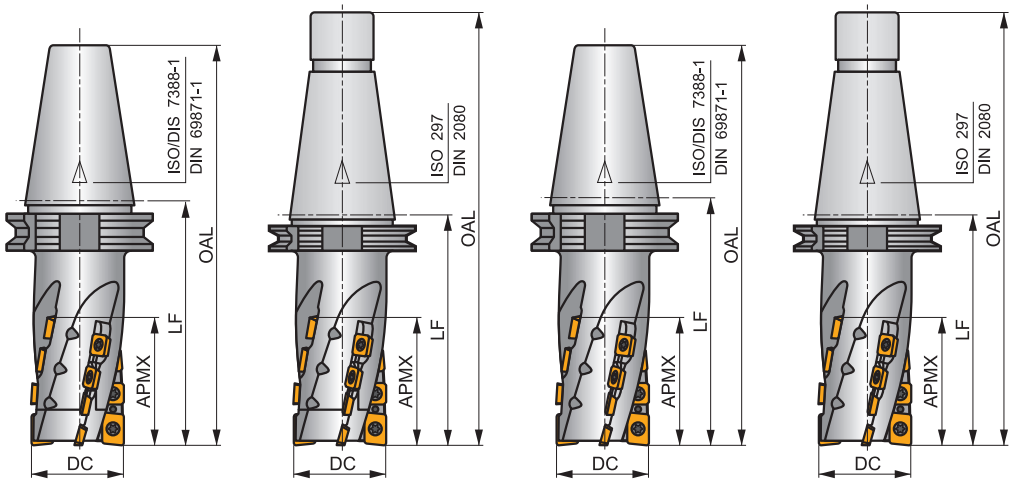
Langfræsning til mellemfræsning til AP .. 15 og SP .. 12 skær

90° endefræser med positiv AD .. 15 skær med APMX på 12 mm. Velegnet til applikationer, herunder plan, hjørne, spor,spiralinterpolation , trochoidal, ramping og lommefræsning. Fås i DIN69871 og DIN 2080 og med differentieret tandafstand. Krop behandlet for længere værktøjslevetid.

KAPR	90°
APMX	58.0 - 95.0 mm







h_m 0.07 - 0.1

	Product	DC	OAL	APMX	LF	GAMF	GAMP	CZCMS	NOF	AP	SP		max.		kg		
		(mm)	(mm)	(mm)	(mm)	(°)	(°)										
ISO/DIS 7388-1	**50J4R128H50-SSAP55+21**	50	230	76.00	128	0	7	50	4	2	16	–	9500	–	3.80	GI128	SQ942
	63J4R150H50-SSAP74+21	63	252	95.00	150	0	7	50	4	2	20	–	8500	–	4.50	GI128	SQ943
ISO 297	**50J4R124X50-SSAP55+21**	50	251	76.00	124	0	7	50	4	2	16	–	9500	–	4.43	GI128	SQ942
	63J4R146X50-SSAP74+21	63	273	95.00	146	0	7	50	4	2	20	–	8500	–	4.75	GI128	SQ943
ISO/DIS 7388-1	**63J4R150H50-SSAP95-A**	63	252	95.00	150	0	7	50	4	2	20	–	8500	–	5.32	GI128	SQ941
	80J6R155H50-SSAP95-A	80	257	95.00	155	0	7	50	6	3	30	–	7500	–	6.30	GI128	SQ941
ISO 297	**50J4R124X50-SSAP76-A**	50	251	76.00	124	0	7	50	4	2	16	–	9500	–	3.80	GI128	SQ941
	63J4R146X50-SSAP95-A	63	273	95.00	146	0	7	50	4	2	20	–	8500	–	4.50	GI128	SQ941
	80J6R151X50-SSAP95-A	80	275	95.00	151	0	7	50	6	3	30	–	7500	–	6.20	GI128	SQ941

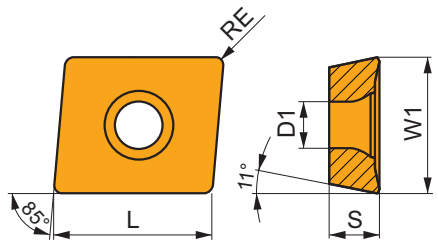
GI128	APE. 1504..	SPE. 1204..

					Nm			
SQ941	–	–	–	US 4511-T20	5.0	M 4.5	11	SDR T20-T
SQ942	P50X21	SR 25	HXK 6	US 4511-T20	5.0	M 4.5	11	SDR T20-T
SQ943	P63X21	SR 26	HXK 8	US 4511-T20	5.0	M 4.5	11	SDR T20-T

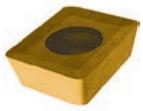
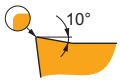
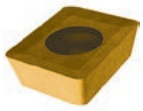
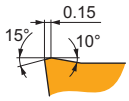
APET 15

PRAMET

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1504	12.700	5.50	15.90	4.76



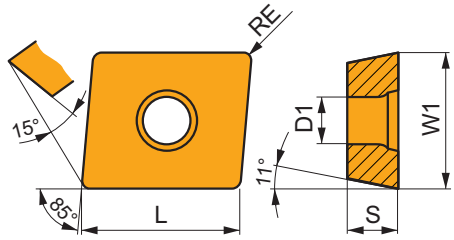
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																					
EN kantforberedelse, positiv geometri til let til medium bearbejdning.																					
APET 150412EN:M8330		1.2	225	0.20	12.0	135	0.18	12.0	210	0.20	12.0	–	–	–	55	0.14	9.6	–	–	–
																					
SN kantforberedelse, positiv geometri til medium til tung bearbejdning.																					
APET 150412SN:M8330		1.2	215	0.25	12.0	125	0.23	12.0	200	0.25	12.0	–	–	–	50	0.25	9.6	–	–	–
APET 150412SN:M8340		1.2	190	0.25	12.0	110	0.23	12.0	180	0.25	12.0	–	–	–	45	0.25	9.6	–	–	–

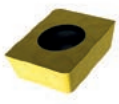
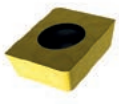
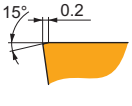
APEW 15

PRAMET

	W1	D1	L	M	S
	(mm)	(mm)	(mm)	(mm)	(mm)
1504	12.700	5.50	15.90	3.7	4.76



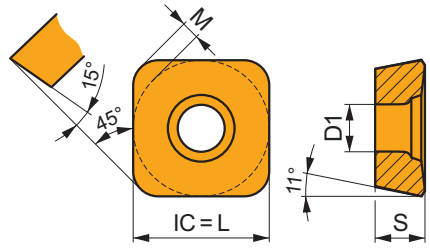
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																					
ER kantforberedelse, nul skærvinkelgeometri til let til medium bearbejdning.																					
APEW 150412ER:M8330		1.2	200	0.20	12.0	–	–	–	190	0.20	12.0	–	–	–	–	–	–	40	0.13	1.0
																					
SR kantforberedelse, nul skærvinkelgeometri til medium til tung bearbejdning.																					
APEW 150412SR:M8330		1.2	200	0.20	12.0	–	–	–	190	0.20	12.0	–	–	–	–	–	–	40	0.13	1.0

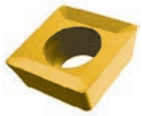
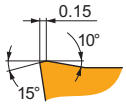
SPET 12

PRAMET

	IC (mm)	D1 (mm)	L (mm)	M (mm)	S (mm)
1204	12.700	5.50	12.70	1.9	4.76



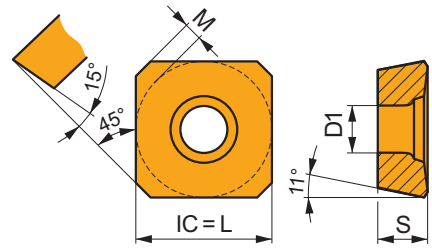
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
  **S** kantforberedelse, positiv generel geometri.																			
SPET 120408S:M8330	0.8	215	0.20	12.0	125	0.18	12.0	200	0.20	12.0	–	–	–	50	0.18	9.6	–	–	–
SPET 120408S:M8340	0.8	190	0.20	12.0	110	0.18	12.0	180	0.20	12.0	–	–	–	45	0.18	9.6	–	–	–

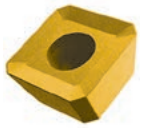
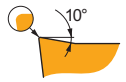
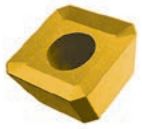
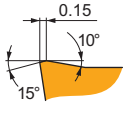
SPET 12 AD

PRAMET

	IC (mm)	D1 (mm)	L (mm)	M (mm)	S (mm)
1204	12.700	5.50	12.70	1.9	4.76

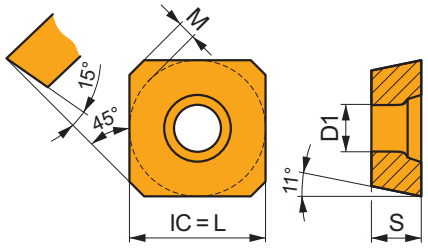


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

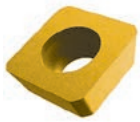
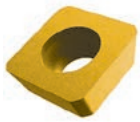
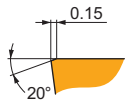
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
  **ADEN** kantforberedelse, positiv geometri til let til medium bearbejdning.																			
SPET 1204ADEN:M8330	–	245	0.20	12.0	145	0.18	12.0	230	0.20	12.0	–	–	–	60	0.14	9.6	–	–	–
SPET 1204ADEN:M8340	–	220	0.20	12.0	130	0.18	12.0	205	0.20	12.0	–	–	–	55	0.14	9.6	–	–	–
  **ADSN** kantfordel, positiv geometri til medium bearbejdning.																			
SPET 1204ADSN:M8330	–	245	0.20	12.0	145	0.18	12.0	230	0.20	12.0	–	–	–	60	0.14	9.6	–	–	–
SPET 1204ADSN:M8340	–	220	0.20	12.0	130	0.18	12.0	205	0.20	12.0	–	–	–	55	0.14	9.6	–	–	–

SPEW 12 AD

	IC	D1	L	M	S
	(mm)	(mm)	(mm)	(mm)	(mm)
1204	12.700	5.50	12.70	1.9	4.76



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
			**ADEN** kantforberedelse, nul skærvinkelgeometri til let til medium bearbejdning.																	
SPEW 1204ADEN:M8330		–	220	0.20	12.0	–	–	–	205	0.20	12.0	–	–	–	–	–	–	40	0.10	1.0
			**ADSN** kantforberedelse, nul skærvinkelgeometri til medium bearbejdning.																	
SPEW 1204ADSN:M8330		–	220	0.20	12.0	–	–	–	205	0.20	12.0	–	–	–	–	–	–	40	0.13	1.0

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	0.89	0.81	0.76	0.73	0.71	0.70	0.67	0.65	0.63	0.62	0.60	0.60	0.60	0.45

$a_{e\,max}$	1		2.5		5		7.5		10		15		20	
DC	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨
50	0.50	0.71	0.32	0.45	0.23	0.32	0.19	0.27	0.16	0.23	0.14	0.19	0.12	0.17
63	0.56	0.80	0.35	0.51	0.25	0.36	0.21	0.30	0.18	0.26	0.15	0.21	0.13	0.19
80	0.63	0.90	0.40	0.57	0.28	0.40	0.23	0.33	0.20	0.29	0.17	0.24	0.15	0.21

$a_{e\,max}$	25		32		40		50		63		80	
DC	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨
50	0.11	0.16	0.10	0.14	0.10	0.14	0.11	0.16	–	–	–	–
63	0.12	0.17	0.11	0.16	0.10	0.15	0.10	0.14	0.11	0.16	–	–
80	0.13	0.19	0.12	0.17	0.11	0.16	0.10	0.15	0.10	0.14	0.11	0.16

	APET 15	APEW 15	SPET 12	SPET 12AD	SPEW 12AD
RE	1.2	1.2	0.8	–	–
BS	–	–	–	–	–

ISO	DC		APMX	a_p
50J4R128H50-SSAP55+21	50	2+2	76	73.6
63J4R150H50-SSAP74+21	63	2+2	95	92.6
50J4R124X50-SSAP55+21	50	2+2	76	73.6
63J4R146X50-SSAP74+21	63	2+2	95	92.6
63J4R150H50-SSAP95-A	63	2+2	95	92.6
80J6R155H50-SSAP95-A	80	3+3	95	92.6
50J4R124X50-SSAP76-A	50	2+2	76	73.6
63J4R146X50-SSAP95-A	63	2+2	95	92.6
80J6R151X50-SSAP95-A	80	3+3	95	92.6

J(T)-CSD12X

P M S

PRAMET

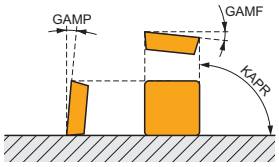
C

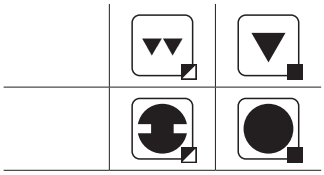
MULTISIDE SD Lang fræser

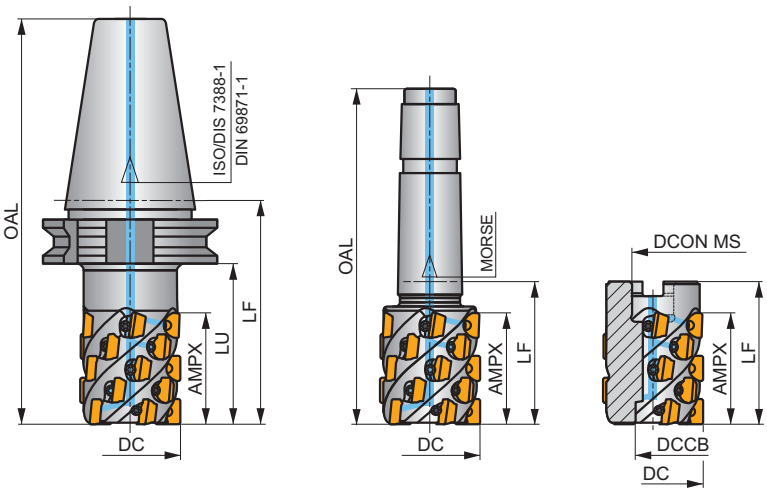
90° langskærs ende fræser med positiv SD .. 12 skær med APMX på 44.1 op til 87.3 mm. Velegnet til hjørne-, spor- eller planfræsning. Fås med dorn, PSC, Morse eller DIN 69871 konisk stil. Krop behandlet for længere værktøjslevetid.

MULTISIDE SD

KAPR	90°
APMX	44.1 - 87.3 mm







h_m	0.025 - 0.05
h_m	0.025 - 0.05

	Product	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	APMX (mm)	GAMF (°)	GAMP (°)	CZC MS	NOF			max.		kg		
ISO/DIS 7388-1	**40J4R090H40-CSD12X44**	40	158.4	–	–	70	90	44.10	-5	8	40	4	16	–	4000	✓	1.16	GI271	SQ091
	50J5R100H50-CSD12X55	50	201.7	–	–	80	100	54.90	-5	8	50	5	25	–	3200	✓	4.20	GI271	SQ091
	63J6R110H50-CSD12X66	63	211.7	–	–	90	110	65.70	-5	8	50	6	36	–	2500	✓	4.90	GI271	SQ091
DIN 228A	**50J5R065E04-CSD12X55**	50	167.5	–	–	–	65	54.90	-5	8	4	5	25	–	3200	✓	1.34	GI271	SQ091
ISO 6462 DIN 8030	**50T05R-C90SD12X55**	50	–	22	18	–	78	54.90	-5	8	–	5	25	–	3200	✓	1.21	GI271	SQ923
	63T06R-C90SD12X66	63	–	27	22	–	90	65.70	-5	8	–	6	36	–	2500	✓	1.72	GI271	SQ924
	80T08R-C90SD12X88	80	–	40	36	–	115	87.30	-5	8	–	8	64	–	2000	✓	3.20	GI271	SQ925

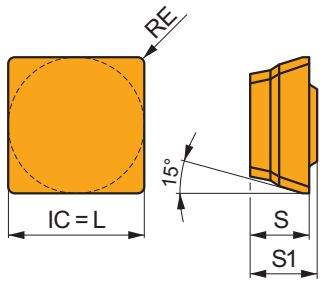
GI271	SDGX 1205..	SDMX 1205..

		Nm					
SQ091	US 63511D-T15P	3.0	M 3.5	11	D-T08P/T15P	FG-15	–
SQ923	US 63511D-T15P	3.0	M 3.5	11	D-T08P/T15P	FG-15	HSD 1070
SQ924	US 63511D-T15P	3.0	M 3.5	11	D-T08P/T15P	FG-15	HS 1280
SQ925	US 63511D-T15P	3.0	M 3.5	11	D-T08P/T15P	FG-15	HS 20100

SDGX 12

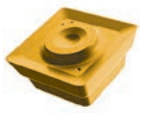
PRAMET

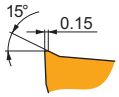
	IC	L	S	S1
	(mm)	(mm)	(mm)	(mm)
1205	12.700	12.70	5.56	6.35



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)





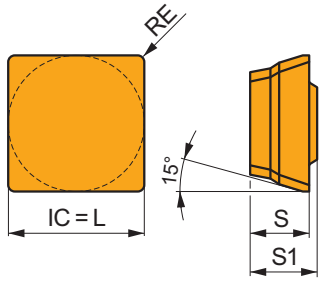
FM geometri med positivt design til let til medium tung bearbejdning.

SDGX 120508EN-FM:M8330	0.8	220	0.15	12.0	130	0.14	12.0	–	–	–	–	–	–	55	0.11	9.6	–	–	–
SDGX 120508EN-FM:M8345	0.8	155	0.15	12.0	90	0.14	12.0	–	–	–	–	–	–	35	0.11	9.6	–	–	–

SDMX 12

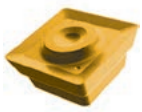
PRAMET

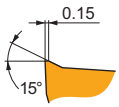
	IC	L	S	S1
	(mm)	(mm)	(mm)	(mm)
1205	12.700	12.70	5.56	6.35



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)





M geometri med positivt design til let til tung bearbejdning.

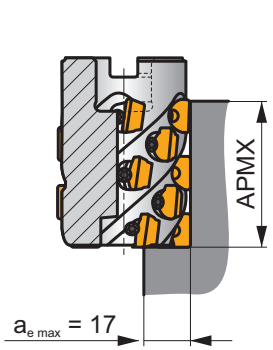
SDMX 120508EN-M:M8330	0.8	220	0.15	12.0	130	0.14	12.0	–	–	–	–	–	–	55	0.11	9.6	–	–	–
SDMX 120508EN-M:M8345	0.8	155	0.15	12.0	90	0.14	12.0	–	–	–	–	–	–	35	0.11	9.6	–	–	–

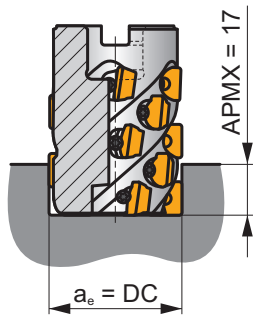
a_e/DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	0.89	0.81	0.76	0.73	0.71	0.70	0.66	0.65	0.63	0.62	0.60	0.60	0.60	0.45

$a_{e\,max}$	1		2.5		5		7.5		10		15		20	
DC	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨
40	0.16	0.32	0.10	0.20	0.07	0.14	0.06	0.12	0.05	0.10	0.04	0.09	0.04	0.08
50	0.18	0.35	0.11	0.23	0.08	0.16	0.07	0.13	0.06	0.12	0.05	0.10	0.04	0.09
63	0.20	0.40	0.13	0.25	0.09	0.18	0.07	0.15	0.06	0.13	0.05	0.11	0.05	0.09
80	0.22	0.45	0.14	0.28	0.10	0.20	0.08	0.17	0.07	0.14	0.06	0.12	0.05	0.10

$a_{e\,max}$	25		32		40		50		63		80	
DC	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨
40	0.04	0.07	0.03	0.07	0.04	0.08	–	–	–	–	–	–
50	0.04	0.08	0.04	0.07	0.03	0.07	0.04	0.08	–	–	–	–
63	0.04	0.09	0.04	0.08	0.04	0.07	0.03	0.07	0.04	0.08	–	–
80	0.05	0.09	0.04	0.09	0.04	0.08	0.04	0.07	0.03	0.07	0.04	0.08

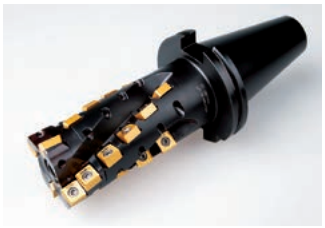
	SDGX 12-FM	SDMX 12-M
RE	0.8	0.8
BS	2.99	2.99



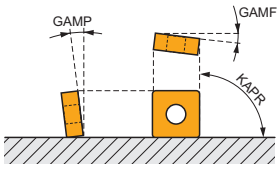


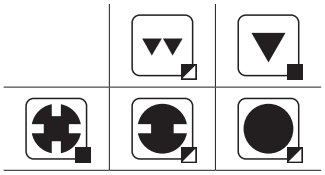
ISO	DC		APMX	a_p
40J4R090H40-CSD12X44	40	4	44.1	42.5
50J5R100H50-CSD12X55	50	5	54.9	53.3
63J6R110H50-CSD12X66	63	6	65.7	64.1
80J8R130H50-CSD12X88	80	8	87.3	85.7
40J4R080XC5-CSD12X44	40	4	44.1	42.5
50J5R080XC5-CSD12X55	50	5	54.9	53.3
63J6R095XC6-CSD12X66	63	6	65.7	64.1
50J5R065E04-CSD12X55	50	5	54.9	53.3
50T05R-C90SD12X55	50	5	54.9	53.3
63T06R-C90SD12X66	63	6	65.7	64.1
80T08R-C90SD12X88	80	8	87.3	85.7

J(T)-SLSN



KAPR	90°
APMX	104.0 - 134.0 mm

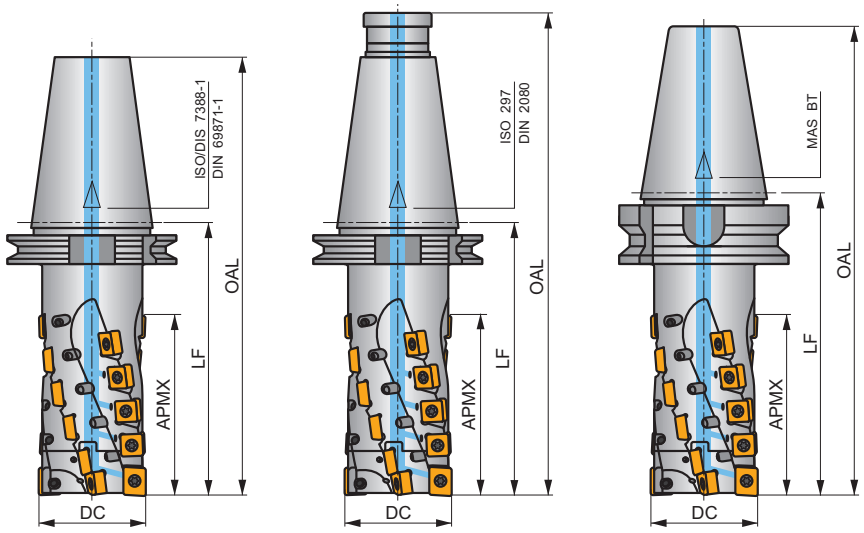




ROUGH SN Langkantfræser til tung fræsning med intern kølevæske

90° langskærsfræser med LNET 16 og SN .. 13 skær med APMX på 104 op til 134 mm. Krop har udskifteligt slutstykke. Velegnet til hjørne-, slids-, plan- og lommefræsning. Fås i DIN 69871, BT og DIN 2080 50 konisk stil. Krop behandlet for længere værktøjslevetid.

ROUGH SN



h_m 0.08 - 0.22

	Product	DC (mm)	OAL (mm)	APMX (mm)	LF (mm)	GAMF (°)	GAMP (°)	CZCMS	NOF	LN	SN		max.		kg		
ISO/DIS 7388-1	**63J2R155H50-SLSN104-C**	63	257	104.00	155	-9	-10	50	4	2	20	–	8500	✓	5.03	GI209	SQ934
	80J2R190H50-SLSN134-C	80	292	134.00	190	-9	-10	50	4	2	26	–	7500	✓	7.45	GI209	SQ935
ISO 297	**63J2R155G50-SLSN104-C**	63	282	104.00	155	-9	-10	50	4	2	20	–	8500	✓	5.20	GI209	SQ934
	80J2R190G50-SLSN134-C	80	317	134.00	190	-9	-10	50	4	2	26	–	7500	✓	7.40	GI209	SQ935
JIS B 6339	**63J2R175X50-SLSN104-C**	63	277	104.00	175	-9	-10	50	4	2	20	–	8500	✓	6.10	GI209	SQ934
	80J2R210X50-SLSN134-C	80	312	134.00	210	-9	-10	50	4	2	26	–	7500	✓	8.50	GI209	SQ935

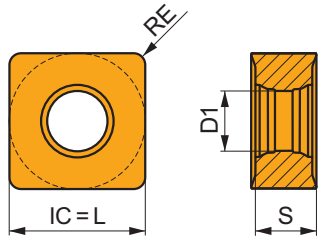
GI209	LNET 1606..	SN.. 1305..

					Nm			
SQ934	EH6326-SL-C	HS 1230	HXK 10	US 45012-T20P	5.0	M 5	12	SDR T20P-T
SQ935	EH8036-SL-C	HS 1640	HXK 14	US 45012-T20P	5.0	M 5	12	SDR T20P-T

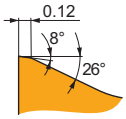
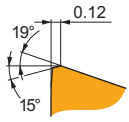
SNGX 13

PRAMET

	IC (mm)	D1 (mm)	S (mm)
1305	13.200	5.90	5.96



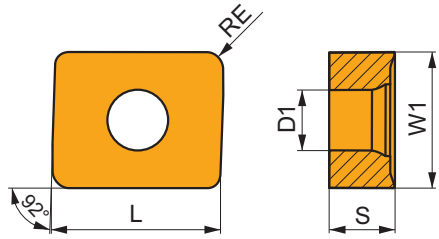
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
M geometri med positivt design til let bearbejdning.																			
SNGX 130512SN-M:M8330	1.2	105	0.15	12.0	–	–	–	95	0.15	12.0	–	–	–	–	–	–	–	–	–
SNGX 130512SN-M:M8340	1.2	105	0.15	12.0	–	–	–	95	0.15	12.0	–	–	–	–	–	–	–	–	–
																			
R geometri med positivt design til hård bearbejdning og ustabile forhold.																			
SNGX 130512PN-R:M8330	1.2	95	0.15	12.0	–	–	–	90	0.15	12.0	–	–	–	–	–	–	–	–	–
SNGX 130512PN-R:M8340	1.2	95	0.15	12.0	–	–	–	90	0.15	12.0	–	–	–	–	–	–	–	–	–

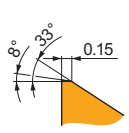
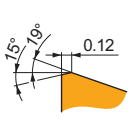
LNET 16

PRAMET

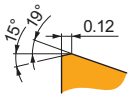
	W1 (mm)	D1 (mm)	L (mm)	S (mm)
1606	13.200	5.90	16.40	6.38



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
M geometri med meget positivt design til medium bearbejdning.																			
LNET 160616SR-M:M8340	1.6	105	0.15	15.0	–	–	–	95	0.15	15.0	–	–	–	–	–	–	–	–	–
																			
R geometri med meget positivt design til medium bearbejdning.																			
LNET 160616SR-R:M8330	1.6	100	0.15	15.0	–	–	–	95	0.15	15.0	–	–	–	–	–	–	–	–	–

Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
LNET 160616SR-R:M8340	1.6	95	0.15	15.0	–	–	–	90	0.15	15.0	–	–	–	–	–	–	–	–	–

R geometri med meget positivt design til medium bearbejdning.

a_e/DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00

$a_{e\,max}$	1		2.5		5		7.5		10		15		20	
DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
63	0.64	1.75	0.40	1.11	0.29	0.79	0.24	0.65	0.21	0.57	0.17	0.47	0.15	0.41
80	0.72	1.97	0.45	1.25	0.32	0.89	0.27	0.73	0.23	0.64	0.19	0.53	0.17	0.46

$a_{e\,max}$	25		32		40		50		63		80	
DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
63	0.14	0.38	0.12	0.34	0.12	0.32	0.11	0.30	0.13	0.35	–	–
80	0.15	0.42	0.14	0.38	0.13	0.35	0.12	0.32	0.11	0.30	0.13	0.35

	LNET 16-M	LNET 16-R	SNGX 13-M	SNGX 13-R
RE	1.6	1.6	1.2	1.2
BS	–	–	–	–

ISO	DC		APMX	a_p
63J2R155H50-SLSN104-C	63	2+2	104	101.2
80J2R190H50-SLSN134-C	80	2+2	134	131.2
63J2R155G50-SLSN104-C	63	2+2	104	101.2
80J2R190G50-SLSN134-C	80	2+2	134	131.2
63J2R175X50-SLSN104-C	63	2+2	104	101.2
80J2R210X50-SLSN134-C	80	2+2	134	131.2

KOPIFRÆSNING

COPY MILLING – ROUND INSERT SEAT

	SRD05	SRD07	SRD10	SRD12	SRD16
	–	–	–	–	–
	APMX (mm) 1.5	APMX (mm) 2.0	APMX (mm) 2.5	APMX (mm) 3.0	APMX (mm) 4.0
	DCX (mm) 10 – 15	DCX (mm) 15 – 25	DCX (mm) 20 – 52	DCX (mm) 24 – 80	DCX (mm) 32 – 100
Cylindrical shank					
Weldon		DCX = 15 (mm)	DCX = 20 (mm)		
Modular		DCX = 15 – 25 (mm)	DCX = 20 – 42 (mm)	DCX = 24 – 42 (mm)	DCX = 32 (mm)
Shell mill			DCX = 42, 52 (mm)	DCX = 50 – 80 (mm)	DCX = 52 – 100 (mm)
Page	160	163	168	174	180
ISO	P K H	P M K N S H	P M K N S H	P M K N S H	P M K N S H
Insert shape					
Inserts	RD 0501	RD 0702	RD 1003	RD 12T3	RD 1604
No. of cutting edges	–	–	–	–	–
Fræsning af formflader (kopifræsning)	■	■	■	■	■
Planfræsning	■	■	■	■	■
Spiralformet interpolation	■	■	■	■	■
Progressiv neddykning	■	■	■	■	■
Ramping	■	■	■	■	■

■ Primary use ◪ Possible use

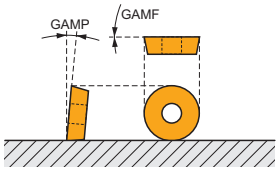
SRD05

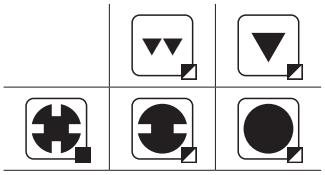
PRAMET

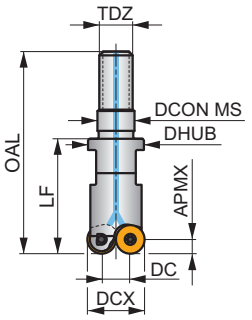
Kopi Fræser til runde skær RDNX 05 med intern kølevæske

Fræser til kopifræsning med positive RDHX 05-skær med APMX på 1,5 mm. Intern kølevæske. Velegnet til plan, spiralformet interpolation, ramping, progressiv lomme og kopifræsning. Fås som modulstil. Krop behandlet for længere værktøjslevetid.

APMX	1.5 mm







h_m 0.03 - 0.1

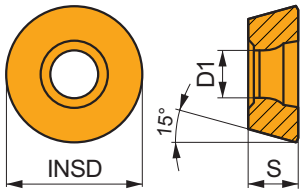
	Product	DCX (mm)	DC (mm)	DHUB (mm)	OAL (mm)	LF (mm)	DCON MS (mm)	TDZ	GAMF (°)	GAMP (°)			max.		kg		
MODULAR	**10E2R020M06-SRD05-CF**	10	5	9.8	35	20	6.5	M6	5	3	2	–	89300	✓	0.01	GI117	CO352
MODULAR	**12E3R020M06-SRD05-CF**	12	7	10	35	20	6.5	M6	0	3	3	–	81500	✓	0.01	GI117	CO352
MODULAR	**15E4R020M08-SRD05-CF**	15	10	13.5	38	20	8.5	M8	0	3	4	–	72900	✓	0.02	GI117	CO352

GI117	RD.. 0501M0..

CO352	US 62003B-T06P	0.9 Nm	M 2	3	Flag T06P

RDHX 05

	INSD	D1	S
	(mm)	(mm)	(mm)
0501	5.000	2.20	1.51

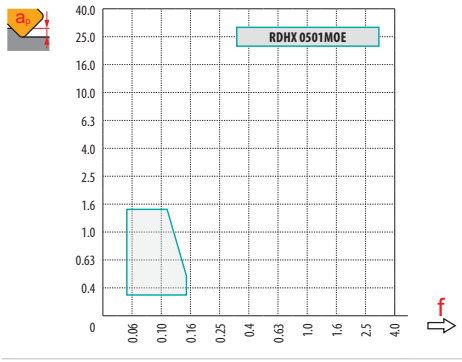


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
			HFC E																	
MOE nul skærvinkeldesign til bearbejdning af finish.																				
RDHX 0501MOE:M8310		–	400	0.10	0.5	–	–	–	380	0.10	0.5	–	–	–	–	–	–	80	0.10	0.3

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RDHX 05
RE	2.5
BS	–



DCX	a_p	0.00	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50
10	DEF	5.0	7.4	8.0	8.6	9.0	9.3	9.6	9.9	10.0
12		7.0	9.4	10.0	10.6	11.0	11.3	11.6	11.9	12.0
15		10.0	12.4	13.0	13.6	14.0	14.3	14.6	14.9	15.0
	a_p	–	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50
	f	–	0.25	0.19	0.16	0.14	0.13	0.12	0.10	0.09

DCX	RPMX	APMX/I
10	15.0	1.3/11
12	11.0	1.3/14
15	7.0	1.3/22

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
10	12.0	20.0	1.2	1.2
12	16.0	24.0	1.2	1.2
15	22.0	30.0	1.2	1.2

a_p
1.0

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
10	FE	0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
12		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
15		0.424	0.548	0.775	0.949	1.095	1.342	1.549	1.732	1.897	2.191	2.449
RE	µm	3	5	10	15	20	30	40	50	60	80	100
2.5	FE	0.245	0.316	0.447	0.548	0.632	0.775	0.894	1.000	1.095	1.265	1.414

SRD07

P M K N S H

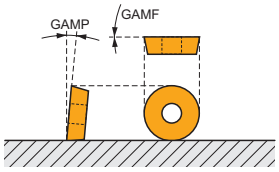
PRAMET

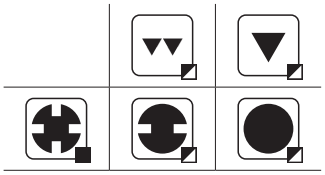
S

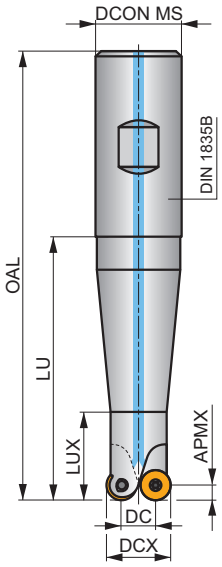
Kopi Fræser til runde skær RD 07 med intern kølevæske

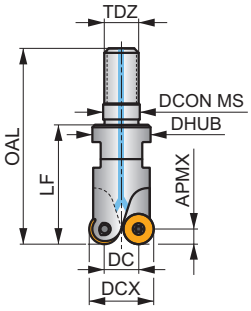
Fræser til kopfræsning ved hjælp af positive RD .. 07 skær med APMX på 2 mm. Intern kølevæske. Velegnet til plan, spiralformet interpolation, ramping, progressiv lomme og kopifræsning. Fås i weldon og modulær. Krop behandlet for længere værktøjslevetid.

APMX	2.0 mm









h_m 0.065 - 0.13

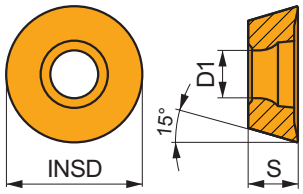
	Product	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DHUB (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835B	**15E2R040B16-SRD07-CF**	15	8	88	16	–	40	20	–	–	1	0	2	–	44200	✓	0.12	GI118	C0354
	15E2R060B16-SRD07-CF	15	8	108	16	–	60	20	–	–	1	0	2	–	44200	✓	0.15	GI118	C0354
	15E2R080B20-SRD07-CF	15	8	130	20	–	80	22	–	–	1	0	2	–	44200	✓	0.22	GI118	C0354
	15E2R100B20-SRD07-CF	15	8	150	20	–	100	22	–	–	1	0	2	–	44200	✓	0.25	GI118	C0354
	15E2R120B25-SRD07-CF	15	8	176	25	–	120	22	–	–	1	0	2	–	44200	✓	0.45	GI118	C0354
MODULAR	**15E2R028M08-SRD07-CF**	15	8	46	8.5	13.5	–	–	28	M8	1	0	2	–	44200	✓	0.03	GI118	C0354
	15E3R028M08-SRD07-CF	15	8	46	10.5	13.5	–	–	28	M8	2	0	3	–	44200	✓	0.05	GI118	C0354
	20E4R028M10-SRD07-CF	20	13	47	12.5	18	–	–	28	M10	-8	0	4	–	38200	✓	0.07	GI118	C0354
	25E5R028M12-SRD07-CF	25	18	50	12.5	21	–	–	28	M12	-2	0	5	–	34200	✓	0.09	GI118	C0354

GI118	RD.. 07..MO..

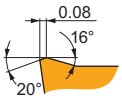
		Nm			
C0354	US 42505-T07P	1.2	M 2.5	5	Flag T07P

RDGT 07

	INSD	D1	S
	(mm)	(mm)	(mm)
0702	7.000	2.80	2.38

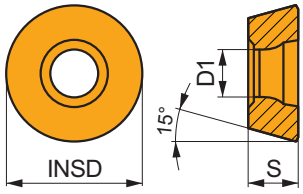


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

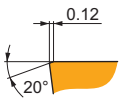
Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
 **MOT** pM-geometri med positivt design til alle formål.																			
RDGT 0702MOT:M8325	–	305	0.15	0.5	145	0.14	0.5	–	–	–	–	–	–	–	–	–	–	–	–
RDGT 0702MOT:M8345	–	270	0.15	0.5	160	0.14	0.5	–	–	–	–	–	–	65	0.12	0.4	–	–	–

RDHX 07

	INSD	D1	S
	(mm)	(mm)	(mm)
0702	7.000	2.80	2.38
07T1	7.000	2.80	1.98

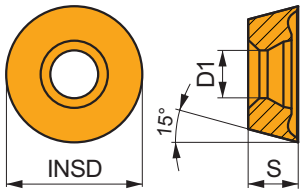


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

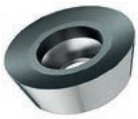
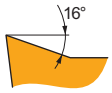
Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
 **MOT** nul skærvinkeldesign til bearbejdning af finish.																			
RDHX 0702MOT:M4303	–	370	0.15	0.5	–	–	–	350	0.15	0.5	–	–	–	–	–	–	70	0.11	0.5
RDHX 0702MOT:M8310	–	360	0.15	0.5	–	–	–	340	0.15	0.5	–	–	–	–	–	–	70	0.11	0.5
RDHX 0702MOT:M8325	–	275	0.15	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RDHX 07T1MOT:M8310	–	360	0.15	0.5	–	–	–	340	0.15	0.5	–	–	–	–	–	–	70	0.11	0.5

RDHT 07-FA

	INSD	D1	S
	(mm)	(mm)	(mm)
0702	7.000	2.80	2.38

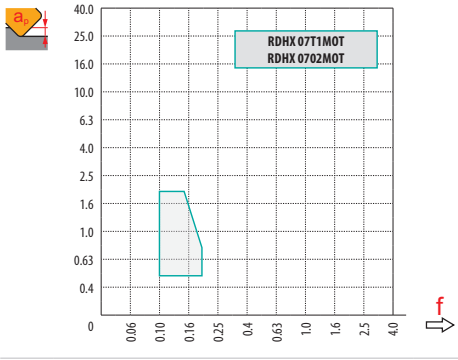


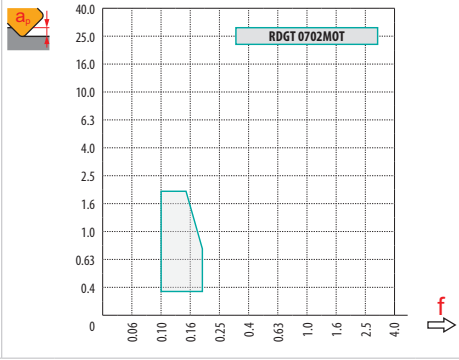
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

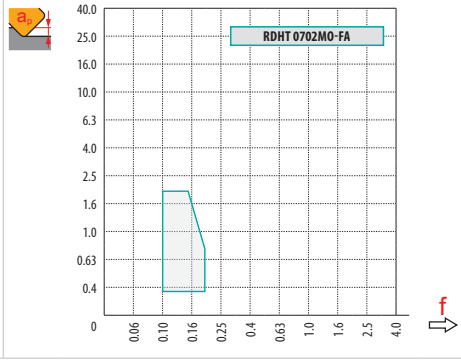
Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																			
FA geometri med meget positivt design til finbearbejdning til medium bearbejdning.																			
RDHT 0702M0-FA:HF7	●	–	–	–	–	–	–	–	–	–	–	–	–	■ 420	0.18	0.5	–	–	–	–	–	–

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RDHX 07	RDGT 07	RDHT 07-FA
RE	3.5	3.5	3.5
BS	–	–	–







DCX	a_p	0.00	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50
15	DEF	8.0	10.8	11.6	12.3	12.9	13.4	13.7	14.3	14.7	14.9	15.0
20		13.0	15.8	16.6	17.3	17.9	18.4	18.7	19.3	19.7	19.9	20.0
25		18.0	20.8	21.6	22.3	22.9	23.4	23.7	24.3	24.7	24.9	25.0
	a_p	**0.00**	**0.30**	**0.50**	**0.75**	**1.00**	**1.25**	**1.50**	**2.00**	**2.50**	**3.00**	**3.50**
	f	–	0.29	0.23	0.19	0.16	0.15	0.13	0.12	0.11	0.10	0.09

DCX	RPMX	APMX/I
15	11.0	1.7/20
20	7.0	1.7/30
25	6.0	1.7/35

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
15	17.0	30.0	0.4	1.7
20	28.0	40.0	1.7	1.7
25	38.0	50.0	1.7	1.7

a_p
1.2

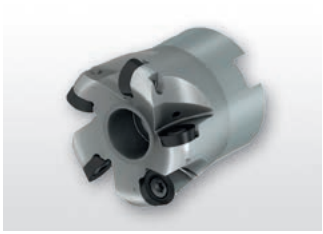
DCX	µm	3	5	10	15	20	30	40	50	60	80	100
15		0.424	0.548	0.775	0.949	1.095	1.342	1.549	1.732	1.897	2.191	2.449
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
RE	µm	3	5	10	15	20	30	40	50	60	80	100
3.5		0.290	0.374	0.529	0.648	0.748	0.917	1.058	1.183	1.296	1.497	1.673

SRD10

P M K N S H

PRAMET

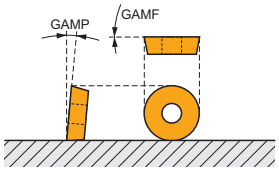
S

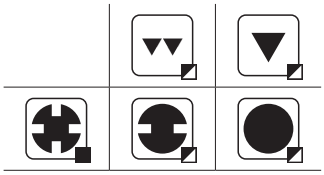


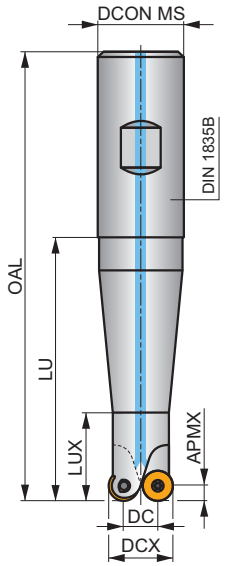
Kopi Fræser til runde skær RD 10 med intern kølevæske

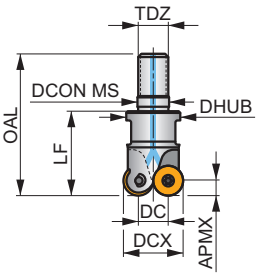
Fræser til kopfræsning ved hjælp af positive RD .. 10 skær med APMX på 2.5 mm. Intern kølevæske. Velegnet til plan, spiralformet interpolation, ramping, progressiv lomme og kopifræsning. Fås i weldon og modulær. Krop behandlet for længere værktøjslevetid.

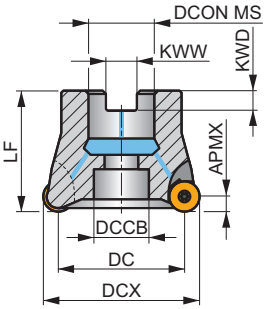
APMX	2.5 mm











h_m 0.065 - 0.19

	Product	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DHUB (mm)	DCCB (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835B	20E2R040B20-SRD10-CF	20	10	90	20	–	–	40	20	–	–	–	–	-2	0	2	–	30800	✓	0.20	GI119	C0356
	20E2R060B20-SRD10-CF	20	10	110	20	–	–	60	22	–	–	–	–	-2	0	2	–	30800	✓	0.20	GI119	C0356
	20E2R080B25-SRD10-CF	20	10	136	25	–	–	80	25	–	–	–	–	-2	0	2	–	30800	✓	0.40	GI119	C0356
	20E2R100B25-SRD10-CF	20	10	156	25	–	–	100	25	–	–	–	–	-2	0	2	–	30800	✓	0.45	GI119	C0356
	20E2R120B25-SRD10-CF	20	10	176	25	–	–	120	25	–	–	–	–	-2	0	2	–	30800	✓	0.46	GI119	C0356
MODULAR	20E2R028M10-SRD10-CF	20	10	47	10.5	18	–	–	–	28	M10	–	–	-2	0	2	–	30800	✓	0.07	GI119	C0356
	25E2R032M12-SRD10-CF	25	15	54	12.5	21	–	–	–	32	M12	–	–	0.5	0.5	2	–	27500	✓	0.08	GI119	C0356
	25E3R032M12-SRD10-CF	25	15	54	12.5	21	–	–	–	32	M12	–	–	0.5	0.5	3	–	27500	✓	0.10	GI119	C0356
	30E4R042M16-SRD10-CF	30	20	65	17	29	–	–	–	42	M16	–	–	0	0	4	–	25100	✓	0.20	GI119	C0356
	32E4R042M16-SRD10-CF	32	22	65	17	29	–	–	–	42	M16	–	–	0	0	4	–	24300	✓	0.19	GI119	C0356
	35E5R042M16-SRD10-CF	35	25	65	17	29	–	–	–	42	M16	–	–	0	0	5	–	23200	✓	0.22	GI119	C0356
	42E4R042M16-SRD10-CF	42	32	65	17	29	–	–	–	42	M16	–	–	0	0	4	–	21200	✓	0.24	GI119	C0356
	42E5R042M16-SRD10-CF	42	32	65	17	29	–	–	–	42	M16	–	–	0	0	5	–	21200	✓	0.24	GI119	C0356
ISO 6462 DIN 8030	42A05R-SMORD10-CF	42	32	–	16	–	14	–	–	40	–	8.4	8.4	0	0	5	–	21200	✓	0.20	GI119	C0358
	52A07R-SMORD10-CF	52	42	–	22	–	18	–	–	40	–	10.4	10.4	0	0	7	–	19100	✓	0.41	GI119	C0360

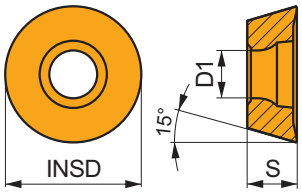
GI119	RD.. 1003M0T	RDHT 1003M0-FA

		Nm					
C0356	US 63507-T15P	3.0	M 3.5	7	Flag T15P	–	–
C0358	US 63507-T15P	3.0	M 3.5	7	D-T08P/T15P	FG-15	HS 0830C
C0360	US 63507-T15P	3.0	M 3.5	7	D-T08P/T15P	FG-15	HS 1030C

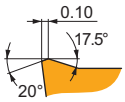
RDGT 10

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1003	10.000	3.90	3.18



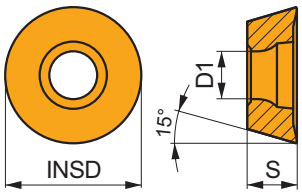
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 **MOT** pM-geometri med positivt design til alle formål.																			
RDGT 1003MOT:M6330	–	290	0.15	1.0	205	0.14	1.0	–	–	–	–	–	–	85	0.12	0.8	–	–	–
RDGT 1003MOT:M8310	–	375	0.15	1.0	190	0.14	1.0	355	0.15	1.0	–	–	–	–	–	–	–	–	–
RDGT 1003MOT:M8325	–	280	0.15	1.0	130	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
RDGT 1003MOT:M8345	–	250	0.15	1.0	150	0.14	1.0	–	–	–	–	–	–	60	0.12	0.8	–	–	–
RDGT 1003MOT:M9340	–	395	0.15	1.0	235	0.14	1.0	–	–	–	–	–	–	95	0.12	0.8	–	–	–

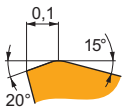
RDMT 10

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1003	10.000	3.90	3.18



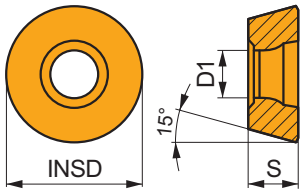
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 **MOT** pM-geometri med positivt design til alle formål.																			
RDMT 1003MOT:M8325	–	280	0.15	1.0	130	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–
RDMT 1003MOT:M8345	–	250	0.15	1.0	150	0.14	1.0	–	–	–	–	–	–	–	–	–	–	–	–

RDMX 10

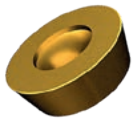
PRAMET

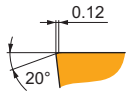
	INSD	D1	S
	(mm)	(mm)	(mm)
1003	10.000	3.90	3.18



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
RDMX 1003MOT:M8310	–	335	0.15	1.0	–	–	–	315	0.15	1.0	–	–	–	–	–	–	65	0.11	0.7
RDMX 1003MOT:M8325	–	250	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RDMX 1003MOT:M8345	–	225	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



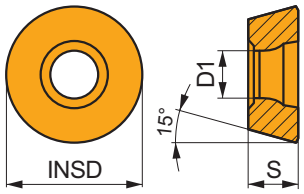


MOT nul skærvinkeldesign til bearbejdning af finish.

RDHX 10

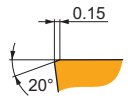
PRAMET

	INSD	D1	S
	(mm)	(mm)	(mm)
1003	10.000	3.90	3.18



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

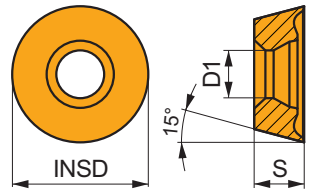
Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
RDHX 1003MOT:M4303	–	340	0.15	1.0	–	–	–	320	0.15	1.0	–	–	–	–	–	–	65	0.12	0.7
RDHX 1003MOT:M8310	–	335	0.15	1.0	–	–	–	315	0.15	1.0	–	–	–	–	–	–	65	0.12	0.7
RDHX 1003MOT:M8325	–	250	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RDHX 1003MOT:M8345	–	225	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



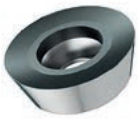
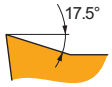
MOT nul skærvinkeldesign til bearbejdning af finish.

RDHT 10-FA

	INSD	D1	S
	(mm)	(mm)	(mm)
1003	10.000	3.90	3.18



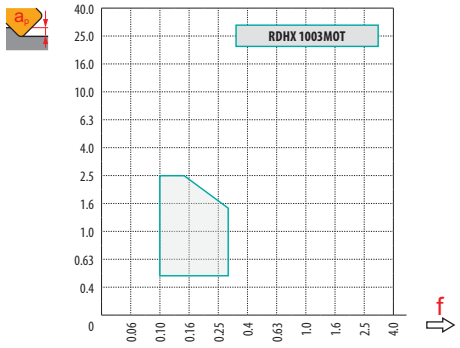
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

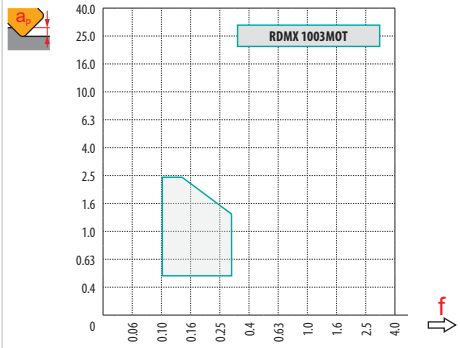
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				
RDHT 1003MO-FA:HF7	●	–	–	–	–	–	–	–	–	–	–	■	390	0.18	1.0	–	–	–	–	–	–

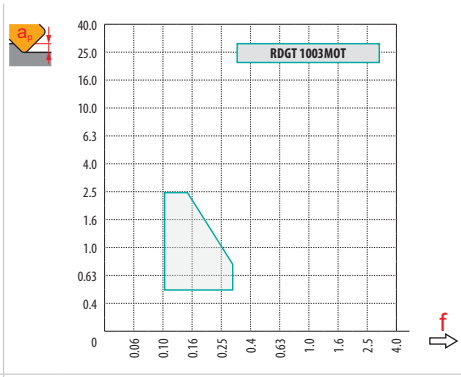
FA geometri med meget positivt design til finbearbejdning til medium bearbejdning.

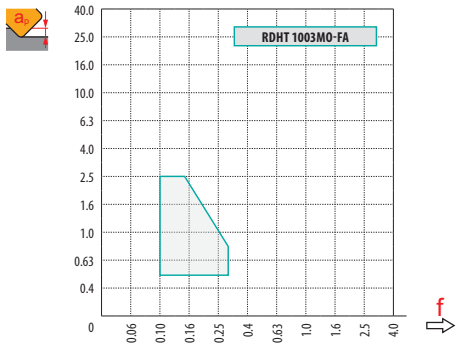
a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

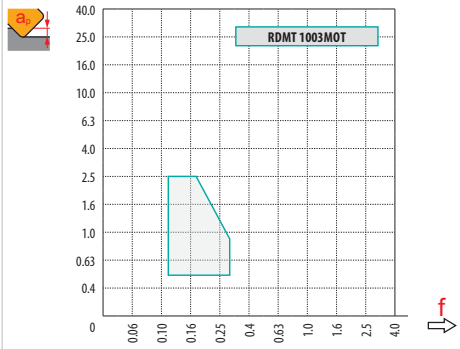
	RDHX 10	RDMX 10	RDGT 10	RDHT 10-FA	RDMT 10
RE	5.0	5.0	5.0	5.0	5.0
BS	–	–	–	–	–











DCX	a_p	0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00
20	DEF	10.0	14.4	15.3	16.0	16.6	17.1	18.0	18.7	19.2	19.5	19.8	20.0
25		15.0	19.4	20.3	21.0	21.6	22.1	23.0	23.7	24.2	24.5	24.8	25.0
30		20.0	24.4	25.3	26.0	26.6	27.1	28.0	28.7	29.2	29.5	29.8	30.0
32		22.0	26.4	27.3	28.0	28.6	29.1	30.0	30.7	31.2	31.5	31.8	32.0
35		25.0	29.4	30.3	31.0	31.6	32.1	33.0	33.7	34.2	34.5	34.8	35.0
42		32.0	36.4	37.3	38.0	38.6	39.1	40.0	40.7	41.2	41.5	41.8	42.0
52		42.0	46.4	47.3	48.0	48.6	49.1	50.0	50.7	51.2	51.5	51.8	52.0
	a_p	0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00
	f	–	0.54	0.44	0.39	0.35	0.32	0.28	0.25	0.23	0.22	0.21	0.19

DCX	RPMX	APMX/l
20	20	2.5/15
25	12	2.5/25
30	8	2.5/37
32	7.5	2.5/20
35	7	2.5/42
42	4	2.5/37
52	3	2.5/49

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
20	22.0	40.0	2.5	2.5
25	32.0	50.0	2.5	2.5
30	42.0	60.0	2.5	2.5
32	46.0	64.0	2.5	2.5
35	52.0	70.0	2.5	2.5
42	66.0	84.0	2.5	2.5
52	86.0	104.0	2.5	2.5

a_p
2.5

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
20	FE	0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
30		0.600	0.775	1.095	1.342	1.549	1.897	2.191	2.449	2.683	3.098	3.464
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
35		0.648	0.837	1.183	1.449	1.673	2.049	2.366	2.646	2.898	3.347	3.742
42		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
RE	µm	**3**	**5**	**10**	**15**	**20**	**30**	**40**	**50**	**60**	**80**	**100**
5.0	FE	0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000

SRD12

P M K N S H

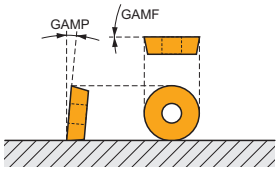
PRAMET

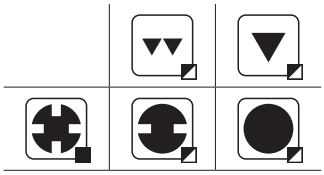
S(C)

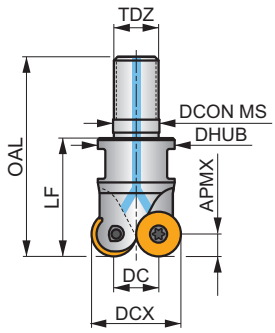
Kopi Fræser til runde skær RD 12 med intern kølevæske

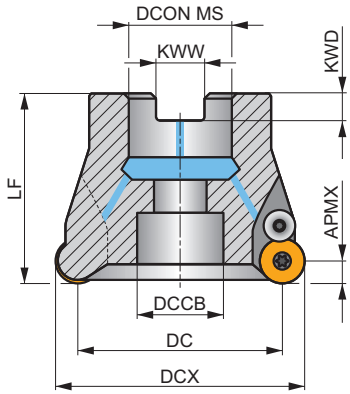
Fræser til kopfræsning ved hjælp af positive RD .. 12 skær med APMX på 3 mm. Intern kølevæske. Velegnet til plan, spiralformet interpolation, ramping, progressiv lomme og kopifræsning. Fås i weldon og modulær type. Krop behandlet for længere værktøjslevetid.

APMX	3.0 mm









h_m	0.065 - 0.25
h_m	0.065 - 0.22

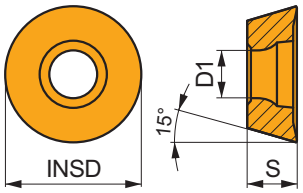
	Product	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DHUB (mm)	DCCB (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)	max.	kg			
MODULAR	**24E2R032M12-SRD12-CF**	24	12	54	12.5	21	–	32	M12	–	–	-3	0	21900	0.10	GI120	C0362	
MODULAR	**35E3R042M16-SCRD12-CF**	35	23	65	17	29	–	42	M16	–	–	0	0	18100	0.22	GI120	C0364	
MODULAR	**35E4R042M16-SRD12-CF**	35	23	65	17	29	–	42	M16	–	–	0	0	18100	0.20	GI120	C0362	
MODULAR	**42E4R042M16-SCRD12-CF**	42	30	65	17	29	–	42	M16	–	–	0	0	16600	0.21	GI120	C0364	
MODULAR	**42E5R042M16-SRD12-CF**	42	30	65	17	29	–	42	M16	–	–	0	0	16600	0.22	GI120	C0366	
ISO 6462 DIN 8030	**50A05R-SCMORD12-CF**	50	38	–	22	–	18	50	–	10.4	10.4	2	7	15200	0.29	GI120	C0366	
ISO 6462 DIN 8030	**52A05R-SCMORD12-CF**	52	40	–	22	–	18	50	–	10.4	10.4	2	7	14900	0.44	GI120	C0366	
ISO 6462 DIN 8030	**66A06R-SCMORD12-CF**	66	54	–	27	–	22	50	–	12.4	12.4	2	7	13200	0.54	GI120	C0370	
ISO 6462 DIN 8030	**80A07R-SCMORD12-CF**	80	68	–	27	–	38	52	–	12.4	12.4	2	7	12000	0.89	GI120	C0372	

GI120	RD.. 12T3M0T	RDHT 12T3M0-FA

		Nm							
C0362	US 3508-T15P	3.5	M 3.5	8	–	–	Flag T15P	–	–
C0364	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	–	CS12P	–
C0366	US 3508-T15P	3.5	M 3.5	8	D-T08P/T15P	FG-15	–	CS12P	HS 1030C
C0370	US 3508-T15P	3.5	M 3.5	8	D-T08P/T15P	FG-15	–	CS12P	HS 1230C
C0372	US 3508-T15P	3.5	M 3.5	8	D-T08P/T15P	FG-15	–	CS12P	–

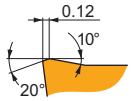
RDGT 12

	INSD	D1	S
	(mm)	(mm)	(mm)
12T3	12.000	3.90	3.97



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

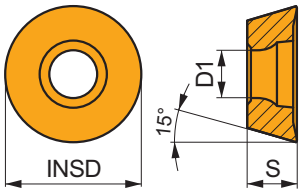
Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
RDGT 12T3MOT:M6330	–	260	0.20	1.5	185	0.18	1.5	–	–	–	–	–	–	75	0.14	1.2	–	–	–
RDGT 12T3MOT:M8310	–	330	0.20	1.5	165	0.18	1.5	310	0.20	1.5	–	–	–	–	–	–	–	–	–
RDGT 12T3MOT:M8325	–	250	0.20	1.5	120	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–
RDGT 12T3MOT:M8345	–	225	0.20	1.5	135	0.18	1.5	–	–	–	–	–	–	55	0.14	1.2	–	–	–
RDGT 12T3MOT:M9340	–	340	0.20	1.5	200	0.18	1.5	–	–	–	–	–	–	85	0.14	1.2	–	–	–



MOT pM-geometri med positivt design til alle formål.

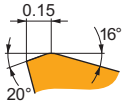
RDMT 12

	INSD	D1	S
	(mm)	(mm)	(mm)
12T3	12.000	3.90	3.97



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
RDMT 12T3MOT:M8345	–	225	0.20	1.5	135	0.18	1.5	–	–	–	–	–	–	–	–	–	–	–	–

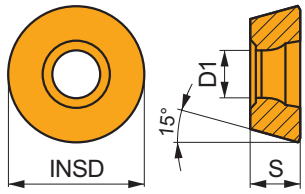


MOT pM-geometri med positivt design til alle formål.

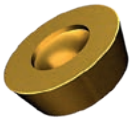
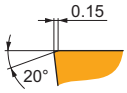
RDMX 12

PRAMET

	INSD	D1	S
	(mm)	(mm)	(mm)
12T3	12.000	3.90	3.97



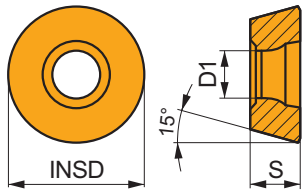
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
 																			
MOT nul skærvinkeldesign til bearbejdning af finish.																			
RDMX 12T3MOT:M8310	–	300	0.20	1.5	–	–	–	285	0.20	1.5	–	–	–	–	–	–	60	0.10	0.8
RDMX 12T3MOT:M8325	–	225	0.20	1.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RDMX 12T3MOT:M8345	–	200	0.20	1.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

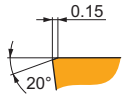
RDHX 12

PRAMET

	INSD	D1	S
	(mm)	(mm)	(mm)
12T3	12.000	3.90	3.97

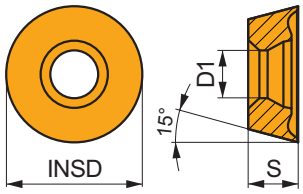


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

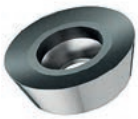
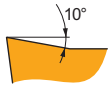
Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																			
MOT nul skærvinkeldesign til bearbejdning af finish.																			
RDHX 12T3MOT:M4303	–	300	0.20	1.5	–	–	–	285	0.20	1.5	–	–	–	–	–	–	60	0.14	0.8
RDHX 12T3MOT:M8310	–	300	0.20	1.5	–	–	–	285	0.20	1.5	–	–	–	–	–	–	60	0.14	0.8
RDHX 12T3MOT:M8325	–	225	0.20	1.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RDHX 12T3MOT:M8345	–	200	0.20	1.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

RDHT 12-FA

	INSD	D1	S
	(mm)	(mm)	(mm)
12T3	12.000	3.90	3.97



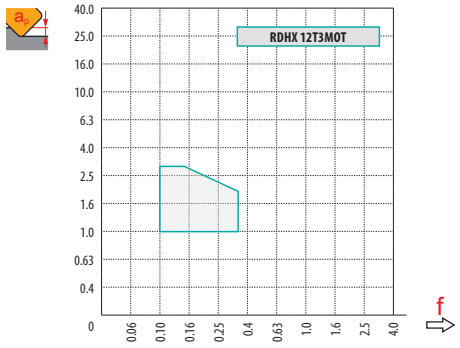
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

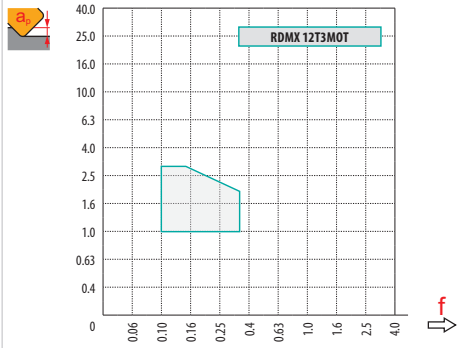
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				
RDHT 12T3M0-FA:HF7	●	–	–	–	–	–	–	–	–	–	–	■	360	0.24	1.5	–	–	–	–	–	–

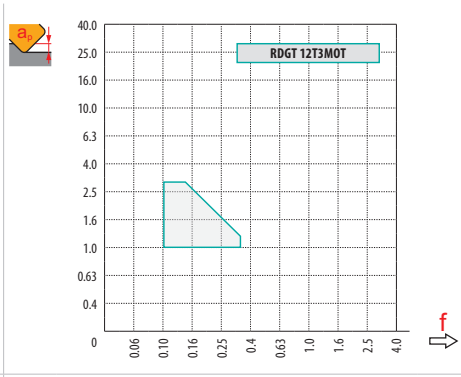
FA geometri med meget positivt design til finbearbejdning til medium bearbejdning.

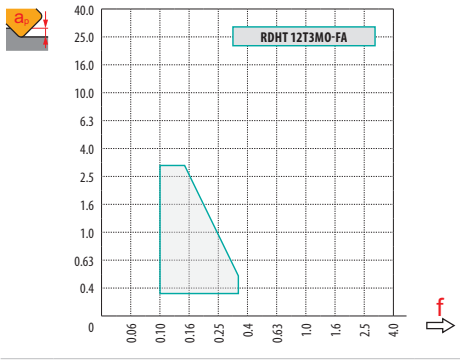
a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

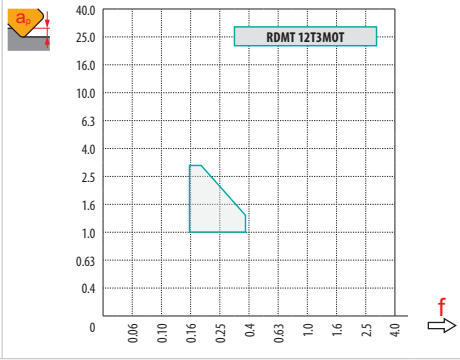
	RDHX 12	RDMX 12	RDGT 12	RDHT 12-FA	RDMT 12
RE	6.0	6.0	6.0	6.0	6.0
a_p	–	–	–	–	–











DCX	a_p	0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00	6.00
24	DEF	12.0	16.8	17.8	18.6	19.3	19.9	20.9	21.7	22.4	22.9	23.3	23.8	24.0
35		23.0	27.8	28.8	29.6	30.3	30.9	31.9	32.7	33.4	33.9	34.3	34.8	35.0
42		30.0	34.8	35.8	36.6	37.3	37.9	38.9	39.7	40.4	40.9	41.3	41.8	42.0
50		38.0	42.8	43.8	44.6	45.3	45.9	46.9	47.7	48.4	48.9	49.3	49.8	50.0
52		40.0	44.8	45.8	46.6	47.3	47.9	48.9	49.7	50.4	50.9	51.3	51.8	52.0
66		54.0	58.8	59.8	60.6	61.3	61.9	62.9	63.7	64.4	64.9	65.3	65.8	66.0
80		68.0	72.8	73.8	74.6	75.3	75.9	76.9	77.7	78.4	78.9	79.3	79.8	80.0
	a_p	0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00	6.00
	f	–	0.49	0.40	0.35	0.32	0.29	0.25	0.23	0.21	0.20	0.18	0.17	0.16

DCX	RPMX	APMX/I
24	25.0	3.0/14
35	9.0	3.0/39
42	8.0	3.0/44
50	4.0	3.0/87
52	4.0	3.0/87
66	3.0	3.0/100
80	2.2	3.0/100

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
24	26.0	48.0	3.0	3.0
35	46.0	70.0	3.0	3.0
42	62.0	84.0	3.0	3.0
50	78.0	100.0	2.8	2.8
52	82.0	104.0	2.8	2.8
66	110.0	132.0	2.8	2.8
80	136.0	160.0	2.8	2.8

a_p
2.8

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
24	FE	0.537	0.693	0.980	1.200	1.386	1.697	1.960	2.191	2.400	2.771	3.098
35		0.648	0.837	1.183	1.449	1.673	2.049	2.366	2.646	2.898	3.347	3.742
42		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
RE	µm	3	5	10	15	20	30	40	50	60	80	100
6.0	FE	0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191

SRD16

P M K N S H

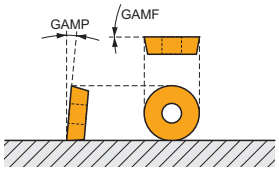
PRAMET

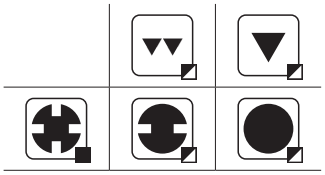
S(C)

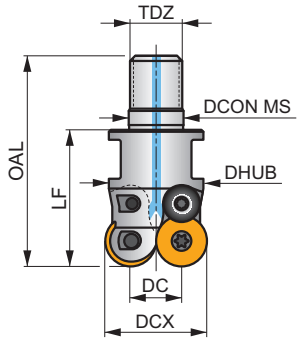
Kopi Fræser til runde skær RD 16 med intern kølevæske

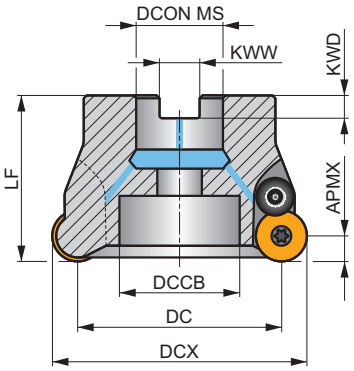
Fræser til kopfræsning ved hjælp af positive RD .. 16 skær med APMX på 4 mm. Intern kølevæske. Velegnet til plan, spiralformet interpolation, ramping, progressiv lomme og kopifræsning. Fås i weldon og dorn. Krop behandlet for længere værktøjslevetid.

APMX	4.0 mm









h_m	0.11 - 0.25
h_m	0.1 - 0.2

	Product	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DHUB (mm)	DCCB (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
MODULAR	**32E2R042M16-SCRD16-CF**	32	16	65	17	29	–	42	M16	–	–	-2	0	2	–	12600	✓	0.18	GI121	C0374
	52A04R-SCMORD16-CF	52	36	–	22	–	16.5	50	–	10.4	10.4	0	7	4	–	9900	✓	0.41	GI121	C0376
ISO 6462 DIN 8030	**66A05R-SCMORD16-CF**	66	50	–	27	–	22	50	–	12.4	12.4	0	7	5	–	8800	✓	0.60	GI121	C0378
	80A06R-SCMORD16-CF	80	64	–	27	–	38	52	–	12.4	12.4	0	7	6	–	8000	✓	0.87	GI121	C0380
	100A07R-SCMORD16-CF	100	84	–	32	–	45	52	–	14.4	14.4	0	7	7	–	7100	✓	1.41	GI121	C0380

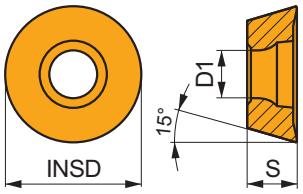
GI121	RD.. 1604MOT	RDHT 1604MO-FA

		Nm						
C0374	US 64510-T20P	4.5	M 4.5	10	–	Flag T20P	CS16P	–
C0376	US 64510-T20P	4.5	M 4.5	10	SDR T20P-T	–	CS16P	HS 1030C
C0378	US 64510-T20P	4.5	M 4.5	10	SDR T20P-T	–	CS16P	HS 1230C
C0380	US 64510-T20P	4.5	M 4.5	10	SDR T20P-T	–	CS16P	–

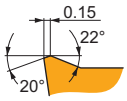
RDGT 16

PRAMET

	INSD	D1	S
	(mm)	(mm)	(mm)
1604	16.000	5.20	4.76



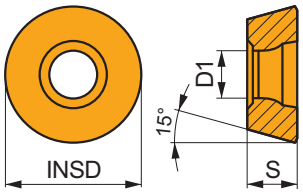
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
 **MOT** pM-geometri med positivt design til alle formål.																			
RDGT 1604MOT:M8310	–	285	0.30	2.0	145	0.27	2.0	270	0.30	2.0	–	–	–	–	–	–	–	–	–
RDGT 1604MOT:M8325	–	220	0.30	2.0	105	0.27	2.0	–	–	–	–	–	–	–	–	–	–	–	–
RDGT 1604MOT:M8345	–	200	0.30	2.0	120	0.27	2.0	–	–	–	–	–	–	50	0.21	1.6	–	–	–

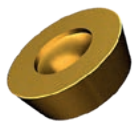
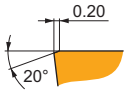
RDMX 16

PRAMET

	INSD	D1	S
	(mm)	(mm)	(mm)
1604	16.000	5.20	4.76



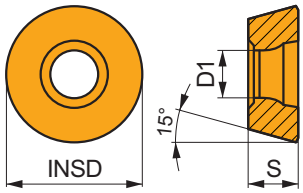
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
  **MOT** nul skærvinkeldesign til bearbejdning af finish.																			
RDMX 1604MOT:M8310	–	255	0.30	2.0	–	–	–	240	0.30	2.0	–	–	–	–	–	–	50	0.15	1.1

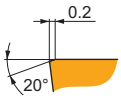
RDHX 16

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1604	16.000	5.20	4.76



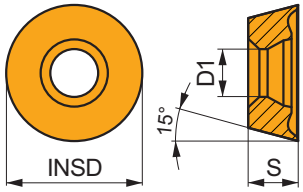
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 **MOT** nul skærvinkeldesign til bearbejdning af finish.																			
RDHX 1604MOT:M8310	–	255	0.30	2.0	–	–	–	240	0.30	2.0	–	–	–	–	–	–	50	0.15	1.1
RDHX 1604MOT:M8325	–	195	0.30	2.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RDHX 1604MOT:M8345	–	180	0.30	2.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
RDHX 1604MOT:M9325	–	290	0.30	2.0	–	–	–	275	0.30	2.0	–	–	–	–	–	–	55	0.15	1.1

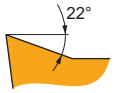
RDHT 16-FA

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
1604	16.000	5.20	4.76

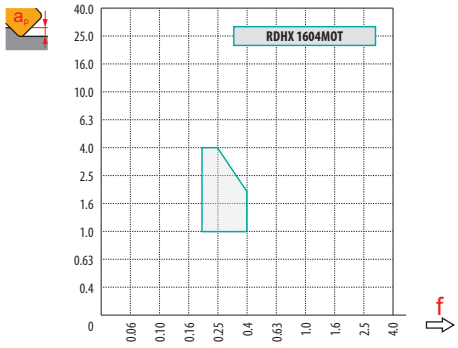


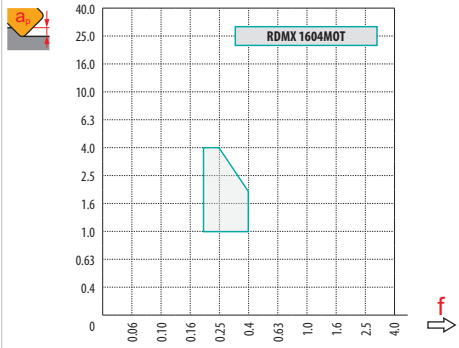
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

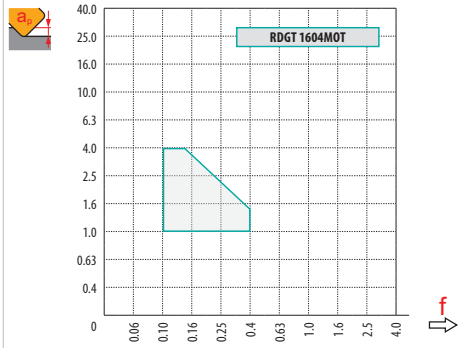
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 **FA** geometri med meget positivt design til finbearbejdning til medium bearbejdning.																			
RDHT 1604MO-FA:HF7	–	–	–	–	–	–	–	–	–	–	315	0.36	2.0	–	–	–	–	–	–

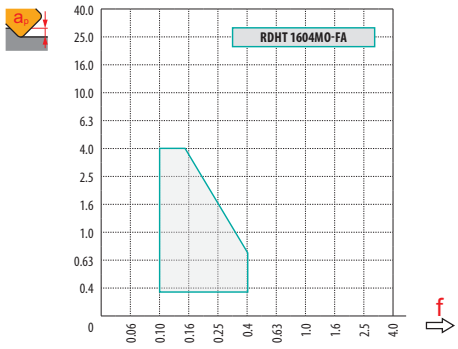
a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RDHX 16	RDMX 16	RDGT 16	RDHT 16-FA
RE	8.0	8.0	8.0	8.0
BS	–	–	–	–









DCX	a_p	0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00	6.00	7.00	8.00
32	DEF	16.0	21.6	22.8	23.7	24.6	25.3	26.6	27.6	28.5	29.2	29.9	30.8	31.5	31.9	32.0
52		36.0	41.6	42.8	43.7	44.6	45.3	46.6	47.6	48.5	49.2	49.9	50.8	51.5	51.9	52.0
66		50.0	55.6	56.8	57.7	58.6	59.3	60.6	61.6	62.5	63.2	63.9	64.8	65.5	65.9	66.0
80		64.0	69.6	70.8	71.7	72.6	73.3	74.6	75.6	76.5	77.2	77.9	78.8	79.5	79.9	80.0
100		84.0	89.6	90.8	91.7	92.6	93.3	94.6	95.6	96.5	97.2	97.9	98.8	99.5	99.9	100.0
	a_p	0.00	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	3.50	4.00	5.00	6.00	7.00	8.00
	f	–	0.91	0.74	0.65	0.58	0.53	0.46	0.42	0.38	0.36	0.34	0.30	0.28	0.26	0.25

DCX	RPMX	APMX/I
32	25.0	4.0/19
52	8.0	4.0/58
66	6.0	4.0/78
80	4.0	4.0/100
100	3.0	4.0/100

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
32	34.0	64.0	4.0	4.0
52	74.0	104.0	4.0	4.0
66	102.0	132.0	4.0	4.0
80	130.0	160.0	4.0	4.0
100	170.0	200.0	4.0	4.0

a_p
4.0

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
32	FE	0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
RE	µm	3	5	10	15	20	30	40	50	60	80	100
8.0	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530

COPY MILLING – SEAT WITH LOCATING FLATS

	SRC10	SRC12	SRC16	SRC20		
	–	–	–	–		
	APMX (mm) 5.0	APMX (mm) 6.0	APMX (mm) 8.0	APMX (mm) 10.0		
	DCX (mm) 25 – 66	DCX (mm) 40 – 100	DCX (mm) 63 – 160	DCX (mm) 80 – 160		
Cylindrical shank	DCX = 25, 32 (mm)					
Weldon						
Modular	DCX = 25 – 35 (mm)					
Shell mill	DCX = 40 – 66 (mm)					
Page	186	190	194	198		
ISO	P M K S H	P M K S H	P M K S H	P M K S H		
Insert shape						
Inserts	RC 10T3	RC 1204	RC 1606	RC 2006		
No. of cutting edges	8	12	8	8		
Fræsning af formflader (kopifræsning)	■	■	■	■		
Planfræsning	■	■	■	■		
Spiralformet interpolation	■	■	■	■		
Progressiv neddykning	■	■	■	■		
Ramping	■	■	■	■		

■ Primary use ◪ Possible use

SRC10

P M K S H

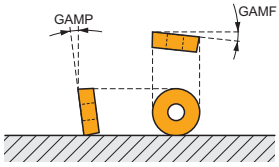
PRAMET

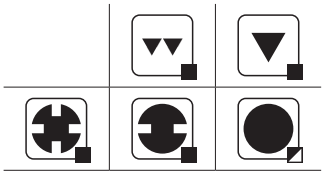
S

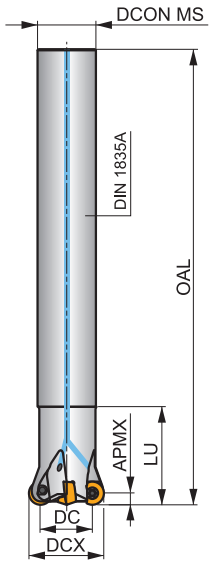
Kopi Fræser til runde skær RCMT 10 med intern kølevæske

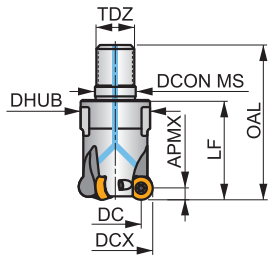
Fræser til kopifræsning ved hjælp af positive RCMT 10 skær med APMX på 5 mm. Intern kølevæske. Velegnet til plan, spiralformet interpolation, ramping, progressiv lomme og high feed fræsning. Fås i cylindrisk, modulær og dorn-stil. Krop behandlet for længere værktøjslevetid.

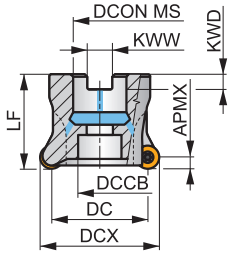
APMX	5.0 mm











h_m	0.05 - 0.12
h_m	0.08 - 0.15

	Product	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DHUB (mm)	DCCB (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)	max.	kg			
DIN 1835A	25E2R034A20-SRC10-C	25	15	170	20	–	–	34	–	–	–	–	-3	-7	2	–	20900	✓	0.40	GI328	C0010
	25E3R034A20-SRC10-C	25	15	170	20	–	–	34	–	–	–	–	-3	-7	3	–	20900	✓	0.36	GI328	C0010
	32E3R042A25-SRC10-C	32	22	200	25	–	–	42	–	–	–	–	-2.6	-7	4	–	18500	✓	0.67	GI328	C0010
	32E4R042A25-SRC10-C	32	22	200	25	–	–	42	–	–	–	–	-2.6	-7	3	–	18500	✓	0.70	GI328	C0010
MODULAR	25E2R032M12-SRC10-C	25	15	54	12.5	21	–	–	32	M12	–	–	-3	-7	2	–	20900	✓	0.11	GI328	C0010
	25E3R032M12-SRC10-C	25	15	54	12.5	21	–	–	32	M12	–	–	-3	-7	3	–	20900	✓	0.08	GI328	C0010
	32E4R042M16-SRC10-C	32	22	65	17	29	–	–	42	M16	–	–	-2.6	-7	4	–	18500	✓	0.20	GI328	C0010
	35E4R042M16-SRC10-C	35	25	65	17	29	–	–	42	M16	–	–	-2.4	-7	4	–	17700	✓	0.20	GI328	C0010
ISO 6462 DIN 8030	40A05R-SMORC10-C	40	30	–	16	–	14	–	40	–	8.4	5.6	-2.2	-7	5	–	16500	✓	0.21	GI328	C0012
	50A05R-SMORC10-C	50	40	–	22	–	18	–	40	–	10.4	6.3	-2	-7	5	–	14800	✓	0.34	GI328	C0013
	50A06R-SMORC10-C	50	40	–	22	–	18	–	40	–	10.4	6.3	-2	-7	6	–	14800	✓	0.33	GI328	C0013
	52A05R-SMORC10-C	52	42	–	22	–	18	–	40	–	10.4	6.3	-2	-7	5	–	14500	✓	0.35	GI328	C0013
	52A06R-SMORC10-C	52	42	–	22	–	18	–	40	–	10.4	6.3	-2	-7	6	–	14500	✓	0.28	GI328	C0013
	63A06R-SMORC10-C	63	53	–	22	–	18	–	40	–	10.4	6.3	-1.8	-7	6	–	13200	✓	0.52	GI328	C0013
	63A07R-SMORC10-C	63	53	–	22	–	18	–	40	–	10.4	6.3	-1.8	-7	7	–	13200	✓	0.52	GI328	C0013
	66A06R-SMORC10-C	66	56	–	27	–	22	–	50	–	12.4	7	-1.4	-7	6	–	12800	✓	0.58	GI328	C0014
	66A07R-SMORC10-C	66	56	–	27	–	22	–	50	–	12.4	7	-1.4	-7	7	–	12800	✓	0.60	GI328	C0014

GI328	RCMT 10T3M0..

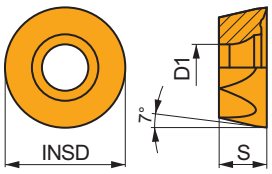
		Nm				
C0010	US 63509-T10P	3.0	M 3.5	9	Flag T10P	–
C0012	US 63509-T10P	3.0	M 3.5	9	Flag T10P	HS 0830C

		Nm				
C0013	US 63509-T10P	3.0	M 3.5	9	Flag T10P	HS 1030C
C0014	US 63509-T10P	3.0	M 3.5	9	Flag T10P	HS 1230C

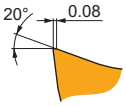
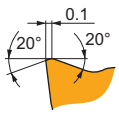
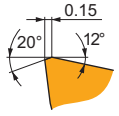
RCMT 10

PRAMET

	INSD (mm)	D1 (mm)	S (mm)
10T3	10.000	3.90	3.97

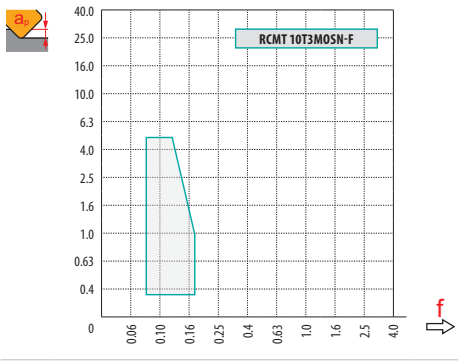


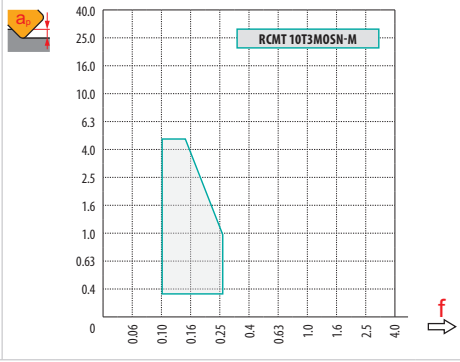
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

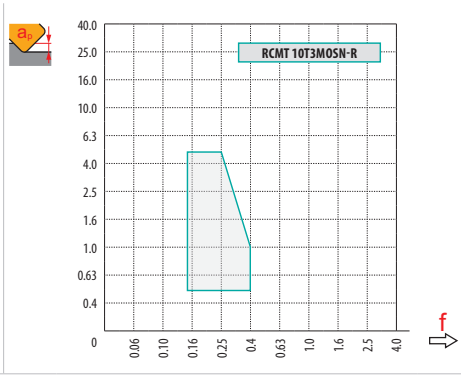
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
F geometri med meget positivt design til let bearbejdning.																			
RCMT 10T3MOSN-F:M6330	–	340	0.10	1.0	240	0.09	1.0	–	–	–	–	–	–	100	0.08	0.8	–	–	–
RCMT 10T3MOSN-F:M8330	–	395	0.10	1.0	235	0.09	1.0	–	–	–	–	–	–	95	0.08	0.8	–	–	–
																			
M geometri med meget positivt design til medium bearbejdning.																			
RCMT 10T3MOSN-M:M6330	–	310	0.12	1.0	220	0.11	1.0	–	–	–	–	–	–	90	0.11	0.8	–	–	–
RCMT 10T3MOSN-M:M8310	–	400	0.12	1.0	200	0.11	1.0	380	0.12	1.0	–	–	–	–	–	–	–	–	–
RCMT 10T3MOSN-M:M8330	–	360	0.12	1.0	215	0.11	1.0	340	0.12	1.0	–	–	–	90	0.11	0.8	–	–	–
RCMT 10T3MOSN-M:M8340	–	330	0.12	1.0	195	0.11	1.0	310	0.12	1.0	–	–	–	80	0.11	0.8	–	–	–
																			
R geometri med positivt design til grovkopibearbejdning.																			
RCMT 10T3MOSN-R:M8310	–	345	0.17	1.0	–	–	–	325	0.17	1.0	–	–	–	–	–	–	65	0.12	0.7
RCMT 10T3MOSN-R:M8330	–	310	0.17	1.0	–	–	–	290	0.17	1.0	–	–	–	75	0.17	0.8	60	0.12	0.7

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RCMT 10-F	RCMT 10-M	RCMT 10-R
RE	5.0	5.0	5.0
BS	–	–	–







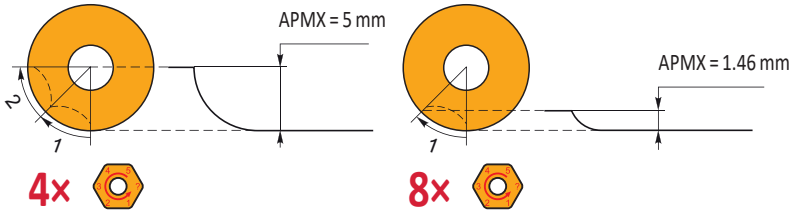
DCX	a_p	0.00	0.15	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00
25		15.00	17.43	18.41	19.36	20.27	21.00	21.61	22.14	23.00	23.66	24.17	24.80	25.00
32		22.00	24.43	25.41	26.36	27.27	28.00	28.61	29.14	30.00	30.66	31.17	31.80	32.00
35		25.00	27.43	28.41	29.36	30.27	31.00	31.61	32.14	33.00	33.66	34.17	34.80	35.00
40	DEF	30.00	32.43	33.41	34.36	35.27	36.00	36.61	37.14	38.00	38.66	39.17	39.80	40.00
50		40.00	42.43	43.41	44.36	45.27	46.00	46.61	47.14	48.00	48.66	49.17	49.80	50.00
52		42.00	44.43	45.41	46.36	47.27	48.00	48.61	49.14	50.00	50.66	51.17	51.80	52.00
63		53.00	55.43	56.41	57.36	58.27	59.00	59.61	60.14	61.00	61.66	62.17	62.80	63.00
66		56.00	58.43	59.41	60.36	61.27	62.00	62.61	63.14	64.00	64.66	65.17	65.80	66.00
	a_p	–	0.15	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00
	f	–	0.90	0.64	0.50	0.41	0.35	0.32	0.29	0.25	0.23	0.21	0.19	0.17

DCX	RPMX	APMX/I
25	13.2	5/23
32	12.6	5/24
35	12.3	5/24
40	9.5	5/31
50	6.4	5/46
52	6.1	5/48
63	4.7	5/62
66	4.4	5/66

DCX	DMIN	DMAX	SMAX / DMIN	SMAX / DMAX
25	32.0	50.0	3.0	3.0
32	45.0	64.0	3.0	3.0
35	51.0	70.0	3.0	3.0
40	61.0	80.0	3.0	3.0
50	81.0	100.0	3.0	3.0
52	85.0	104.0	3.0	3.0
63	107.0	126.0	3.0	3.0
66	113.0	132.0	3.0	3.0

a_p
2.24

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
25	FE	0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
35		0.648	0.837	1.183	1.449	1.673	2.049	2.366	2.646	2.898	3.347	3.742
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
RE	µm	3	5	10	15	20	30	40	50	60	80	100
5.0	FE	0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000



SRC12

P M K S H

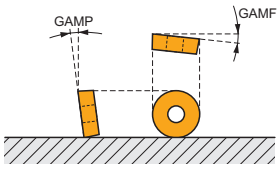
PRAMET

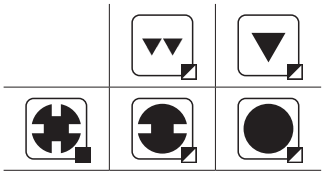
S

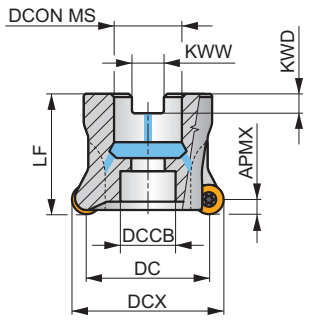
Kopi Fræser til runde skær RCMT 12 med intern kølevæske

Fræser til mediumfræsning ved hjælp af positive RCMT 12 skær med APMX på 6 mm. Intern kølevæske. Velegnet til plan, spiralformet interpolation, ramping, progressiv lomme og high feed fræsning. Fås kun i dorn type. Krop behandlet for længere værktøjslevetid.

APMX	6.0 mm







h_m 0.1 - 0.2

	Product	DCX (mm)	DC (mm)	DCON MS (mm)	DCCB (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	**40A03R-SMORC12-C**	40	28	16	12	40	8.4	5.6	-2.1	-7	3	–	14800	✓	0.27	GI279	C0022	–
	50A04R-SMORC12-C	50	38	22	18	40	10.4	6.3	-2	-7	4	–	13200	✓	0.36	GI279	C0023	–
	52A05R-SMORC12-C	52	40	22	18	40	10.4	6.3	-2	-7	5	–	12900	✓	0.15	GI279	C0023	–
	63A05R-SMORC12-C	63	51	22	30	40	10.4	6.3	-2	-7	5	–	11800	✓	0.45	GI279	C0023	–
	66A06R-SMORC12-C	66	54	27	22	50	12.4	7	-1.5	-7	6	–	11400	✓	0.65	GI279	C0024	–
	80A05R-SMORC12-C	80	68	27	37	50	12.4	7	-1.7	-7	5	–	10400	✓	1.08	GI279	C0024	–
	100A06R-SMORC12-C	100	88	32	45	50	14.4	8	-1.8	-7	6	–	9300	✓	1.78	GI279	C0021	AC002

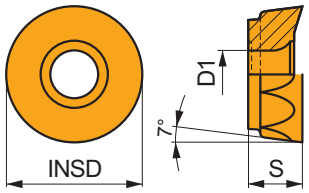
GI279	RCMT 1204M0..

		Nm					
C0021	US 63509-T15P	3.0	M 3.5	10	D-T08P/T15P	FG-15	–
C0022	US 63509-T15P	3.0	M 3.5	10	D-T08P/T15P	FG-15	HS 90835
C0023	US 63509-T15P	3.0	M 3.5	10	D-T08P/T15P	FG-15	HS 1030C
C0024	US 63509-T15P	3.0	M 3.5	10	D-T08P/T15P	FG-15	HS 1230C

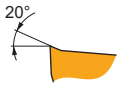
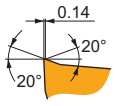
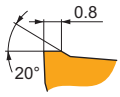
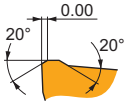
AC002	KS 1635	K.FMH32

RCMT 12

	INSD	D1	S
	(mm)	(mm)	(mm)
1204	12.000	4.40	4.76

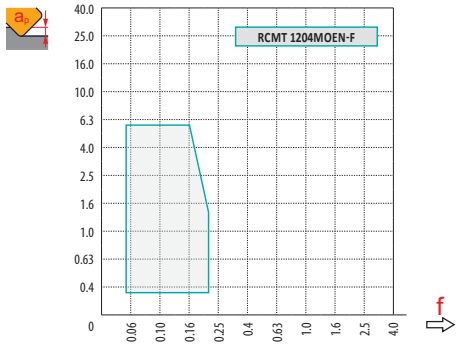


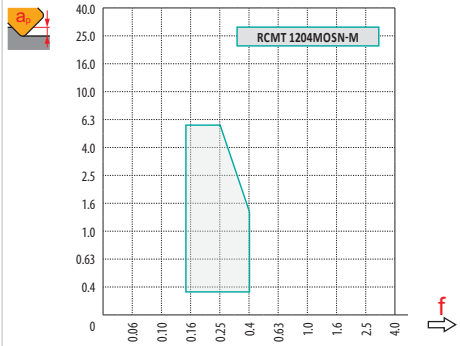
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

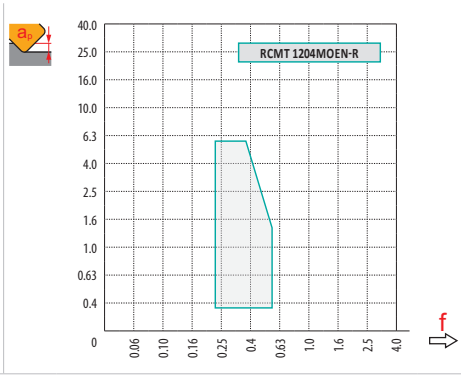
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
			**F** geometri med meget positivt design til let bearbejdning.																	
RCMT 1204MOEN-F:M8310		–	■ 420	0.10	1.5	◪ 210	0.09	1.5	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 1204MOEN-F:M8330		–	■ 380	0.10	1.5	■ 225	0.09	1.5	–	–	–	–	–	–	◪ 95	0.07	1.2	–	–	–
			**M** geometri med meget positivt design til medium bearbejdning.																	
RCMT 1204MOSN-M:M6330		–	■ 265	0.20	1.5	◪ 185	0.18	1.5	–	–	–	–	–	–	■ 75	0.16	1.2	–	–	–
RCMT 1204MOSN-M:M8310		–	■ 335	0.20	1.5	◪ 170	0.18	1.5	■ 315	0.20	1.5	–	–	–	–	–	–	–	–	–
RCMT 1204MOSN-M:M8330		–	■ 305	0.20	1.5	◪ 180	0.18	1.5	■ 285	0.20	1.5	–	–	–	◪ 75	0.16	1.2	–	–	–
RCMT 1204MOSN-M:M8345		–	■ 225	0.20	1.5	◪ 135	0.18	1.5	–	–	–	–	–	–	■ 55	0.16	1.2	–	–	–
RCMT 1204MOSN-M:M9325		–	■ 380	0.20	1.5	–	–	–	■ 360	0.20	1.5	–	–	–	–	–	–	–	–	–
RCMT 1204MOSN-M:M9340		–	■ 345	0.20	1.5	◪ 205	0.18	1.5	–	–	–	–	–	–	■ 85	0.16	1.2	–	–	–
			**EN-R** geometri med positivt design til grov kopibearbejdning.																	
RCMT 1204MOEN-R:M8310		–	■ 280	0.30	1.5	◪ 140	0.27	1.5	■ 265	0.30	1.5	–	–	–	–	–	–	■ 55	0.15	0.8
RCMT 1204MOEN-R:M8330		–	■ 260	0.30	1.5	◪ 155	0.27	1.5	■ 245	0.30	1.5	–	–	–	◪ 65	0.24	1.2	◪ 50	0.15	0.8
			**SN-R** geometri med positivt design til grov kopimaskiner.																	
RCMT 1204MOSN-R:M8345		–	■ 190	0.35	1.5	–	–	–	–	–	–	–	–	–	◪ 45	0.25	1.2	–	–	–
RCMT 1204MOSN-R:M9315		–	■ 315	0.35	1.5	–	–	–	■ 295	0.35	1.5	–	–	–	–	–	–	◪ 60	0.18	0.8

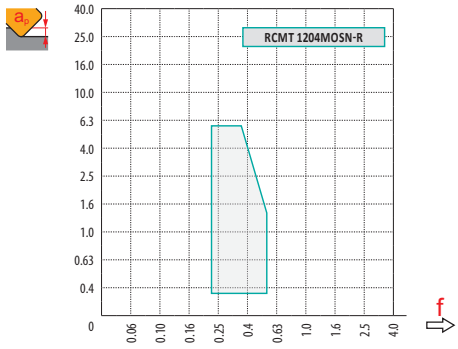
a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RCMT 12-F	RCMT 12-M	RCMT 12 EN-R	RCMT 12 SN-R
RE	6.0	6.0	6.0	6.0
BS	–	–	–	–









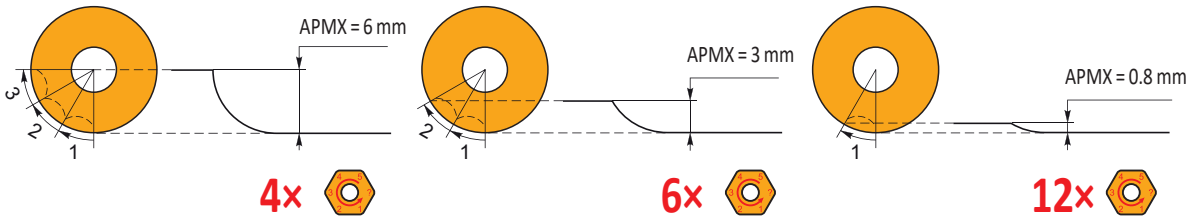
DCX	a_p	0.00	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00
40		28.0	31.7	32.8	33.8	34.6	35.3	35.9	36.9	37.7	38.4	39.3	39.8	40.0
50		38.0	41.7	42.8	43.8	44.6	45.3	45.9	46.9	47.7	48.4	49.3	49.8	50.0
52		40.0	43.7	44.8	45.8	46.6	47.3	47.9	48.9	49.7	50.4	51.3	51.8	52.0
63	DEF	51.0	54.7	55.8	56.8	57.6	58.3	58.9	59.9	60.7	61.4	62.3	62.8	63.0
66		54.0	57.7	58.8	59.8	60.6	61.3	61.9	62.9	63.7	64.4	65.3	65.8	66.0
80		68.0	71.7	72.8	73.8	74.6	75.3	75.9	76.9	77.7	78.4	79.3	79.8	80.0
100		88.0	91.7	92.8	93.8	94.6	95.3	95.9	96.9	97.7	98.4	99.3	99.8	100.0
	a_p	–	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00
	f	–	0.95	0.74	0.61	0.53	0.47	0.43	0.38	0.34	0.31	0.28	0.25	0.24

DC	RPMX	APMX/l
40	9.0	6.0/39
50	7.0	6.0/50
52	6.5	6.0/53
63	5.0	6.0/70
66	4.5	6.0/76
80	3.0	5.1/100
100	2.0	3.3/100

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
40	56.0	80.0	6.0	6.0
50	76.0	100.0	6.0	6.0
52	80.0	104.0	6.0	6.0
63	102.0	126.0	6.0	6.0
66	108.0	132.0	6.0	6.0
80	136.0	160.0	6.0	6.0
100	176.0	200.0	6.0	6.0

a_p
3.5

DC	µm	3	5	10	15	20	30	40	50	60	80	100
40	FE	0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
RE	µm	3	5	10	15	20	30	40	50	60	80	100
6.0	FE	0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191



SRC16

P M K S H

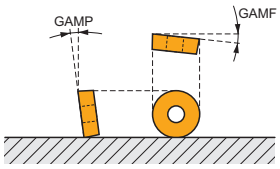
PRAMET

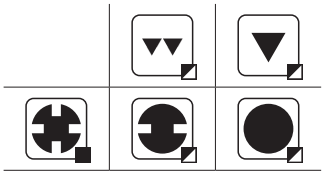
S

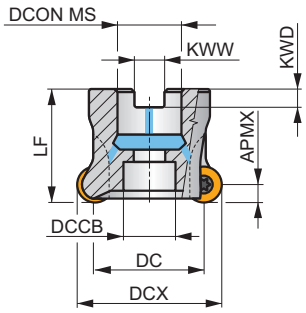
Kopi Fræser til runde skær RCMT 16 med intern kølevæske

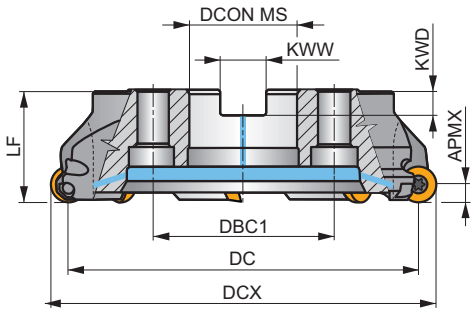
Fræser til medium til kraftig kopifræsning ved hjælp af positive RCMT 16 skær med APMX på 8 mm. Intern kølevæske. Velegnet til plan, spiralformet interpolation, ramping, progressiv lomme og high feed fræsning. Fås i dorn type. Krop behandlet for længere værktøjslevetid.

APMX	8.0 mm









h_m 0.1 - 0.25

	Product	DCX (mm)	DC (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
	63A04R-SMORC16-C	63	47	22	18	–	50	10.4	6.3	-2.6	-7	4	–	9700	✓	0.60	GI280	C0033	–
	66A05R-SMORC16-C	66	50	27	22	–	50	12.4	7	-2.5	-7	5	–	9200	✓	0.59	GI280	C0030	–
ISO 6462 DIN 8030	**80A05R-SMORC16-C**	80	64	27	37	–	50	12.4	7	-1.7	-7	5	–	8600	✓	0.87	GI280	C0030	–
	100A06R-SMORC16-C	100	84	32	45	–	50	14.4	8	-1.7	-7	6	–	7700	✓	1.27	GI280	C0031	AC002
	125A07R-SMORC16-C	125	109	40	36	–	63	16.4	9	-1.2	-7	7	–	6500	✓	3.03	GI280	C0032	–
	160C08R-SMORC16-C	160	144	40	–	66.7	63	16.4	9	-0.9	-7	8	–	5400	✓	5.63	GI280	C0034	–

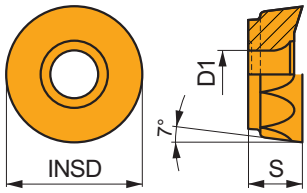
GI280	RCMT 1606M0..

		Nm							
C0030	US 65014-T20P	5.0	M 5	14	SDR T20P-T	HS 1230C	–	–	–
C0031	US 65014-T20P	5.0	M 5	14	SDR T20P-T	–	–	–	–
C0032	US 65014-T20P	5.0	M 5	14	SDR T20P-T	HSD 2040	–	–	–
C0033	US 65014-T20P	5.0	M 5	14	SDR T20P-T	HS 1030C	–	–	–
C0034	US 65014-T20P	5.0	M 5	14	SDR T20P-T	HS 1240C	CAC 160C	HSD 0825C	HXK 5

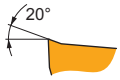
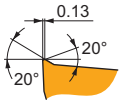
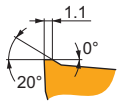
AC002	KS 1635	K.FMH32

RCMT 16

	INSD	D1	S
	(mm)	(mm)	(mm)
1606	16.000	5.50	6.35

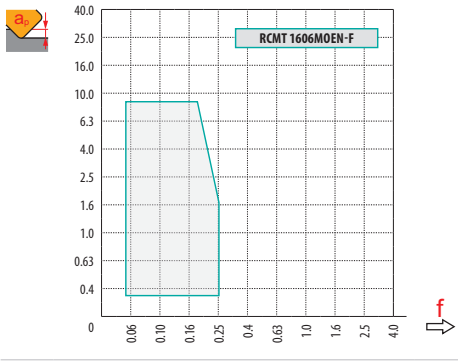


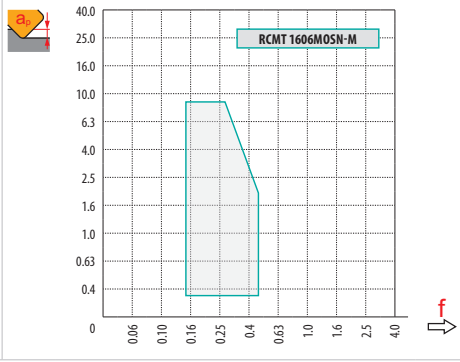
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

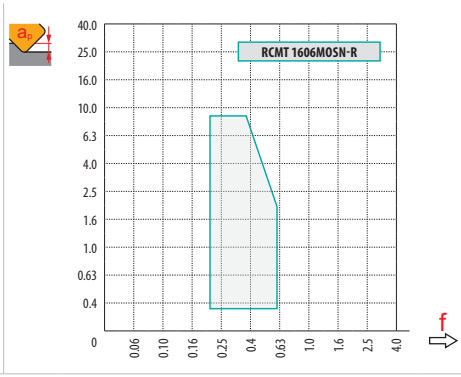
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				
F geometri med meget positivt design til let bearbejdning.																				
RCMT 1606MOEN-F:M8310		–	410	0.10	2.0	205	0.09	2.0	–	–	–	–	–	–	–	–	–	–	–	–
RCMT 1606MOEN-F:M8330		–	370	0.10	2.0	220	0.09	2.0	–	–	–	–	–	–	90	0.07	1.6	–	–	–
																				
M geometri med meget positivt design til medium bearbejdning.																				
RCMT 1606MOSN-M:M6330		–	255	0.20	2.0	180	0.18	2.0	–	–	–	–	–	–	75	0.16	1.6	–	–	–
RCMT 1606MOSN-M:M8330		–	300	0.20	2.0	180	0.18	2.0	285	0.20	2.0	–	–	–	75	0.16	1.6	–	–	–
RCMT 1606MOSN-M:M8345		–	215	0.20	2.0	125	0.18	2.0	–	–	–	–	–	–	50	0.16	1.6	–	–	–
RCMT 1606MOSN-M:M9325		–	370	0.20	2.0	–	–	–	350	0.20	2.0	–	–	–	–	–	–	–	–	–
RCMT 1606MOSN-M:M9340		–	335	0.20	2.0	200	0.18	2.0	–	–	–	–	–	–	80	0.16	1.6	–	–	–
																				
R geometri med positivt design til grovkopibearbejdning.																				
RCMT 1606MOSN-R:M8310		–	250	0.40	2.0	–	–	–	235	0.40	2.0	–	–	–	–	–	–	50	0.20	1.1
RCMT 1606MOSN-R:M8330		–	240	0.40	2.0	–	–	–	225	0.40	2.0	–	–	–	60	0.28	1.6	45	0.20	1.1
RCMT 1606MOSN-R:M8345		–	175	0.40	2.0	–	–	–	–	–	–	–	–	–	40	0.28	1.6	–	–	–

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RCMT 16-F	RCMT 16-M	RCMT 16-R
RE	8.0	8.0	8.0
BS	–	–	–







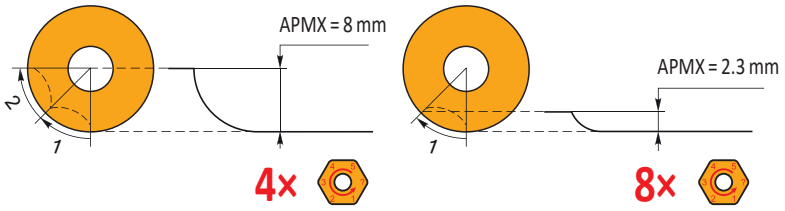
DCX	a_p	0.00	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00	7.00	8.00
63		47.0	51.3	52.6	53.8	54.7	55.6	56.3	57.6	58.6	59.5	60.9	61.8	62.5	62.9	63.0
66		50.0	54.3	55.6	56.8	57.8	58.6	59.3	60.6	61.6	62.5	63.9	64.8	65.5	65.9	66.0
80	DEF	64.0	68.3	69.6	70.8	71.7	72.6	73.3	74.6	75.6	76.5	77.9	78.8	79.5	79.9	80.0
100		84.0	88.3	89.6	90.8	91.7	92.6	93.3	94.6	95.6	96.5	97.9	98.8	99.5	99.9	100.0
125		109.0	113.3	114.6	115.8	116.7	117.6	118.3	119.6	120.6	121.5	122.9	123.8	124.5	124.9	125.0
160		144.0	148.3	149.6	150.8	151.7	152.6	153.3	154.6	155.6	156.5	157.9	158.8	159.5	159.9	160.0
	a_p	–	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00	7.00	8.00
	f	–	1.10	0.85	0.70	0.61	0.54	0.50	0.43	0.39	0.36	0.31	0.28	0.26	0.25	0.24

DC	RPMX	APMX/I
63	7.0	8.0/67
66	6.5	8.0/71
80	5.0	8.0/93
100	4.0	6.8/100

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
63	94.0	126.0	8.0	8.0
66	100.0	132.0	8.0	8.0
80	128.0	160.0	8.0	8.0
100	168.0	200.0	8.0	8.0

a_p
5.0

DC	µm	3	5	10	15	20	30	40	50	60	80	100
63	FE	0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
125		1.225	1.581	2.236	2.739	3.162	3.873	4.472	5.000	5.477	6.325	7.071
160		1.386	1.789	2.530	3.098	3.578	4.382	5.060	5.657	6.197	7.155	8.000
RE	**µm**	**3**	**5**	**10**	**15**	**20**	**30**	**40**	**50**	**60**	**80**	**100**
8.0	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530



SRC20

P M K S H

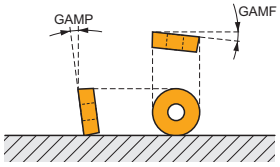
PRAMET

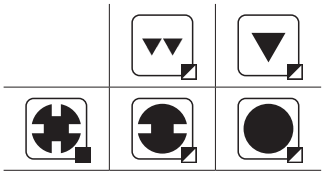
S

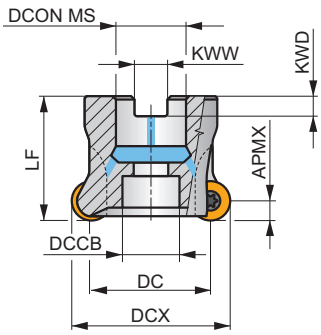
Kopi Fræser til runde skær RCMT 20 med intern kølevæske

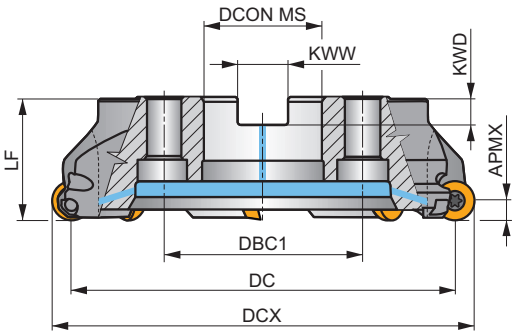
Fræser til kraftig kopifræsning ved hjælp af positive RCMT 20 skær med APMX på 10 mm. Intern kølevæske. Velegnet til plan, spiralformet interpolation, ramping, progressiv lomme og højfræsning. Fås i dorn type. Krop behandlet for længere værktøjslevetid.

APMX	10.0 mm









h_m 0.11 - 0.32

	Product	DCX (mm)	DC (mm)	DCON MS (mm)	DCCB (mm)	DBC1 (mm)	LF (mm)	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	**80A04R-SMORC20-C**	80	60	27	28	–	50	12.4	7	-2.7	-7	4	–	8500	✓	0.91	GI281	C0040	–
	100A05R-SMORC20-C	100	80	32	45	–	50	14.4	8	-1.7	-7	5	–	7600	✓	1.20	GI281	C0041	AC002
	125A06R-SMORC20-C	125	105	40	36	–	63	16.4	9	-1	-7	6	–	6500	✓	2.92	GI281	C0042	–
	160C07R-SMORC20-C	160	140	40	–	66.7	63	16.4	9	-0.9	-7	7	–	5400	✓	5.37	GI281	C0046	–

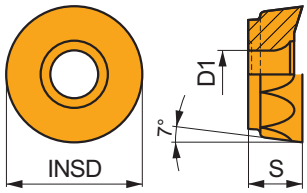
GI281	RCMT 2006M0..

		Nm							
C0040	US 66015-T25P	7.5	M 6	15	SDR T25P-T	HS 1230C	–	–	–
C0041	US 66015-T25P	7.5	M 6	15	SDR T25P-T	–	–	–	–
C0042	US 66015-T25P	7.5	M 6	15	SDR T25P-T	HSD 2040	–	–	–
C0046	US 66015-T25P	7.5	M 6	15	SDR T25P-T	HS 1240C	CAC 160C	HSD 0825C	HXK 5

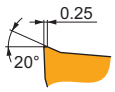
AC002	KS 1635	K.FMH32

RCMT 20

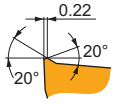
	INSD	D1	S
	(mm)	(mm)	(mm)
2006	20.000	6.50	6.35



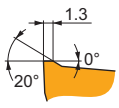
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				
RCMT 2006M0SN-F:M8330		–	■	320	0.15	3.0	◪	190	0.14	3.0		–	–	–		–	–	–	◪	80	0.11	2.4		–	–	–

F geometri med meget positivt design til let bearbejdning.

																				
RCMT 2006M0SN-M:M6330		–	■	225	0.30	3.0	◪	155	0.27	3.0		–	–	–		–	–	–	■	65	0.21	2.4		–	–	–
RCMT 2006M0SN-M:M8330		–	■	255	0.30	3.0	◪	150	0.27	3.0	■	240	0.30	3.0		–	–	–	◪	60	0.21	2.4		–	–	–
RCMT 2006M0SN-M:M8345		–	■	190	0.30	3.0	◪	110	0.27	3.0		–	–	–		–	–	–	■	45	0.21	2.4		–	–	–
RCMT 2006M0SN-M:M9315		–	■	330	0.30	3.0		–	–	–	■	310	0.30	3.0		–	–	–		–	–	–		–	–	–
RCMT 2006M0SN-M:M9325		–	■	315	0.30	3.0		–	–	–	■	295	0.30	3.0		–	–	–		–	–	–		–	–	–
RCMT 2006M0SN-M:M9340		–	■	275	0.30	3.0	◪	165	0.27	3.0		–	–	–		–	–	–	■	65	0.21	2.4		–	–	–

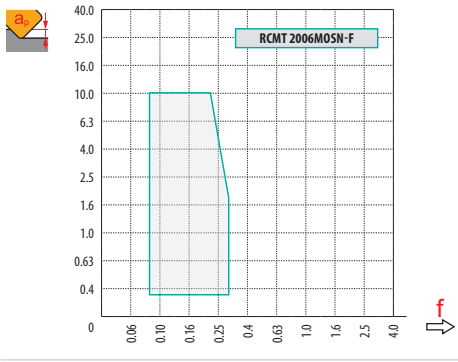
M geometri med meget positivt design til medium bearbejdning.

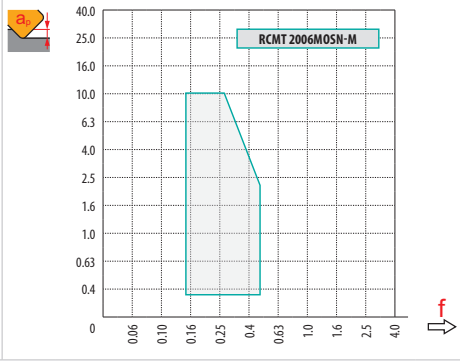
																				
RCMT 2006M0SN-R:M8330		–	■	225	0.45	3.0		–	–	–	■	210	0.45	3.0		–	–	–	◪	55	0.32	2.4	◪	45	0.23	1.3
RCMT 2006M0SN-R:M8345		–	■	165	0.45	3.0		–	–	–		–	–	–		–	–	–	◪	40	0.32	2.4		–	–	–
RCMT 2006M0SN-R:M9325		–	■	260	0.45	3.0		–	–	–	■	245	0.45	3.0		–	–	–		–	–	–	◪	50	0.23	1.3

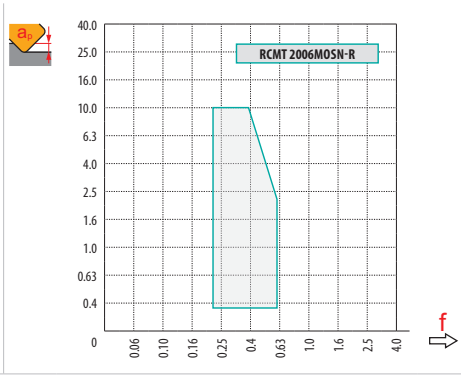
R geometri med positivt design til grovkopibearbejdning.

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	RCMT 20-F	RCMT 20-M	RCMT 20-R
RE	10.0	10.0	10.0
BS	–	–	–







DCX	a_p	0.00	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00	7.00	8.00	9.00	10.00
80	DEF	60.0	64.9	66.2	67.6	68.7	69.7	70.5	72.0	73.2	74.3	76.0	77.3	78.3	79.1	79.6	79.9	80.0
100		80.0	84.9	86.2	87.6	88.7	89.7	90.5	92.0	93.2	94.3	96.0	97.3	98.3	99.1	99.6	99.9	100.0
125		105.0	109.9	111.2	112.6	113.7	114.7	115.5	117.0	118.2	119.3	121.0	122.3	123.3	124.1	124.6	124.9	125.0
160		140.0	144.9	146.2	147.6	148.7	149.7	150.5	152.0	153.2	154.3	156.0	157.3	158.3	159.1	159.6	159.9	160.0
	a_p	–	0.30	0.50	0.75	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00	7.00	8.00	9.00	10.00
	f	–	1.23	0.95	0.78	0.68	0.61	0.55	0.48	0.43	0.40	0.35	0.31	0.29	0.27	0.26	0.25	0.24

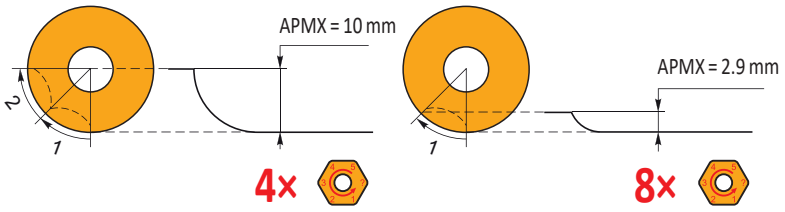
DCX	RPMX	APMX/I
80	7.0	10.0/83
100	5.0	8.6/100

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
80	120.0	160.0	10.0	10.0
100	160.0	200.0	10.0	10.0

a_p
6.0

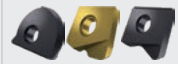
DCX	µm	3	5	10	15	20	30	40	50	60	80	100
80	FE	0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
125		1.225	1.581	2.236	2.739	3.162	3.873	4.472	5.000	5.477	6.325	7.071
160		1.386	1.789	2.530	3.098	3.578	4.382	5.060	5.657	6.197	7.155	8.000

RE	µm	3	5	10	15	20	30	40	50	60	80	100
10.0	FE	0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828



PROFILFRÆSNING

PROFILE MILLING – BALL NOSE

	L2-SZP	K2-SRC	K2-SLC	K2-PPH	K3-CXP
	–	–	90°	–	–
	APMX (mm) 8.9 – 44.7 DCX (mm) 10 – 50	APMX (mm) 0.6 – 3.2 DCX (mm) 8 – 32	APMX (mm) 1.0 – 3.0 DCX (mm) 12 – 20	APMX (mm) 0.3 – 4.0 DCX (mm) 8 – 32	APMX (mm) 8.0 – 16.0 DCX (mm) 16 – 32
Cylindrical shank	DCX = 10 – 32 (mm)	DCX = 8 – 32 (mm)		DCX = 8 – 32 (mm)	DCX = 16 – 32 (mm)
Weldon	DCX = 12 – 50 (mm)				DCX = 16 – 25 (mm)
Modular	DCX = 10 – 32 (mm)	DCX = 8 – 20 (mm)		DCX = 16, 20 (mm)	DCX = 16 – 25 (mm)
Morse	DCX = 12 – 32 (mm)				
Page	206	211	218	222	234
ISO	P M K S H	P M K H	P M K H	P M K S H	P M K S H
Insert shape					
Inserts	ZP	RC LC	LC	PPH PPHF PPHT	XP
No. of cutting edges	2	2	2	2	1
Fræsning af formflader (kopifræsning)	■	■	■	■	■
Spiralformet interpolation			◪	◪	
Progressiv neddykning			◪	◪	
Ramping			◪	◪	
Fasfræsning			◪	◪	

■ Primary use ◪ Possible use

L2-SZP

P M K S H

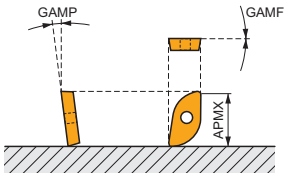
PRAMET

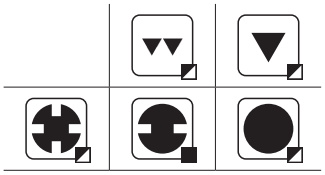
S

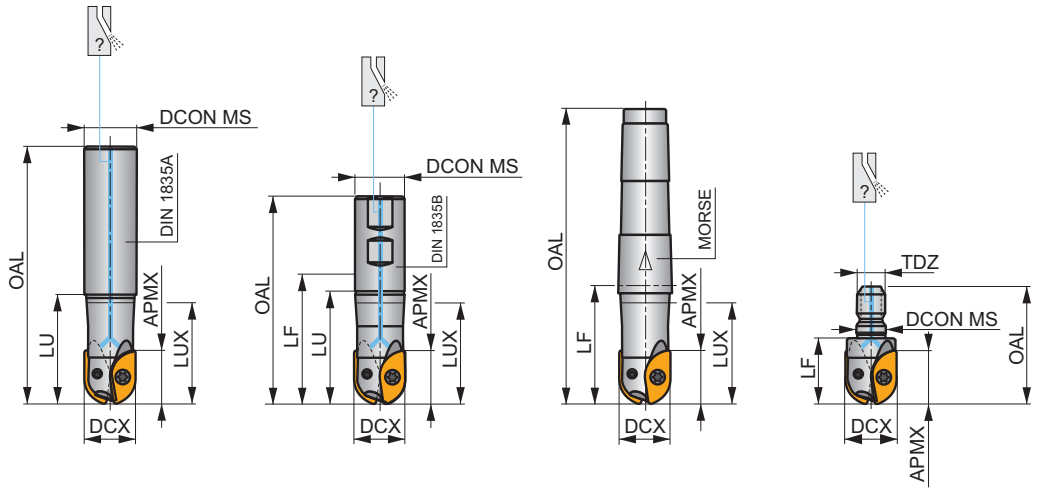
Kuglenæse Profilfræser til ZP .. skær

Kugleformet fræser med ZP .. skær med APMX fra 8.9 op til 44.7 mm. Velegnet til profilfræsning. Fås i cylindrisk, weldon, MK og dorn. Krop behandlet for længere værktøjslevetid.

APMX	8.9 - 44.7 mm







h_m	0.05 - 0.19

	Product	DCX (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	CZC MS	APMX (mm)	GAMF (°)	GAMP (°)			max.		kg		
	10L2R030A10-SZP10	10	130	10	30	30	–	–	–	8.90	0	-10	2	–	35800	–	0.11	GI255	C0510
	10L2R050A16-SZP10	10	160	16	50	22.3	–	–	–	8.90	0	-10	2	–	35800	–	0.24	GI255	C0510
	12L2R035A12-SZP12	12	140	12	35	35	–	–	–	10.70	0	-10	2	–	21000	–	0.15	GI253	C0510
	12L2R045A20-SZP12	12	200	20	–	22	–	–	–	10.70	0	-10	2	–	21000	–	0.48	GI253	C0511
	16L2R040A16-SZP16-C	16	160	16	40	40	–	–	–	14.40	0	-10	2	–	20000	✓	0.24	GI256	C0510
DIN 1835A	**16L2R045A20-SZP16-C**	16	200	20	–	29.4	–	–	–	14.40	0	-10	2	–	20000	✓	0.43	GI256	C0512
	20L2R050A20-SZP20-C	20	250	20	50	–	–	–	–	17.90	0	-10	2	–	24000	✓	0.54	GI254	C0513
	20L2R055A25-SZP20-C	20	200	25	–	36.1	–	–	–	17.90	0	-10	2	–	24000	✓	0.68	GI254	C0513
	25L2R060A25-SZP25-C	25	250	25	60	–	–	–	–	22.30	0	-10	2	–	24000	✓	0.85	GI257	C0514
	25L2R065A32-SZP25-C	25	250	32	–	43	–	–	–	22.30	0	-10	2	–	24000	✓	1.34	GI257	C0514
	32L2R070A32-SZP32-C	32	250	32	–	–	–	–	–	28.60	0	-10	2	–	18500	✓	1.43	GI258	C0515
	12L2R040B20-SZP12	12	91	20	40	21.5	66.5	–	–	10.70	0	-10	2	–	21000	–	0.19	GI253	C0511
	12L2R060B20-SZP12	12	111	20	60	23.8	86.5	–	–	10.70	0	-10	2	–	21000	–	0.22	GI253	C0511
	16L2R040B20-SZP16-C	16	91	20	40	28.3	66.5	–	–	14.40	0	-10	2	–	20000	✓	0.15	GI256	C0512
	16L2R060B20-SZP16-C	16	111	20	60	32.9	86.5	–	–	14.40	0	-10	2	–	20000	✓	0.21	GI256	C0512
	20L2R050B25-SZP20-C	20	107	25	50	35.1	75.5	–	–	17.90	0	-10	2	–	24000	✓	0.30	GI254	C0513
	20L2R070B25-SZP20-C	20	127	25	70	39.5	95.5	–	–	17.90	0	-10	2	–	24000	✓	0.36	GI254	C0513
DIN 1835B	**25L2R060B25-SZP25-C**	25	117	25	60	–	85.5	–	–	22.30	0	-10	2	–	24000	✓	0.36	GI257	C0514
	25L2R080B25-SZP25-C	25	137	25	80	–	105	–	–	22.30	0	-10	2	–	24000	✓	0.42	GI257	C0514
	32L2R070B32-SZP32-C	32	131	32	70	–	95.5	–	–	28.60	0	-10	2	–	18500	✓	0.72	GI258	C0515
	32L2R100B32-SZP32-C	32	161	32	100	–	125.5	–	–	28.60	0	-10	2	–	18500	✓	0.81	GI258	C0515
	40L2R070B32-SZP40-C	40	131	32	70	–	95.5	–	–	35.70	0	-10	2	–	8000	✓	0.81	GI259	C0516
	40L2R100B40-SZP40-C	40	171	40	100	–	131	–	–	35.70	0	-10	2	–	8000	✓	1.40	GI259	C0516
	50L2R100B50-SZP50-C	50	181	50	100	–	136.5	–	–	44.70	0	-10	2	–	7000	✓	2.25	GI260	C0517
	12L2R060E02-SZP12	12	124	–	–	25.8	60	–	2	10.70	0	-10	2	–	21000	–	0.17	GI253	C0511
DIN 228A	**12L2R090E02-SZP12**	12	154	–	–	25.8	90	–	2	10.70	0	-10	2	–	21000	–	0.23	GI253	C0511
	16L2R060E02-SZP16	16	124	–	–	42.2	60	–	2	14.40	0	-10	2	–	20000	–	0.19	GI256	C0512

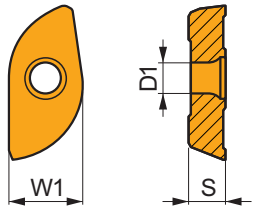
	Product	DCX (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	CZC MS	APMX (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 228A	**16L2R090E02-SZP16**	16	154	–	–	75.9	90	–	2	14.40	0	-10	2	–	20000	–	0.23	GI256	C0512
	20L2R070E03-SZP20	20	151	–	–	–	70	–	3	17.90	0	-10	2	–	24000	–	0.37	GI254	C0513
	20L2R100E03-SZP20	20	181	–	–	77.4	100	–	3	17.90	0	-10	2	–	24000	–	0.42	GI254	C0513
	25L2R080E03-SZP25	25	161	–	–	–	80	–	3	22.30	0	-10	2	–	24000	–	0.44	GI257	C0514
	25L2R110E04-SZP25	25	213	–	–	92.7	110	–	4	22.30	0	-10	2	–	24000	–	0.83	GI257	C0514
	32L2R100E04-SZP32	32	203	–	–	–	100	–	4	28.60	0	-10	2	–	18500	–	0.90	GI258	C0515
	32L2R150E04-SZP32	32	253	–	–	–	150	–	4	28.60	0	-10	2	–	18500	–	1.10	GI258	C0515
MODULAR	**10L2R025M08-SZP10**	10	–	8.5	–	–	25	M8	–	8.90	0	-10	2	–	–	–	0.03	GI255	C0510
	12L2R025M06-SZP12	12	–	6.5	–	–	25	M6	–	10.70	0	-10	2	–	–	–	0.05	GI253	C0510
	12L2R025M08-SZP12	12	–	8.5	–	–	25	M8	–	10.70	0	-10	2	–	–	–	0.04	GI253	C0511
	16L2R025M08-SZP16	16	–	8.5	–	–	25	M8	–	14.40	0	-10	2	–	–	–	0.05	GI256	C0512
	20L2R030M10-SZP20-C	20	–	10.5	–	–	30	M10	–	17.90	0	-10	2	–	–	✓	0.07	GI254	C0513
	25L2R035M12-SZP25-C	25	–	12.5	–	–	35	M12	–	22.30	0	-10	2	–	–	✓	0.09	GI257	C0514
	32L2R045M16-SZP32-C	32	–	17	–	–	45	M16	–	27.90	0	-10	2	–	–	✓	0.15	GI258	C0515

GI253	ZP 12..
GI254	ZP 20..
GI255	ZP 10..
GI256	ZP 16..
GI257	ZP 25..
GI258	ZP 32..
GI259	ZP 40..
GI260	ZP 50..

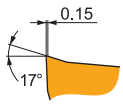
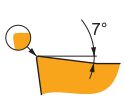
					Nm			
C0510	–	–	Flag T06P	US 62004-T06P	0.6	M 2	4	–
C0511	–	–	Flag T08P	US 62506-T08P	1.2	M 2.5	6	–
C0512	–	–	Flag T08P	US 62508-T08P	1.2	M 2.5	7	–
C0513	–	–	Flag T10P	US 63510-T10P	2.0	M 3.5	9	–
C0514	–	–	Flag T15P	US 4011A-T15P	3.5	M 4	11	–
C0515	–	–	–	US 65013-T20	5.0	M 5	13	SDR T20
C0516	–	–	–	US 66015-T25P	7.5	M 6	15	SDR T25P
C0517	SZN 400322	US 3508-T15P	Flag T15P	US 68020-T30P	15.0	M 8	20	SDR T30P

ZP

	W1 (mm)	D1 (mm)	S (mm)
10	10.000	2.20	1.70
12	12.000	2.90	2.38
16	16.000	2.90	3.18
20	20.000	4.00	3.97
25	25.000	4.70	4.76
32	32.000	5.90	6.35
40	40.000	7.00	7.94
50	50.000	9.60	7.94



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

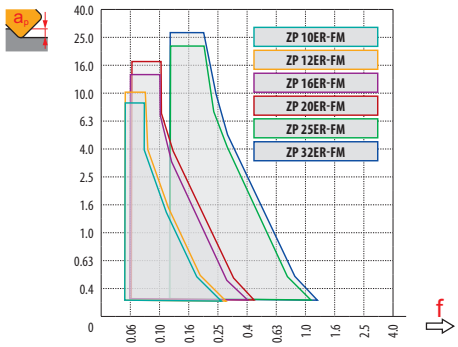
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
		FM geometri med skarpt neutralt design til let til medium bearbejdning.																	
ZP 10ER-FM:M8310	–	305	0.36	0.5	–	–	–	285	0.36	0.5	–	–	–	–	–	–	60	0.25	0.5
ZP 10ER-FM:M8345	–	210	0.36	0.5	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
ZP 12ER-FM:M8310	–	300	0.36	0.6	–	–	–	285	0.36	0.6	–	–	–	–	–	–	60	0.25	0.6
ZP 12ER-FM:M8345	–	205	0.36	0.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
ZP 16ER-FM:M8310	–	290	0.36	0.8	–	–	–	275	0.36	0.8	–	–	–	–	–	–	55	0.25	0.8
ZP 20ER-FM:M8310	–	285	0.36	1.0	–	–	–	270	0.36	1.0	–	–	–	–	–	–	55	0.25	1.0
ZP 25ER-FM:M8310	–	275	0.36	1.3	–	–	–	260	0.36	1.3	–	–	–	–	–	–	55	0.25	1.3
ZP 32ER-FM:M8310	–	270	0.36	1.6	–	–	–	255	0.36	1.6	–	–	–	–	–	–	50	0.25	1.6
		**M** geometri med meget positivt design til medium bearbejdning.																	
ZP 12ER-M:M8330	–	280	0.36	0.6	165	0.32	0.6	265	0.36	0.6	–	–	–	70	0.25	0.5	–	–	–
ZP 12ER-M:M8345	–	205	0.36	0.6	120	0.32	0.6	–	–	–	–	–	–	50	0.25	0.5	–	–	–
ZP 16ER-M:M8330	–	270	0.36	0.8	160	0.32	0.8	255	0.36	0.8	–	–	–	65	0.25	0.6	–	–	–
ZP 16ER-M:M8340	–	250	0.36	0.8	150	0.32	0.8	235	0.36	0.8	–	–	–	60	0.25	0.6	–	–	–
ZP 16ER-M:M8345	–	200	0.36	0.8	120	0.32	0.8	–	–	–	–	–	–	50	0.25	0.6	–	–	–
ZP 20ER-M:M8330	–	265	0.36	1.0	155	0.32	1.0	250	0.36	1.0	–	–	–	65	0.25	0.8	–	–	–
ZP 20ER-M:M8345	–	195	0.36	1.0	115	0.32	1.0	–	–	–	–	–	–	45	0.25	0.8	–	–	–
ZP 25ER-M:M8330	–	260	0.36	1.3	155	0.32	1.3	245	0.36	1.3	–	–	–	65	0.25	1.0	–	–	–
ZP 25ER-M:M8345	–	190	0.36	1.3	110	0.32	1.3	–	–	–	–	–	–	45	0.25	1.0	–	–	–
ZP 32ER-M:M8330	–	255	0.36	1.6	150	0.32	1.6	240	0.36	1.6	–	–	–	60	0.25	1.3	–	–	–
		**R** geometri med skarpt let positivt design til let til medium bearbejdning.																	
ZP 16ER-R:M8345	–	190	0.45	0.8	110	0.41	0.8	–	–	–	–	–	–	45	0.32	0.8	–	–	–
ZP 20ER-R:M8345	–	185	0.45	1.0	110	0.41	1.0	–	–	–	–	–	–	45	0.32	1.0	–	–	–
ZP 25ER-R:M8345	–	180	0.45	1.3	105	0.41	1.3	–	–	–	–	–	–	45	0.32	1.3	–	–	–
ZP 32ER-R:M8330	–	240	0.45	1.6	140	0.41	1.6	225	0.45	1.6	–	–	–	60	0.32	1.6	45	0.32	1.6
ZP 32ER-R:M8345	–	175	0.45	1.6	105	0.41	1.6	–	–	–	–	–	–	40	0.32	1.6	–	–	–
ZP 40ER-R:M8345	–	170	0.45	2.0	100	0.41	2.0	–	–	–	–	–	–	40	0.32	2.0	–	–	–
ZP 50ER-R:M8345	–	165	0.45	2.5	95	0.41	2.5	–	–	–	–	–	–	40	0.32	2.5	–	–	–

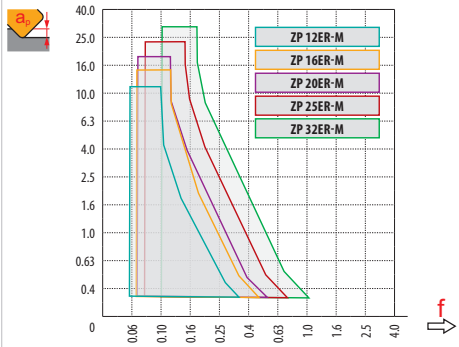
a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

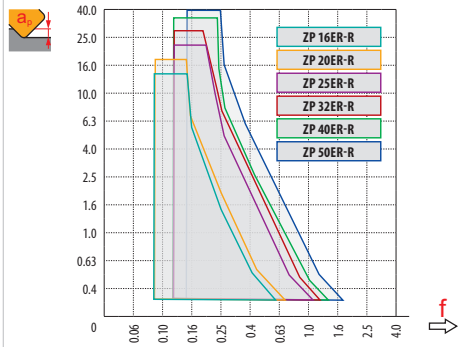
	ZP 10-FM	ZP 12-FM	ZP 16-FM	ZP 20-FM	ZP 25-FM	ZP 32-FM
RE	5.0	6.0	8.0	10.0	12.5	16.0
BS	–	–	–	–	–	–

	ZP 12-M	ZP 16-M	ZP 20-M	ZP 25-M	ZP 32-M
RE	6.0	8.0	10.0	12.5	16.0
BS	–	–	–	–	–

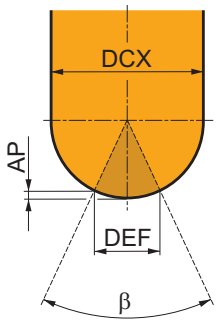
	ZP 16-R	ZP 20-R	ZP 25-R	ZP 32-R	ZP 40-R	ZP 50-R
RE	8.0	10.0	12.5	16.0	20.0	25.0
BS	–	–	–	–	–	–







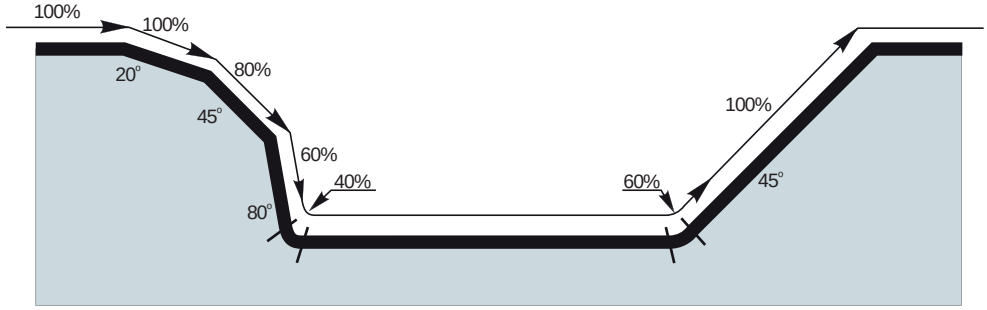
DCX	a_p	0.30	0.40	0.50	0.70	1.00	1.25	1.50	2.00	2.50	3.00	4.00	5.00	6.00	8.00	10.00	12.00	15.00	16.00	20.00	22.50	25.00
10		3.4	3.9	4.4	5.1	6.0	6.6	7.1	8.0	8.7	9.2	9.8	10.0	–	–	–	–	–	–	–	–	–
12		3.7	4.3	4.8	5.6	6.6	7.3	7.9	8.9	9.7	10.4	11.3	11.8	12.0	–	–	–	–	–	–	–	–
16		4.3	5.0	5.6	6.5	7.7	8.6	9.3	10.6	11.6	12.5	13.9	14.8	15.5	16.0	–	–	–	–	–	–	–
20	DEF	4.9	5.6	6.2	7.4	8.7	9.7	10.5	12.0	13.2	14.3	16.0	17.3	18.3	19.6	20.0	–	–	–	–	–	–
25		5.4	6.3	7.0	8.2	9.8	10.9	11.9	13.6	15.0	16.2	18.3	20.0	21.4	23.3	24.5	25.0	–	–	–	–	–
32		6.2	7.1	7.9	9.4	11.1	12.4	13.5	15.5	17.2	18.7	21.2	23.2	25.0	27.7	29.7	31.2	31.9	32.0	–	–	–
40		6.9	8.0	8.9	10.5	12.5	13.9	15.2	17.4	19.4	21.1	24.0	26.5	28.6	32.0	34.6	37.1	38.7	39.2	40.0	–	–
50		7.7	8.9	9.9	11.7	14.0	15.6	17.1	19.6	21.8	23.7	27.1	30.0	32.5	36.7	40.0	43.3	45.8	46.6	49.0	49.7	50.0



DCX		β	DEF	AP
10	FM	41°	3.496	0.322
12	FM	41°	4.194	0.381
16	FM	42°	5.660	0.520
20	FM	42°	7.100	0.650
25	FM	41°	8.756	0.794
35	FM	41°	11.113	0.998
40	R	41°	14.108	1.298
50	R	45°	19.176	1.915

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
10		0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
12		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
16	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25	FE	0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472

DEF	a_e	1 %	2.5 %	5 %	7.5 %	10 %	15 %	20 %	25 %	30 %	35 %	40 %	45 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	a_p										⇨ x.f									
19.9 %	1.0 %	2.86	1.84	1.33	1.12	1.00	0.89	–	–	–	–	–	–	–	–	–	–	–	–	–
31.2 %	2.5 %	3.58	2.28	1.64	1.36	1.20	1.01	0.92	0.88	0.91	–	–	–	–	–	–	–	–	–	–
43.6 %	5.0 %	4.22	2.68	1.92	1.58	1.39	1.16	1.03	0.95	0.90	0.88	0.89	–	–	–	–	–	–	–	–
52.7 %	7.5 %	4.63	2.95	2.10	1.73	1.51	1.26	1.11	1.02	0.96	0.91	0.89	0.88	0.90	–	–	–	–	–	–
60.0 %	10.0 %	4.94	3.14	2.24	1.84	1.61	1.33	1.18	1.07	1.00	0.95	0.91	0.89	0.88	1.00	–	–	–	–	–
71.4 %	15.0 %	5.39	3.42	2.43	2.00	1.74	1.44	1.27	1.15	1.07	1.01	0.96	0.93	0.90	0.88	0.93	–	–	–	–
80.0 %	20.0 %	5.70	3.62	2.57	2.11	1.84	1.52	1.33	1.21	1.12	1.05	1.00	0.96	0.93	0.89	0.88	0.89	1.00	–	–
86.6 %	25.0 %	5.93	3.76	2.67	2.20	1.91	1.58	1.38	1.25	1.16	1.08	1.03	0.99	0.95	0.90	0.88	0.88	0.89	–	–
91.7 %	30.0 %	6.10	3.87	2.75	2.26	1.96	1.62	1.42	1.28	1.18	1.11	1.05	1.01	0.97	0.92	0.89	0.88	0.88	0.93	–
95.4 %	35.0 %	6.23	3.95	2.80	2.30	2.00	1.65	1.44	1.31	1.20	1.13	1.07	1.02	0.98	0.93	0.89	0.88	0.88	0.90	–
98.0 %	40.0 %	6.31	4.00	2.84	2.33	2.03	1.67	1.46	1.32	1.22	1.14	1.08	1.03	0.99	0.93	0.90	0.89	0.88	0.89	–
99.5%	45.0 %	6.36	4.03	2.86	2.35	2.04	1.68	1.47	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	–
100.0 %	50.0 %	6.38	4.04	2.87	2.35	2.05	1.69	1.48	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	1.00



Overlapning (multipel af diameter *DCX*)	< 3.0	3.0 – 3.5	3.6 – 4.0	4.1 – 4.5	> 4.6
Multiplikationsfaktor for hastighed	1.0	0.9	0.8	0.7	0.5

K2-SRC

P M K H

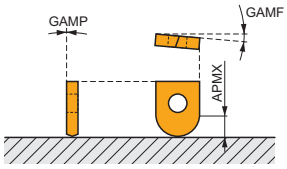
PRAMET

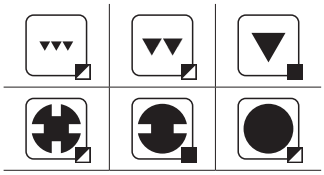
S

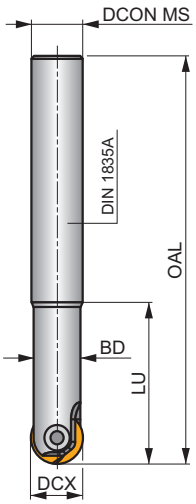
Kopi og profil Ende fræser

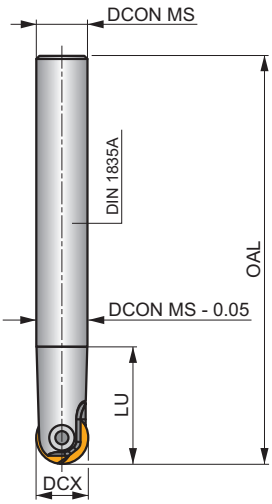
Fleksibel endefræser til en bred vifte af værktøjsfremstilling applikationer. En værktøjsløsning til kugle- og toroidal skær. Fås i cylindrisk og modulær stil. Krop behandlet for længere værktøjslevetid.

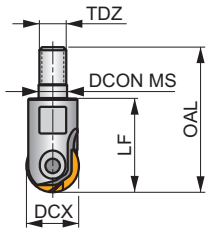
APMX	0.6 - 3.2 mm











h_m	0.07 - 0.14

	Product	DCX (mm)	OAL (mm)	DCON MS (mm)	BD (mm)	LU (mm)	LF (mm)	TDZ			max.		kg		
	08K2R025A10-SRC08-A	8	110	10	7.5	25	–	–	2	–	56000	–	0.08	GI030	C0530
	08K2R050A12-SRC08-A	8	140	12	–	13.5	–	–	2	–	56000	–	0.14	GI030	C0530
	10K2R030A12-SRC10-A	10	130	12	9	30	–	–	2	–	42000	–	0.16	GI031	C0531
	10K2R060A16-SRC10-A	10	150	16	–	19.5	–	–	2	–	42000	–	0.18	GI031	C0531
	12K2R030A12-SRC12-A	12	130	12	10.5	30	–	–	2	–	35000	–	0.11	GI032	C0532
DIN 1835A	**12K2R060A16-SRC12-A**	12	160	16	–	24.5	–	–	2	–	35000	–	0.14	GI032	C0532
DIN 1835A	**16K2R035A16-SRC16-A**	16	140	16	14	35	–	–	2	–	22000	–	0.23	GI033	C0533
DIN 1835A	**16K2R065A20-SRC16-A**	16	175	20	–	31.5	–	–	2	–	22000	–	0.30	GI033	C0533
DIN 1835A	**20K2R045A20-SRC20-A**	20	160	20	18	45	–	–	2	–	16000	–	0.40	GI034	C0534
DIN 1835A	**20K2R080A25-SRC20-A**	20	190	25	–	33.5	–	–	2	–	16000	–	0.66	GI034	C0534
DIN 1835A	**25K2R045A25-SRC25-A**	25	160	25	22.4	45	–	–	2	–	10000	–	0.59	GI035	C0535
DIN 1835A	**32K2R060A32-SRC32-A**	32	180	32	28.6	60	–	–	2	–	6000	–	1.10	GI036	C0536
	08K2R30M06-SRC08-A	8	45	6.5	–	–	30	M6	2	–	–	–	0.02	GI123	C0530
	10K2R30M06-SRC10-A	10	45	6.5	–	–	30	M6	2	–	–	–	0.03	GI124	C0531
MODULAR	**12K2R30M06-SRC12-A**	12	45	6.5	–	–	30	M6	2	–	–	–	0.15	GI125	C0530
MODULAR	**12K2R30M08-SRC12-A**	12	48	8.5	–	–	30	M8	2	–	–	–	0.04	GI125	C0532
MODULAR	**16K2R35M08-SRC16-A**	16	53	8.5	–	–	35	M8	2	–	–	–	0.16	GI033	C0533
MODULAR	**20K2R35M10-SRC20-A**	20	54	10.5	–	–	35	M10	2	–	–	–	0.08	GI034	C0534

GI030	RC 08	–	LC 08-KP	LC 08-KPF
GI031	RC 10	RC 10-F	LC 10-KP	LC 10-KPF
GI032	RC 12	RC 12-F	–	–
GI033	RC 16	RC 16-F	–	–
GI034	RC 20	–	–	–
GI035	RC 25	–	–	–

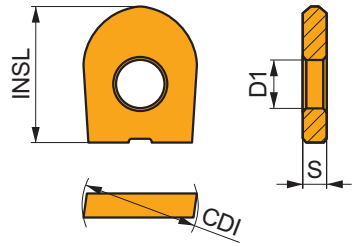
GI036	RC 32	–	–	–
GI123	RC 08	–	–	–
GI124	RC 10	RC 10-F	–	–
GI125	RC 12	RC 12-F	–	–

		Nm						
C0530	CS 3007-T08P	1.2	M 3	7	–	–	–	Flag T08P
C0531	CS 4008-T15P	3.0	M 4	8	–	D-T08P/T15P	FG-15	–
C0532	CS 5009-T20P	5.0	M 5	9	SDR T20P	–	–	–
C0533	CS 5013-T20P	5.0	M 5	13	SDR T20P	–	–	–
C0534	CS 5015-T20P	5.0	M 5	15	SDR T20P	–	–	–
C0535	CS 6020-T20P	7.5	M 6	20	SDR T20P	–	–	–
C0536	CS 8025-T30P	15.0	M 8	25	SDR T30P	–	–	–

RC

PRAMET

	CDI (mm)	D1 (mm)	INSL (mm)	S (mm)
08	8.0	3.00	9.5	2.00
10	10.0	4.00	11.5	2.50
12	12.0	5.00	12.0	2.50
16	16.0	5.00	14.0	3.00
20	20.0	5.00	16.0	3.00
25	25.0	6.00	21.5	4.00
32	32.0	8.00	25.8	5.00



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			U E																	
RC 08:M4310		–	255	0.36	0.4	–	–	–	240	0.36	0.4	–	–	–	–	–	–	50	0.18	0.8
RC 08:M8310		–	295	0.36	0.4	–	–	–	280	0.36	0.4	–	–	–	–	–	–	55	0.18	0.8
RC 10:M4310		–	250	0.36	0.5	–	–	–	235	0.36	0.5	–	–	–	–	–	–	50	0.18	1.0
RC 10:M8310		–	290	0.36	0.5	–	–	–	275	0.36	0.5	–	–	–	–	–	–	55	0.18	1.0
RC 10:M8330		–	270	0.36	0.5	–	–	–	255	0.36	0.5	–	–	–	–	–	–	50	0.18	1.0
RC 12:M4310		–	245	0.36	0.6	–	–	–	230	0.36	0.6	–	–	–	–	–	–	45	0.18	1.2
RC 12:M8310		–	285	0.36	0.6	–	–	–	270	0.36	0.6	–	–	–	–	–	–	55	0.18	1.2
RC 12:M8330		–	265	0.36	0.6	–	–	–	250	0.36	0.6	–	–	–	–	–	–	50	0.18	1.2
RC 16:M4310		–	235	0.36	0.8	–	–	–	220	0.36	0.8	–	–	–	–	–	–	45	0.18	1.1
RC 16:M8310		–	275	0.36	0.8	–	–	–	260	0.36	0.8	–	–	–	–	–	–	55	0.18	1.1
RC 16:M8330		–	255	0.36	0.8	–	–	–	240	0.36	0.8	–	–	–	–	–	–	50	0.18	1.1
RC 20:M4310		–	235	0.36	1.0	–	–	–	220	0.36	1.0	–	–	–	–	–	–	45	0.18	1.3
RC 20:M8310		–	270	0.36	1.0	–	–	–	255	0.36	1.0	–	–	–	–	–	–	50	0.18	1.3
RC 20:M8330		–	250	0.36	1.0	–	–	–	235	0.36	1.0	–	–	–	–	–	–	50	0.18	1.3
RC 25:M8310		–	260	0.36	1.3	–	–	–	245	0.36	1.3	–	–	–	–	–	–	50	0.18	1.7
RC 25:M8330		–	245	0.36	1.3	–	–	–	230	0.36	1.3	–	–	–	–	–	–	45	0.18	1.7
RC 32:M4310		–	220	0.36	1.6	–	–	–	205	0.36	1.6	–	–	–	–	–	–	40	0.18	2.1
RC 32:M8330		–	240	0.36	1.6	–	–	–	225	0.36	1.6	–	–	–	–	–	–	45	0.18	2.1

N neutralt skær med et positivt skærdesign.

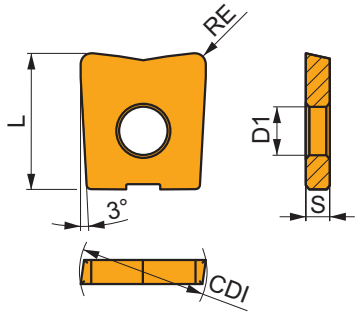
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

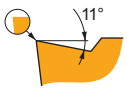
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
F																			
F geometri er skarp og velegnet til sletbearbejdning.																			
RC 10-F:M4310	–	250	0.36	0.5	125	0.32	0.5	235	0.36	0.5	–	–	–	–	–	–	50	0.18	1.0
RC 12-F:M4310	–	245	0.36	0.6	120	0.32	0.6	230	0.36	0.6	–	–	–	–	–	–	45	0.18	1.2
RC 16-F:M4310	–	235	0.36	0.8	115	0.32	0.8	220	0.36	0.8	–	–	–	–	–	–	45	0.18	1.1
RC 16-F:M8330	–	255	0.36	0.8	150	0.32	0.8	240	0.36	0.8	–	–	–	–	–	–	50	0.18	1.1

LC

PRAMET

	CDI (mm)	D1 (mm)	L (mm)	S (mm)
08	8.0	3.00	9.50	2.00
10	10.0	4.00	11.50	2.50

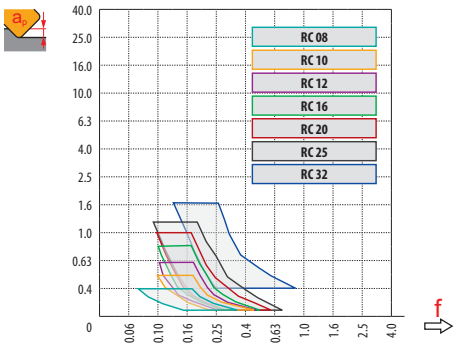


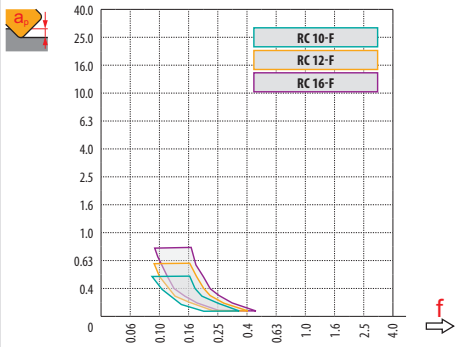
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
U E																			
KP geometri med nul skærevinkel design til let til medium bearbejdning.																			
LC 0806-KP:M4310	0.6	280	0.16	0.3	–	–	–	265	0.16	0.3	–	–	–	–	–	–	55	0.11	0.6
LC 0806-KP:M8310	0.6	325	0.16	0.3	–	–	–	305	0.16	0.3	–	–	–	–	–	–	65	0.11	0.6
LC 0810-KP:M4310	1.0	280	0.16	0.5	–	–	–	265	0.16	0.5	–	–	–	–	–	–	55	0.11	1.0
LC 1008-KP:M4310	0.8	270	0.16	0.4	–	–	–	255	0.16	0.4	–	–	–	–	–	–	50	0.08	0.8
LC 1008-KP:M8310	0.8	315	0.16	0.4	–	–	–	295	0.16	0.4	–	–	–	–	–	–	60	0.08	0.8
LC 1010-KP:M4310	1.0	280	0.16	0.5	–	–	–	265	0.16	0.5	–	–	–	–	–	–	55	0.08	1.0
LC 1010-KP:M8310	1.0	325	0.16	0.5	–	–	–	305	0.16	0.5	–	–	–	–	–	–	65	0.08	1.0
 F																			
KPF geometri med positivt design til let til medium bearbejdning.																			
LC 0806-KPF:M4310	0.6	280	0.16	0.3	140	0.14	0.3	265	0.16	0.3	–	–	–	–	–	–	55	0.08	0.6
LC 1008-KPF:M4310	0.8	270	0.16	0.4	135	0.14	0.4	255	0.16	0.4	–	–	–	–	–	–	50	0.08	0.8

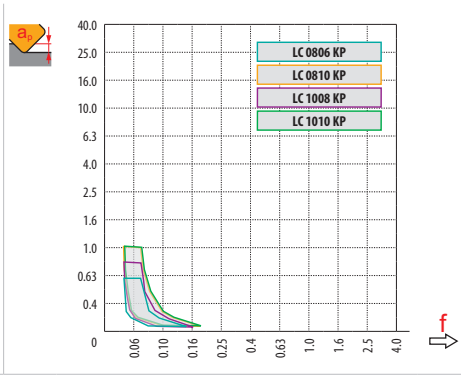
	RC 08	RC 10	RC 12	RC 16	RC 20	RC 25	RC 32
RE	4.0	5.0	6.0	8.0	10.0	12.5	16.0
BS	–	–	–	–	–	–	–

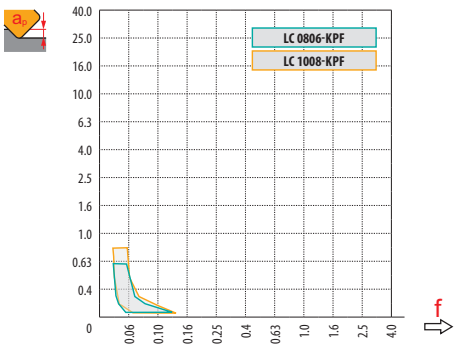
	RC 10-F	RC 12-F	RC 16-F
RE	5.0	6.0	8.0
BS	–	–	–

	LC 08-KP	LC 08-KP	LC 10-KP	LC 10-KP	LC 08-KPF	LC 10-KPF
RE	0.6	1.0	0.8	1.0	0.6	0.8
BS	–	–	–	–	–	–









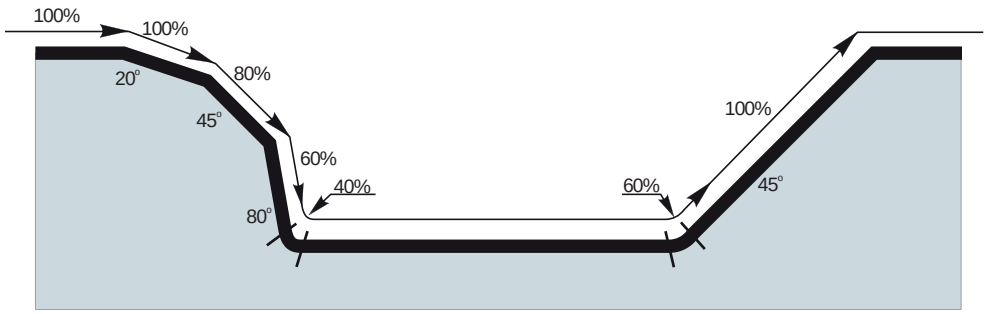
	DCX
RC 08	8
RC 10 / RC 10-F	10
RC 12 / RC 12-F	12
RC 16 / RC 16-F	16
RC 20	20
RC 25	25
RC 32	32

a_p	0.3	0.4	0.5	0.7	1.0	1.25	1.5	2.0	2.5	3.0	4.0	5.0	6.0	8.0	10.0	12.0	15.0	16.0
DEF	3.0	3.5	3.9	4.5	5.3	5.8	6.2	6.9	7.4	7.7	8.0	–	–	–	–	–	–	–
	3.4	3.9	4.4	5.1	6.0	6.6	7.1	8.0	8.7	9.2	9.8	10.0	–	–	–	–	–	–
	3.7	4.3	4.8	5.6	6.6	7.3	7.9	8.9	9.7	10.4	11.3	11.8	12.0	–	–	–	–	–
	4.3	5.0	5.6	6.5	7.7	8.6	9.3	10.6	11.6	12.5	13.9	14.8	15.5	16.0	–	–	–	–
	4.9	5.6	6.2	7.4	8.7	9.7	10.5	12.0	13.2	14.3	16.0	17.3	18.3	19.6	20.0	–	–	–
	5.4	6.3	7.0	8.2	9.8	10.9	11.9	13.6	15.0	16.2	18.3	20.0	21.4	23.3	24.5	25.0	–	–
	6.17	7.11	7.94	9.36	11.14	12.40	13.53	15.49	17.18	18.65	21.17	23.24	24.98	27.71	29.66	30.98	31.94	32.00

	DCX
RC 08	8
RC 10 / RC 10-F	10
RC 12 / RC 12-F	12
RC 16 / RC 16-F	16
RC 20	20
RC 25	25
RC 32	32

µm	3	5	10	15	20	30	40	50	60	80	100
FE	0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789
FE	0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
	0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
	0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
	0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
	0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578

DEF	a_e	1.0 %	2.5 %	5.0 %	7.5 %	10 %	15 %	20 %	25 %	30 %	35 %	40 %	45 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	a_p										⇨ x.f									
19.9%	1.0%	2.86	1.84	1.33	1.12	1.00	0.89	–	–	–	–	–	–	–	–	–	–	–	–	–
31.2%	2.5%	3.58	2.28	1.64	1.36	1.20	1.01	0.92	0.88	0.91	–	–	–	–	–	–	–	–	–	–
43.6%	5.0%	4.22	2.68	1.92	1.58	1.39	1.16	1.03	0.95	0.90	0.88	0.89	–	–	–	–	–	–	–	–
52.7%	7.5%	4.63	2.95	2.10	1.73	1.51	1.26	1.11	1.02	0.96	0.91	0.89	0.88	0.90	–	–	–	–	–	–
60.0%	10.0%	4.94	3.14	2.24	1.84	1.61	1.33	1.18	1.07	1.00	0.95	0.91	0.89	0.88	1.00	–	–	–	–	–
71.4%	15.0%	5.39	3.42	2.43	2.00	1.74	1.44	1.27	1.15	1.07	1.01	0.96	0.93	0.90	0.88	0.93	–	–	–	–
80.0%	20.0%	5.70	3.62	2.57	2.11	1.84	1.52	1.33	1.21	1.12	1.05	1.00	0.96	0.93	0.89	0.88	0.89	1.00	–	–
86.6%	25.0%	5.93	3.76	2.67	2.20	1.91	1.58	1.38	1.25	1.16	1.08	1.03	0.99	0.95	0.90	0.88	0.88	0.89	–	–
91.7%	30.0%	6.10	3.87	2.75	2.26	1.96	1.62	1.42	1.28	1.18	1.11	1.05	1.01	0.97	0.92	0.89	0.88	0.88	0.93	–
95.4%	35.0%	6.23	3.95	2.80	2.30	2.00	1.65	1.44	1.31	1.20	1.13	1.07	1.02	0.98	0.93	0.89	0.88	0.88	0.90	–
98.0%	40.0%	6.31	4.00	2.84	2.33	2.03	1.67	1.46	1.32	1.22	1.14	1.08	1.03	0.99	0.93	0.90	0.89	0.88	0.89	–
99.5%	45.0%	6.36	4.03	2.86	2.35	2.04	1.68	1.47	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	–
100.0%	50.0%	6.38	4.04	2.87	2.35	2.05	1.69	1.48	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	1.00



	DCX	RE	a_p 0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00	1.25	1.50	2.00	2.50	3.00	4.00
LC 0806-KP	8	0.6	6.8	7.8	7.9	8.0	8.0	–	–	–	–	–	–	–	–	–	–
LC 0806-KPF		0.6	6.8	7.8	7.9	8.0	8.0	–	–	–	–	–	–	–	–	–	–
LC 0810-KP		1.0	6.0	7.4	7.6	7.7	7.8	7.9	8.0	8.0	8.0	–	–	–	–	–	–
LC 1008-KP	10	0.8	8.4	9.6	9.8	9.9	9.9	10.0	10.0	–	–	–	–	–	–	–	–
LC 1008-KPF		0.8	8.4	9.6	9.8	9.9	9.9	10.0	10.0	–	–	–	–	–	–	–	–
LC 1010-KP		1.0	8.0	9.4	9.6	9.7	9.8	9.9	10.0	10.0	10.0	–	–	–	–	–	–

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
8	FE	0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789
10		0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
RE	**µm**	**3**	**5**	**10**	**15**	**20**	**30**	**40**	**50**	**60**	**80**	**100**
0.6	FE	0.120	0.155	0.219	0.268	0.310	0.379	0.438	0.490	0.537	0.620	0.693
0.8		0.139	0.179	0.253	0.310	0.358	0.438	0.506	0.566	0.620	0.716	0.800
1.0		0.155	0.200	0.283	0.346	0.400	0.490	0.566	0.632	0.693	0.800	0.89

	DCX	RE	max
LC 0806-KP	8	0.6	3.0
LC 0806-KPF		0.6	2.8
LC 0810-KP		1.0	3.0
LC 1008-KP	10	0.8	3.8
LC 1008-KPF		0.8	3.6
LC 1010-KP		1.0	3.8

	DCX	RE	RPMX	APMX/I
LC 0806-KP	8	0.6	2.5	1.5/35
LC 0806-KPF		0.6	2.2	1.5/39
LC 0810-KP		1.0	2.4	1.5/36
LC 1008-KP	10	0.8	2.6	1.5/33
LC 1008-KPF		0.8	2.3	1.5/38
LC 1010-KP		1.0	2.6	1.5/33

	DCX	RE	DMIN	DMAX	SMAX DMIN	SMAX DMAX
LC 0806-KP	8	0.6	9.8	15.9	0.8	1.0
LC 0806-KPF		0.6	10.2	15.9	0.1	0.1
LC 0810-KP		1.0	9.9	15.9	0.1	0.1
LC 1008-KP	10	0.8	12.2	19.9	0.9	1.1
LC 1008-KPF		0.8	12.6	19.9	0.2	0.2
LC 1010-KP		1.0	12.2	19.9	0.2	0.2

	DCX	RE	a_p
LC 0806-KP	8	0.6	0.15
LC 0806-KPF		0.6	0.13
LC 0810-KP		1.0	0.13
LC 1008-KP	10	0.8	0.2
LC 1008-KPF		0.8	0.18
LC 1010-KP		1.0	0.19

Overlapning (multipel af diameter *DCX*)	< 3.0	3.0 – 3.5	3.6 – 4.0	4.1 – 4.5	> 4.6
Multiplikationsfaktor for hastighed	1.0	0.9	0.8	0.7	0.5

K2-SLC

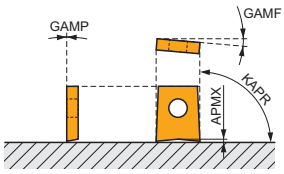
PRAMET

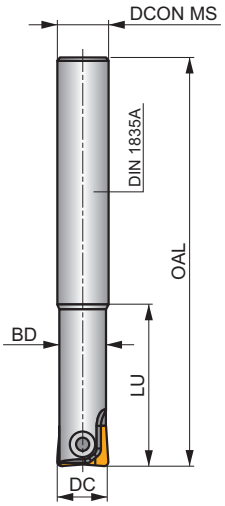
S

Kopi og profil Endefræser til efterbehandling

Endefræser til efterbehandling i en lang række applikationer ved hjælp af LC-skær. Højpræcisions skærholder giver fremragende nøjagtighed. Til profilering, affasning, spiralinterpolation, progressiv sporfræsning og rampning. Fås kun i cylindrisk type. Krop behandlet for længere levetid på værktøjet.

APMX	1.0 - 3.0 mm





h_m 0.03 - 0.10

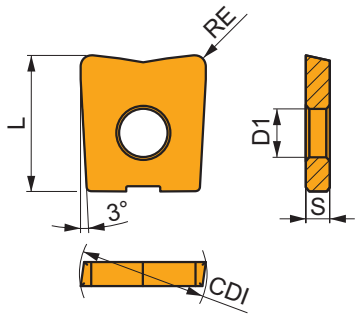
	Product	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	BD (mm)			max.		kg		
DIN 1835A	**12K2R030A12-SLC12-A**	12	130	12	30	10.5	2	–	35000	–	0.11	GI037	CO532
	16K2R035A16-SLC16-A	16	140	16	35	14	2	–	22000	–	0.20	GI038	CO533
	20K2R045A20-SLC20-A	20	160	20	45	18	2	–	16000	–	0.38	GI039	CO534

GI037	LC 12-KP	LC 12-KPF
GI038	LC 16-KP	–
GI039	LC 20-KP	–

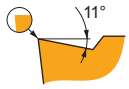
		Nm			
CO532	CS 5009-T20P	5.0	M 5	9	SDR T20P
CO533	CS 5013-T20P	5.0	M 5	13	SDR T20P
CO534	CS 5015-T20P	5.0	M 5	15	SDR T20P

LC

	CDI	D1	L	S
	(mm)	(mm)	(mm)	(mm)
12	12.0	5.00	14.00	2.50
16	16.0	5.00	16.00	3.00
20	20.0	5.00	18.00	3.00

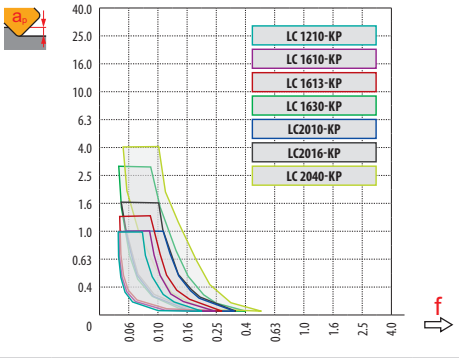


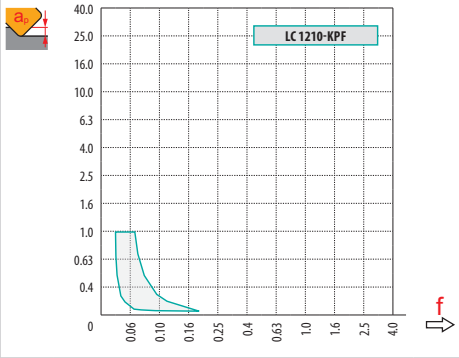
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
		U E																	
KP geometri med nul skærevinkel design til let til medium bearbejdning.																			
LC 1210-KP:M4310	1.0	280	0.16	0.5	–	–	–	265	0.16	0.5	–	–	–	–	–	–	55	0.08	1.0
LC 1210-KP:M8310	1.0	325	0.16	0.5	–	–	–	305	0.16	0.5	–	–	–	–	–	–	65	0.08	1.0
LC 1210-KP:M8330	1.0	295	0.16	0.5	–	–	–	280	0.16	0.5	–	–	–	–	–	–	55	0.08	1.0
LC 1610-KP:M4310	1.0	280	0.16	0.5	–	–	–	265	0.16	0.5	–	–	–	–	–	–	55	0.08	1.0
LC 1610-KP:M8310	1.0	325	0.16	0.5	–	–	–	305	0.16	0.5	–	–	–	–	–	–	65	0.08	1.0
LC 1610-KP:M8330	1.0	295	0.16	0.5	–	–	–	280	0.16	0.5	–	–	–	–	–	–	55	0.08	1.0
LC 1613-KP:M4310	1.3	270	0.16	0.7	–	–	–	255	0.16	0.7	–	–	–	–	–	–	50	0.08	1.3
LC 1613-KP:M8310	1.3	315	0.16	0.7	–	–	–	295	0.16	0.7	–	–	–	–	–	–	60	0.08	1.3
LC 2010-KP:M4310	1.0	280	0.16	0.5	–	–	–	265	0.16	0.5	–	–	–	–	–	–	55	0.08	1.0
LC 2010-KP:M8310	1.0	325	0.16	0.5	–	–	–	305	0.16	0.5	–	–	–	–	–	–	65	0.08	1.0
LC 2016-KP:M4310	1.6	280	0.16	0.8	–	–	–	265	0.16	0.8	–	–	–	–	–	–	55	0.08	1.1
LC 2016-KP:M8310	1.6	325	0.16	0.8	–	–	–	305	0.16	0.8	–	–	–	–	–	–	65	0.08	1.1
LC 2040-KP:M8330	4.0	285	0.16	2.0	–	–	–	270	0.16	2.0	–	–	–	–	–	–	55	0.08	2.7
		F																	
KPF geometri med positivt design til let til medium bearbejdning.																			
LC 1210-KPF:M4310	1.0	280	0.16	0.5	140	0.14	0.5	265	0.16	0.5	–	–	–	–	–	–	55	0.08	1.0
LC 1210-KPF:M8330	1.0	295	0.16	0.5	175	0.14	0.5	280	0.16	0.5	–	–	–	–	–	–	55	0.08	1.0

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	LC 1210-KP	LC 1610-KP	LC 1613-KP	LC 2010-KP	LC 2016-KP	LC 2040-KP	LC 1210-KPF
RE	1.0	1.3	3.0	1.0	1.6	4.0	1.0
BS	–	–	–	–	–	–	–





	DC	RE	a_p 0.0	0.3	0.4	0.5	0.6	0.7	0.8	0.9	1.0	1.25	1.5	2.0	2.5	3.0	4.0
LC 1210-KP	12	1.0	10.0	11.4	11.6	11.7	11.8	11.9	12.0	12.0	12.0	–	–	–	–	–	–
LC 1210-KPF		1.0	10.0	11.4	11.6	11.7	11.8	11.9	12.0	12.0	12.0	–	–	–	–	–	–
LC 1610-KP	16	1.0	14.0	15.4	15.6	15.7	15.8	15.9	16.0	16.0	16.0	–	–	–	–	–	–
LC 1613-KP		1.3	13.4	15.1	15.3	15.4	15.6	15.7	15.8	15.9	15.9	16.0	–	–	–	–	–
LC 2010-KP	20	1.0	18.0	19.4	19.6	19.7	19.8	19.9	20.0	20.0	20.0	–	–	–	–	–	–
LC 2016-KP		1.6	16.8	18.7	18.9	19.1	19.3	19.4	19.6	19.7	19.8	19.9	20.0	–	–	–	–
LC 2040-KP		4.0	12.0	15.0	15.5	15.9	16.2	16.5	16.8	17.1	17.3	17.8	18.2	18.9	19.4	–	–

DC	µm	3	5	10	15	20	30	40	50	60	80	100
12		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
16		0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
RE	**µm**	**3**	**5**	**10**	**15**	**20**	**30**	**40**	**50**	**60**	**80**	**100**
1.3		0.177	0.228	0.322	0.395	0.456	0.559	0.645	0.721	0.790	0.912	1.020
1.6	FE	0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
4.0		0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789

	DC	RE	max
LC 1210-KP	12	1.0	4.8
LC 1210-KPF		1.0	4.4
LC 1610-KP	16	1.0	6.6
LC 1613-KP		1.3	6.6
LC 2010-KP	20	1.0	8.5
LC 2016-KP		1.6	8.5
LC 2040-KP		4.0	8.5

	DC	RE	RPMX	APMX/I
LC 1210-KP	12	1.0	4.7	1.5/19
LC 1210-KPF		1.0	3.8	1.5/23
LC 1610-KP	16	1.0	4.8	1.5/18
LC 1613-KP		1.3	4.8	1.5/18
LC 2010-KP	20	1.0	5.0	1.5/18
LC 2016-KP		1.6	4.9	1.6/19
LC 2040-KP		4.0	4.5	4.0/51

	DC	RE	DMIN	DMAX	SMAX DMIN	SMAX DMAX
LC 1210-KP	12	1.0	14.1	23.9	1.0	1.2
LC 1210-KPF		1.0	15.0	23.9	0.4	0.4
LC 1610-KP	16	1.0	18.6	31.9	1.1	1.4
LC 1613-KP		1.3	18.6	31.9	0.6	0.6
LC 2010-KP	20	1.0	22.8	39.9	1.3	1.5
LC 2016-KP		1.6	22.8	39.9	0.8	0.8
LC 2040-KP		4.0	22.8	39.9	0.5	0.5

	DC	RE	a_p
LC 1210-KP	12	1.0	0.44
LC 1210-KPF		1.0	0.9
LC 1610-KP	16	1.0	0.65
LC 1613-KP		1.3	0.62
LC 2010-KP	20	1.0	0.85
LC 2016-KP		1.6	0.79
LC 2040-KP		4.0	0.54

Overlapning (multipel af diameter *DCX*)	< 3.0	3 – 3.5	3.6 – 4.0	4.1 – 4.5	> 4.6
Multiplikationsfaktor for hastighed	1.0	0.9	0.8	0.7	0.5

K2-PPH

P M K S H

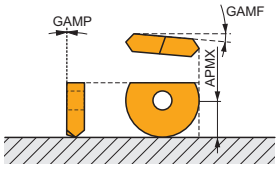
PRAMET

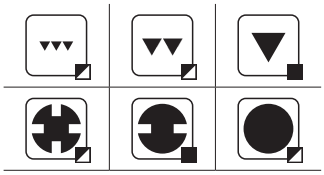
S

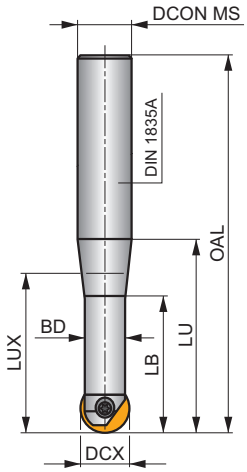
Kopi og profil Ende fræser

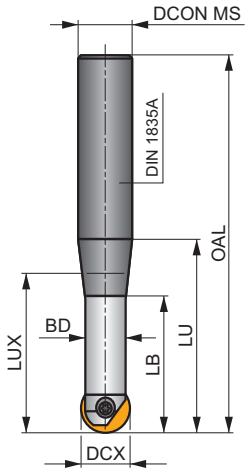
Fleksibel endefræser til en bred vifte af værktøjsfremstilling applikationer. Én værktøjsløsning til kugle-, toroidal- og high feed skær. Højpræcisions grundskær giver høj nøjagtighed. Fås i cylindrisk og modulær stil. Krop behandlet for længere værktøjslevetid.

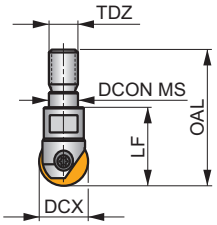
APMX	0.3 - 4.0 mm











h_m 0.07 - 0.14

	Product	DCX (mm)	OAL (mm)	DCON MS (mm)	BD (mm)	LB (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	Carbide	max.		kg		
	PPH-08/02-QC12-092	8	92	12	6.5	19	35	23.1	–	–	–	40000	–	0.14	GI284	C0540
	PPH-08/02-QC12-110	8	110	12	6.5	33.5	53	41.5	–	–	–	33600	–	0.14	GI284	C0540
	PPH-08/02-QC12-132	8	132	12	6.5	19	75	41.8	–	–	–	16800	–	0.15	GI284	C0540
	PPH-10/02-QC12-092	10	92	12	8	22.4	38	30	–	–	–	40000	–	0.12	GI285	C0541
	PPH-10/02-QC12-110	10	110	12	8	38.7	53	51.9	–	–	–	40000	–	0.15	GI285	C0541
	PPH-10/02-QC12-132	10	132	12	8	21.8	75	73.6	–	–	–	20300	–	0.16	GI285	C0541
	PPH-12/02-QC16-145	12	145	16	10	22.5	85	63.3	–	–	–	19800	–	0.23	GI286	C0542
	PPH-16/02-QC20-166	16	166	20	14	29.5	100	75.5	–	–	–	20000	–	0.37	GI287	C0543
	PPH-20/02-QC25-191	20	191	25	17	35	115	82.2	–	–	–	18400	–	0.64	GI288	C0544
	PPH-25/02-QC32-215	25	215	32	21	42.5	135	97	–	–	–	16500	–	1.07	GI289	C0545
	PPH-12/02-QC12-083	12	83	12	10	–	26	–	–	–	–	40000	–	0.15	GI286	C0542
	PPH-12/02-QC12-110	12	110	12	10	–	53	–	–	–	–	40000	–	0.15	GI286	C0542
	PPH-16/02-QC16-092	16	92	16	14	–	92	–	–	–	–	36000	–	0.20	GI287	C0543
DIN 1835A	**PPH-16/02-QC16-123**	16	123	16	14	–	63	–	–	–	–	36000	–	0.24	GI287	C0543
	PPH-20/02-QC20-104	20	104	20	17	–	38	–	–	–	–	40000	–	0.34	GI288	C0544
	PPH-20/02-QC20-141	20	141	20	17	–	75	–	–	–	–	40000	–	0.41	GI288	C0544
	PPH-25/02-QC25-121	25	121	25	21	–	45	–	–	–	–	40000	–	0.53	GI289	C0545
	PPH-25/02-QC25-166	25	166	25	21	–	90	–	–	–	–	37100	–	0.57	GI289	C0545
	PPH-32/02-QC32-186	32	186	32	26	–	107	–	–	–	–	32500	–	1.09	GI290	C0546
	PPH-32/02-QC32-240	32	240	32	26	–	160	–	–	–	–	14500	–	1.37	GI290	C0546
	PPH-08/02-QC12-110HSCW	8	110	12	6.5	19	53	30.1	–	–	✓	40000	–	0.21	GI284	C0540
	PPH-08/02-QC12-132HSCW	8	132	12	6.5	19	75	37.1	–	–	✓	23400	–	0.22	GI284	C0540
	PPH-10/02-QC12-092HSCW	10	92	12	8	21.9	38.1	90.9	–	–	✓	40000	–	0.20	GI285	C0541
	PPH-10/02-QC12-132HSCW	10	132	12	8	21.8	75.1	51.1	–	–	✓	23400	–	0.24	GI285	C0541
	PPH-12/02-QC16-145HSCW	12	145	16	10	21.5	85	65.6	–	–	✓	21000	–	0.28	GI286	C0542
	PPH-16/02-QC20-166HSCW	16	166	20	14	28.5	100	87.2	–	–	✓	25500	–	0.66	GI287	C0543
	PPH-20/02-QC25-191HSCW	20	191	25	17	35	115	75.6	–	–	✓	18500	–	1.07	GI288	C0544
	PPH-08/02-QC08-130HSCW	8	130	8	6.5	–	20	–	–	–	✓	40000	–	0.17	GI284	C0540

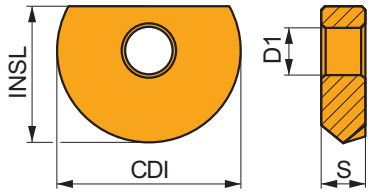
	Product	DCX (mm)	OAL (mm)	DCON MS (mm)	BD (mm)	LB (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	Carbide	max.		kg		
DIN 1835A	**PPH-10/02-QC10-140HSCW**	10	140	10	8	–	25	–	–	–	✓	40000	–	0.22	GI285	C0541
	PPH-12/02-QC12-083HSCW	12	83	12	10	–	26	–	–	–	✓	40000	–	0.19	GI286	C0542
	PPH-12/02-QC12-110HSCW	12	110	12	10	–	53	–	–	–	✓	40000	–	0.22	GI286	C0542
	PPH-16/02-QC16-092HSCW	16	92	16	14	–	32	–	–	–	✓	43000	–	0.29	GI287	C0543
	PPH-16/02-QC16-123HSCW	16	123	16	14	–	63	–	–	–	✓	43000	–	0.36	GI287	C0543
	PPH-20/02-QC20-104HSCW	20	104	20	17	–	38	–	–	–	✓	40000	–	0.50	GI288	C0544
	PPH-20/02-QC20-141HSCW	20	141	20	17	–	75	–	–	–	✓	40000	–	0.62	GI288	C0544
MODULAR	**PPH-16/02-025-P08**	16	–	8.5	–	–	–	–	25	M8	–	–	–	0.10	GI287	C0543
	PPH-20/02-030-P10	20	–	10.5	–	–	–	–	30	M10	–	–	–	0.16	GI288	C0544

GI284	PPH 08..	–	PPHT 08..	PPHF 08..
GI285	PPH 10..	PPHE 10..	PPHT 10..	PPHF 10..
GI286	PPH 12..	PPHE 12..	PPHT 12..	PPHF 12..
GI287	PPH 16..	PPHE 16..	PPHT 16..	PPHF 16..
GI288	PPH 20..	PPHE 20..	PPHT 20..	PPHF 20..
GI289	PPH 25..	–	PPHT 25..	–
GI290	PPH 32..	–	–	–

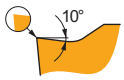
		Nm						
C0540	CS 42506-T07P	1.0	M 2.5	6	D-T07P/T09P	FG-15	–	–
C0541	CS 43008-T08P	1.2	M 3	8	D-T08P/T15P	FG-15	–	–
C0542	CS 43509-T10P	2.0	M 3.5	9	–	–	SDR T10P	–
C0543	CS 44013-T15P	3.0	M 4	13	D-T08P/T15P	FG-15	–	–
C0544	CS 45016-T20P	5.0	M 5	16	–	–	SDR T20P	–
C0545	CS 46020-T25P	7.5	M 6	20	–	–	–	SDR T25P-T
C0546	CS 48025-T40P	15.0	M 8	25	–	–	–	SDR T40P-T

PPH

	CDI (mm)	D1 (mm)	INSL (mm)	S (mm)
0800	8.0	2.50	7.0	2.40
1000	10.0	3.00	8.5	2.60
1200	12.0	3.50	10.0	3.00
1600	16.0	4.00	12.0	4.00
2000	20.0	5.00	15.0	5.00
2500	25.0	6.00	18.5	6.00
3000	30.0	8.00	22.5	7.00
3200	32.0	8.00	23.5	7.00

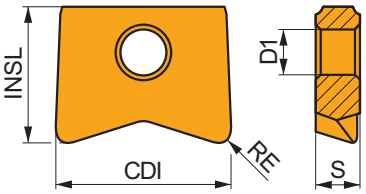


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
CL1 geometri med skarpt design.																			
PPH 0800-CL1:2003	–	285	0.36	0.4	145	0.32	0.4	270	0.36	0.4	–	–	–	–	–	–	55	0.18	0.8
PPH 1000-CL1:2003	–	280	0.36	0.5	140	0.32	0.5	265	0.36	0.5	–	–	–	–	–	–	55	0.18	1.0
PPH 1200-CL1:2003	–	275	0.36	0.6	140	0.32	0.6	260	0.36	0.6	–	–	–	–	–	–	55	0.18	1.2
PPH 1600-CL1:2003	–	265	0.36	0.8	135	0.32	0.8	250	0.36	0.8	–	–	–	–	–	–	50	0.18	1.1
PPH 2000-CL1:2003	–	260	0.36	1.0	130	0.32	1.0	245	0.36	1.0	–	–	–	–	–	–	50	0.18	1.3
PPH 2500-CL1:2003	–	250	0.36	1.3	125	0.32	1.3	235	0.36	1.3	–	–	–	–	–	–	50	0.18	1.7
PPH 3000-CL1:2003	–	245	0.36	1.5	120	0.32	1.5	230	0.36	1.5	–	–	–	–	–	–	45	0.18	2.0
PPH 3200-CL1:2003	–	245	0.36	1.6	120	0.32	1.6	230	0.36	1.6	–	–	–	–	–	–	45	0.18	2.1
CL4 geometri med skarpt design til afbrudte snit.																			
PPH 0800-CL4:8215	–	270	0.36	0.4	–	–	–	255	0.36	0.4	–	–	–	–	–	–	50	0.18	0.8
PPH 1000-CL4:8215	–	265	0.36	0.5	–	–	–	250	0.36	0.5	–	–	–	–	–	–	50	0.18	1.0
PPH 1200-CL4:8215	–	255	0.36	0.6	–	–	–	240	0.36	0.6	–	–	–	–	–	–	50	0.18	1.2
PPH 1600-CL4:8215	–	250	0.36	0.8	–	–	–	235	0.36	0.8	–	–	–	–	–	–	50	0.18	1.1
PPH 2000-CL4:8215	–	245	0.36	1.0	–	–	–	230	0.36	1.0	–	–	–	–	–	–	45	0.18	1.3
 **SM1** geometri med skarpt design.																			
PPHE 1000-SM1:8215	–	275	0.31	0.5	165	0.28	0.5	260	0.31	0.5	–	–	–	–	–	–	55	0.16	1.0
PPHE 1200-SM1:8215	–	255	0.36	0.6	150	0.32	0.6	240	0.36	0.6	–	–	–	–	–	–	50	0.18	1.2
PPHE 1600-SM1:8215	–	260	0.31	0.8	155	0.28	0.8	245	0.31	0.8	–	–	–	–	–	–	50	0.16	1.1
PPHE 2000-SM1:8215	–	250	0.31	1.0	150	0.28	1.0	235	0.31	1.0	–	–	–	–	–	–	50	0.16	1.3

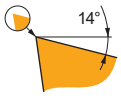
PPHT

	CDI (mm)	D1 (mm)	INSL (mm)	S (mm)
0800	8.0	2.50	7.0	2.40
1000	10.0	3.00	8.5	2.60
1200	12.0	3.50	10.0	3.00
1600	16.0	4.00	12.0	4.00
2000	20.0	5.00	15.0	5.00
2500	25.0	6.00	18.5	6.00



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
PPHT 080003-A2:2003	0.3	275	0.10	0.3	140	0.09	0.3	260	0.10	0.3	–	–	–	–	–	–	55	0.07	0.3
PPHT 080005-A2:2003	0.5	270	0.13	0.3	135	0.12	0.3	255	0.13	0.3	–	–	–	–	–	–	50	0.09	0.5
PPHT 080010-A2:2003	1.0	315	0.14	0.5	160	0.13	0.5	295	0.14	0.5	–	–	–	–	–	–	60	0.10	1.0
PPHT 100005-A2:2003	0.5	270	0.13	0.3	135	0.12	0.3	255	0.13	0.3	–	–	–	–	–	–	50	0.09	0.5
PPHT 100008-A2:2003	0.8	305	0.14	0.4	155	0.13	0.4	285	0.14	0.4	–	–	–	–	–	–	60	0.10	0.8
PPHT 100010-A2:2003	1.0	315	0.14	0.5	160	0.13	0.5	295	0.14	0.5	–	–	–	–	–	–	60	0.10	1.0
PPHT 120005-A2:2003	0.5	270	0.13	0.3	135	0.12	0.3	255	0.13	0.3	–	–	–	–	–	–	50	0.09	0.5
PPHT 120010-A2:2003	1.0	315	0.14	0.5	160	0.13	0.5	295	0.14	0.5	–	–	–	–	–	–	60	0.10	1.0
PPHT 120020-A2:2003	2.0	320	0.14	1.0	160	0.13	1.0	300	0.14	1.0	–	–	–	–	–	–	60	0.10	1.3
PPHT 160010-A2:2003	1.0	315	0.14	0.5	160	0.13	0.5	295	0.14	0.5	–	–	–	–	–	–	60	0.10	1.0
PPHT 160013-A2:2003	1.3	300	0.15	0.6	150	0.13	0.6	285	0.15	0.6	–	–	–	–	–	–	60	0.10	1.3
PPHT 160020-A2:2003	2.0	320	0.14	1.0	160	0.13	1.0	300	0.14	1.0	–	–	–	–	–	–	60	0.10	1.3
PPHT 200010-A2:2003	1.0	315	0.14	0.5	160	0.13	0.5	295	0.14	0.5	–	–	–	–	–	–	60	0.10	1.0
PPHT 200016-A2:2003	1.6	310	0.14	0.8	155	0.13	0.8	290	0.14	0.8	–	–	–	–	–	–	60	0.10	1.1
PPHT 200030-A2:2003	3.0	305	0.14	1.5	155	0.13	1.5	285	0.14	1.5	–	–	–	–	–	–	60	0.10	2.0
PPHT 200040-A2:2003	4.0	295	0.14	2.0	150	0.13	2.0	280	0.14	2.0	–	–	–	–	–	–	55	0.10	2.7
PPHT 250020-A2:2003	2.0	320	0.14	1.0	160	0.13	1.0	300	0.14	1.0	–	–	–	–	–	–	60	0.10	1.3

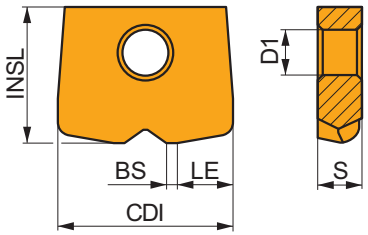


A2 geometri med positivt design til let til medium bearbejdning.

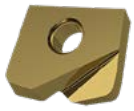
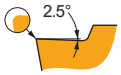
PPHF

PRAMET

	BS	LE	CDI	D1	INSL	S
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)
0800	0.40	2.60	8.0	2.50	7.0	2.40
1000	0.50	3.20	10.0	3.00	8.5	2.60
1200	0.60	3.90	12.0	3.50	10.0	3.00
1600	0.80	5.20	16.0	4.00	12.0	4.00
2000	1.00	6.40	20.0	5.00	15.0	5.00



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				

CE1 geometri med stærkt design til high feed bearbejdning.

PPHF 080004-CE1:M8330	●	–	200	0.30	0.3	120	0.27	0.3	190	0.30	0.3	–	–	–	50	0.27	0.2	40	0.21	0.2
PPHF 100005-CE1:M8330	●●	–	190	0.35	0.3	110	0.32	0.3	180	0.35	0.3	–	–	–	45	0.32	0.2	35	0.25	0.2
PPHF 120006-CE1:M8330	●●	–	205	0.45	0.4	120	0.41	0.4	190	0.45	0.4	–	–	–	50	0.41	0.3	40	0.32	0.3
PPHF 160008-CE1:M8330	●●	–	190	0.60	0.5	110	0.54	0.5	180	0.60	0.5	–	–	–	45	0.54	0.4	35	0.42	0.4
PPHF 200010-CE1:M8330	●●	–	185	0.75	0.6	110	0.68	0.6	175	0.75	0.6	–	–	–	45	0.68	0.5	35	0.53	0.4

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	PPH 08-CL1	PPH 10-CL1	PPH 12-CL1	PPH 16-CL1	PPH 20-CL1	PPH 25-CL1	PPH 30-CL1	PPH 32-CL1
RE	4.0	5.0	6.0	8.0	10.0	12.5	15.0	16.0
BS	–	–	–	–	–	–	–	–

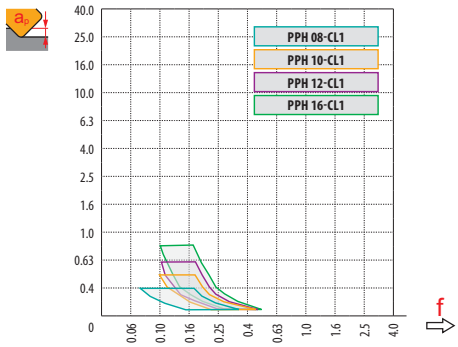
	PPH 08-CL4	PPH 10-CL4	PPH 12-CL4	PPH 16-CL4	PPH 20-CL4
RE	4.0	5.0	6.0	8.0	10.0
BS	–	–	–	–	–

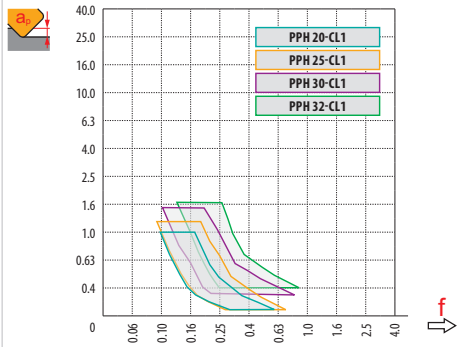
	PPHE 10-SM1	PPHE 12-SM1	PPHE 16-SM1	PPHE 20-SM1
RE	5.0	6.0	8.0	10.0
BS	–	–	–	–

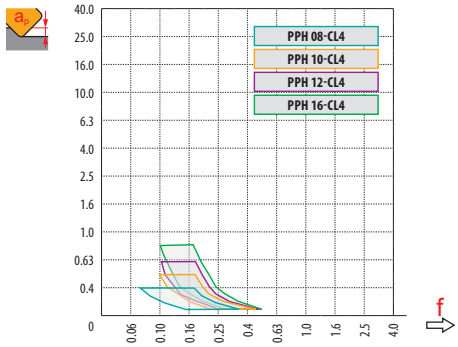
	PPHF 08-CE1	PPHF 10-CE1	PPHF 12-CE1	PPHF 16-CE1	PPHF 20-CE1
RE	0.6	0.8	1.0	1.3	1.6
BS	0.40	0.50	0.60	0.80	1.00

	PPHT 08-A2	PPHT 08-A2	PPHT 08-A2	PPHT 10-A2	PPHT 10-A2	PPHT 10-A2	PPHT 12-A2	PPHT 12-A2	PPHT 12-A2
RE	0.3	0.5	1.0	0.5	0.8	1.0	0.5	1.0	2.0
BS	–	–	–	–	–	–	–	–	–

	PPHT 16-A2	PPHT 16-A2	PPHT 16-A2	PPHT 20-A2	PPHT 20-A2	PPHT 20-A2	PPHT 20-A2	PPHT 25-A2
RE	1.0	1.3	2.0	1.0	1.6	3.0	4.0	2.0
BS	–	–	–	–	–	–	–	–


a_p
PPH 08-CL1
PPH 10-CL1
PPH 12-CL1
PPH 16-CL1
f


a_p
PPH 20-CL1
PPH 25-CL1
PPH 30-CL1
PPH 32-CL1
f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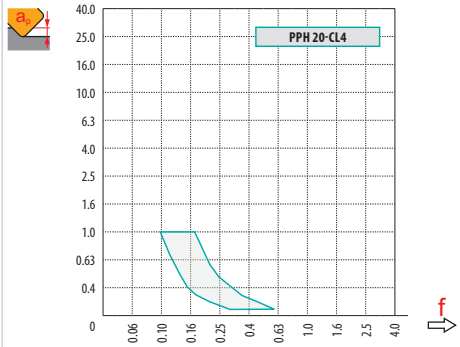
PPH 10-CL4
PPH 12-CL4
PPH 16-CL4
f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PPH 20-CL4
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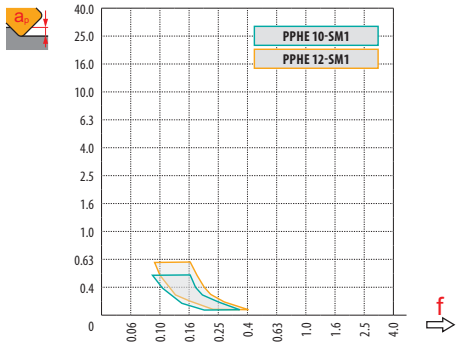
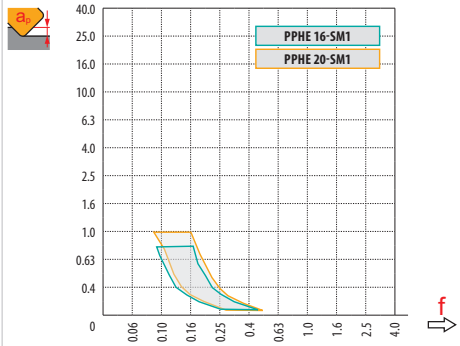
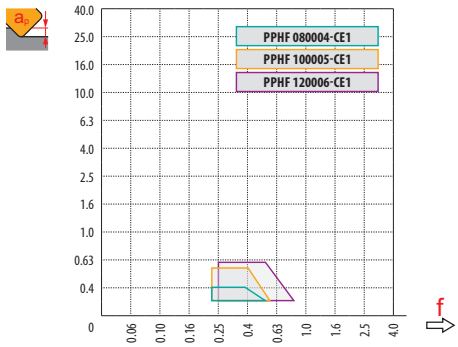

a_p
PPHE 10-SM1
PPHE 12-SM1
f


a_p
PPHE 16-SM1
PPHE 20-SM1
f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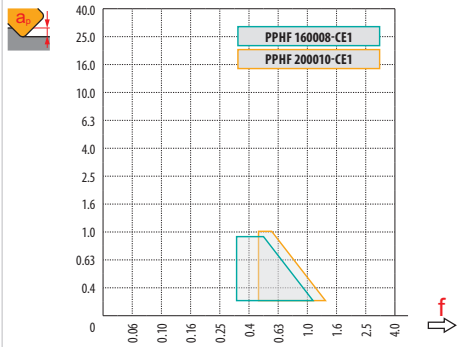
PPHF 100005-CE1
PPHF 120006-CE1
f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PPHF 200010-CE1
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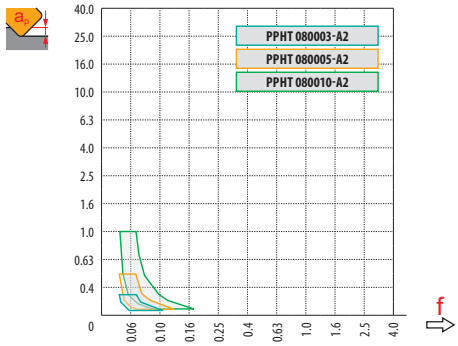
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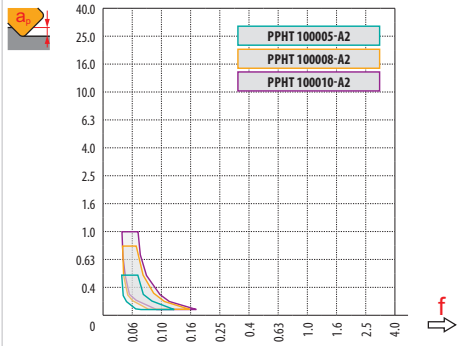
PPHT 080005-A2
PPHT 080010-A2
f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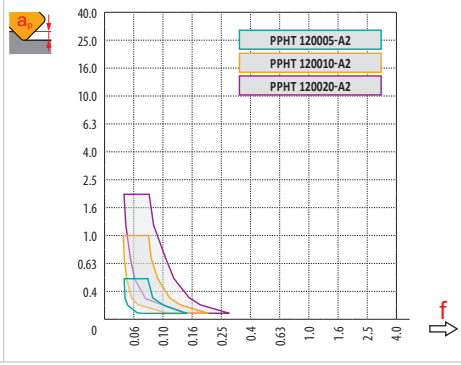
PPHT 100008-A2
PPHT 100010-A2
f


a_p
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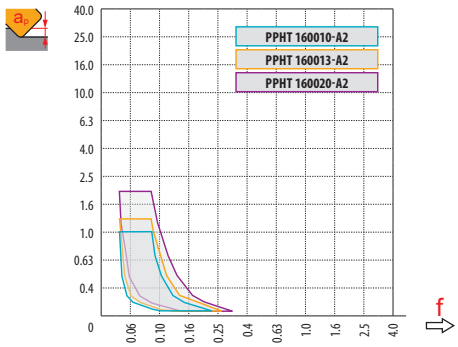
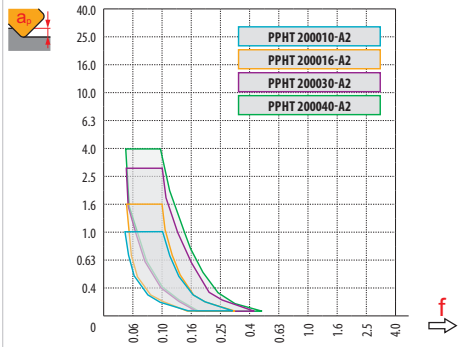
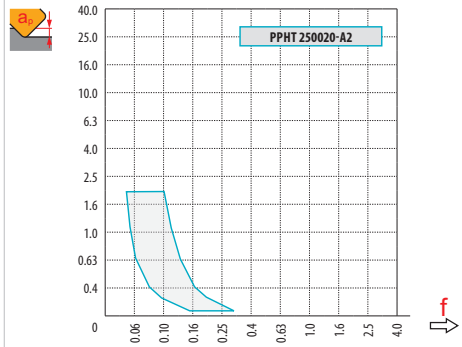
PPHT 120010-A2
PPHT 120020-A2
f







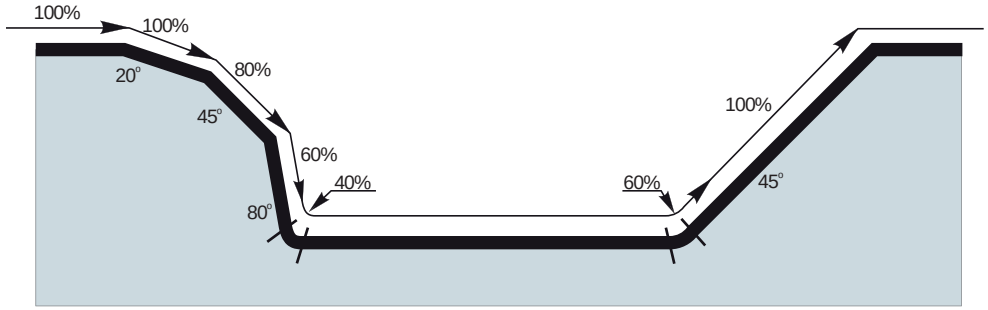
	DCX	a_p	0.3	0.4	0.5	0.7	1.0	1.25	1.5	2.0	2.5	3.0	4.0	5.0	6.0	8.0	10.0	12.0	15.0	16.0
PPH 08	**8**	DEF	3.0	3.5	3.9	4.5	5.3	5.8	6.2	6.9	7.4	7.7	8.0	–	–	–	–	–	–	–
PPH 10	**10**		3.4	3.9	4.4	5.1	6.0	6.6	7.1	8.0	8.7	9.2	9.8	10.0	–	–	–	–	–	–
PPH 12	**12**		3.7	4.3	4.8	5.6	6.6	7.3	7.9	8.9	9.7	10.4	11.3	11.8	12.0	–	–	–	–	–
PPH 16	**16**		4.3	5.0	5.6	6.5	7.7	8.6	9.3	10.6	11.6	12.5	13.9	14.8	15.5	16.0	–	–	–	–
PPH 20	**20**		4.9	5.6	6.2	7.4	8.7	9.7	10.5	12.0	13.2	14.3	16.0	17.3	18.3	19.6	20.0	–	–	–
PPH 25	**25**		5.4	6.3	7.0	8.2	9.8	10.9	11.9	13.6	15.0	16.2	18.3	20.0	21.4	23.3	24.5	25.0	–	–
PPH 32	**32**		6.17	7.11	7.94	9.36	11.14	12.40	13.53	15.49	17.18	18.65	21.17	23.24	24.98	27.71	29.66	30.98	31.94	32.00

	DCX	µm	3	5	10	15	20	30	40	50	60	80	100
PPH 08	**8**		0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789
PPH 10	**10**	FE	0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
PPH 12	**12**		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
PPH 16	**16**	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
PPH 20	**20**		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
PPH 25	**25**		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
PPH 32	**32**		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578

DEF	a_e	1 %	2.5 %	5 %	7.5 %	10 %	15 %	20 %	25 %	30 %	35 %	40 %	45 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	a_p										⇨x.f									
19.9 %	1.0 %	2.86	1.84	1.33	1.12	1.00	0.89	–	–	–	–	–	–	–	–	–	–	–	–	–
31.2 %	2.5 %	3.58	2.28	1.64	1.36	1.20	1.01	0.92	0.88	0.91	–	–	–	–	–	–	–	–	–	–
43.6 %	5.0 %	4.22	2.68	1.92	1.58	1.39	1.16	1.03	0.95	0.90	0.88	0.89	–	–	–	–	–	–	–	–
52.7 %	7.5 %	4.63	2.95	2.10	1.73	1.51	1.26	1.11	1.02	0.96	0.91	0.89	0.88	0.90	–	–	–	–	–	–
60.0 %	10.0 %	4.94	3.14	2.24	1.84	1.61	1.33	1.18	1.07	1.00	0.95	0.91	0.89	0.88	1.00	–	–	–	–	–
71.4 %	15.0 %	5.39	3.42	2.43	2.00	1.74	1.44	1.27	1.15	1.07	1.01	0.96	0.93	0.90	0.88	0.93	–	–	–	–
80.0 %	20.0 %	5.70	3.62	2.57	2.11	1.84	1.52	1.33	1.21	1.12	1.05	1.00	0.96	0.93	0.89	0.88	0.89	1.00	–	–
86.6 %	25.0 %	5.93	3.76	2.67	2.20	1.91	1.58	1.38	1.25	1.16	1.08	1.03	0.99	0.95	0.90	0.88	0.88	0.89	–	–
91.7 %	30.0 %	6.10	3.87	2.75	2.26	1.96	1.62	1.42	1.28	1.18	1.11	1.05	1.01	0.97	0.92	0.89	0.88	0.88	0.93	–
95.4 %	35.0 %	6.23	3.95	2.80	2.30	2.00	1.65	1.44	1.31	1.20	1.13	1.07	1.02	0.98	0.93	0.89	0.88	0.88	0.90	–
98.0 %	40.0 %	6.31	4.00	2.84	2.33	2.03	1.67	1.46	1.32	1.22	1.14	1.08	1.03	0.99	0.93	0.90	0.89	0.88	0.89	–
99.5 %	45.0 %	6.36	4.03	2.86	2.35	2.04	1.68	1.47	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	–
100.0 %	50.0 %	6.38	4.04	2.87	2.35	2.05	1.69	1.48	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	1.00

	DCX																
		RE	0.0	0.3	0.4	0.5	0.6	0.7	0.8	0.9	1.0	1.25	1.5	2.0	2.5	3.0	4.0
PPHT 08-A2	**8**	0.3	7.4	8.0	–	–	–	–	–	–	–	–	–	–	–	–	–
PPHT 08-A2		0.5	7.0	7.9	8.0	8.0	–	–	–	–	–	–	–	–	–	–	–
PPHT 08-A2		0.8	6.4	7.6	7.8	7.9	7.9	8.0	8.0	–	–	–	–	–	–	–	–
PPHT 08-A2		1.0	6.0	7.4	7.6	7.7	7.8	7.9	8.0	8.0	8.0	–	–	–	–	–	–
PPHT 10-A2	**10**	0.5	9.0	9.9	10.0	10.0	–	–	–	–	–	–	–	–	–	–	–
PPHT 10-A2		0.8	8.4	9.6	9.8	9.9	9.9	10.0	10.0	–	–	–	–	–	–	–	–
PPHT 10-A2		1.0	8.0	9.4	9.6	9.7	9.8	9.9	10.0	10.0	10.0	–	–	–	–	–	–
PPHT 12-A2	**12**	0.5	11.0	11.9	12.0	12.0	–	–	–	–	–	–	–	–	–	–	–
PPHT 12-A2		1.0	10.0	11.4	11.6	11.7	11.8	11.9	12.0	12.0	12.0	–	–	–	–	–	–
PPHT 12-A2		2.0	8.0	10.1	10.4	10.6	10.9	11.0	11.2	11.3	11.5	11.7	11.9	12.0	–	–	–
PPHT 16-A2	**16**	1.0	14.0	15.4	15.6	15.7	15.8	15.9	16.0	16.0	16.0	–	–	–	–	–	–
PPHT 16-A2		1.3	13.4	15.1	15.3	15.4	15.6	15.7	15.8	15.9	15.9	16.0	–	–	–	–	–
PPHT 16-A2		2.0	12.0	14.1	14.4	14.6	14.9	15.0	15.2	15.3	15.5	15.7	15.9	16.0	–	–	–
PPHT 16-A2		3.0	10.0	12.6	13.0	13.3	13.6	13.9	14.1	14.3	14.5	14.9	15.2	15.7	15.9	16.0	–
PPHT 20-A2	**20**	1.0	18.0	19.4	19.6	19.7	19.8	19.9	20.0	20.0	20.0	–	–	–	–	–	–
PPHT 20-A2		1.6	16.8	18.7	18.9	19.1	19.3	19.4	19.6	19.7	19.8	19.9	20.0	–	–	–	–
PPHT 20-A2		3.0	14.0	16.6	17.0	17.3	17.6	17.9	18.1	18.3	18.5	18.9	19.2	19.7	19.9	20.0	–
PPHT 20-A2		4.0	12.0	15.0	15.5	15.9	16.2	16.5	16.8	17.1	17.3	17.8	18.2	18.9	19.4	19.7	20.0
PPHT 25-A2	**25**	2.0	21.0	23.1	23.4	23.6	23.9	24.0	24.2	24.3	24.5	24.7	24.9	25.0	–	–	–
PPHF 08-CE1	**8**	0.6	2.8	6.0	7.1	–	–	–	–	–	–	–	–	–	–	–	–
PPHF 10-CE1	**10**	0.8	3.6	6.8	7.9	9.0	–	–	–	–	–	–	–	–	–	–	–
PPHF 12-CE1	**12**	1.0	4.2	7.4	8.5	9.6	10.7	11.8	–	–	–	–	–	–	–	–	–
PPHF 16-CE1	**16**	1.3	5.6	8.8	9.9	11.0	12.1	13.2	14.2	15.3	–	–	–	–	–	–	–
PPHF 20-CE1	**20**	1.6	7.2	10.4	11.5	12.6	13.7	14.8	15.8	16.9	18.0	–	–	–	–	–	–
PPHF 25-CE1	**25**	1.9	9.2	12.4	13.5	14.6	15.7	16.8	17.8	18.9	20.0	22.7	–	–	–	–	–

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
8	FE	0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789
10		0.346	0.447	0.632	0.775	0.894	1.095	1.265	1.414	1.549	1.789	2.000
12		0.379	0.490	0.693	0.849	0.980	1.200	1.386	1.549	1.697	1.960	2.191
16		0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
RE	**µm**	**3**	**5**	**10**	**15**	**20**	**30**	**40**	**50**	**60**	**80**	**100**
1.3	FE	0.177	0.228	0.322	0.395	0.456	0.559	0.645	0.721	0.790	0.912	1.020
1.6		0.196	0.253	0.358	0.438	0.506	0.620	0.716	0.800	0.876	1.012	1.131
1.9		0.214	0.276	0.390	0.477	0.551	0.675	0.780	0.872	0.955	1.103	1.233
2.0		0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265
3.0		0.268	0.346	0.490	0.600	0.693	0.849	0.980	1.095	1.200	1.386	1.549
4.0		0.310	0.400	0.566	0.693	0.800	0.980	1.131	1.265	1.386	1.600	1.789



	DCX	RE	max
PPHT 08-A2	8	0.3	2.4
PPHT 08-A2		0.5	2.4
PPHT 08-A2		0.8	2.5
PPHT 08-A2		1.0	2.7
PPHT 10-A2	10	0.5	3.2
PPHT 10-A2		0.8	3.3
PPHT 10-A2		1.0	3.4
PPHT 12-A2	12	0.5	4.0
PPHT 12-A2		1.0	4.2
PPHT 12-A2		2.0	4.6
PPHT 16-A2	16	1.0	5.7
PPHT 16-A2		1.3	5.8
PPHT 16-A2		2.0	6.0
PPHT 16-A2		3.0	6.4
PPHT 20-A2	20	1.0	7.2
PPHT 20-A2		1.6	7.4
PPHT 20-A2		3.0	7.8
PPHT 20-A2		4.0	8.2
PPHT 25-A2	25	2.0	9.3

	DCX	RE	max
PPHF 08-CE1	8	0.6	2.0
PPHF 10-CE1	10	0.8	2.5
PPHF 12-CE1	12	1.0	3.0
PPHF 16-CE1	16	1.3	4.0
PPHF 20-CE1	20	1.6	5.0
PPHF 25-CE1	25	1.9	6.0

	DCX	RE	RPMX	APMX/l
PPHT 08-A2	8	0.3	6.3	1.2/11
PPHT 08-A2		0.5	6.1	1.2/12
PPHT 08-A2		0.8	5.7	1.2/12
PPHT 08-A2		1.0	6.8	1.2/11
PPHT 10-A2	10	0.5	6.9	1.5/13
PPHT 10-A2		0.8	6.6	1.5/13
PPHT 10-A2		1.0	7.5	1.5/12
PPHT 12-A2	12	0.5	7.9	1.8/13
PPHT 12-A2		1.0	7.5	1.8/14
PPHT 12-A2		2.0	9.0	1.8/12
PPHT 16-A2	16	1.0	8.9	2.4/16
PPHT 16-A2		1.3	8.9	2.4/16
PPHT 16-A2		2.0	8.5	2.4/17
PPHT 16-A2		3.0	12.3	2.4/11
PPHT 20-A2	20	1.0	9.3	3/19
PPHT 20-A2		1.6	9.1	3/19
PPHT 20-A2		3.0	8.8	3/20
PPHT 20-A2		4.0	11.4	3/15
PPHT 25-A2	25	2.0	8.3	3.7/26

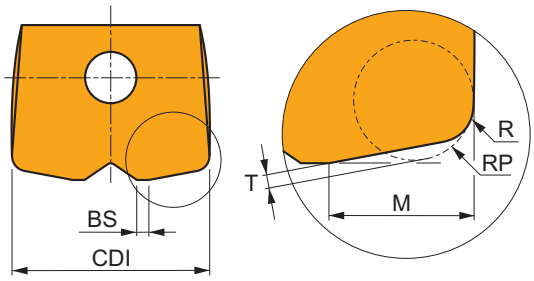
	DCX	RE	RPMX	APMX/l
PPHF 08-CE1	8	0.6	8.0	0.4/3
PPHF 10-CE1	10	0.8	8.0	0.5/4
PPHF 12-CE1	12	1.0	8.0	0.6/5
PPHF 16-CE1	16	1.3	8.0	0.8/6
PPHF 20-CE1	20	1.6	8.0	1.0/8
PPHF 25-CE1	25	1.9	8.0	1.2/9

	DCX	RE	DMIN	DMAX	SMAX DMIN	SMAX DMAX
PPHT 08-A2	8	0.3	11.0	15.9	0.5	0.5
PPHT 08-A2		0.5	10.9	15.9	0.5	0.5
PPHT 08-A2		0.8	10.7	15.9	0.4	0.4
PPHT 08-A2		1.0	10.3	15.9	0.4	0.4
PPHT 10-A2	10	0.5	13.4	19.9	0.7	0.7
PPHT 10-A2		0.8	13.2	19.9	0.6	0.6
PPHT 10-A2		1.0	12.9	19.9	0.6	0.6
PPHT 12-A2	12	0.5	15.8	23.9	1.0	1.0
PPHT 12-A2		1.0	15.4	23.9	0.8	0.8
PPHT 12-A2		2.0	14.6	23.9	0.7	0.7
PPHT 16-A2	16	1.0	20.4	31.9	1.3	1.3
PPHT 16-A2		1.3	20.2	31.9	1.3	1.3
PPHT 16-A2		2.0	19.7	31.9	1.0	1.0
PPHT 16-A2		3.0	18.9	31.9	1.2	1.2
PPHT 20-A2	20	1.0	25.4	39.9	1.8	1.8
PPHT 20-A2		1.6	24.9	39.9	1.6	1.6
PPHT 20-A2		3.0	24.1	39.9	1.2	1.2
PPHT 20-A2		4.0	23.3	39.9	1.3	1.3
PPHT 25-A2	25	2.0	31.1	49.9	1.8	1.8

	DCX	RE	DMIN	DMAX	SMAX DMIN	SMAX DMAX
PPHF 08-CE1	8	0.6	10.0	14.7	0.40	0.40
PPHF 10-CE1	10	0.8	13.0	18.4	0.50	0.50
PPHF 12-CE1	12	1.0	15.7	22.0	0.60	0.60
PPHF 16-CE1	16	1.3	20.9	29.4	0.80	0.80
PPHF 20-CE1	20	1.6	26.2	36.7	1.00	1.00
PPHF 25-CE1	25	1.9	33.0	46.1	1.20	1.20

	DCX	RE	a_p
PPHT 08-A2	**8**	0.3	0.52
PPHT 08-A2		0.5	0.47
PPHT 08-A2		0.8	0.39
PPHT 08-A2		1.0	0.40
PPHT 10-A2	**10**	0.5	0.69
PPHT 10-A2		0.8	0.61
PPHT 10-A2		1.0	0.62
PPHT 12-A2	**12**	0.5	0.97
PPHT 12-A2		1.0	0.79
PPHT 12-A2		2.0	0.68
PPHT 16-A2	**16**	1.0	1.33
PPHT 16-A2		1.3	1.26
PPHT 16-A2		2.0	1.03
PPHT 16-A2		3.0	1.15
PPHT 20-A2	**20**	1.0	1.80
PPHT 20-A2		1.6	1.59
PPHT 20-A2		3.0	1.21
PPHT 20-A2		4.0	1.27
PPHT 25-A2	**25**	2.0	1.83

	DCX	RE	a_p
PPHF 08-CE1	**8**	0.6	0.40
PPHF 10-CE1	**10**	0.8	0.50
PPHF 12-CE1	**12**	1.0	0.60
PPHF 16-CE1	**16**	1.3	0.80
PPHF 20-CE1	**20**	1.6	1.00
PPHF 25-CE1	25	1.9	1.20



DCX	R	RP	M	T
08	0.6	1.0	2.6	0.3
10	0.8	1.2	3.2	0.4
12	1.0	1.5	3.9	0.4
16	1.3	2.0	5.2	0.6
20	1.6	2.5	6.4	0.7
25	1.9	3.0	7.9	0.9

Overlapning (multipel af diameter *DCX*)	**< 3.0**	**3.0 – 3.5**	**3.6 – 4.0**	**4.1 – 4.5**	**> 4.6**
Multiplikationsfaktor for hastighed	1.0	0.9	0.8	0.7	0.5

K3-CXP

P M K S H

PRAMET

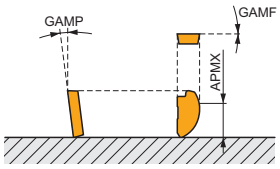
C

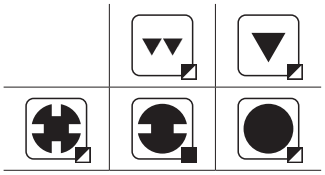
MULTISITE WP-profil Fræser

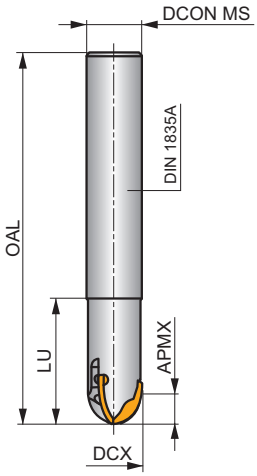
Kugleformet fræser med XP .. skær med APMX fra 8 op til 16 mm. Unik fastspænding muliggør brug af tre skær. Fås i cylindrisk og modulær stil. Krop behandlet for længere værktøjslevetid.

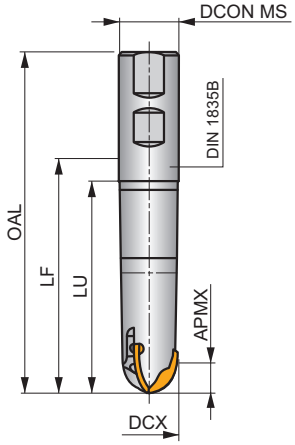
MULTISIDE XP

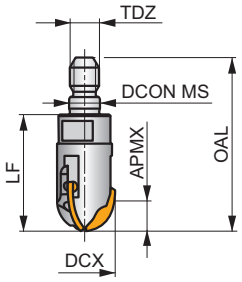
APMX	8.0 - 16.0 mm











h_m	0.05 - 0.19

	Product	DCX (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	APMX (mm)	GAMF (°)	GAMP (°)			max.		kg		
	16K3R050A16-CXP16	16	200	16	50	–	–	–	8.00	0	-5	3	–	22600	–	0.35	GI267	C0520
	16K3R050A20-CXP16	16	200	20	50	–	–	–	8.00	0	-5	3	–	22600	–	0.50	GI267	C0520
DIN 1835A	**20K3R050A20-CXP20**	20	200	20	50	–	–	–	10.00	0	-5	3	–	20000	–	0.52	GI268	C0521
	20K3R060A25-CXP20	20	250	25	60	–	–	–	10.00	0	-5	3	–	20000	–	0.92	GI268	C0521
	25K3R060A25-CXP25	25	250	25	60	–	–	–	12.50	0	-5	3	–	20000	–	0.96	GI269	C0522
	32K3R080A32-CXP32	32	250	32	80	–	–	–	16.00	0	-5	3	–	15000	–	1.50	GI270	C0523
	16K3R060B20-CXP16	16	111	20	60	–	86.5	–	8.00	0	-5	3	–	22600	–	0.23	GI267	C0520
DIN 1835B	**20K3R070B25-CXP20**	20	127	25	70	–	95.5	–	10.00	0	-5	3	–	20000	–	0.41	GI268	C0521
	25K3R080B25-CXP25	25	137	25	80	–	105	–	12.50	0	-5	3	–	20000	–	0.49	GI269	C0522
	16K3R035M10-CXP16	16	–	10.5	–	–	35	M10	8.00	0	-5	3	–	–	–	0.07	GI267	C0520
MODULAR	**20K3R040M10-CXP20**	20	–	10.5	–	–	40	M10	10.00	0	-5	3	–	–	–	0.07	GI268	C0521
	25K3R045M12-CXP25	25	–	12.5	–	–	45	M12	12.50	0	-5	3	–	–	–	0.16	GI269	C0522

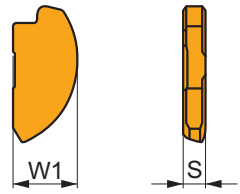
GI267	XP 16..
GI268	XP 20..
GI269	XP 25..
GI270	XP 32..

		Nm			
C0520	US 63009-T09P	1.2	M 3	9	Flag T09P
C0521	US 63513-T15P	3.0	M 3.5	13	Flag T15P
C0522	US 64014-T15P	3.5	M 4	14	Flag T15P
C0523	US 65017-T20P	5.0	M 5	17	Flag T20P

XP

PRAMET

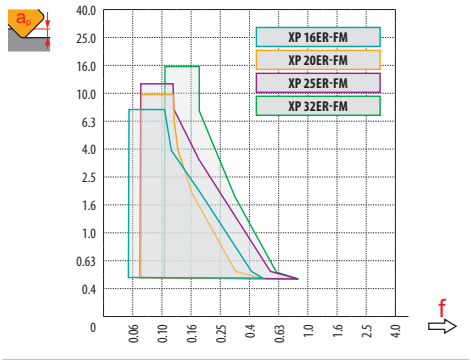
	W1 (mm)	S (mm)
16	16.000	2.00
20	20.000	2.50
25	25.000	3.17
32	32.000	4.00



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

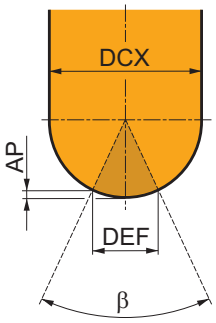
Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			FM geometri med neutralt design til let bearbejdning.																	
XP 16ER-FM:M8310		–	■ 285	0.27	0.8	◪ 145	0.24	0.8	■ 270	0.27	0.8	–	–	–	–	–	–	■ 55	0.19	0.8
XP 20ER-FM:M8330		–	■ 260	0.27	1.0	◪ 155	0.24	1.0	■ 245	0.27	1.0	–	–	–	◪ 65	0.19	1.0	◪ 50	0.19	1.0
XP 20ER-FM:M8345		–	■ 190	0.27	1.0	◪ 110	0.24	1.0	–	–	–	–	–	–	◪ 45	0.19	1.0	–	–	–
XP 25ER-FM:M8310		–	■ 270	0.27	1.3	◪ 135	0.24	1.3	■ 255	0.27	1.3	–	–	–	–	–	–	■ 50	0.19	1.3
XP 32ER-FM:M8345		–	■ 180	0.27	1.6	◪ 105	0.24	1.6	–	–	–	–	–	–	◪ 45	0.19	1.6	–	–	–

	XP 16-FM	XP 20-FM	XP 25-FM	XP 32-FM
RE	8.0	10.0	12.5	16.0
BS	–	–	–	–



DCX	a_p	0.3	0.4	0.5	0.7	1.0	1.25	1.5	2.0	2.5	3.0	4.0	5.0	6.0	8.0	10.0	12.0	15.0
16	DEF	4.3	5.0	5.6	6.5	7.7	8.6	9.3	10.6	11.6	12.5	13.9	14.8	15.5	16.0	–	–	–
20		4.9	5.6	6.2	7.4	8.7	9.7	10.5	12.0	13.2	14.3	16.0	17.3	18.3	19.6	20.0	–	–
25		5.4	6.3	7.0	8.2	9.8	10.9	11.9	13.6	15.0	16.2	18.3	20.0	21.4	23.3	24.5	25.0	–
32		6.2	7.1	7.9	9.4	11.1	12.4	13.5	15.5	17.2	18.7	21.2	23.2	25.0	27.7	29.7	31.2	31.9

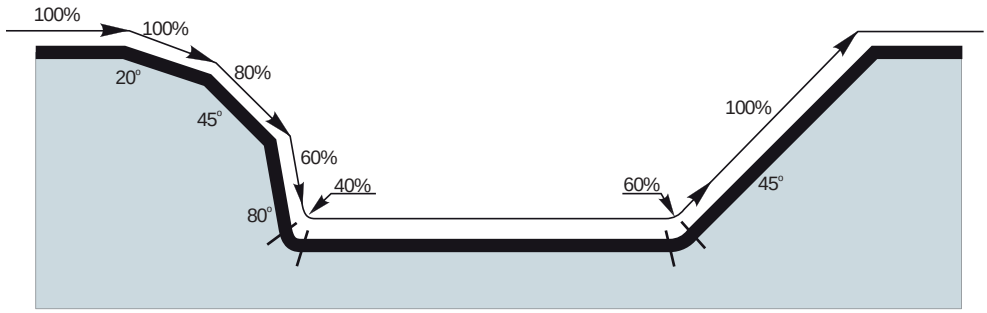
Effektivt område for 1 værktøjsskær.



DCX	β	DEF	AP
16	41°	5.568	0.51
20	37°	6.314	0.52
25	37°	7.901	0.65
32	37°	10.122	0.83

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
16	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25	FE	0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578

DEF	a_e	1.0 %	2.5 %	5.0 %	7.5 %	10 %	15 %	20 %	25 %	30 %	35 %	40 %	45 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
	a_p										⇨x.f									
19.9 %	1.0 %	2.86	1.84	1.33	1.12	1.00	0.89	–	–	–	–	–	–	–	–	–	–	–	–	–
31.2 %	2.5 %	3.58	2.28	1.64	1.36	1.20	1.01	0.92	0.88	0.91	–	–	–	–	–	–	–	–	–	–
43.6 %	5.0 %	4.22	2.68	1.92	1.58	1.39	1.16	1.03	0.95	0.90	0.88	0.89	–	–	–	–	–	–	–	–
52.7 %	7.5 %	4.63	2.95	2.10	1.73	1.51	1.26	1.11	1.02	0.96	0.91	0.89	0.88	0.90	–	–	–	–	–	–
60.0 %	10.0 %	4.94	3.14	2.24	1.84	1.61	1.33	1.18	1.07	1.00	0.95	0.91	0.89	0.88	1.00	–	–	–	–	–
71.4 %	15.0 %	5.39	3.42	2.43	2.00	1.74	1.44	1.27	1.15	1.07	1.01	0.96	0.93	0.90	0.88	0.93	–	–	–	–
80.0 %	20.0 %	5.70	3.62	2.57	2.11	1.84	1.52	1.33	1.21	1.12	1.05	1.00	0.96	0.93	0.89	0.88	0.89	1.00	–	–
86.6 %	25.0 %	5.93	3.76	2.67	2.20	1.91	1.58	1.38	1.25	1.16	1.08	1.03	0.99	0.95	0.90	0.88	0.88	0.89	–	–
91.7 %	30.0 %	6.10	3.87	2.75	2.26	1.96	1.62	1.42	1.28	1.18	1.11	1.05	1.01	0.97	0.92	0.89	0.88	0.88	0.93	–
95.4 %	35.0 %	6.23	3.95	2.80	2.30	2.00	1.65	1.44	1.31	1.20	1.13	1.07	1.02	0.98	0.93	0.89	0.88	0.88	0.90	–
98.0 %	40.0 %	6.31	4.00	2.84	2.33	2.03	1.67	1.46	1.32	1.22	1.14	1.08	1.03	0.99	0.93	0.90	0.89	0.88	0.89	–
99.5 %	45.0 %	6.36	4.03	2.86	2.35	2.04	1.68	1.47	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	–
100.0 %	50.0 %	6.38	4.04	2.87	2.35	2.05	1.69	1.48	1.33	1.23	1.15	1.09	1.04	1.00	0.94	0.90	0.89	0.88	0.88	1.00



Overlapning (multipel af diameter *DCX*)	< 3.0	3.1 – 4.0	4.1 – 6.0	> 6.1
Multiplikationsfaktor for hastighed	1.0	0.9	0.7	0.5

PROFILE MILLING – BULL NOSE

	SVC22C	SCN05C	SWN04C			
	90°	90° (93°)	90° (93°)			
	APMX (mm) 3.0 (16.0)	APMX (mm) 0.5 (1.0)	APMX (mm) 0.5 (2.0)			
	DC (mm) 32 – 80	DC (mm) 12 – 20	DC (mm) 16 – 35			
Cylindrical shank	DC = 32, 40 (mm)	DC = 12 – 20 (mm)	DC = 16 – 32 (mm)			
Weldon						
Modular	DC = 32, 40 (mm)	DC = 12 – 20 (mm)	DC = 16 – 35 (mm)			
Shell mill	DC = 50 – 80 (mm)					
Page	240	243	246			
ISO	N	P K H	P K H			
Insert shape						
Inserts	VCGT 220530	CN.. 0502	WN.. 0403			
No. of cutting edges	2	4	6			
Fræsning af formflader (kopifræsning)		■	■			
Planfræsning		■	■			
Spiralformet interpolation	■					
Progressiv neddykning	■					
Ramping	◪	■	■			
Fræsning i lav spor	◪					
Dyb hjørne fræsning	◪	■	■			
Dykfræsning		■	■			

■ Primary use ◪ Possible use

SVC22C

N

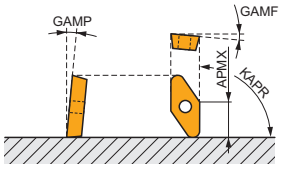
PRAMET

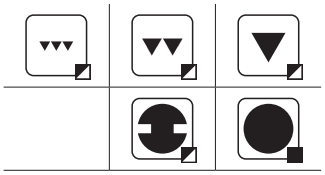
S

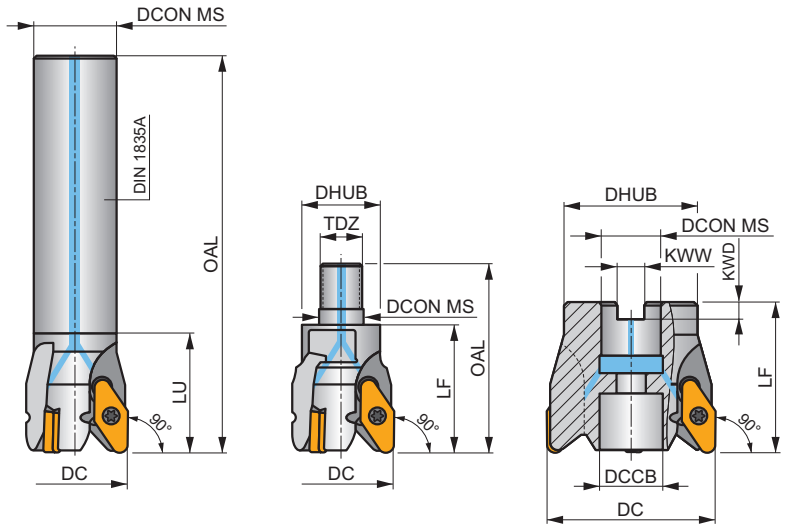
Fræser til bearbejdning af ikke-jernholdige materialer med intern kølevæske

Meget produktiv fræser til aluminium og ikke-jernholdigt materiale ved hjælp af VCGT 22 skær med APMX på 16 mm. Intern kølevæske. Velegnet til plan, progressivt spring, hjørne, ramping og sporfræsning. Fås i cylindrisk, modulær og dorn-type. Krop behandlet for længere værktøjslevetid.

KAPR	90°
APMX	3.0 (16.0) mm







h_m	0.03 - 0.5
h_m	0.03 - 0.55

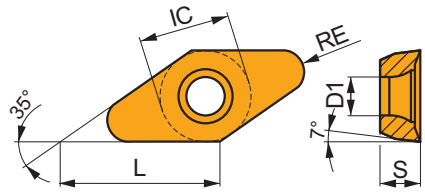
	Product	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	DHUB (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	**32A2R045A25-SVC22C**	32	120	25	–	45	–	–	–	–	–	4	3	2	–	10400	✓	0.46	GI141	C0560
	40A3R045A32-SVC22C	40	150	32	–	45	–	–	–	–	–	8	3	3	–	9300	✓	0.91	GI141	C0560
MODULAR	**32A2R048M16-SVC22C**	32	71	17	–	–	48	29	M16	–	–	11	3	2	–	–	✓	0.17	GI141	C0560
	40A3R048M16-SVC22C	40	71	17	–	–	48	29	M16	–	–	13	3	3	–	–	✓	0.24	GI141	C0560
ISO 6462 DIN 8030	**50A03R-S90VC22C**	50	–	22	18	–	56	40	–	10	6.3	4	3	3	–	8400	✓	0.42	GI141	C0563
	63A04R-S90VC22C	63	–	22	18	–	56	50	–	10	6.3	6	3	4	–	7400	✓	0.68	GI141	C0563
	80A05R-S90VC22C	80	–	27	20	–	56	63	–	12	7	8	3	5	–	6600	✓	1.12	GI141	C0562

GI141	VCGT 220530F-FA

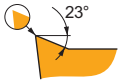
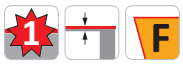
		Nm					
C0560	US 4511-T20	5.0	M 4.5	11	–	–	Flag T20
C0562	US 4511-T20	5.0	M 4.5	11	SDR T20-T	–	–
C0563	US 4511-T20	5.0	M 4.5	11	SDR T20-T	HS 1030C	–

VCGT 22-FA

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
2205	12.700	5.20	22.00	5.50

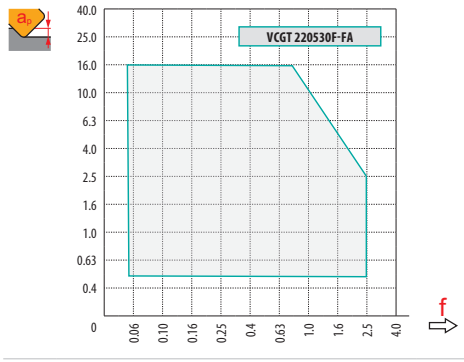


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
			**FA** geometri med meget positivt design til medium til grov bearbejdning.																			
VCGT 220515F-FA:HF7	●	1.5	–	–	–	–	–	–	–	–	–	■	255	0.24	0.4	–	–	–	–	–	–
VCGT 220520F-FA:HF7	●	2.0	–	–	–	–	–	–	–	–	–	■	255	0.30	0.5	–	–	–	–	–	–
VCGT 220530F-FA:HF7	●	3.0	–	–	–	–	–	–	–	–	–	■	210	0.48	1.0	–	–	–	–	–	–

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	VCGT 22-FA		
RE	1.5	2.0	3.0
BS	–	–	–



a_p	0.5	3.0	12.0
f	0.86	0.31	0.05

DC	RPMX	APMX/I
32	8.0	12.0/87
40	8.0	12.0/87
50	6.0	10.4/100
63	4.2	7.2/100
80	3.1	5.3/100

DC	DMIN	DMAX	SMAX DMIN	SMAX DMAX
32	42.0	64.0	4.2	12.0
40	58.0	80.0	7.7	12.0
50	78.0	100.0	9.0	12.0
63	104.0	126.0	9.3	12.0
80	138.0	160.0	9.7	12.0

a_p
9

DC	µm	3	5	10	15	20	30	40	50	60	80	100
32	FE	0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
RE	µm	3	5	10	15	20	30	40	50	60	80	100
3.0	FE	0.268	0.346	0.490	0.600	0.693	0.849	0.980	1.095	1.200	1.386	1.549

SCN05C

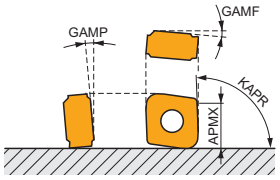
P K H

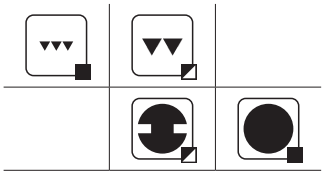
PRAMET S

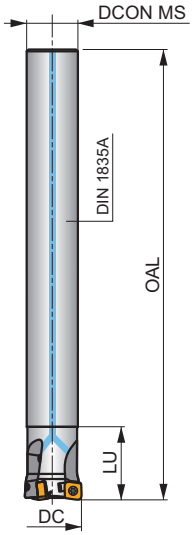
Endefræser til applikationer til matricer og støbeforme med intern kølevæske

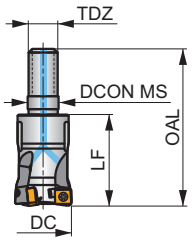
Endefræser til en lang række applikationer i efterbehandlingsområdet til værktøjsfremstilling med APMX på 0.5 mm. Højpræcisionsstøbt dobbeltsidet CNHX 05-skær med 4 skærekanter giver høj nøjagtighed og økonomi. Fås i cylindrisk og modulær stil. Krop behandlet for længere værktøjslevetid.

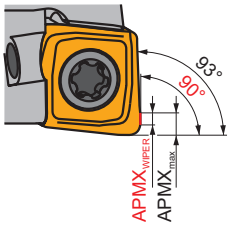
KAPR	90° (93°)
APMX	0.5 (1.0 mm)











h_m 0.02 - 0.07

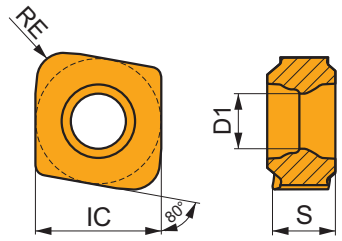
	Product	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	TDZ	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	**12A2R020A10-SCN05C-C**	12	100	10	20	–	–	-15	-8	2	–	48700	✓	0.08	GI330	C0601
	16A3R020A14-SCN05C-C	16	130	14	20	–	–	-13.5	-7.8	3	–	42200	✓	0.16	GI330	C0601
	20A5R020A18-SCN05C-C	20	160	18	20	–	–	-12.7	-7.5	5	✓	37700	✓	0.31	GI330	C0601
MODULAR	**12A2R020M06-SCN05C-C**	12	35	6.5	–	20	M6	-15	-8	2	–	–	✓	0.04	GI330	C0601
	16A3R025M08-SCN05C-C	16	43	8.5	–	25	M8	-13.5	-7.8	3	–	–	✓	0.05	GI330	C0601
	20A5R030M10-SCN05C-C	20	49	10.5	–	30	M10	-12.7	-7.5	5	✓	–	✓	0.08	GI330	C0601

GI330	CNHX0502..

		Nm			
C0601	US 62005-T06P	0.9	M 2	4.9	Flag T06P

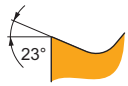
CNHX 05

	IC	D1	S
	(mm)	(mm)	(mm)
0502	4.800	2.10	2.40



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
CNHX 050205ER-WM:M4310	●	0.5	350	0.10	0.5	–	–	–	335	0.10	0.5	–	–	–	–	–	–	70	0.10	0.5
CNHX 050205ER-WM:M8330	⬌	0.5	310	0.10	0.5	–	–	–	290	0.10	0.5	–	–	–	–	–	–	60	0.10	0.5
CNHX 050210ER-WM:M4310	⬌	1.0	440	0.10	0.5	–	–	–	420	0.10	0.5	–	–	–	–	–	–	85	0.10	0.5
CNHX 050210ER-WM:M8330	⬌	1.0	390	0.10	0.5	–	–	–	370	0.10	0.5	–	–	–	–	–	–	75	0.10	0.5

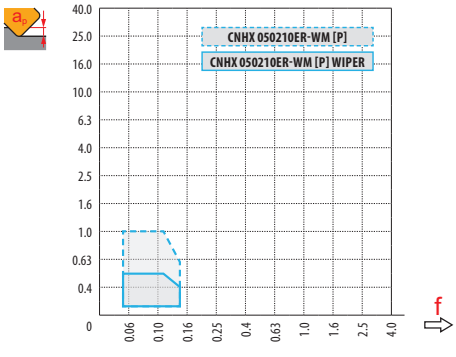


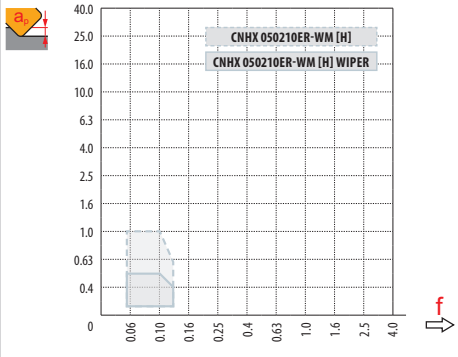
WM geometri med Wiper design til halvbearbejdning til færdigbearbejdning.

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00

a_e / DC	0.5 %	1.0 %	2.0 %	3.0 %	4.0 %	5.0 %
X.V	2.04	1.85	1.68	1.59	1.53	1.48

	CNHX 05-WM	
RE	0.5	1.0
BS	0.50	0.50





DC	max
12	0.4
16	0.4
20	0.5

DC	RPMX	APMX/I
12	2.4	1/25
16	1.5	1/40
20	1.1	1/54

SWN04C

P K H

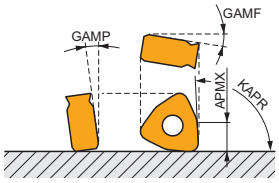
PRAMET

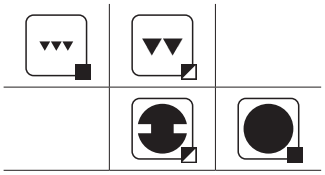
S

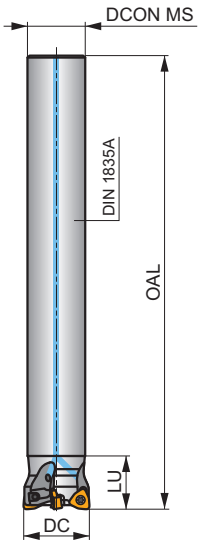
Endefræser til applikationer til matricer og støbeforme med intern kølevæske

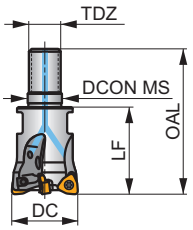
Endefræser til en lang række applikationer i efterbehandlingsområdet til værktøjsfremstilling med APMX på 0.5 mm. Højpræcisions WNHX 04-skær med 6 skærekanter giver høj nøjagtighed og økonomi. Fås i cylindrisk og modulær stil. Krop behandlet for længere værktøjslevetid.

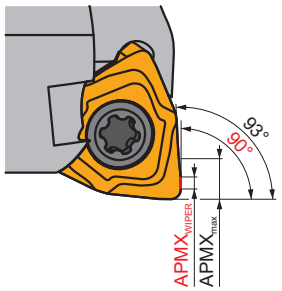
KAPR	90° (93°)
APMX	0.5 (2.0 mm)











h_m 0.02 - 0.07

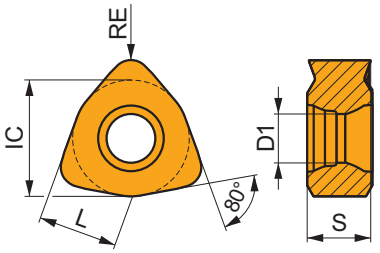
	Product	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	TDZ	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	**16A2R020A14-SWN04C-C**	16	140	14	20	–	–	-13.5	-8	2	–	33200	✓	0.14	GI331	C0602
	20A3R020A18-SWN04C-C	20	160	18	20	–	–	-12	-8	3	–	19700	✓	0.27	GI331	C0602
	25A4R020A22-SWN04C-C	25	180	22	20	–	–	-11.5	-8	4	✓	26600	✓	0.45	GI331	C0602
	32A6R020A25-SWN04C-C	32	200	25	20	–	–	-11.2	-8	6	✓	23500	✓	0.69	GI331	C0602
MODULAR	**16A2R025M08-SWN04C-C**	16	43	8.5	–	25	M08	-13.5	-8	2	–	33200	✓	0.05	GI331	C0602
	20A3R030M10-SWN04C-C	20	49	10.5	–	30	M10	-12	-8	3	–	–	✓	0.07	GI331	C0602
	25A4R033M12-SWN04C-C	25	55	12.5	–	33	M12	-11.5	-8	4	✓	–	✓	0.10	GI331	C0602
	32A6R040M16-SWN04C-C	32	63	17	–	40	M16	-11.2	-8	6	✓	–	✓	0.21	GI331	C0602
	35A6R043M16-SWN04C-C	35	66	17	–	43	M16	-11.1	-8	6	✓	–	✓	0.22	GI331	C0602

GI331	WNHX0403..

C0602	US 42507-T07P	1.2	M 2.5	7	Flag T07P

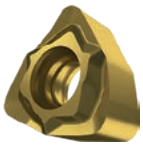
WNHX 04

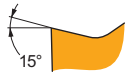
	IC	D1	S
	(mm)	(mm)	(mm)
0403	6.200	2.60	3.38



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
WNHX 040305ER-WM:M4310	●	0.5	◪ 290	0.15	1.0	–	–	–	■ 275	0.15	1.0	–	–	–	–	–	–	■ 55	0.10	0.7
WNHX 040305ER-WM:M8330	⬌	0.5	■ 260	0.15	1.0	–	–	–	■ 245	0.15	1.0	–	–	–	–	–	–	◪ 50	0.10	0.7
WNHX 040310ER-WM:M4310	⬌	1.0	◪ 370	0.15	1.0	–	–	–	■ 350	0.15	1.0	–	–	–	–	–	–	■ 70	0.10	0.7
WNHX 040310ER-WM:M8330	⬌	1.0	■ 330	0.15	1.0	–	–	–	■ 310	0.15	1.0	–	–	–	–	–	–	◪ 65	0.10	0.7
WNHX 040315ER-WM:M4310	⬌	1.5	◪ 390	0.15	1.0	–	–	–	■ 370	0.15	1.0	–	–	–	–	–	–	■ 75	0.10	0.7
WNHX 040315ER-WM:M8330	⬌	1.5	■ 345	0.15	1.0	–	–	–	■ 325	0.15	1.0	–	–	–	–	–	–	◪ 65	0.10	0.7



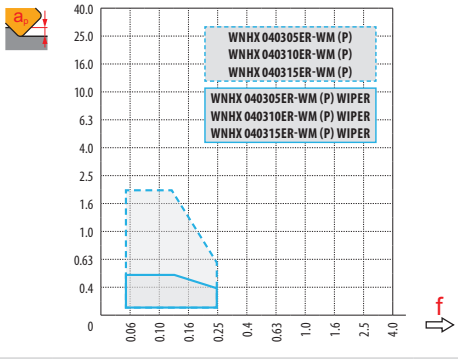


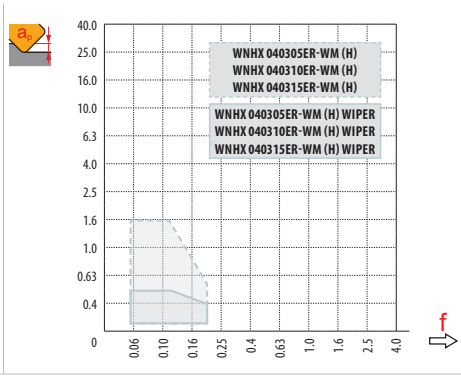
WM geometri med Wiper design til halvbearbejdning til færdigbearbejdning.

a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00

a_e / DC	0.5 %	1.0 %	2.0 %	3.0 %	4.0 %	5.0 %
X.V	2.04	1.85	1.68	1.59	1.53	1.48

	WNHX 04-WM		
RE	0.5	1.0	1.5
BS	0.50	0.50	0.50



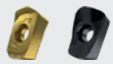


DC	max
16	
20	0.4
25	0.5
32	0.5
35	0.5

DC	RPMX	APMX/I
16		
20	0.7	1.1/100
25	0.5	0.75/100
32	0.3	0.4/100
35	0.3	0.4/100

FRÆSNING MED HØJ TIISPÆNDNING

HIGH FEED MILLING – POSITIVE INSERTS

	SBN10	SSN11				
	20°	18°				
	APMX (mm) 1.0	APMX (mm) 1.7				
	DCX (mm) 16 – 66	DCX (mm) 32 – 125				
Cylindrical shank	DCX = 16 – 35 (mm)	DCX = 32, 35 (mm)				
Weldon						
Modular	DCX = 16 – 40 (mm)	DCX = 32 – 40 (mm)				
Shell mill	DCX = 40 – 66 (mm)	DCX = 40 – 125 (mm)				
Page	252	258				
ISO	P M K S H	P M K S H				
Insert shape						
Inserts	BNGX 10T3 ANHX 10T3	SNGX 1104				
No. of cutting edges	4 / 2	8				
Face milling	■	■				
Helical interpolation	■	◪				
Shallow shoulder milling	■	■				
Plunge milling	■	■				
Progressive plunging	■	◪				
Ramping	■	◪				
Shape surfaces milling (copy milling)	■	■				
Shallow slot milling	◪	◪				

■ Primary use ◪ Possible use

SBN10

P M K S H

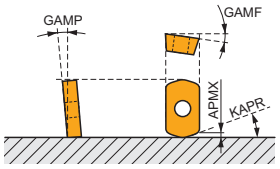
PRAMET

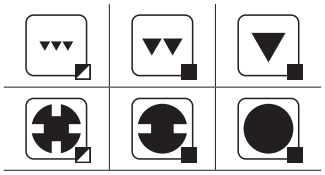
S

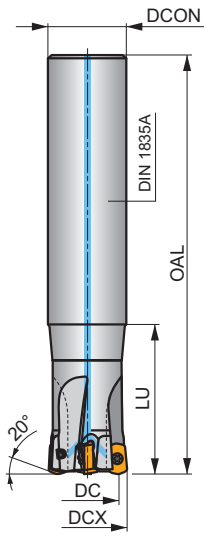
High Feed fræser til BN .. 10 skær med intern kølevæske, næste generation

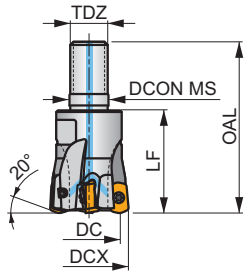
High feed fræser til mindre diametre ved hjælp af dobbeltsidede BNGX 10 skær med fire skærekanter og APMX på 1 mm. Intern kølevæske. Velegnet til en lang række applikationer. Fås i cylindrisk, modulær og dorn-type. Krop behandlet for længere værktøjslevetid.

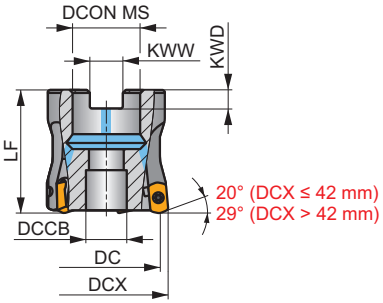
KAPR	20° (29°)
APMX	1.0 mm











h_m	0.17 - 0.41
h_m	0.17 - 0.41

	Product	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	KAPR (°)	GAMF (°)	GAMP (°)			max.		kg		
	16E2R030A16-SBN10-C	16	9.4	100	16	–	30	–	–	–	–	20	-12	-10	2	✓	31100	✓	0.13	GI329	C0310
	16E2R050A16-SBN10-C	16	9.4	150	16	–	50	–	–	–	–	20	-12	-10	2	–	31100	✓	0.18	GI329	C0310
	16E2R030A14-SBN10-C	16	9.4	150	14	–	30	–	–	–	–	20	-12	-10	2	–	31100	✓	0.18	GI329	C0310
	18E2R030A16-SBN10-C	18	11.4	150	16	–	30	–	–	–	–	20	-11	-10	2	–	29200	✓	0.23	GI329	C0310
	20E3R040A20-SBN10-C	20	13.4	130	20	–	40	–	–	–	–	20	-10	-10	3	–	27700	✓	0.25	GI329	C0310
	20E3R080A20-SBN10-C	20	13.4	160	20	–	80	–	–	–	–	20	-10	-10	3	–	27700	✓	0.29	GI329	C0310
	20E3R040A18-SBN10-C	20	13.4	180	18	–	40	–	–	–	–	20	-10	-10	3	–	27700	✓	0.29	GI329	C0310
	20E4R040A20-SBN10-C	20	13.4	130	20	–	40	–	–	–	–	20	-10	-10	4	–	27700	✓	0.28	GI329	C0310
DIN 1835A	**25E4R050A25-SBN10-C**	25	18.4	140	25	–	50	–	–	–	–	20	-9	-10	4	✓	24800	✓	0.42	GI329	C0310
	25E4R100A25-SBN10-C	25	18.4	180	25	–	100	–	–	–	–	20	-9	-10	4	✓	24800	✓	0.51	GI329	C0310
	25E4R050A22-SBN10-C	25	18.4	220	22	–	50	–	–	–	–	20	-9	-10	4	✓	24800	✓	0.58	GI329	C0310
	25E5R050A25-SBN10-C	25	18.4	140	25	–	50	–	–	–	–	20	-9	-10	5	–	24800	✓	0.42	GI329	C0310
	32E5R070A32-SBN10-C	32	25.4	150	32	–	70	–	–	–	–	20	-8	-10	5	✓	21900	✓	0.73	GI329	C0310
	32E6R070A32-SBN10-C	32	25.4	150	32	–	70	–	–	–	–	20	-8	-10	6	✓	21900	✓	0.76	GI329	C0310
	32E5R120A32-SBN10-C	32	25.4	200	32	–	120	–	–	–	–	20	-8	-10	5	✓	21900	✓	0.96	GI329	C0310
	35E5R050A32-SBN10-C	35	28.4	200	32	–	50	–	–	–	–	20	-7.5	-10	5	✓	21000	✓	1.08	GI329	C0310
	35E6R050A32-SBN10-C	35	28.4	200	32	–	50	–	–	–	–	20	-7.5	-10	6	✓	21000	✓	1.08	GI329	C0310
	16E2R025M08-SBN10-C	16	9.4	43	8.5	–	–	25	M8	–	–	20	-12	-10	2	–	31100	✓	0.05	GI329	C0310
	18E2R025M08-SBN10-C	18	11.4	43	8.5	–	–	25	M8	–	–	20	-11	-10	2	–	29200	✓	0.05	GI329	C0310
	20E3R030M10-SBN10-C	20	13.4	49	10.5	–	–	30	M10	–	–	20	-10	-10	3	–	27700	✓	0.07	GI329	C0310
	20E4R030M10-SBN10-C	20	13.4	49	10.5	–	–	30	M10	–	–	20	-10	-10	4	–	27700	✓	0.06	GI329	C0310
MODULAR	**25E4R033M12-SBN10-C**	25	18.4	55	12.5	–	–	33	M12	–	–	20	-9	-10	4	✓	24800	✓	0.08	GI329	C0310
	25E5R033M12-SBN10-C	25	18.4	55	12.5	–	–	33	M12	–	–	20	-9	-10	5	–	24800	✓	0.10	GI329	C0310
	28E5R035M12-SBN10-C	28	21.4	57	12.5	–	–	35	M12	–	–	20	-8.5	-10	5	✓	23400	✓	0.12	GI329	C0310
	32E5R040M16-SBN10-C	32	25.4	63	17	–	–	40	M16	–	–	20	-8	-10	5	✓	21900	✓	0.21	GI329	C0310
	32E6R040M16-SBN10-C	32	25.4	63	17	–	–	40	M16	–	–	20	-8	-10	6	✓	21900	✓	0.21	GI329	C0310
	35E6R043M16-SBN10-C	35	28.4	66	17	–	–	43	M16	–	–	20	-7.5	-10	6	✓	21000	✓	0.23	GI329	C0310

	Product	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	KAPR (°)	GAMF (°)	GAMP (°)			max.		kg		
MODULAR	**40E6R043M16-SBN10-C**	40	33.4	66	17	–	–	43	M16	–	–	20	-7	-10	6	✓	19600	✓	0.27	GI329	C0310
MODULAR	**40E7R043M16-SBN10-C**	40	33.4	66	17	–	–	43	M16	–	–	20	-7	-10	7	✓	19600	✓	0.26	GI329	C0310
	40A05R-SMOBN10-C	40	33.4	–	16	14.1	–	40	–	8.4	5.6	20	-7	-10	5	✓	19600	✓	0.23	GI329	C0312
	40A07R-SMOBN10-C	40	33.4	–	16	14.1	–	40	–	8.4	5.6	20	-7	-10	7	✓	19600	✓	0.27	GI329	C0312
	42A05R-SMOBN10-C	42	35.4	–	16	14.1	–	40	–	8.4	5.6	20	-7	-10	5	✓	19100	✓	0.23	GI329	C0312
	42A07R-SMOBN10-C	42	35.4	–	16	14.1	–	40	–	8.4	5.6	20	-7	-10	7	✓	19100	✓	0.36	GI329	C0312
ISO 6462 DIN 8030	**50A07R-SMOBN10-C**	50	45	–	22	18.1	–	40	–	10.4	6.3	29	-6	-7	7	✓	17500	✓	0.46	GI343	C0311
ISO 6462 DIN 8030	**50A08R-SMOBN10-C**	50	45	–	22	18.1	–	40	–	10.4	6.3	29	-6	-7	8	✓	17500	✓	0.34	GI343	C0311
ISO 6462 DIN 8030	**52A07R-SMOBN10-C**	52	47	–	22	18.1	–	40	–	10.4	6.3	29	-6	-7	7	✓	17200	✓	0.49	GI343	C0311
ISO 6462 DIN 8030	**52A08R-SMOBN10-C**	52	47	–	22	18.1	–	40	–	10.4	6.3	29	-6	-7	8	✓	17200	✓	0.37	GI343	C0311
ISO 6462 DIN 8030	**66A08R-SMOBN10-C**	66	61	–	27	22.1	–	50	–	12.4	7	29	-6	-7	8	✓	15200	✓	0.89	GI343	C0313

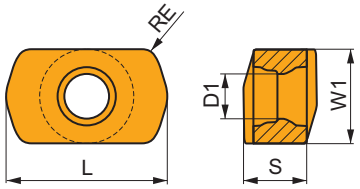
GI329	BNGX 10T3…	ANHX 10T3..
GI343	BNGX 10T3…	–

		Nm						
C0310	US 42507-T07P	1.2	M 2.5	7	Flag T07P	–	–	–
C0313	US 42507-T07P	1.2	M 2.5	7	–	D-T07P/T09P	FG-15	HS 1230C
C0312	US 42507-T07P	1.2	M 2.5	7	–	D-T07P/T09P	FG-15	HS 0830C
C0311	US 42507-T07P	1.2	M 2.5	7	–	D-T07P/T09P	FG-15	HS 1030C

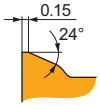
BNGX 10

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
10T3	5.800	2.76	9.92	3.90

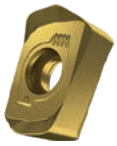
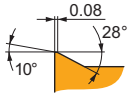
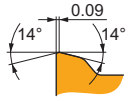


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
BNGX 10T308SR-M:8215	0.8	240	0.65	0.7	–	–	–	225	0.65	0.7	–	–	–	–	–	–	45	0.36	0.5
BNGX 10T308SR-M:M6330	0.8	210	0.65	0.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
BNGX 10T308SR-M:M8310	0.8	250	0.65	0.7	–	–	–	235	0.65	0.7	–	–	–	–	–	–	50	0.36	0.5
BNGX 10T308SR-M:M8330	0.8	240	0.65	0.7	–	–	–	225	0.65	0.7	–	–	–	–	–	–	45	0.36	0.5
BNGX 10T308SR-M:M8340	0.8	225	0.65	0.7	–	–	–	210	0.65	0.7	–	–	–	–	–	–	–	–	–
BNGX 10T308SR-M:M8345	0.8	180	0.65	0.7	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
BNGX 10T308SR-M:M9325	0.8	275	0.65	0.7	–	–	–	260	0.65	0.7	–	–	–	–	–	–	55	0.36	0.5

M geometri med positivt design til high feed bearbejdning.

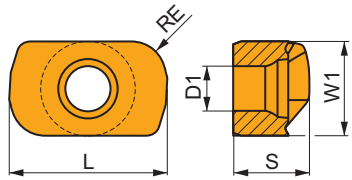
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 	**MM** geometri med meget positivt design til bearbejdning med high feed.																		
BNGX 10T308SR-MM:M6330	0.8	215	0.65	0.6	150	0.59	0.6	–	–	–	–	–	–	60	0.46	0.5	–	–	–
BNGX 10T308SR-MM:M8310	0.8	255	0.65	0.6	130	0.59	0.6	–	–	–	–	–	–	–	–	–	–	–	–
BNGX 10T308SR-MM:M8330	0.8	245	0.65	0.6	145	0.59	0.6	–	–	–	–	–	–	60	0.46	0.5	–	–	–
BNGX 10T308SR-MM:M8340	0.8	230	0.65	0.6	135	0.59	0.6	–	–	–	–	–	–	55	0.46	0.5	–	–	–
BNGX 10T308SR-MM:M8345	0.8	180	0.65	0.6	105	0.59	0.6	–	–	–	–	–	–	45	0.46	0.5	–	–	–
BNGX 10T308SR-MM:M9325	0.8	280	0.65	0.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
BNGX 10T308SR-MM:M9340	0.8	250	0.65	0.6	150	0.59	0.6	–	–	–	–	–	–	60	0.46	0.5	–	–	–
	**HM** geometri med stærkt design til high feed bearbejdning																		
BNGX 10T308SR-HM:8215	0.8	–	–	–	–	–	–	240	0.65	0.4	–	–	–	–	–	–	50	0.65	0.4
BNGX 10T308SR-HM:M8310	0.8	–	–	–	–	–	–	250	0.65	0.4	–	–	–	–	–	–	50	0.65	0.4
BNGX 10T308SR-HM:M8330	0.8	–	–	–	–	–	–	240	0.65	0.4	–	–	–	–	–	–	50	0.65	0.4

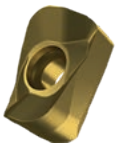
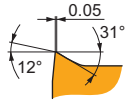
ANHX 10

PRAMET

	W1 (mm)	D1 (mm)	L (mm)	S (mm)
10T3	5.800	2.76	9.72	4.70



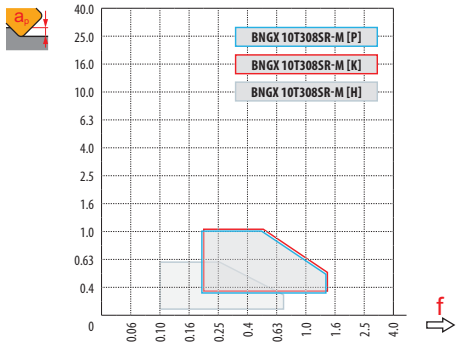
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

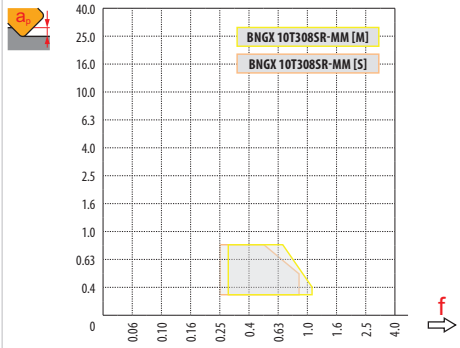
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 	**F** geometri med positivt design til fin og halvgrovbearbejdning.																		
ANHX 10T320SR-F:M8310	2.0	380	0.10	2.5	190	0.09	2.5	–	–	–	–	–	–	–	–	–	–	–	–
ANHX 10T320SR-F:M8330	2.0	340	0.10	2.5	200	0.09	2.5	–	–	–	–	–	–	–	–	–	–	–	–

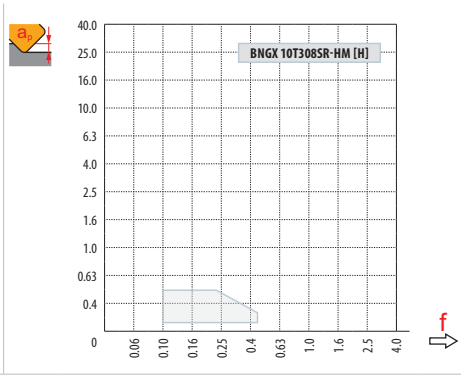
a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

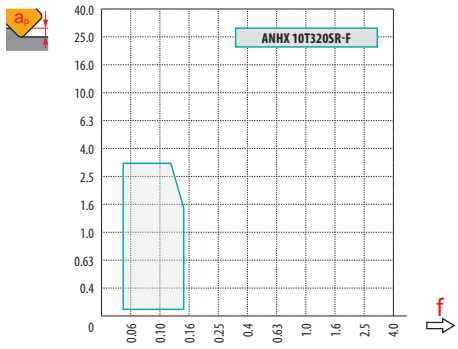
	BNGX 10-M	BNGX 10-MM	BNGX 10-HM
RE	0.8	0.8	0.8
BS	–	–	–

	ANHX 10 - F
RE	2.0
BS	0.92









BNGX 10 (HFC)

DCX	a_p	0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00
16		9.40	12.85	13.36	13.80	14.20	14.56	14.88	15.19	15.47
18		11.40	14.85	15.36	15.80	16.20	16.56	16.88	17.19	17.47
20		13.40	16.85	17.36	17.80	18.20	18.56	18.88	19.19	19.47
25		18.40	21.85	22.36	22.80	23.20	23.56	23.88	24.19	24.47
32	DEF	25.40	28.85	29.36	29.80	30.20	30.56	30.88	31.19	31.47
35		28.40	31.85	32.36	32.80	33.20	33.56	33.88	34.19	34.47
40		33.40	36.85	37.36	37.80	38.20	38.56	38.88	39.19	39.47
42		35.40	38.85	39.36	39.80	40.20	40.56	40.88	41.19	41.47
50		43.98	46.09	46.45	46.82	47.18	47.54	47.90	48.26	48.56
52		45.98	48.09	48.45	48.82	49.18	49.54	49.90	50.26	50.56
66		59.98	62.09	62.45	62.82	63.18	63.54	63.90	64.26	64.56
	a_p	**0.00**	**0.30**	**0.40**	**0.50**	**0.60**	**0.70**	**0.80**	**0.90**	**1.00**
	f	–	1.30	1.10	0.90	0.80	0.72	0.68	0.65	0.50

BNGX 10

DCX	a_{emax}	f_{max}
16	3.5	0.12
18	3.5	0.12
20	4.0	0.15
25	4.0	0.15
32	4.0	0.17
35	4.0	0.17
40	4.0	0.17
42	4.0	0.17
50	4.5	0.30
52	4.5	0.30
66	4.5	0.30

BNGX 10 (HFC)

a_p	0.3	0.6	1.0
f	1.10	0.60	0.30

BNGX 10 (HFC) / ANHX 10

DCX	BNGX 10 (HFC) RPMX	BNGX 10 (HFC) APMX/I	ANHX 10 RPMX	ANHX 10 APMX/I
16	3.8	1/17	1.6°	2.65/100
18	3.8	1/17	1.3°	2.15/100
20	3.8	1/17	1.1°	1.80/100
25	2.6	1/24	0.8°	1.25/100
32	1.8	1/33	0.5°	0.75/100
35	1.6	1/37	0.5°	0.75/100
40	1.3	1/46	0.4°	0.55/100
42	1.3	1/46	0.4°	0.55/100
50	0.4	0.55/100	–	–
52	0.4	0.55/100	–	–
66	0.3	0.4/100	–	–

BNGX 10 (HFC)

DCX	a_p	f_{max}
16	0.4	0.15
18	0.7	0.15
20	0.7	0.15
25	0.7	0.15
32	0.7	0.2
35	0.7	0.2
40	0.7	0.2
42	0.7	0.2
50	0.3	0.2
52	0.3	0.2
66	0.3	0.2

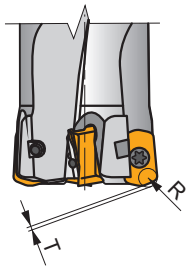
BNGX 10 (HFC)

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
16	22.4	31.8	0.5	0.5
18	25.4	35.8	0.5	0.5
20	29.4	39.8	0.5	0.5
25	39.4	49.8	0.5	0.5
32	53.4	63.8	0.5	0.5
35	59.4	69.8	0.5	0.5
40	69.4	79.8	0.5	0.5
42	73.4	83.8	0.5	0.5
50	89.6	99.6	0.5	0.5
52	93.6	103.6	0.5	0.5
66	121.6	131.6	0.5	0.5

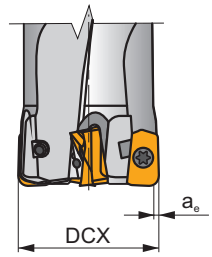
DCX	µm	3	5	10	15	20	30	40	50	60	80	100
16	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
18		0.465	0.600	0.849	1.039	1.200	1.470	1.697	1.897	2.078	2.400	2.683
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
35		0.648	0.837	1.183	1.449	1.673	2.049	2.366	2.646	2.898	3.347	3.742
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
42		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099

ANHX 10

RE	µm	3	5	10	15	20	30	40	50	60	80	100
2.0	FE	0.219	0.283	0.400	0.490	0.566	0.693	0.800	0.894	0.980	1.131	1.265



	R	T
BNGX 10T308	1.60	0.44



	max a_e/DCX
ANHX 10T320	0.05

SSN11

P M K S H

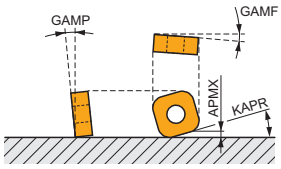
PRAMET

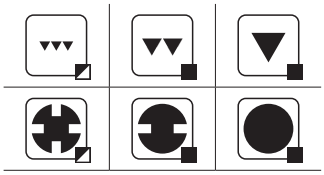
S

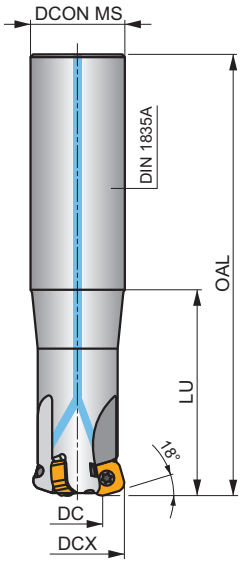
High Feed fræser til SN .. 11 skær med intern kølevæske, næste generation

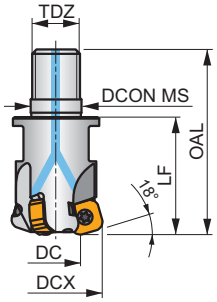
High feed fræser til større diametre ved hjælp af dobbeltsidede SNGX 11 skær med otte skærekanter og APMX på 1.7 mm. Intern kølevæske. Velegnet til en lang række applikationer. Fås i cylindrisk, modulær og dorn-type. Krop behandlet for længere værktøjslevetid.

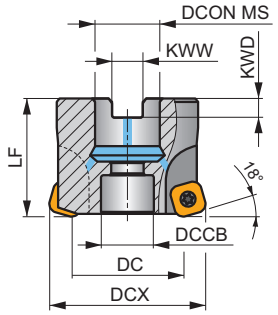
KAPR	18°
APMX	1.7 mm











h_m	0.20 - 0.46
h_m	0.20 - 0.46

	Product	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835A	32E3R070A32-SSN11-C	32	18.3	150	32	–	70	–	–	–	–	-11.5	-10	3	–	17500	✓	0.69	GI339	C0314	–
	32E3R120A32-SSN11-C	32	18.3	200	32	–	120	–	–	–	–	-11.5	-10	3	–	17500	✓	0.89	GI339	C0314	–
	35E3R050A32-SSN11-C	35	21.2	200	32	–	50	–	–	–	–	-11	-10	3	–	16800	✓	1.08	GI339	C0314	–
MODULAR	32E3R040M16-SSN11-C	32	18.3	63	17	–	–	40	M16	–	–	-11.5	-10	3	–	17500	✓	0.19	GI339	C0314	–
	35E3R040M16-SSN11-C	35	21.2	63	17	–	–	40	M16	–	–	-11	-10	3	–	16800	✓	0.19	GI339	C0314	–
	40E4R043M16-SSN11-C	40	26.2	66	17	–	–	43	M16	–	–	-10.5	-10	4	✓	15700	✓	0.26	GI339	C0314	–
ISO 6462 DIN 8030	40A04R-SMOSN11-C	40	26.2	–	16	12.4	–	40	–	8.4	5.6	-10.5	-10	4	✓	15700	✓	0.19	GI339	C0316	–
	42A04R-SMOSN11-C	42	28.2	–	16	14.1	–	40	–	8.4	5.6	-10.5	-10	4	✓	15300	✓	0.21	GI339	C0318	–
	50A05R-SMOSN11-C	50	36.1	–	22	18.1	–	40	–	10.4	6.3	-10	-10	5	✓	14000	✓	0.31	GI339	C0320	–
	50A06R-SMOSN11-C	50	36.1	–	22	18.1	–	40	–	10.4	6.3	-10	-10	6	✓	14000	✓	0.43	GI339	C0320	–
	52A05R-SMOSN11-C	52	38.1	–	22	18.1	–	40	–	10.4	6.3	-10	-10	5	✓	13800	✓	0.47	GI339	C0320	–
	52A06R-SMOSN11-C	52	38.1	–	22	18.1	–	40	–	10.4	6.3	-10	-10	6	✓	13800	✓	0.46	GI339	C0320	–
	63A06R-SMOSN11-C	63	49.1	–	22	18.1	–	40	–	10.4	6.3	-10	-10	6	✓	12500	✓	0.46	GI339	C0320	–
	63A08R-SMOSN11-C	63	49.1	–	22	18.1	–	40	–	10.4	6.3	-10	-10	8	✓	12500	✓	0.60	GI339	C0320	–
	66A06R-SMOSN11-C	66	52.1	–	27	18.1	–	50	–	12.4	7	-10	-10	6	✓	12200	✓	0.88	GI339	C0322	–
	66A08R-SMOSN11-C	66	52.1	–	27	18.1	–	50	–	12.4	7	-10	-10	8	✓	12200	✓	0.88	GI339	C0322	–
	80A07R-SMOSN11-C	80	66.1	–	27	38.1	–	50	–	12.4	7	-10	-10	7	✓	11100	✓	0.95	GI339	C0324	AC001
	80A09R-SMOSN11-C	80	66.1	–	27	38.1	–	50	–	12.4	7	-10	-10	9	✓	11100	✓	1.03	GI339	C0324	AC001
	100A08R-SMOSN11-C	100	86.1	–	32	45.1	–	50	–	14.4	8	-10	-10	8	✓	9900	✓	1.83	GI339	C0324	AC002
	115A08R-SMOSN11-C	115	101.1	–	32	45.1	–	50	–	14.4	8	-10	-10	8	✓	9200	✓	2.30	GI339	C0324	AC002
	125A08R-SMOSN11-C	125	111.1	–	40	56.1	–	63	–	16.4	9	-10	-10	8	✓	8900	✓	3.34	GI339	C0324	AC003

GI339	SNGX 1104..

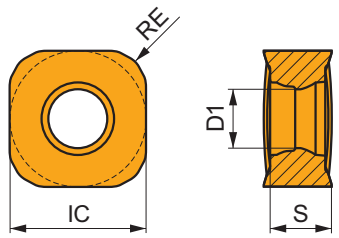
		Nm						
C0314	US 44012-T15P	3.5	M 4	12	–	–	Flag T15P	–
C0316	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	HCS 0840C
C0318	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	HS 90835
C0320	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	HS 1030C
C0322	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	HS 1230C
C0324	US 44012-T15P	3.5	M 4	12	D-T08P/T15P	FG-15	–	–

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

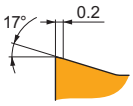
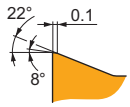
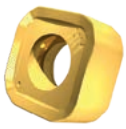
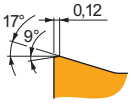
SNGX 11

PRAMET

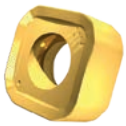
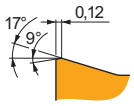
	IC (mm)	D1 (mm)	S (mm)
1104	10.600	4.56	4.76



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

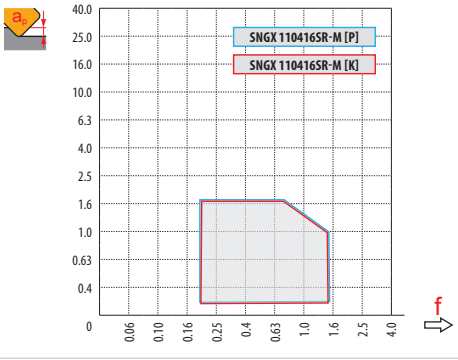
Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			**M** geometri med positivt design til high feed bearbejdning.																	
SNGX 110416SR-M:8215		1.6	260	0.60	1.0	–	–	–	245	0.60	1.0	–	–	–	–	–	–	–	–	–
SNGX 110416SR-M:M8310		1.6	275	0.60	1.0	–	–	–	260	0.60	1.0	–	–	–	–	–	–	–	–	–
SNGX 110416SR-M:M8330		1.6	260	0.60	1.0	–	–	–	245	0.60	1.0	–	–	–	–	–	–	–	–	–
SNGX 110416SR-M:M8340		1.6	245	0.60	1.0	–	–	–	230	0.60	1.0	–	–	–	–	–	–	–	–	–
SNGX 110416SR-M:M9325		1.6	305	0.60	1.0	–	–	–	285	0.60	1.0	–	–	–	–	–	–	–	–	–
SNGX 110416SR-M:M9340		1.6	270	0.60	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
			**MM** geometri med meget positivt design til bearbejdning med high feed.																	
SNGX 110416SR-MM:M6330		1.6	175	0.60	1.0	125	0.54	1.0	–	–	–	–	–	–	50	0.42	0.8	–	–	–
SNGX 110416SR-MM:M8340		1.6	190	0.60	1.0	110	0.54	1.0	–	–	–	–	–	–	45	0.42	0.8	–	–	–
SNGX 110416SR-MM:M8345		1.6	150	0.60	1.0	90	0.54	1.0	–	–	–	–	–	–	35	0.42	0.8	–	–	–
SNGX 110416SR-MM:M9340		1.6	210	0.60	1.0	125	0.54	1.0	–	–	–	–	–	–	50	0.42	0.8	–	–	–
			**HM** geometri med stærkt design til high feed bearbejdning																	
SNGX 110416SR-HM:8215		1.6	230	1.00	1.0	–	–	–	215	1.00	1.0	–	–	–	–	–	–	45	0.70	0.7
SNGX 110416SR-HM:M8310		1.6	240	1.00	1.0	–	–	–	225	1.00	1.0	–	–	–	–	–	–	45	0.70	0.7

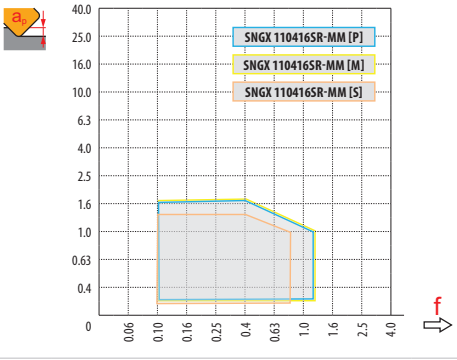
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

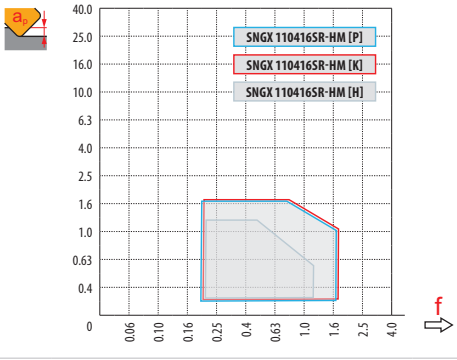
Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
HM geometri med stærkt design til high feed bearbejdning																				
SNGX 110416SR-HM:M8330		1.6	235	1.00	1.0	–	–	–	220	1.00	1.0	–	–	–	–	–	–	45	0.70	0.7
SNGX 110416SR-HM:M9325		1.6	260	1.00	1.0	–	–	–	245	1.00	1.0	–	–	–	–	–	–	50	0.70	0.7

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SNGX 11 - M	SNGX 11 - MM	SNGX 11 - HM
RE	1.6	1.6	1.6
BS	–	–	–







		HFC												
DCX	a_p	0.00	0.20	0.40	0.60	0.80	1.00	1.10	1.20	1.30	1.40	1.50	1.60	1.70
32		18.30	19.53	20.76	21.99	23.22	24.46	25.07	25.69	26.30	26.92	27.53	28.15	28.76
35		21.20	22.43	23.66	24.89	26.12	27.36	27.97	28.59	29.20	29.82	30.43	31.05	31.66
40		26.20	27.43	28.66	29.89	31.12	32.36	32.97	33.59	34.20	34.82	35.43	36.05	36.66
42		28.20	29.43	30.66	31.89	33.12	34.36	34.97	35.59	36.20	36.82	37.43	38.05	38.66
50		36.10	37.33	38.56	39.79	41.02	42.26	42.87	43.49	44.10	44.72	45.33	45.95	46.56
52	DEF	38.10	39.33	40.56	41.79	43.02	44.26	44.87	45.49	46.10	46.72	47.33	47.95	48.56
63		49.10	50.33	51.56	52.79	54.02	55.26	55.87	56.49	57.10	57.72	58.33	58.95	59.56
66		52.10	53.33	54.56	55.79	57.02	58.26	58.87	59.49	60.10	60.72	61.33	61.95	62.56
80		66.10	67.33	68.56	69.79	71.02	72.26	72.87	73.49	74.10	74.72	75.33	75.95	76.56
100		86.10	87.33	88.56	89.79	91.02	92.26	92.87	93.49	94.10	94.72	95.33	95.95	96.56
115		101.10	102.33	103.56	104.79	106.02	107.26	107.87	108.49	109.10	109.72	110.33	110.95	111.56
125		111.10	112.33	113.56	114.79	116.02	117.26	117.87	118.49	119.10	119.72	120.33	120.95	121.56
	a_p	–	0.20	0.40	0.60	0.80	1.00	1.10	1.20	1.30	1.40	1.50	1.60	1.70
	f	–	1.37	0.98	0.81	0.71	0.64	0.62	0.59	0.58	0.56	0.54	0.53	0.52

SNGX		
DCX	a_{emax}	f_{max}
32	5.0	0.25
35	5.0	0.25
40	5.2	0.30
42	5.2	0.30
50	5.3	0.30
52	5.3	0.30
63	5.4	0.30
66	5.4	0.30
80	5.5	0.35
100	5.5	0.35
115	5.5	0.35
125	5.5	0.35

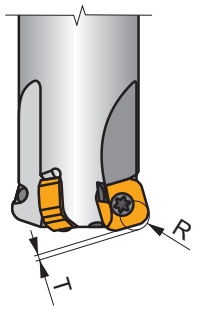
SNGX (HFC)		
DCX	RPMX	APMX/I
32	0.8	1.4/100
35	0.8	1.4/100
40	0.7	1.2/100
42	0.7	1.2/100
50	0.5	0.9/100
52	0.5	0.9/100
63	0.4	0.7/100
66	0.4	0.7/100
80	0.3	0.5/100
100	0.2	0.3/100
115	0.2	0.3/100
125	0.2	0.3/100

SNGX (HFC)		
DCX	a_p	f_{max}
32	0.2	0.3
35	0.2	0.3
40	0.2	0.3
42	0.2	0.3
50	0.3	0.4
52	0.3	0.4
63	0.3	0.4
66	0.3	0.4
80	0.3	0.4
100	0.3	0.4
115	0.3	0.4
125	0.3	0.4

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
32	FE	0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
35		0.648	0.837	1.183	1.449	1.673	2.049	2.366	2.646	2.898	3.347	3.742
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
42		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
115		1.175	1.517	2.145	2.627	3.033	3.715	4.290	4.796	5.254	6.066	6.782
125		1.225	1.581	2.236	2.739	3.162	3.873	4.472	5.000	5.477	6.325	7.071

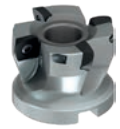
	SNGX			
a_p	0.2	0.5	1.0	1.7
1 f	1.20	1.00	0.50	0.25

SNGX (HFC)				
DCX	DMIN	DMAX	SMAX / DMIN	SMAX / DMAX
32	48.0	63.8	0.7	1.4
35	54.0	69.8	0.8	1.5
40	64.0	79.8	0.9	1.5
42	68.0	83.8	1.0	1.6
50	84.0	99.8	0.9	1.4
52	88.0	103.8	1.0	1.4
63	109.0	125.8	1.0	1.4
66	115.0	131.8	1.1	1.4
80	143.0	159.8	1.0	1.3
100	183.0	199.8	0.9	1.1
115	213.0	229.8	1.1	1.3
125	233.0	249.8	1.2	1.4



SNGX	R	T
SNGX 110416	4.6	0.92

HIGH FEED MILLING – POSITIVE INSERTS

	SSO12	SPD09	SZD07	SZD09	SZD12
	12°	19°	–	–	–
	APMX (mm) 1.9	APMX (mm) 2.0	APMX (mm) 1.0	APMX (mm) 1.0	APMX (mm) 1.6
	DCX (mm) 35 – 125	DCX (mm) 32 – 140	DCX (mm) 16 – 25	DCX (mm) 25 – 63	DCX (mm) 32 – 80
Cylindrical shank	DC = 35, 40 (mm)	DCX = 32, 40 (mm)	DCX = 16 – 25 (mm)		
Weldon	DC = 35, 40 (mm)			DCX = 25, 32 (mm)	
Modular				DCX = 25, 32 (mm)	DCX = 32, 40 (mm)
Shell mill	DC = 42 – 125 (mm)	DCX = 42 – 140 (mm)		DCX = 40 – 63 (mm)	 DCX = 50 – 80 (mm)
Page	266	270	276	280	284
ISO	P M K N S H	P M K S H	P K H	P K H	P K H
Insert shape					
Inserts	SOHT 1205	PD.. 0905	ZDCW 0703	ZDCW 09T3	ZDEW 1204
No. of cutting edges	4	5	4	4	4
Face milling	■	■	■	■	■
Helical interpolation	■	■	◪	◪	◪
Shallow shoulder milling	■	■	◪	◪	◪
Plunge milling	■	■	◪	◪	◪
Progressive plunging	■	■	◪	◪	◪
Ramping	■	■			
Shape surfaces milling (copy milling)		◪	◪	◪	◪
Shallow slot milling	■	◪	◪	◪	◪

■ Primary use ◪ Possible use

SSO12

P M K S H

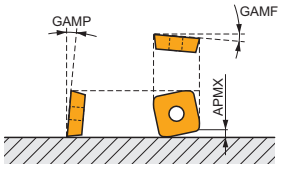
PRAMET

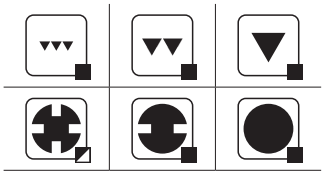
S

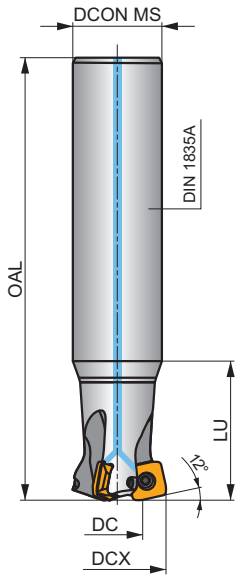
VER SO12 12° fræsning med høj tilspændingmed indvendig kølevæske

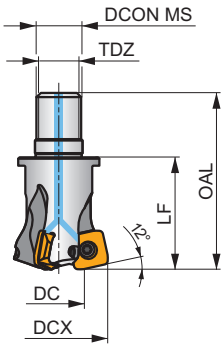
Meget alsidig 12° fræser med høj tilspænding, der bruger enkeltsidede SO... 12-skær med APMX på 1.9 mm. Egnet til en bred vifte af opgaver i de fleste emnematerialer. Cylindrisk, modulær og dorn-type tilgængelig, med forskellig tandafstand. Kølevæske gennem kanaler og krop behandlet for længere værktøjslevetid.

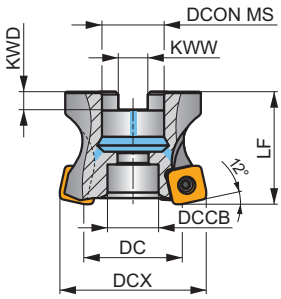
KAPR	12°
APMX	1.9 mm











h_m	0.09-0.93
h_m	0.09-0.93

	Product	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835A	35E3R050A32-SSO12-C	35	17.3	200	32	–	50	–	–	–	–	-5	5	3	–	15700	✓	1.07	GI350	SQ501	–
DIN 1835A	35E3R120A32-SSO12-C	35	17.3	200	32	–	120	–	–	–	–	-5	5	3	–	15700	✓	0.95	GI350	SQ501	–
DIN 1835A	40E4R120A32-SSO12-C	40	22.3	200	32	–	120	–	–	–	–	-5	5	4	–	14700	✓	1.00	GI350	SQ501	–
MODULAR	35E3R040M16-SSO12-C	35	17.3	63	17	–	–	40	M16	–	–	-5	5	3	–	15700	✓	0.15	GI350	SQ501	–
MODULAR	40E4R043M16-SSO12-C	40	22.3	66	17	–	–	43	M16	–	–	-5	5	4	–	14700	✓	0.18	GI350	SQ501	–
	42A04R-SMOSO12-C	42	24.3	–	16	12.4	–	40	–	8.4	5.6	-5	5	4	–	14300	✓	0.16	GI350	SQ502	–
	50A05R-SMOSO12-C	50	32.3	–	22	18.1	–	40	–	10.4	6.3	-5	5	5	✓	13100	✓	0.23	GI350	SQ503	–
	52A05R-SMOSO12-C	52	34.3	–	22	18.1	–	40	–	10.4	6.3	-5	5	5	✓	12800	✓	0.35	GI350	SQ503	–
ISO 6462 DIN 8030	63A06R-SMOSO12-C	63	45.3	–	27	22.1	–	50	–	12.4	7	-5	5	6	✓	11700	✓	0.48	GI350	SQ504	–
ISO 6462 DIN 8030	66A06R-SMOSO12-C	66	48.3	–	27	22.1	–	50	–	12.4	7	-5	5	6	✓	11400	✓	0.51	GI350	SQ504	–
ISO 6462 DIN 8030	80A07R-SMOSO12-C	80	62.3	–	27	22.1	–	50	–	12.4	7	-5	5	7	✓	10400	✓	0.76	GI350	SQ504	–
	100A08R-SMOSO12-C	100	82.3	–	32	45.1	–	50	–	14.4	8	-5	5	8	✓	9300	✓	1.32	GI350	SQ505	AC002
	125A10R-SMOSO12-C	125	107.3	–	40	56.1	–	63	–	16.4	9	-5	5	10	✓	8300	✓	2.46	GI350	SQ505	AC003

GI350	SOHT 1205..

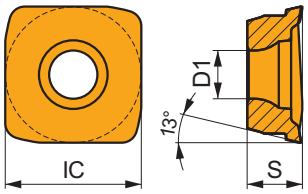
		Nm					
SQ501	US 4011-T15P	3.5	M 4	10.6	FLAG T15P	–	–
SQ502	US 4011-T15P	3.5	M 4	10.6	–	SDR T15P-T	HCS 0840C
SQ503	US 4011-T15P	3.5	M 4	10.6	–	SDR T15P-T	HS 1030C
SQ504	US 4011-T15P	3.5	M 4	10.6	–	SDR T15P-T	HS 1230C
SQ505	US 4011-T15P	3.5	M 4	10.6	–	SDR T15P-T	–

AC002	KS 1635	K.FMH32
AC003	KS 2040	K.FMH40

SOHT 12

PRAMET

	IC (mm)	D1 (mm)	S (mm)
1205	12.700	4.50	5.15

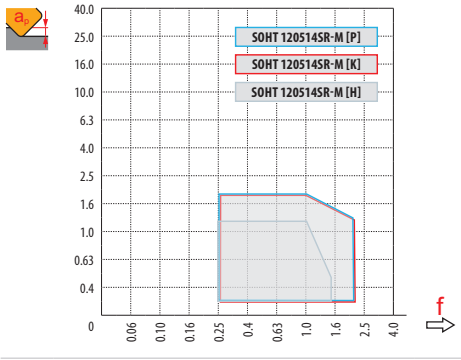


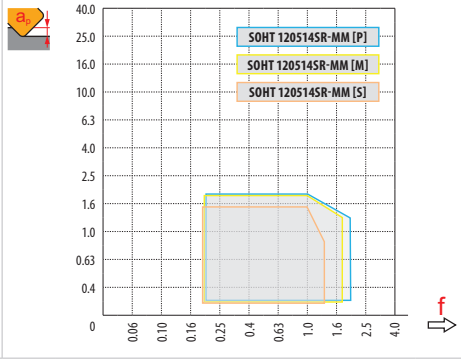
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			0.20 / 0.12 / 2° / 10° / 5°																	
M geometrien er alsidig til en bred vifte af arbejdsforhold. Designet med positiv spåntagning, medium T-land og afrunding af skæret til jævn HFC-fræsning. Førstevalg til stål, støbejern og hærdet stål.																				
SOHT 120514SR-M:8215	✱	1.4	215	1.00	1.0	125	0.90	1.0	200	1.00	1.0	–	–	–	50	0.70	0.8	40	0.68	0.8
SOHT 120514SR-M:M8310	✱	1.4	225	1.00	1.0	110	0.90	1.0	210	1.00	1.0	–	–	–	–	–	–	45	0.68	0.8
SOHT 120514SR-M:M8330	✱	1.4	220	1.00	1.0	130	0.90	1.0	205	1.00	1.0	–	–	–	55	0.70	0.8	40	0.68	0.8
SOHT 120514SR-M:M8340	✱	1.4	205	1.00	1.0	120	0.90	1.0	190	1.00	1.0	–	–	–	50	0.70	0.8	–	–	–
SOHT 120514SR-M:M9325	✱	1.4	245	1.00	1.0	–	–	–	230	1.00	1.0	–	–	–	–	–	–	45	0.68	0.8
SOHT 120514SR-M:M9340	✱	1.4	215	1.00	1.0	125	0.90	1.0	–	–	–	–	–	–	50	0.70	0.8	–	–	–
			0.17 / 0.08 / 4° / 12°																	
MM geometrien er skarp og velegnet til store overhæng eller tyndvæggede og slanke emner. Designet med positiv hældning, smalt T-land og afrunding af skærkanten for jævn HFC-fræsning. Førstevalg til rustfrit stål og superlegeringer.																				
SOHT 120514SR-MM:M6330	✱	1.4	190	1.00	1.0	135	0.90	1.0	–	–	–	–	–	–	55	0.70	0.8	–	–	–
SOHT 120514SR-MM:M8340	✱	1.4	205	1.00	1.0	120	0.90	1.0	–	–	–	–	–	–	50	0.70	0.8	–	–	–
SOHT 120514SR-MM:M8345	✱	1.4	165	1.00	1.0	95	0.90	1.0	–	–	–	–	–	–	40	0.70	0.8	–	–	–
SOHT 120514SR-MM:M9325	✱	1.4	245	1.00	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SOHT 120514SR-MM:M9340	✱	1.4	215	1.00	1.0	125	0.90	1.0	–	–	–	–	–	–	50	0.70	0.8	–	–	–

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	SOHT 12-M	SOHT 12-MM
RE	1.4	1.4
BS	2.00	2.00





		HFC												
DCX	a_p	0.00	0.20	0.40	0.60	0.80	1.00	1.20	1.40	1.50	1.60	1.70	1.80	1.90
35		17.3	19.2	21.1	22.9	24.8	26.7	28.6	30.5	31.4	32.4	33.1	33.5	33.9
40		22.3	24.2	26.1	27.9	29.8	31.7	33.6	35.5	36.4	37.4	38.1	38.5	38.9
42		24.3	26.2	28.1	29.9	31.8	33.7	35.6	37.5	38.4	39.4	40.1	40.5	40.9
50		32.3	34.2	36.1	37.9	39.8	41.7	43.6	45.5	46.4	47.4	48.1	48.5	48.9
52	DEF	34.3	36.2	38.1	39.9	41.8	43.7	45.6	47.5	48.4	49.4	50.1	50.5	50.9
63		45.3	47.2	49.1	50.9	52.8	54.7	56.6	58.5	59.4	60.4	61.1	61.5	61.9
66		48.3	50.2	52.1	53.9	55.8	57.7	59.6	61.5	62.4	63.4	64.1	64.5	64.9
80		62.3	64.2	66.1	67.9	69.8	71.7	73.6	75.5	76.4	77.4	78.1	78.5	78.9
100		82.3	84.2	86.1	87.9	89.8	91.7	93.6	95.5	96.4	97.4	98.1	98.5	98.9
125		107.3	109.2	111.1	112.9	114.8	116.7	118.6	120.5	121.4	122.4	123.1	123.5	123.9
	a_p	0.00	0.20	0.40	0.60	0.80	1.00	1.20	1.40	1.50	1.60	1.70	1.80	1.90
	f	-	2.20	2.00	1.80	1.60	1.40	1.20	1.10	1.00	0.90	0.80	0.70	0.60

DCX	a_{emax}	f_{max}
35	10.0	0.10
40	10.0	0.10
42	10.0	0.12
50	10.0	0.12
52	10.0	0.12
63	10.0	0.15
66	10.0	0.15
80	10.0	0.20
100	10.0	0.20
125	10.0	0.20

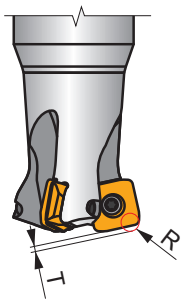
DCX	RPMX	APMX/I
35	9.6	1.9/11
40	6.9	1.9/16
42	6.1	1.9/18
50	4.3	1.9/25
52	4.0	1.9/27
63	2.6	1.9/41
66	2.5	1.9/44
80	1.9	1.9/59
100	1.4	1.9/79
125	1.0	1.9/105

DCX	a_p	f_{max}
35	1.6	0.17
40	1.6	0.17
42	1.6	0.15
50	1.6	0.10
52	1.6	0.10
63	1.6	0.05
66	1.6	0.05
80	1.6	0.05
100	1.6	0.05
125	1.6	0.05

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
35		0.648	0.837	1.183	1.449	1.673	2.049	2.366	2.646	2.898	3.347	3.742
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
42		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52	FE	0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657
100		1.095	1.414	2.000	2.449	2.828	3.464	4.000	4.472	4.899	5.657	6.325
125		1.225	1.581	2.236	2.739	3.162	3.873	4.472	5.000	5.477	6.325	7.071

a_p	0.2	0.6	1.0	1.5	1.9
1 f	2.0	1.6	1.2	0.8	0.5

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
35	46.0	69.8	1.9	1.9
40	56.0	79.8	1.9	1.9
42	60.0	83.8	1.9	1.9
50	76.0	99.8	1.9	1.9
52	80.0	103.8	1.9	1.9
63	102.0	125.8	1.9	1.9
66	108.0	131.8	1.9	1.9
80	136.0	159.8	1.9	1.9
100	176.0	199.8	1.9	1.9
125	226.0	249.8	1.9	1.9



SOHT	R	T
SOHT 120514	3.37	1.21

SPD09

P M K S H

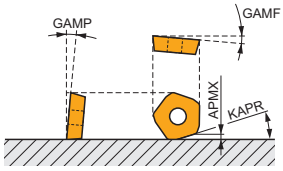
PRAMET

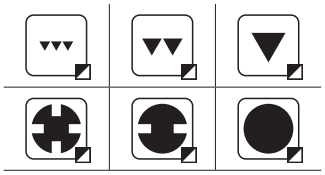
S

PENTA HF fræser high feed med intern kølevæske

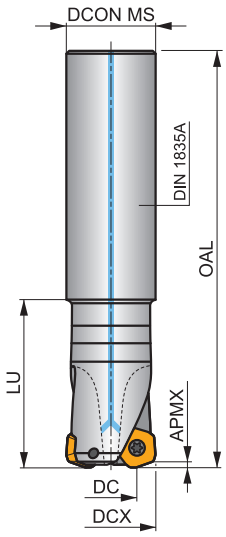
Produktiv high feed fræser til fræsning med enkeltsidet positiv PD .. 09-skær med 5 skærekanter og APMX på 2 mm. Intern kølevæske. Velegnet til en lang række applikationer. Fås i cylindrisk og dorn type. Krop behandlet for længere værktøjslevetid.

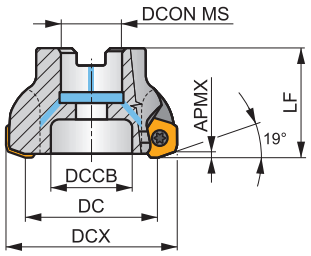
KAPR	19°
APMX	2.0 mm





PENTA HF





h_m	0.065 - 0.975
h_m	0.065 - 0.975

	Product	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LF (mm)	GAMF (°)	GAMP (°)			max.		kg			
DIN 1835A	**32E2R060A32-SPD09-C**	32	18.4	250	32	–	60	–	-24	10	2	–	13100	✓	1.34	GI245	C0340	–
DIN 1835A	**40E3R060A32-SPD09-C**	40	25.5	250	32	–	60	–	-11	10	3	–	11700	✓	1.43	GI245	C0340	–
	42A03R-S19PD09-C	42	27.5	–	16	12	–	40	-8	10	3	–	11500	✓	0.18	GI245	C0342	–
	50A04R-S19PD09-C	50	35.3	–	22	18	–	40	-3	10	4	–	10500	✓	0.23	GI245	C0343	–
	50A05R-S19PD09-C	50	35.3	–	22	18	–	40	-3	10	5	–	10500	✓	0.33	GI245	C0343	–
	52A04R-S19PD09-C	52	37.3	–	22	18	–	40	-3	10	4	–	10300	✓	0.25	GI245	C0343	–
	63A05R-S19PD09-C	63	48.2	–	22	18	–	40	-1	10	5	–	9400	✓	0.44	GI245	C0343	–
	63A06R-S19PD09-C	63	48.2	–	22	18	–	40	-1	10	6	–	9300	✓	0.45	GI245	C0343	–
	66A06R-S19PD09-C	66	51.2	–	22	18	–	40	-1	10	6	–	9200	✓	0.35	GI245	C0343	–
ISO 6462 DIN 8030	**66A06R-S19PD09-CF**	66	51.2	–	27	22	–	50	-1	10	6	–	9100	✓	0.67	GI245	C0344	–
	80A05R-S19PD09-C	80	65.3	–	27	37	–	50	-1	10	5	–	8300	✓	0.84	GI245	C0341	AC001
	80A06R-S19PD09-C	80	65.3	–	27	37	–	50	-1	10	6	–	8300	✓	0.86	GI245	C0341	AC001
	100A06R-S19PD09-C	100	58.3	–	32	45	–	50	-1	10	6	–	7400	✓	1.46	GI245	C0341	AC002
	100A08R-S19PD09-C	100	85.3	–	32	45	–	50	-1	10	8	–	7400	✓	1.40	GI245	C0341	AC002
	125A08R-S19PD09-C	125	110.3	–	40	36	–	63	-1	10	8	–	6600	✓	3.10	GI245	C0349	–
	125A10R-S19PD09-C	125	110.3	–	40	36	–	63	-1	10	10	–	6600	✓	3.11	GI245	C0349	–
	140A08R-S19PD09-C	140	125.3	–	40	36	–	63	-1	10	8	–	6200	✓	3.57	GI245	C0349	–

GI245	PD.X 0905ZE..	PDKT 0905..	PDMW 0905..

		Nm					
C0340	US 45011-T20P	5.0	M 5	11	–	–	Flag T20P
C0341	US 45011-T20P	5.0	M 5	11	SDR T20P-T	–	–

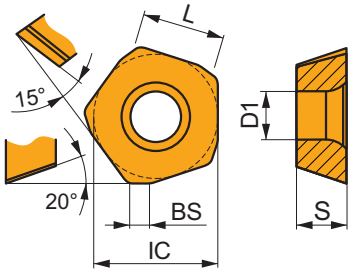
		Nm					
C0342	US 45011-T20P	5.0	M 5	11	SDR T20P-T	HS 90835	–
C0343	US 45011-T20P	5.0	M 5	11	SDR T20P-T	HS 1030C	–
C0344	US 45011-T20P	5.0	M 5	11	SDR T20P-T	HS 1230C	–
C0349	US 45011-T20P	5.0	M 5	11	SDR T20P-T	HSD 2040	–

AC001	KS 1230	K.FMH27
AC002	KS 1635	K.FMH32

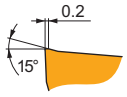
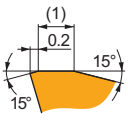
PDMX 09

PRAMET

	BS (mm)	IC (mm)	D1 (mm)	L (mm)	S (mm)
0905	2.00	13.500	5.50	9.00	5.47



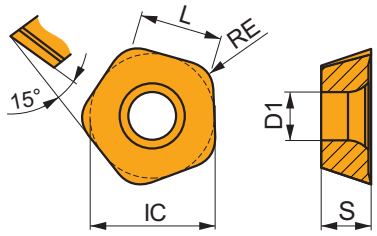
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			**M** geometri med positivt design til mellemhøj high feed af bearbejdning.																	
PDMX 0905ZEER-M:8215	–	215	1.00	1.2	125	0.90	1.2	200	1.00	1.2	–	–	–	–	–	–	–	–	–
PDMX 0905ZEER-M:M8330	–	220	1.00	1.2	130	0.90	1.2	205	1.00	1.2	–	–	–	–	–	–	–	–	–
PDMX 0905ZEER-M:M8345	–	165	1.00	1.2	95	0.90	1.2	–	–	–	–	–	–	–	–	–	–	–	–
PDMX 0905ZEER-M:M9340	–	215	1.00	1.2	125	0.90	1.2	–	–	–	–	–	–	–	–	–	–	–	–
			**R** geometri med stærkt design til high feed bearbejdning.																	
PDMX 0905ZESR-R:8215	–	215	1.00	1.3	–	–	–	200	1.00	1.3	–	–	–	–	–	–	40	0.70	0.9
PDMX 0905ZESR-R:M8330	–	215	1.00	1.3	–	–	–	200	1.00	1.3	–	–	–	–	–	–	40	0.70	0.9
PDMX 0905ZESR-R:M8345	–	165	1.00	1.3	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
PDMX 0905ZESR-R:M9325	–	245	1.00	1.3	–	–	–	230	1.00	1.3	–	–	–	–	–	–	45	0.70	0.9

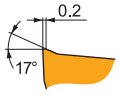
PDKT 09

PRAMET

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0905	13.500	5.50	9.00	5.47



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

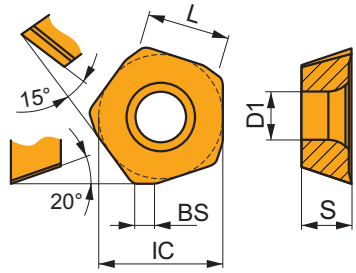
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				
PDKT 090530ER-FM:8215		3.0	■	240	1.00	1.2	◪	140	0.90	1.2	◪	225	1.00	1.2	–	–	–	◪	60	0.70	1.0	–	–	–
PDKT 090530ER-FM:M6330		3.0	■	210	1.00	1.2	■	150	0.90	1.2		–	–	–	–	–	–	■	60	0.70	1.0	–	–	–
PDKT 090530ER-FM:M8310		3.0	■	250	1.00	1.2	◪	125	0.90	1.2	◪	235	1.00	1.2	–	–	–		–	–	–	–	–	–
PDKT 090530ER-FM:M8330		3.0	■	245	1.00	1.2	■	145	0.90	1.2	◪	230	1.00	1.2	–	–	–	◪	60	0.70	1.0	–	–	–
PDKT 090530ER-FM:M8345		3.0	■	180	1.00	1.2	■	105	0.90	1.2		–	–	–	–	–	–	■	45	0.70	1.0	–	–	–
PDKT 090530ER-FM:M9325		3.0	■	275	1.00	1.2		–	–	–	◪	260	1.00	1.2	–	–	–		–	–	–	–	–	–

FM geometri med yderst positivt design til let til mellemhøj tilspændingsbearbejdning.

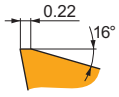
PDKX 09

PRAMET

	BS	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)	(mm)
0905	2.00	13.500	5.50	9.00	5.47



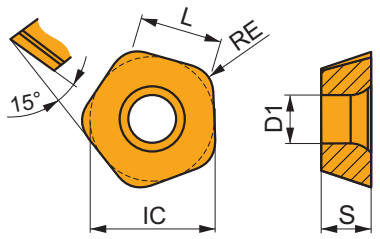
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				
PDKX 0905ZEER-FM:M6330		–	■	195	1.00	1.2	■	135	0.90	1.2		–	–	–	–	–	–	■	55	0.70	1.0	–	–	–
PDKX 0905ZEER-FM:M8345		–	■	165	1.00	1.2	■	95	0.90	1.2		–	–	–	–	–	–	■	40	0.70	1.0	–	–	–
PDKX 0905ZEER-FM:M9340		–	■	215	1.00	1.2	■	125	0.90	1.2		–	–	–	–	–	–	■	50	0.70	1.0	–	–	–

FM geometri med meget positivt design til bearbejdning af mellemhøj skærehastighed.

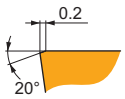
PDMW 09

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0905	13.500	5.50	9.00	5.47



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
PDMW 090530SR:M8310	✱	3.0	245	1.00	1.4	–	–	–	230	1.00	1.4	–	–	–	–	–	–	45	0.70	1.0
PDMW 090530SR:M8345	✱	3.0	180	1.00	1.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
PDMW 090530SR:M9325	✱	3.0	270	1.00	1.4	–	–	–	255	1.00	1.4	–	–	–	–	–	–	50	0.70	1.0

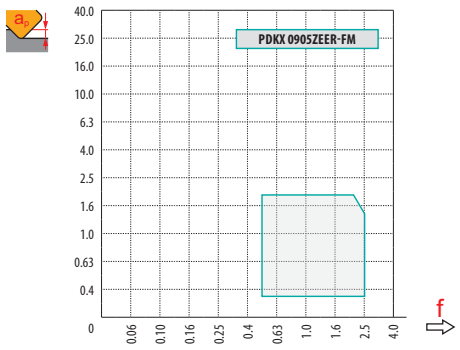


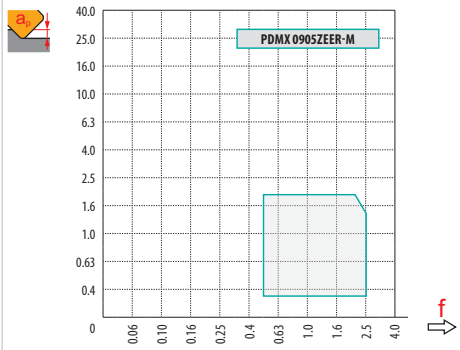
HFC S

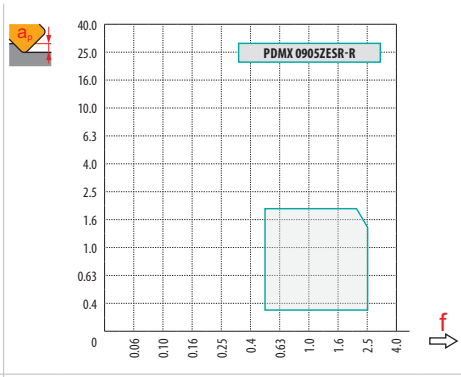
SR nul skærvinkeldesign til high feed bearbejdning.

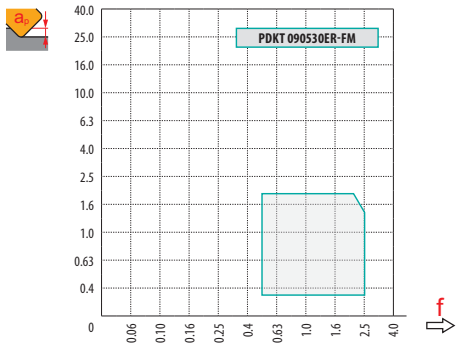
a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

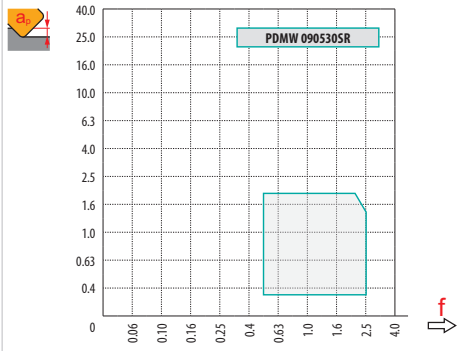
	PDKX 09-FM	PDMX 09-M	PDMX 09-R	PDKT 09-FM	PDMW 09
RE	–	–	–	3.0	3.0
BS	2.00	2.00	2.00	–	–











DCX	a_p	0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00	1.25	1.50	2.00
32	DEF	18.4	20.1	20.7	21.3	21.9	22.5	23.0	23.6	24.2	25.7	27.1	30.0
40		25.5	27.2	27.8	28.4	29.0	29.6	30.1	30.7	31.3	32.8	34.2	37.1
42		27.5	29.2	29.8	30.4	31.0	31.6	32.1	32.7	33.3	34.8	36.2	39.1
50		35.3	37.0	37.6	38.2	38.8	39.4	39.9	40.5	41.1	42.6	44.0	46.9
52		37.3	39.0	39.6	40.2	40.8	41.4	41.9	42.5	43.1	44.6	46.0	48.9
63		48.2	49.9	50.5	51.1	51.7	52.3	52.8	53.4	54.0	55.5	56.9	59.8
66		51.2	52.9	53.5	54.1	54.7	55.3	55.8	56.4	57.0	58.5	59.9	62.8
80		65.3	67.0	67.6	68.2	68.8	69.4	69.9	70.5	71.1	72.6	74.0	76.9
100		85.3	87.0	87.6	88.2	88.8	89.4	89.9	90.5	91.1	92.6	94.0	96.9
125		110.3	112.3	112.9	113.5	114.1	114.6	115.2	115.8	116.4	117.9	119.3	122.2
140		125.3	127.3	127.9	128.5	129.1	129.7	130.2	130.8	131.4	132.9	134.3	137.2
	a_p	0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00	1.25	1.50	2.00
	f	–	3.00	3.00	2.90	2.80	2.70	2.60	2.50	2.40	2.25	1.50	1.50

Følg instruktionerne for planfræsning. I tilfælde af fræsning tæt på lodret flade skal tilspændingen pr. tand (f_z) reduceres til 50 % for at undgå vibrationer og skader på skær.

DCX	max	f_{max}
32	5.0	0.20
40	5.0	0.20
42	5.0	0.20
50	6.0	0.20
52	6.0	0.20
63	7.0	0.25
66	7.0	0.25
80	8.0	0.30
100	8.0	0.30

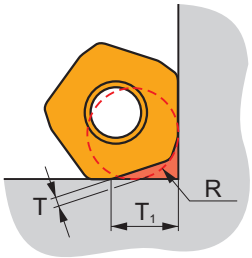
DCX	RPMX	APMX/I
40	8.0	1.80/16
42	8.0	2.00/16
50	8.0	2.00/16
52	8.0	2.00/16
63	7.0	2.00/18
66	6.0	2.00/21
80	5.0	2.00/24
100	3.0	2.00/40

	HFC		
a_p	0.5	1.0	2.0
1 f	3.0	2.3	1.5

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
40	63.7	80.0	2.00	2.00
42	67.5	84.0	2.00	2.00
50	83.3	100.0	2.00	2.00
52	87.3	104.0	2.00	2.00
63	109.2	126.0	2.00	2.00
66	115.2	132.0	2.00	2.00
80	143.3	160.0	2.00	2.00
100	183.3	200.0	2.00	2.00

DCX	a_p	f_{max}
32	1.8	0.20
40	1.8	0.20
42	2.0	0.20
50	2.0	0.20
52	2.0	0.20
63	2.0	0.25
66	2.0	0.25
80	2.0	0.30
100	2.0	0.30

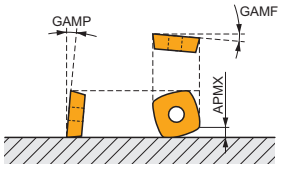
DCX	µm	3	5	10	15	20	30	40	50	60	80	100
32	FE	0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
42		0.710	0.917	1.296	1.587	1.833	2.245	2.592	2.898	3.175	3.666	4.099
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
52		0.790	1.020	1.442	1.766	2.040	2.498	2.884	3.225	3.533	4.079	4.561
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
66		0.890	1.149	1.625	1.990	2.298	2.814	3.250	3.633	3.980	4.596	5.138
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657

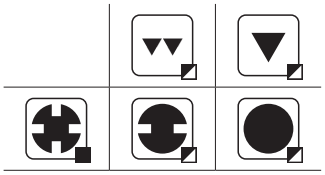


DCX	R	T	T_1
32	4.5	1.1	6.8
40 – 140	4.5	1.1	7.3

SZD07

APMX	1.0 mm

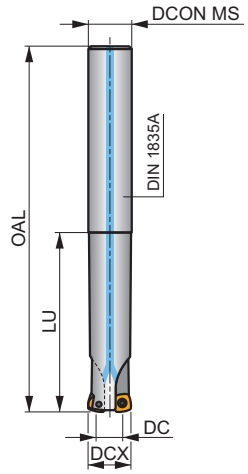




FEED ZD07 fræser high feed med intern kølevæske

Produktiv high feed fræser til fræsning med enkeltsidet ZD .. 07-skær med 4 skærekanter og en APMX på 1 mm. Intern kølevæske. Velegnet til en lang række applikationer. Fås i cylindrisk og modulær type. Krop behandlet for længere værktøjslevetid.

FEED ZD



h_m 0.175 - 0.44

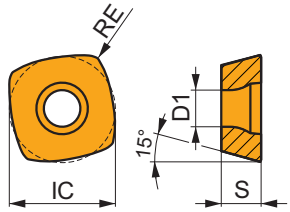
	Product	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	**16E2R030A16-SZD07**	16	6	100	16	30	–	-5	8	2	–	47400	✓	0.13	GI201	C0350
	16E2R065A16-SZD07	16	6	145	16	65	–	-5	8	2	–	47400	✓	0.22	GI201	C0350
	20E3R040A20-SZD07	20	10	120	20	40	–	-5	8	3	–	42400	✓	0.25	GI201	C0350
	20E3R080A20-SZD07	20	10	165	20	80	–	-5	8	3	–	42400	✓	0.33	GI201	C0350
	25E3R050A25-SZD07	25	15	140	25	50	–	-5	8	3	–	37900	✓	0.47	GI201	C0350
	25E3R100A25-SZD07	25	15	190	25	100	–	-5	8	3	–	37900	✓	0.60	GI201	C0350

GI201	ZDCW 0703..

		Nm			
C0350	US 2205-T07P	0.9	M 2.2	5	Flag T07P

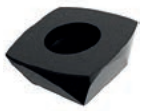
ZDCW 07

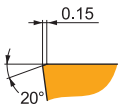
	IC	D1	S
	(mm)	(mm)	(mm)
0703	6.800	2.60	3.18



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
ZDCW 070304:M8310	0.4	420	0.60	0.4	–	–	–	395	0.60	0.4	–	–	–	–	–	–	80	0.42	0.3
ZDCW 070304:M8325	0.4	325	0.60	0.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
ZDCW 070304:M8345	0.4	305	0.60	0.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

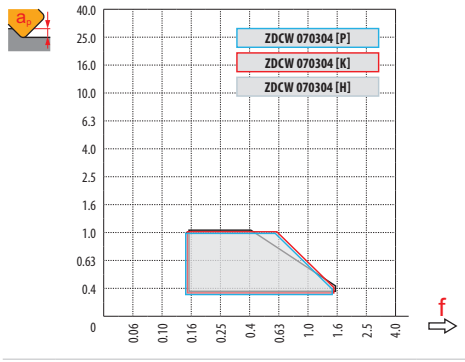




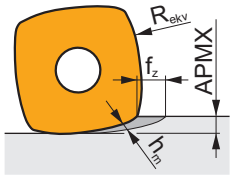
ZDCW speciel geometri til high feed bearbejdning.

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ZDCW 07
RE	0.4
BS	–



DCX	a_p	0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00
16	DEF	6.0	12.0	12.9	13.7	14.4	15.1	15.7	16.2	16.8
20		10.0	16.0	16.9	17.7	18.4	19.1	19.7	20.2	20.8
25		15.0	21.0	21.9	22.7	23.4	24.1	24.7	25.2	25.8
	a_p	0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00
	f	–	1.50	1.50	1.13	1.00	0.88	0.75	0.61	0.60



$$f_z = h_m \times \sqrt{\frac{2R_{ekv.}}{APMX}} \quad \text{(mm/tand)}$$

Følg instruktionerne for planfræsning. I tilfælde af fræsning tæt på lodret flade skal tilspændingen pr. tand (f_z) reduceres til 50 % for at undgå vibrationer og skader på skær.

DCX	max	f_{max}
16	5.6	0.12
20	5.6	0.15
25	5.6	0.17

HFC			
a_p	0.3	0.6	1.0
f	1.50	0.80	0.40

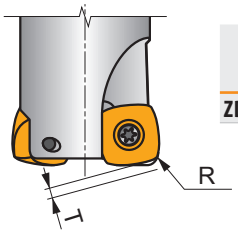
DCX	RPMX	APMX/I
16	7.8	1.0/9
20	9.7	1.0/7
25	4.9	1.0/13

HFC		
DCX	RPMX	APMX/I
16	0.5	0.75/100
20	0.3	0.40/100
25	0.2	0.20/100

DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
16	21.0	32.0	0.10	0.40
20	29.0	40.0	0.10	0.30
25	39.0	50.0	0.15	0.25

DCX	a_p	f_{max}
16	0.05	0.12
20	0.05	0.15
25	0.05	0.17

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
16	FE	0.438	0.566	0.800	0.980	1.131	1.386	1.600	1.789	1.960	2.263	2.530
20		0.490	0.632	0.894	1.095	1.265	1.549	1.789	2.000	2.191	2.530	2.828
25		0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162



	R	T
ZDCW 070304	1.70	0.60

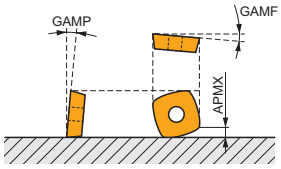
SZD09

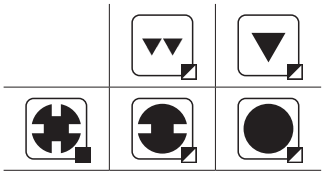
FEED ZD09 fræser high feed med intern kølevæske

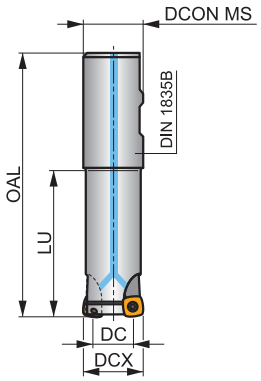
Produktiv high feed fræser til fræsning med enkeltsidet ZD .. 09-skær med 4 skærekanter og en APMX på 1 mm. Intern kølevæske. Velegnet til en lang række applikationer. Fås i cylindrisk og modulær type. Krop behandlet for længere værktøjslevetid.

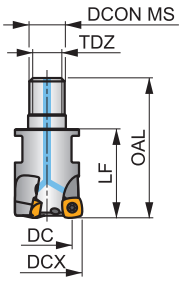
FEED ZD

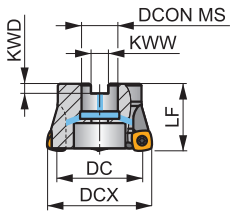
APMX	1.0 mm











h_m	0.31 - 0.618
h_m	0.31 - 0.618

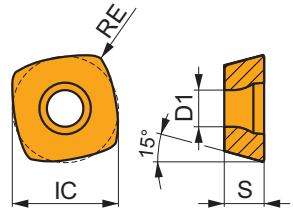
	Product	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835B	**25E2R080B25-SZD09-C**	25	11.6	140	25	80	–	–	–	–	-6	10	2	–	22800	✓	0.46	GI191	SQ400
	25E2R140B25-SZD09-C	25	11.6	200	25	140	–	–	–	–	-6	10	2	–	22800	✓	0.63	GI191	SQ400
	32E2R080B32-SZD09-C	32	18.7	140	32	80	–	–	–	–	-6	10	2	–	20100	✓	0.76	GI191	SQ400
MODULAR	**25E3R032M12-SZD09-C**	25	11.6	54	12.5	–	32	M12	–	–	-6	10	3	–	–	✓	0.11	GI191	SQ400
	32E3R040M16-SZD09-C	32	18.7	63	17	–	40	M16	–	–	-6	10	3	–	–	✓	0.21	GI191	SQ400
ISO 6462 DIN 8030	**40A04R-SMOZD09-C**	40	26.7	–	16	–	40	–	8.4	5.6	-6	10	4	✓	18000	✓	0.34	GI191	SQ402
	50A05R-SMOZD09-C	50	36.7	–	22	–	40	–	10.4	6.4	-6	10	5	✓	16000	✓	0.41	GI191	SQ403
	63A06R-SMOZD09-C	63	49.7	–	22	–	40	–	10.4	6.4	-6	10	6	✓	14300	✓	0.60	GI191	SQ403

GI191	ZDCW 09T3..

		Nm						
SQ400	US 3006-T09P	2.0	M 3	6	–	–	Flag T09P	–
SQ402	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	–	HS 0830C
SQ403	US 3006-T09P	2.0	M 3	6	D-T07P/T09P	FG-15	–	HS 1030C

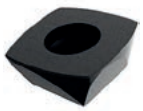
ZDCW 09

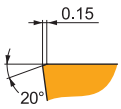
	IC	D1	S
	(mm)	(mm)	(mm)
09T3	9.525	3.40	3.97



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
ZDCW 09T304:M8310	0.4	320	1.00	0.6	–	–	–	300	1.00	0.6	–	–	–	–	–	–	60	0.70	0.4
ZDCW 09T304:M8325	0.4	250	1.00	0.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
ZDCW 09T304:M8345	0.4	235	1.00	0.6	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–



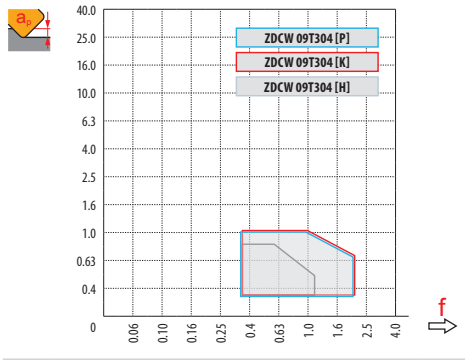


HFC

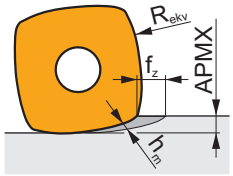
ZDCW speciel geometri til high feed bearbejdning.

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
⇨ X.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
⇨ X.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ZDCW 09
RE	0.4
BS	–



DCX	a_p	0.00	0.30	0.40	0.50	0.60	0.70	0.80	0.90	1.00
25	DEF	11.6	17.4	18.2	19.0	19.7	20.3	20.9	21.5	22.0
32		18.7	24.5	25.3	26.1	26.8	27.4	28.0	28.6	29.1
40		27.7	33.5	34.3	35.1	35.8	36.4	37.0	37.6	38.1
50		36.7	42.3	43.1	43.8	44.5	45.1	45.7	46.2	46.7
63		49.7	55.3	56.1	56.8	57.5	58.1	58.7	59.2	59.7
	a_p	**0.00**	**0.30**	**0.40**	**0.50**	**0.60**	**0.70**	**0.80**	**0.90**	**1.00**
	f	–	2.00	2.00	2.00	1.75	1.50	1.25	1.13	1.00



$$f_z = h_m \times \sqrt{\frac{2R_{ekv.}}{APMX}} \quad \text{(mm/tand)}$$

Følg instruktionerne for planfræsning. I tilfælde af fræsning tæt på lodret flade skal tilspændingen pr. tand (f_z) reduceres til 50 % for at undgå vibrationer og skader på skær.

DCX	max	f_{max}
25	7.7	0.15
32	7.7	0.17
40	7.7	0.20

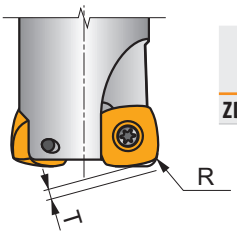
	HFC		
a_p	0.3	0.6	1.0
f	2.00	1.50	1.00

			HFC	
DCX	RPMX	APMX/I	RPMX	APMX/I
25	12.0	1.0/6	0.9	1.00/65
32	7.5	1.0/11	0.5	0.75/100
40	3.6	1.0/17	0.4	0.55/100

DCX	DMIN	DMAX	SMAX / DMIN	SMAX / DMAX
25	35.0	50.0	0.45	1.00
32	49.0	64.0	0.45	0.85
40	65.0	80.0	0.50	0.85

DCX	a_p	f_{max}
25	0.15	0.15
32	0.15	0.17
40	0.15	0.20

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
25	FE	0.548	0.707	1.000	1.225	1.414	1.732	2.000	2.236	2.449	2.828	3.162
32		0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50												
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020



	R	T
ZDCW 09T304	2.27	0.52

SZD12

P K H

PRAMET

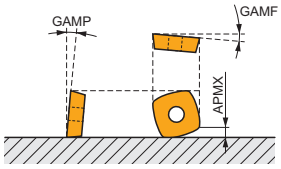
S

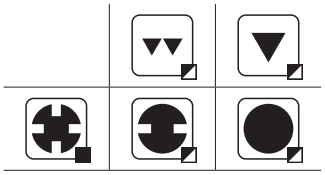
FEED ZD12 Fræser til high feed med intern kølevæske

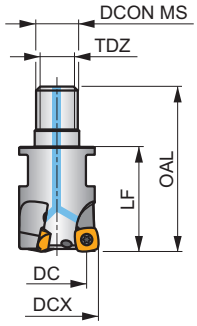
Meget produktiv high feed fræser med enkeltsidet ZD .. 12 skær med 4 skærekanter og APMX på 1.6 mm. Intern kølevæske. Velegnet til en lang række applikationer. Fås i cylindrisk, modulær og dorn-type. Krop behandlet for længere værktøjslevetid.

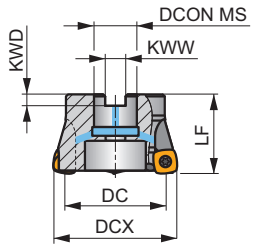
FEED ZD

APMX	1.6 mm









h_m	0.46 - 0.925
h_m	0.46 - 0.925

	Product	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	TDZ	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)			max.		kg			
MODULAR	**32E3R040M16-SZD12-C**	32	14.5	63	17	–	40	M16	–	–	-6	10	3	–	–	✓	0.19	GI192	SQ220	–
MODULAR	**40E4R040M16-SZD12-C**	40	22.5	63	17	–	40	M16	–	–	-6	10	4	–	–	✓	0.22	GI192	SQ220	–
ISO 6462 DIN 8030	**50A04R-SM0ZD12-C**	50	32.5	–	22	–	40	–	10.4	6.4	-6	10	4	✓	14000	✓	0.38	GI192	SQ033	–
ISO 6462 DIN 8030	**63A05R-SM0ZD12-C**	63	45.5	–	22	–	40	–	10.4	6.4	-6	10	5	✓	12500	✓	0.57	GI192	SQ033	–
ISO 6462 DIN 8030	**80A05R-SM0ZD12-C**	80	62.5	–	27	–	50	–	12	7	-6	10	5	✓	11100	✓	1.07	GI192	C0371	AC001

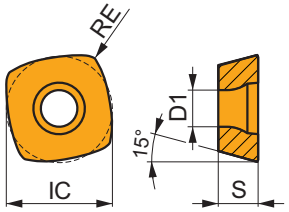
GI192	ZDEW 1204..

		Nm						
C0371	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	–	–
SQ033	US 4011-T15P	3.5	M 4	10.6	D-T08P/T15P	FG-15	–	HS 1030C
SQ220	US 4011-T15P	3.5	M 4	10.6	–	–	Flag T15P	–

AC001	KS 1230	K.FMH27

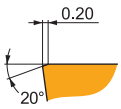
ZDEW 12

	IC	D1	S
	(mm)	(mm)	(mm)
1204	12.700	4.40	4.76



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
ZDEW 120408:M8310	0.8	270	1.00	1.0	–	–	–	255	1.00	1.0	–	–	–	–	–	–	50	0.70	0.7
ZDEW 120408:M8325	0.8	205	1.00	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
ZDEW 120408:M8345	0.8	195	1.00	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

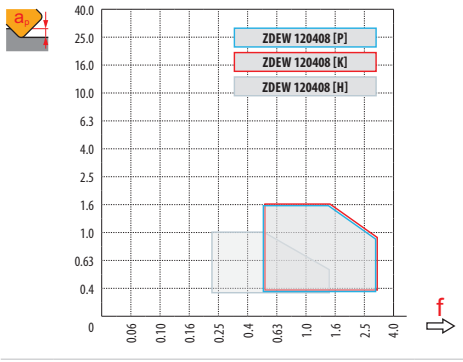


HFC

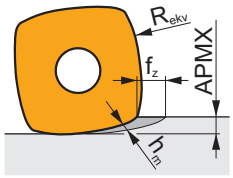
ZDEW speciel geometri til high feed bearbejdning.

a_e / DCX	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00
x.f	2.20	1.60	1.35	1.20	1.10	0.95	0.85	0.75	0.85	0.95	1.00	1.00	1.00	1.00
x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	0.68	0.71	0.72	0.74	0.79	1.00

	ZDEW 12
RE	0.8
BS	–



DCX	a_p	0.00	0.50	0.60	0.70	0.80	0.90	1.00	1.10	1.20	1.30	1.40	1.50	1.60
32	DEF	14.5	22.7	23.5	24.2	24.8	25.4	26.0	26.5	27.0	27.5	28.0	28.5	28.9
40		22.5	30.7	31.5	32.2	32.8	33.4	34.0	34.5	35.0	35.5	36.0	36.5	36.9
50		32.5	40.7	41.5	42.2	42.8	43.4	44.0	44.5	45.0	45.5	46.0	46.5	46.9
63		45.5	53.7	54.5	55.2	55.8	56.4	57.0	57.5	58.0	58.5	59.0	59.5	59.9
80		62.5	70.7	71.5	72.2	72.8	73.4	74.0	74.5	75.0	75.5	76.0	76.5	76.9
	a_p	0.00	0.50	0.60	0.70	0.80	0.90	1.00	1.10	1.20	1.30	1.40	1.50	1.60
	f	–	3.00	3.00	3.00	3.00	3.00	3.00	2.50	2.25	2.00	1.80	1.65	1.50



$$f_z = h_m \times \sqrt{\frac{2R_{ekv.}}{APMX}} \quad \text{(mm/tand)}$$

Følg instruktionerne for planfræsning. I tilfælde af fræsning tæt på lodret flade skal tilspændingen pr. tand (f_z) reduceres til 50 % for at undgå vibrationer og skader på skær.

DCX	max	f_{max}
32	10.0	0.15
40	10.0	0.17
50	10.0	0.20
63	10.0	0.20
80	10.0	0.25

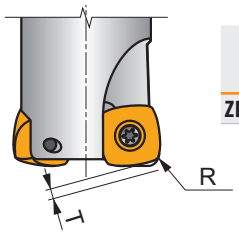
	HFC		
a_p	0.5	1.0	1.6
f	3.00	2.00	1.50

			HFC	
DCX	RPMX	APMX/I	RPMX	APMX/I
32	10	1.6/11	1.2	1.60/78
40	5.5	1.6/18	0.7	1.10/100
50	3.3	1.6/29	0.5	0.75/100
63	2.2	1.6/43	0.3	0.40/100
80	1.5	1.6/63	0.2	0.20/100

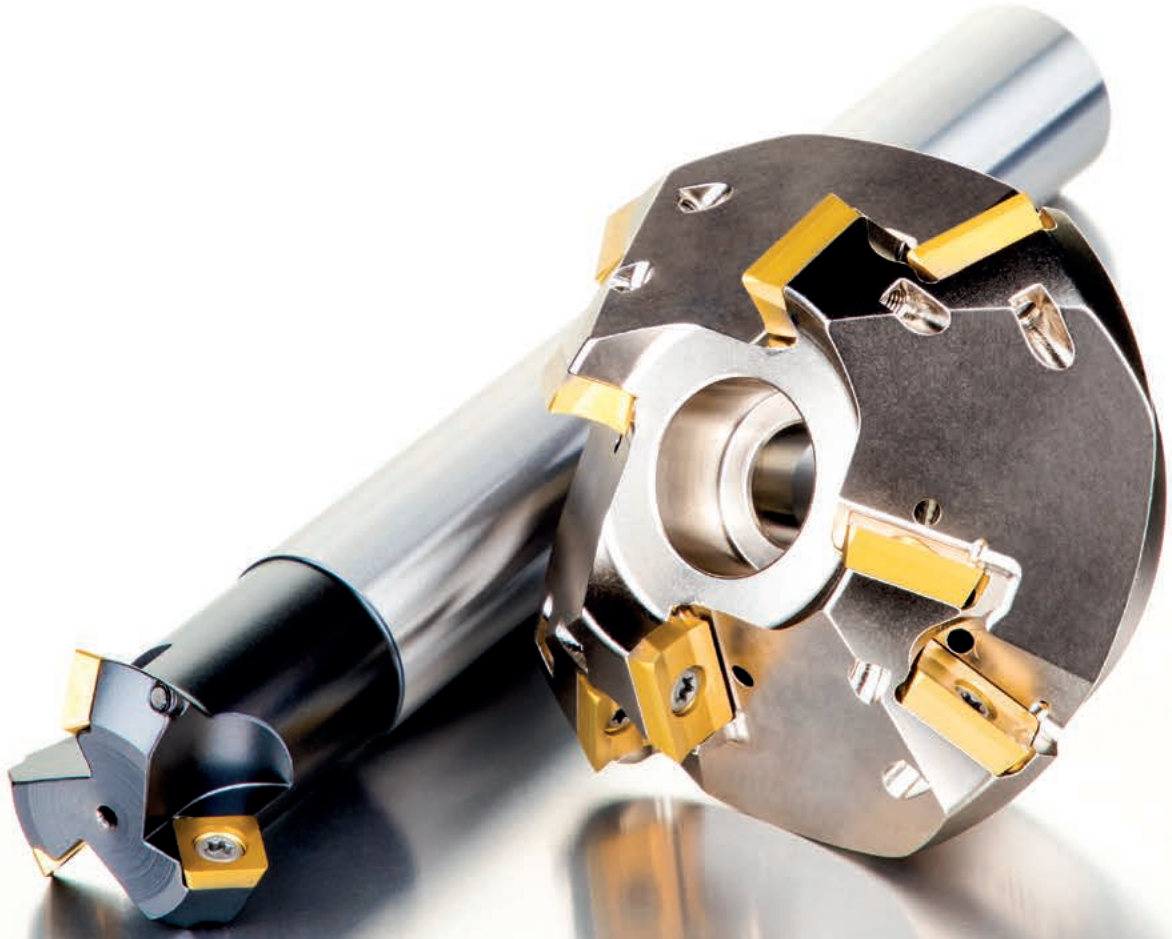
DCX	DMIN	DMAX	SMAX DMIN	SMAX DMAX
32	44.0	64.0	0.75	1.60
40	60.0	80.0	0.75	1.50
50	80.0	100.0	0.80	1.35
63	106.0	126.0	0.70	1.00
80	140.0	160.0	0.65	0.85

DCX	a_p	f_{max}
32	0.25	0.15
40	0.25	0.17
50	0.25	0.20
63	0.25	0.20
80	0.25	0.25

DCX	µm	3	5	10	15	20	30	40	50	60	80	100
32	FE	0.620	0.800	1.131	1.386	1.600	1.960	2.263	2.530	2.771	3.200	3.578
40		0.693	0.894	1.265	1.549	1.789	2.191	2.530	2.828	3.098	3.578	4.000
50		0.775	1.000	1.414	1.732	2.000	2.449	2.828	3.162	3.464	4.000	4.472
63		0.869	1.122	1.587	1.944	2.245	2.750	3.175	3.550	3.888	4.490	5.020
80		0.980	1.265	1.789	2.191	2.530	3.098	3.578	4.000	4.382	5.060	5.657



	R	T
ZDEW 120408	3.52	0.64



AFFASNING

CHANMFERING – POSITIVE INSERTS

	SSD09	N-SSO09	STC	2516	2636	J(T)-SXP16
	45°	45°	45°	45°	10°– 80°	15°– 75°
	APMX (mm) 4.5	APMX (mm) 4.5	APMX (mm) 8.0	APMX (mm) 8.5	APMX (mm) 8.5	APMX (mm) 7.0– 28.0
	DC (mm) 10 – 25	DC (mm) 8 – 25	DC (mm) 20	DC (mm) 11 – 19	DC (mm) 5 – 23	DC (mm) 35 – 45
Cylindrical shank	DC = 16, 25 (mm)					
Weldon	DC = 10 – 25 (mm)					
Morse	DC = 16, 25 (mm)					
Shell mill						
Page	292	295	298	301	304	307
ISO	P M K S H	P M K S	P M K N	P M K N	P M K N	P M K N
Insert shape						
Inserts	SDE. 0903	SOMT 09T3	TCTX 16 STC	TCMT 16T3	TCMT 16T3	XPHT 1604
No. of cutting edges	4	4	3	3	3	2
Chamfer milling	■	■	■	■	■	■

■ Primary use ◪ Possible use

SSD09

P M K S H

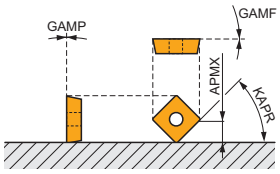
PRAMET

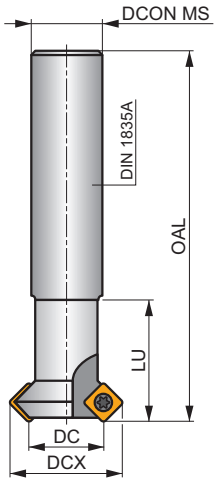
S

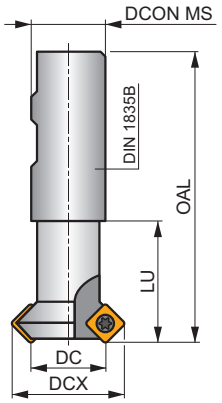
45 ° affasningsfræser til firkantet skær SD .. 09

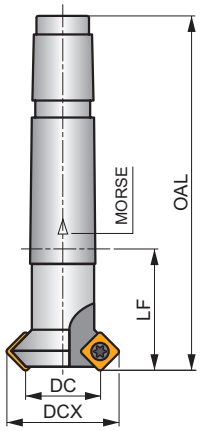
En 45° affasningsfræser, der anvender enkeltsidet SD .. 09-skær med APMX på 4.5 mm. Velegnet til affasning i øverste og nederste side. Fås i cylindrisk, weldon og morse konisk stil. Krop behandlet for længere værktøjslevetid.

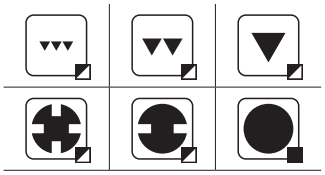
KAPR	45°
APMX	4.5 mm











h_m 0.095 - 0.15

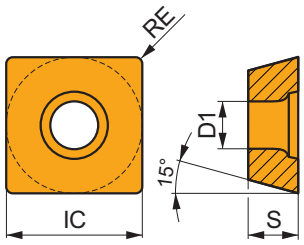
	Product	DC (mm)	DCX (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	LF (mm)	CZC MS	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835A	**16N2R027A16-SSD09**	16	28	200	16	27	–	–	0	0	2	–	32200	–	0.34	GI129	C0070
	25N3R042A25-SSD09	25	37	200	25	42	–	–	0	0	3	–	25800	–	0.77	GI129	CH011
DIN 1835B	**10N1R027B16-SSD09-A**	10	22	75	16	27	–	–	0	0	1	–	40700	–	0.13	GI129	C0070
	16N2R027B16-SSD09-A	16	28	75	16	27	–	–	0	0	2	–	32200	–	0.14	GI129	C0070
	25N3R042B25-SSD09-A	25	37	98	25	42	–	–	0	0	3	–	25800	–	0.37	GI129	CH011
DIN 228A	**16N2R030E02-SSD09-A**	16	28	94	–	–	30	2	0	0	2	–	32200	–	0.14	GI129	C0070
	25N3R043E03-SSD09-A	25	37	124	–	–	43	3	0	0	3	–	25800	–	0.38	GI129	CH011

GI129	SDEW 0903..	SDEX 0903..

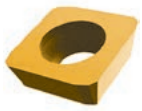
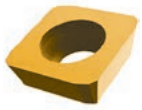
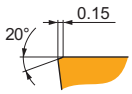
		Nm			
C0070	US 3507-T15	3.0	M 3.5	7	Flag T15
CH011	US 3509-T15	3.0	M 3.5	9	Flag T15

SDEW 09

	IC (mm)	D1 (mm)	S (mm)
0903	9.525	4.40	3.18

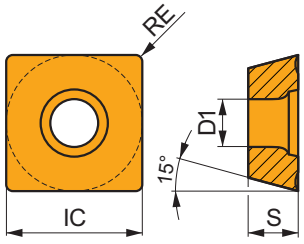


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

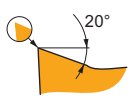
Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			**EN** geometri med nul skærevinkeldesign til 45 ° affasning.																	
SDEW 090308EN:M8330		0.8	235	0.10	4.5	–	–	–	220	0.10	4.5	–	–	–	–	–	–	45	0.09	0.7
SDEW 090308EN:M8340		0.8	210	0.10	4.5	–	–	–	195	0.10	4.5	–	–	–	–	–	–	–	–	–
			**SN** geometri med nul skær vinkel design til 45 ° affasning fræsning.																	
SDEW 090308SN:M8330		0.8	215	0.15	4.5	–	–	–	200	0.15	4.5	–	–	–	–	–	–	40	0.11	0.7
SDEW 090308SN:M8340		0.8	195	0.15	4.5	–	–	–	185	0.15	4.5	–	–	–	–	–	–	–	–	–

SDEX 09

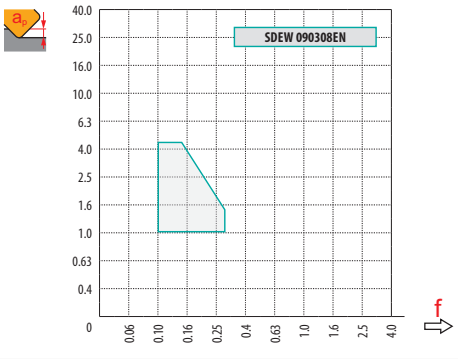
	IC (mm)	D1 (mm)	S (mm)
0903	9.525	4.40	3.18

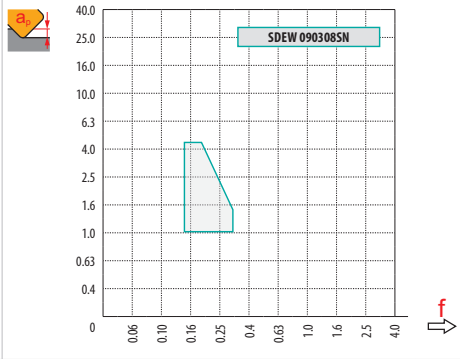


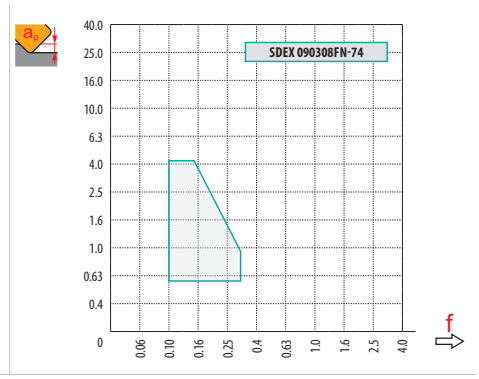
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			**74** geometri med positivt design til 45 ° affasning.																	
SDEX 090308FN-74:M8330		0.8	305	0.12	4.5	180	0.11	4.5	285	0.12	4.5	–	–	–	75	0.11	3.6	–	–	–

	SDEW 09 EN	SDEW 09 SN	SDEX 09-74
RE	0.8	0.8	0.8
BS	–	–	–







DC	DCX	X.V	f_{min}	f_{max}
10	22	1.09	0.20	0.30
16	28	1.17	0.25	0.34
25	37	1.24	0.32	0.39

a_e / DC	**0.10**			**0.15**			**0.20**			**0.25**			**0.30**			**0.35**			**0.40**			**0.50 – 1.00**		
	f																							
45°	0.42	0.54	0.67	0.35	0.44	0.55	0.30	0.38	0.47	0.27	0.34	0.42	0.25	0.31	0.39	0.23	0.29	0.36	0.21	0.27	0.34	0.19	0.24	0.30
X.V	1.35			1.27			1.22			1.19			1.16			1.13			1.11			1.00		

N-SSO09

P M K S

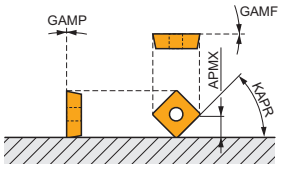
PRAMET

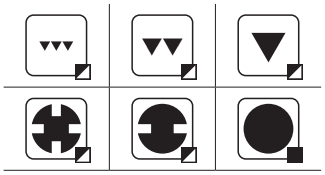
S

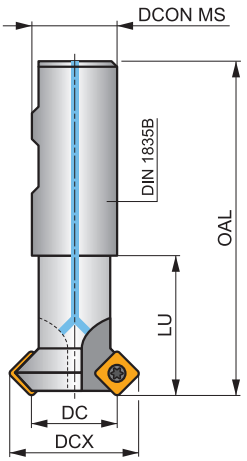
45 ° affasningsfræser til firkantet skær SOMT 09 med intern kølevæske

En 45° affasningsfræser, der anvender enkeltsidede SOMT 09-skær med APMX på 4.5 mm. Intern kølevæske. Velegnet til affasning i øverste og nederste side. Fås i cylindrisk, weldon og morse konisk stil. Krop behandlet for længere værktøjslevetid.

KAPR	45°
APMX	4.5 mm







h_m 0.095 - 0.18

	Product	DC (mm)	DCX (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835B	**16N2R027B16-SSO09-C**	16	28.8	110	16	27	0	0	2	–	26600	✓	0.23	GI146	SQ500
	25N3R042B25-SSO09-C	25	37.8	125	25	42	0	0	3	–	21300	✓	0.49	GI146	SQ500
	8N1R027B16-SSO09-C	8	20.5	90	16	27	0	0	1	–	37700	✓	0.16	GI146	SQ500

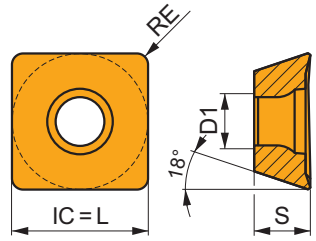
GI146	SOMT 09T3..

SQ500	US 3006-T09P	2.0	M 3	6	Flag T09P

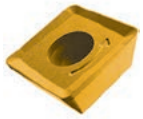
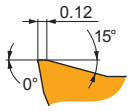
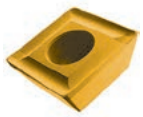
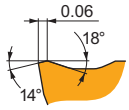
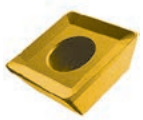
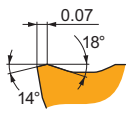
SOMT 09

PRAMET

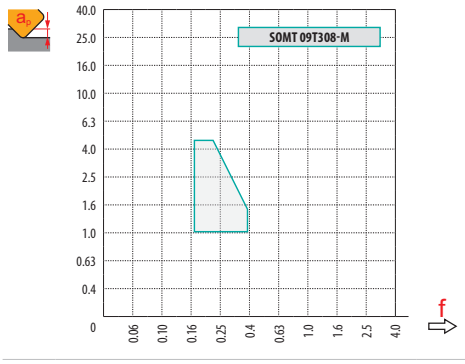
	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
09T3	9.550	3.50	9.55	3.97

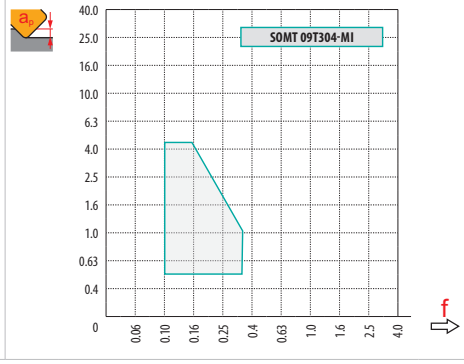


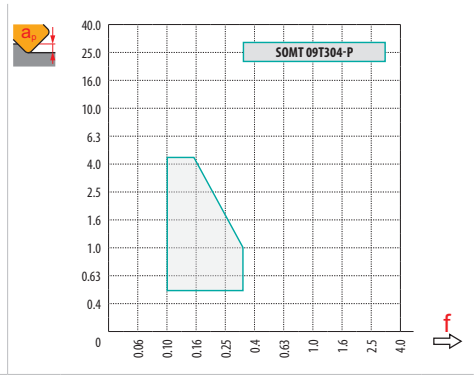
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Betingelserne gælder for indstillingsvinkel 90 °. Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
			**M** geometri med positivt design til medium bearbejdning.																	
SOMT 09T308-M:8215		0.8	■	275	0.14	2.5	◪	165	0.13	2.5	◪	260	0.14	2.5	–	–	–	◪	65	0.13	2.0	–	–	–
SOMT 09T308-M:M5315		0.8	◪	390	0.14	2.5		–	–	–	◪	370	0.14	2.5	–	–	–		–	–	–	–	–	–
SOMT 09T308-M:M8330		0.8	■	270	0.14	2.5	■	160	0.13	2.5	◪	255	0.14	2.5	–	–	–	◪	65	0.13	2.0	–	–	–
SOMT 09T308-M:M8340		0.8	■	250	0.14	2.5	■	150	0.13	2.5	◪	235	0.14	2.5	–	–	–	◪	60	0.13	2.0	–	–	–
SOMT 09T308-M:M9315		0.8	■	380	0.14	2.5		–	–	–	◪	360	0.14	2.5	–	–	–		–	–	–	–	–	–
			**MI** geometri med stabilt positivt design til medium bearbejdning.																	
SOMT 09T304-MI:8215	●	0.4	■	230	0.14	2.5	◪	135	0.13	2.5	◪	215	0.14	2.5	–	–	–	◪	55	0.10	2.0	–	–	–
SOMT 09T304-MI:M8310	●	0.4	■	255	0.14	2.5	◪	130	0.13	2.5	◪	240	0.14	2.5	–	–	–		–	–	–	–	–	–
SOMT 09T304-MI:M8330	●	0.4	■	230	0.14	2.5	■	135	0.13	2.5	◪	215	0.14	2.5	–	–	–	◪	55	0.10	2.0	–	–	–
SOMT 09T304-MI:M8340		0.4	■	210	0.14	2.5	■	125	0.13	2.5	◪	195	0.14	2.5	–	–	–	◪	50	0.10	2.0	–	–	–
SOMT 09T304-MI:M9315	●	0.4	■	320	0.14	2.5		–	–	–	◪	300	0.14	2.5	–	–	–		–	–	–	–	–	–
SOMT 09T304-MI:M9340	●	0.4	■	265	0.14	2.5	■	155	0.13	2.5		–	–	–	–	–	–	◪	65	0.10	2.0	–	–	–
			**P** geometri med meget positivt design til medium bearbejdning.																	
SOMT 09T304-P:M8330	●	0.4	■	250	0.14	2.5	◪	150	0.13	2.5	◪	235	0.14	2.5	–	–	–	◪	60	0.10	2.0	–	–	–
SOMT 09T304-P:M8340	●	0.4	■	230	0.14	2.5	◪	135	0.13	2.5	◪	215	0.14	2.5	–	–	–	◪	55	0.10	2.0	–	–	–
SOMT 09T304-P:M9325	●	0.4	■	320	0.14	2.5		–	–	–	◪	300	0.14	2.5	–	–	–		–	–	–	–	–	–

	SOMT 09-M	SOMT 09-MI	SOMT 09-P
RE	0.8	0.4	0.4
BS	–	–	–







DC	DCX	X.V	f_{min}	f_{max}
8	20.5	1.06	0.18	0.29
16	28.8	1.17	0.25	0.34
25	37.8	1.24	0.32	0.39

a_e / DC	**0.10**			**0.15**			**0.20**			**0.25**			**0.30**			**0.35**			**0.40**			**0.50 – 1.00**		
	f																							
45°	0.42	0.63	0.80	0.35	0.51	0.66	0.30	0.44	0.57	0.27	0.40	0.51	0.25	0.36	0.46	0.23	0.33	0.43	0.21	0.31	0.40	0.19	0.28	0.36
X.V	1.35			1.27			1.22			1.19			1.16			1.13			1.11			1.00		

STC

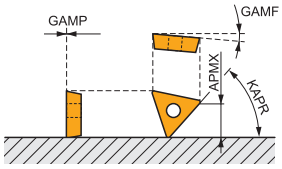
PRAMET

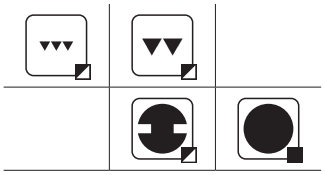
S

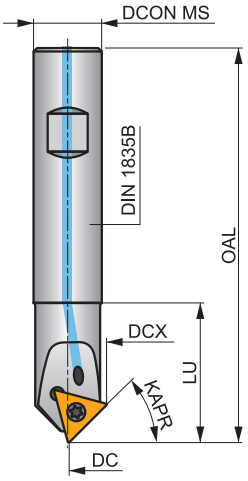
45° affasnings- og graveringsfræser til TC.T 16-skær med intern kølevæske

En 45° affasnings- og graveringsfræser, der anvender ensidige TC.T 16 skær med APMX på 8,5 mm. Intern kølevæske. Velegnet til affasning på oversiden. Fås kun i weldon. Krop behandlet for længere værktøjslevetid.

KAPR	45°







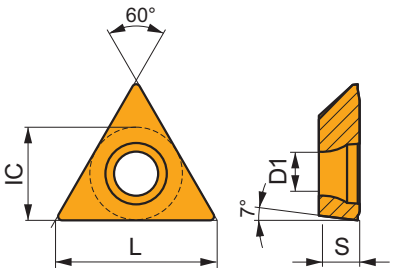
	Product	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)			kg		
DIN 1835B	20N1R040B20-STC-000887	22.8	1.1	114	20	40	1	✓	0.26	GI223	SQ222

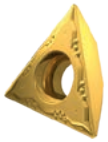
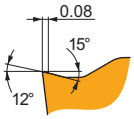
GI223	TC.T 16 STC

		Nm			
SQ222	US 2002-T15P	3.0	4	8.5	Flag T15P

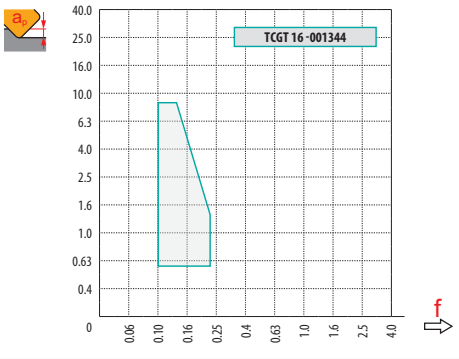
TCXT 16 STC

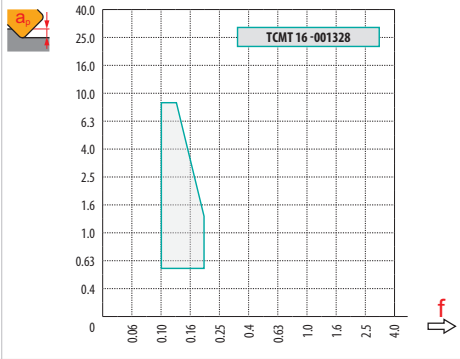
	IC (mm)	D1 (mm)	L (mm)	S (mm)
16	9.525	4.60	16.50	3.97



Product	Interrupted/ Continuous cut	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
328 spånbryderen er skarp og førstevalget til finbearbejdning af stål. Den har en let positiv spånvinkel uden T-land. Den er også velegnet til støbejern.																				
TCMT 16-001328:M8330	–	0.4	■ 150	0.13	8.5	◪ 90	0.12	8.5	◪ 140	0.13	8.5	–	–	–	–	–	–	–	–	–
344 spånbryderen er skarp og førstevalget til allround-bearbejdning af ikke-jernholdige legeringer. Den har en meget positiv spånvinkel uden T-land. Den er også betinget egnet til superlegeringer.																				
TCGT 16-001344:HF7	–	0.4	–	–	–	–	–	–	–	–	–	■ 225	0.10	8.5	–	–	–	–	–	–

	TCGT 16 -001344	TCMT 16 -001328
RE	0.4	0.4
BS	–	–





DC	DCX	X.V	f_{min}	f_{max}
1.1	22.8	1.1	0.1	.018

2516

P M K N

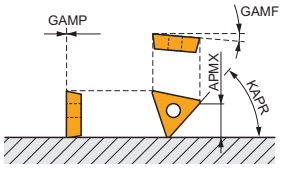
PRAMET

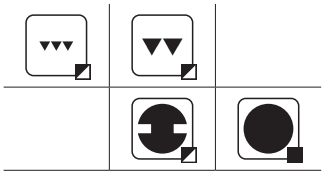
S

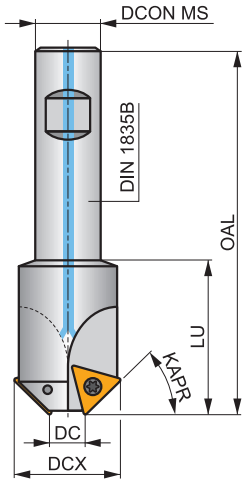
45 ° affasningsfræser til TCMT 16-skær med intern kølevæske

En 45° affasningsfræser, der anvender ensidige TCMT 16 skær med APMX på 8.5 mm. Intern kølevæske. Velegnet til affasning på oversiden. Fås kun i weldon. Krop behandlet for længere værktøjslevetid.

KAPR	45°
APMX	8.5 mm







h_m 0.065 - 0.095

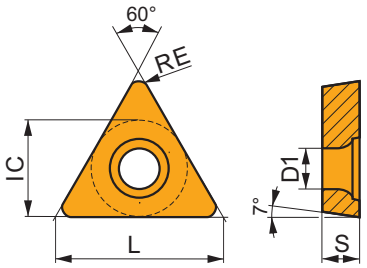
	Product	DCX (mm)	DC (mm)	OAL (mm)	DCON MS (mm)	LU (mm)			max.		kg		
DIN 1835B	**2516-45-11**	31	11	100	16	30	2	–	18100	✓	0.20	GI155	SQ220
DIN 1835B	**2516-45-19**	39	19	100	20	30	2	–	16200	✓	0.31	GI155	SQ220

GI155	TCMT 16T308E-FM:T8..

		Nm			
SQ220	US 4011-T15P	3.5	M 4	10.6	Flag T15P

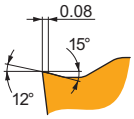
TCMT

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
16T3	9.525	4.40	16.50	3.97



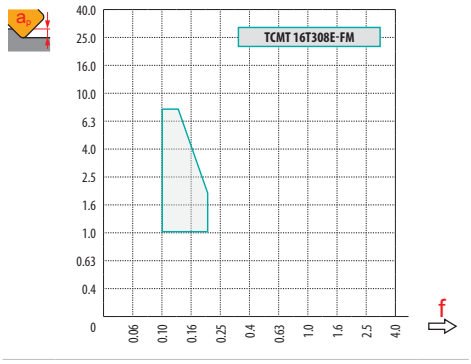
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
TCMT 16T308E-FM:T8315	●	0.8	170	0.17	1.7	100	0.15	1.7	160	0.17	1.7	510	0.20	1.7	–	–	–	–	–	–
TCMT 16T308E-FM:T8415	●	0.8	210	0.17	1.7	110	0.15	1.7	190	0.17	1.7	525	0.20	1.7	–	–	–	–	–	–
TCMT 16T308E-FM:T8430	●	0.8	185	0.17	1.7	100	0.15	1.7	150	0.17	1.7	510	0.20	1.7	–	–	–	–	–	–



FM spånbryderen er alsidig og førstevalget til efterbehandling af stål. Den har en positiv spånvinkel og et positivt, smalt T-land. Den er også velegnet til rustfrit stål og betinget til støbejern og ikke-jernholdige legeringer.

	TCMT 16-FM
RE	0.8
BS	–



DC	DCX	X.V	f_{min}	f_{max}
11.0	31.0	1.02	0.10	0.18
19.0	39.0	1.10	0.14	0.20

2636

P M K N

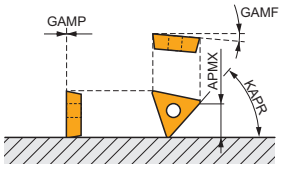
PRAMET

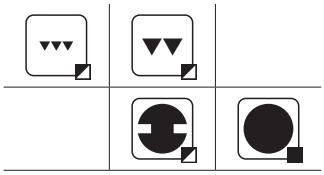
S

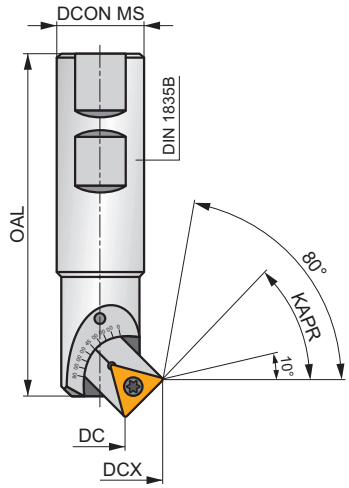
Justerbar fræser til TCMT 16 skær

Justerbar afskæringsfræser med TCMT 16 skær med APMX på 8.5 mm. Justerbart vinkelområde fra 10° til 80°. Fås kun i weldon-stil. Krop behandlet for længere værktøjslevetid.

KAPR	10° – 80°
APMX	8.5 mm







h_m 0.03 – 0.08

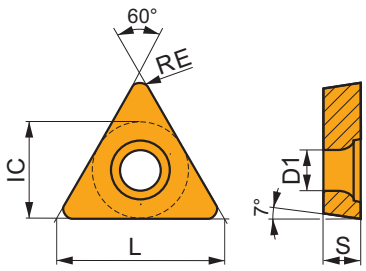
	Product	DCN (mm)	DCX (mm)	OAL (mm)	DCON MS (mm)	KAPR (°)	GAMF (°)	GAMP (°)			max.		kg		
DIN 1835B	**2636-05-25**	5.0	31.0	100	25	10	-8	0	1	–	18100	–	0.35	GI294	CH040
		5.5	31.0			15									
		7.0	29.5			30									
		11.0	29.5			45									
		16.0	28.5			60									
		21.0	26.5			75									
		23.0	26.0			80									

GI294	TCMT 16T304E-FM:T8...	TCMT 16T308E-FM:T8...

CH040	USI 0614	CA 2669	US 4011-T15P	3.5	M 4	10.6	Flag T15

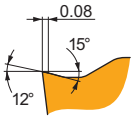
TCMT

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
16T3	9.525	4.40	16.50	3.97



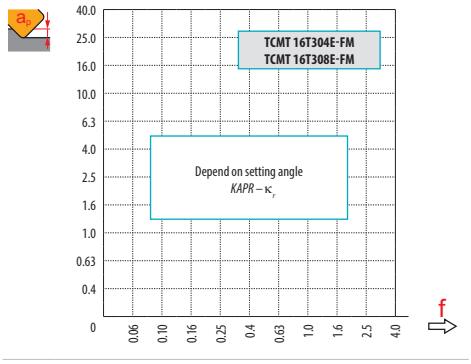
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)	(m/min)	(mm/rev)	(mm)
TCMT 16T304E-FM:T8315	●	0.4	155	0.12	1.7	90	0.11	1.7	145	0.12	1.7	465	0.14	1.7	–	–	–	–	–	–
TCMT 16T304E-FM:T8415	●	0.4	190	0.12	1.7	100	0.11	1.7	170	0.12	1.7	480	0.14	1.7	–	–	–	–	–	–
TCMT 16T304E-FM:T8430	●	0.4	180	0.12	1.7	95	0.11	1.7	145	0.12	1.7	495	0.14	1.7	–	–	–	–	–	–
TCMT 16T308E-FM:T8315	●	0.8	170	0.17	1.7	100	0.15	1.7	160	0.17	1.7	510	0.20	1.7	–	–	–	–	–	–
TCMT 16T308E-FM:T8415	●	0.8	210	0.17	1.7	110	0.15	1.7	190	0.17	1.7	525	0.20	1.7	–	–	–	–	–	–
TCMT 16T308E-FM:T8430	●	0.8	185	0.17	1.7	100	0.15	1.7	150	0.17	1.7	510	0.20	1.7	–	–	–	–	–	–



FM spånbryderen er alsidig og førstevalget til efterbehandling af stål. Den har en positiv spånvinkel og et positivt, smalt T-land. Den er også velegnet til rustfrit stål og betinget til støbejern og ikke-jernholdige legeringer.

	TCMT 16-FM	
RE	0.8	0.4
BS	–	–



	a_p	DC	DCX	X.V	f_{min}	f_{max}
10°	2.6	5.0	31.0	1.38	0.24	0.59
15°	3.9	5.5	31.0	1.30	0.17	0.40
30°	7.6	7.0	29.5	1.18	0.10	0.20
45°	10.7	11.0	29.5	1.13	0.09	0.14
60°	13.2	16.0	28.5	1.09	0.09	0.11
75°	14.7	21.0	26.5	1.06	0.09	0.10
80°	15.0	23.0	26.0	1.06	0.09	0.10

a_e / DC	0.10			0.15			0.20			0.25			0.30			0.35			0.40			0.50 – 1.00		
	f																							
10°	0.55	0.91	1.46	0.45	0.74	1.19	0.39	0.64	1.03	0.35	0.58	0.92	0.32	0.53	0.84	0.29	0.49	0.78	0.27	0.46	0.73	0.24	0.41	0.65
15°	0.37	0.61	0.98	0.30	0.50	0.80	0.26	0.43	0.69	0.23	0.39	0.62	0.21	0.35	0.56	0.20	0.33	0.52	0.18	0.31	0.49	0.16	0.27	0.44
30°	0.19	0.32	0.51	0.15	0.26	0.41	0.13	0.22	0.36	0.12	0.20	0.32	0.11	0.18	0.29	0.10	0.17	0.27	0.09	0.16	0.25	0.08	0.14	0.23
45°	0.13	0.22	0.36	0.11	0.18	0.29	0.09	0.16	0.25	0.08	0.14	0.23	0.08	0.13	0.21	0.07	0.12	0.19	0.07	0.11	0.18	0.06	0.10	0.16
60°	0.11	0.18	0.29	0.09	0.15	0.24	0.08	0.13	0.21	0.07	0.12	0.18	0.06	0.11	0.17	0.06	0.10	0.16	0.05	0.09	0.15	0.05	0.08	0.13
75°	0.10	0.16	0.26	0.08	0.13	0.21	0.07	0.12	0.19	0.06	0.10	0.17	0.06	0.09	0.15	0.05	0.09	0.14	0.05	0.08	0.13	0.04	0.07	0.12
80°	0.10	0.16	0.26	0.08	0.13	0.21	0.07	0.11	0.18	0.06	0.10	0.16	0.06	0.09	0.15	0.05	0.09	0.14	0.05	0.08	0.13	0.04	0.07	0.11
X.V	1.35			1.27			1.22			1.19			1.16			1.13			1.11			1.00		

J(T)-SXP16

P M K N

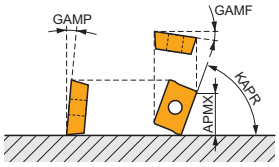
PRAMET

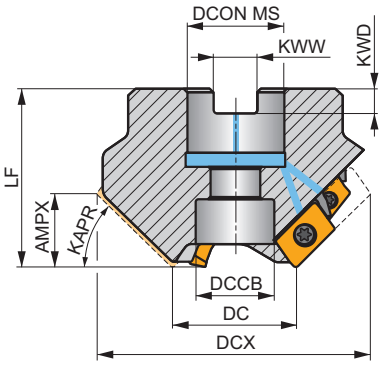
S

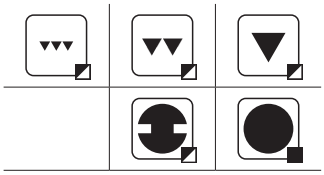
Langkantfaseskær til XPHT 16 skær med intern kølevæske

Affasningsfræser med enkeltsidet XPHT 16 skær med APMX fra 7 til 28 mm. Intern kølevæske. Velegnet til topfasning. Fås kun i dorn-type. Mindre Ø35 og Ø45 mm inden for området 15 °, 25 °, 30 °, 35 °, 40 °, 45 °, 50 °, 55 °, 60 ° og 75 ° affasningsvinkel. Krop behandlet for længere værktøjslevetid.

KAPR	15° - 75°
APMX	7.0 - 28.0 mm







h_m 0.05 - 0.11

	Product	DC (mm)	DCX (mm)	LF (mm)	DCON MS (mm)	DCCB (mm)	KAPR (°)	KWW (mm)	KWD (mm)	APMX (mm)	GAMF (°)	GAMP (°)	NOF			max.		kg		
	35T03R-S15XP1607-C	35	90.6	50	27	22	15	12.4	7	7.00	-6	-1	3	6	–	15200	✓	1.32	GI208	CH050
	35T03R-S25XP1612-C	35	87.3	50	27	22	25	12.4	7	12.00	-6	0	3	6	–	15200	✓	1.15	GI208	CH050
	35T03R-S30XP1614-C	35	85.1	50	27	22	30	12.4	7	14.00	-6	0	3	6	–	15200	✓	1.11	GI208	CH050
	35T03R-S35XP1616-C	35	82.4	50	27	22	35	12.4	7	16.00	-6	0	3	6	–	15200	✓	1.04	GI208	CH050
	35T03R-S40XP1618-C	35	79.4	50	27	22	40	12.4	7	18.00	-6	1	3	6	–	15200	✓	0.96	GI208	CH050
	35T03R-S45XP1620-C	35	76.1	50	27	22	45	12.4	7	20.00	-6	2	3	6	–	15200	✓	0.90	GI208	CH050
	35T03R-S50XP1622-C	35	72.4	50	27	22	50	12.4	7	22.00	-6	2	3	6	–	15200	✓	0.83	GI208	CH050
	35T03R-S55XP1623-C	35	68.4	50	27	22	55	12.4	7	23.00	-6	2	3	6	–	15200	✓	0.72	GI208	CH050
ISO 6462 DIN 8030	**35T03R-S60XP1625-C**	35	64.2	50	27	22	60	12.4	7	25.00	-5	4	3	6	–	15200	✓	0.63	GI208	CH050
	45T03R-S75XP1628-C	45	60.1	50	27	22	75	12.4	7	28.00	-5	5	3	6	–	13400	✓	0.64	GI208	CH050
	45T04R-S25XP1612-C	45	97.3	50	27	22	25	12.4	7	12.00	-6	0	4	8	✓	13400	✓	1.24	GI208	CH050
	45T04R-S30XP1614-C	45	95.1	50	27	22	30	12.4	7	14.00	-6	0	4	8	✓	13400	✓	1.21	GI208	CH050
	45T04R-S35XP1616-C	45	92.4	50	27	22	35	12.4	7	16.00	-6	2	4	8	✓	13400	✓	1.30	GI208	CH050
	45T04R-S40XP1618-C	45	89.5	50	27	22	40	12.4	7	18.00	-6	2	4	8	✓	13400	✓	1.08	GI208	CH050
	45T04R-S45XP1620-C	45	86.1	50	27	22	45	12.4	7	20.00	-6	2	4	8	✓	13400	✓	1.03	GI208	CH050
	45T04R-S50XP1622-C	45	82.4	50	27	22	50	12.4	7	22.00	-6	2	4	8	✓	13400	✓	0.96	GI208	CH050
	45T04R-S55XP1623-C	45	78.4	50	27	22	55	12.4	7	23.00	-6	2	4	8	✓	13400	✓	0.88	GI208	CH050
	45T04R-S60XP1625-C	45	74.2	50	27	22	60	12.4	7	25.00	-5	4	4	8	✓	13400	✓	0.78	GI208	CH050

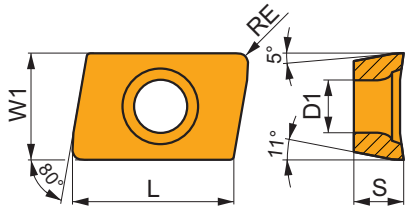
GI208	XPHT 1604..

CH050	US 3509-T15	3.0 Nm	M 3.5	9	D-T07/T15	FG-15	HS 1230C

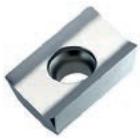
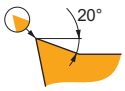
XPHT 16-FA

PRAMET

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.525	4.40	15.88	4.76



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

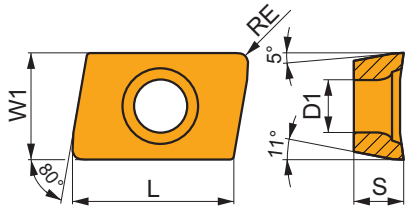
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				
XPHT 160408F-FA:HF7	●	0.8	–	–	–	–	–	–	–	–	–	■ 255	0.12	15.0	–	–	–	–	–	–

FA geometri med meget positivt design til affasningsfræsning.

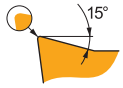
XPHT 16

PRAMET

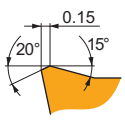
	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.525	4.40	15.88	4.76



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				
XPHT 160412E:8215	❁	1.2	■ 225	0.10	15.0	◪ 135	0.09	15.0	◪ 210	0.10	15.0	–	–	–	–	–	–	–	–	–
XPHT 160412E:M6330	❁	1.2	■ 190	0.10	15.0	■ 135	0.09	15.0	–	–	–	–	–	–	–	–	–	–	–	–
XPHT 160412E:M8330	❁	1.2	■ 220	0.10	15.0	■ 130	0.09	15.0	◪ 205	0.10	15.0	–	–	–	–	–	–	–	–	–
XPHT 160412E:M8340	❁	1.2	■ 195	0.10	15.0	■ 115	0.09	15.0	◪ 185	0.10	15.0	–	–	–	–	–	–	–	–	–

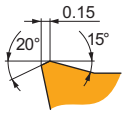
E geometri med meget positivt design til affasningsbearbejdning.



S geometri med meget positivt design til affasning.

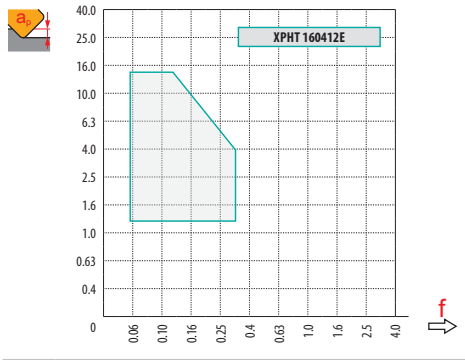
XPHT 160412S:8215	❁	1.2	■ 210	0.12	15.0	◪ 125	0.11	15.0	◪ 195	0.12	15.0	–	–	–	–	–	–	–	–	–
XPHT 160412S:M8330	❁	1.2	■ 210	0.12	15.0	■ 125	0.11	15.0	◪ 195	0.12	15.0	–	–	–	–	–	–	–	–	–
XPHT 160412S:M8340	✱	1.2	■ 190	0.12	15.0	■ 110	0.11	15.0	◪ 180	0.12	15.0	–	–	–	–	–	–	–	–	–

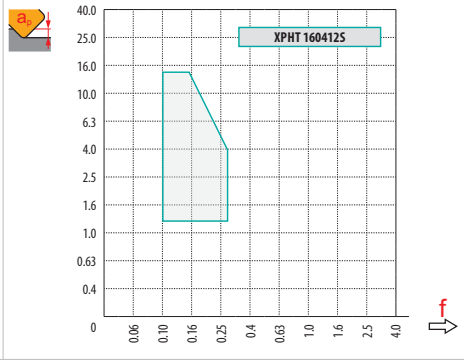
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

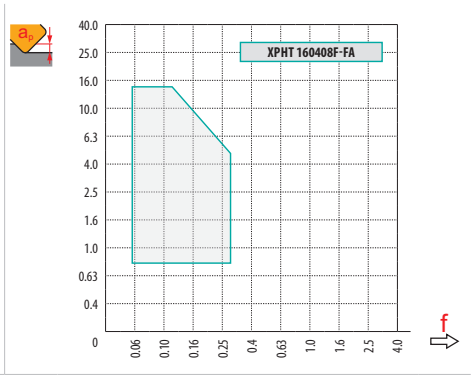
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
XPHT 160412S:M9325	1.2	270	0.12	15.0	–	–	–	255	0.12	15.0	–	–	–	–	–	–	–	–	–
XPHT 160412S:M9340	1.2	245	0.12	15.0	145	0.11	15.0	–	–	–	–	–	–	–	–	–	–	–	–

S geometri med meget positivt design til affasning.

	XPHT 16 E	XPHT 16 S	XPHT 16-FA
RE	1.2	1.2	0.8
BS	–	–	–







a_e / DC	0.10			0.15			0.20			0.25			0.30			0.35			0.40			0.50 – 1.00		
	f																							
15°	0.61	0.98	1.34	0.50	0.80	1.10	0.43	0.69	0.95	0.39	0.62	0.85	0.35	0.56	0.78	0.33	0.52	0.72	0.31	0.49	0.67	0.27	0.44	0.60
25°	0.37	0.60	0.82	0.31	0.49	0.67	0.26	0.42	0.58	0.24	0.38	0.52	0.22	0.35	0.48	0.20	0.32	0.44	0.19	0.30	0.41	0.17	0.27	0.37
30°	0.32	0.51	0.70	0.26	0.41	0.57	0.22	0.36	0.49	0.20	0.32	0.44	0.18	0.29	0.40	0.17	0.27	0.37	0.16	0.25	0.35	0.14	0.23	0.31
35°	0.28	0.44	0.61	0.23	0.36	0.50	0.19	0.31	0.43	0.17	0.28	0.38	0.16	0.25	0.35	0.15	0.24	0.32	0.14	0.22	0.30	0.12	0.20	0.27
40°	0.25	0.39	0.54	0.20	0.32	0.44	0.17	0.28	0.38	0.16	0.25	0.34	0.14	0.23	0.31	0.13	0.21	0.29	0.12	0.20	0.27	0.11	0.18	0.24
45°	0.22	0.36	0.49	0.18	0.29	0.40	0.16	0.25	0.35	0.14	0.23	0.31	0.13	0.21	0.28	0.12	0.19	0.26	0.11	0.18	0.25	0.10	0.16	0.22
50°	0.21	0.33	0.45	0.17	0.27	0.37	0.15	0.23	0.32	0.13	0.21	0.29	0.12	0.19	0.26	0.11	0.18	0.24	0.10	0.17	0.23	0.09	0.15	0.20
55°	0.19	0.31	0.42	0.16	0.25	0.35	0.14	0.22	0.30	0.12	0.20	0.27	0.11	0.18	0.25	0.10	0.17	0.23	0.10	0.15	0.21	0.09	0.14	0.19
60°	0.18	0.29	0.40	0.15	0.24	0.33	0.13	0.21	0.28	0.12	0.18	0.25	0.11	0.17	0.23	0.10	0.16	0.21	0.09	0.15	0.20	0.08	0.13	0.18
75°	0.16	0.26	0.36	0.13	0.21	0.29	0.12	0.19	0.25	0.10	0.17	0.23	0.09	0.15	0.21	0.09	0.14	0.19	0.08	0.13	0.18	0.07	0.12	0.16
X.V	1.35			1.27			1.22			1.19			1.16			1.13			1.11			1.00		

	a_p	DC	DCX	X.V	f_{min}	f_{max}
15°	7	35.0	90.6	1.16	0.43	0.70
25°	12	35.0	87.3	1.16	0.20	0.32
30°	14	35.0	85.1	1.17	0.16	0.25
35°	16	35.0	82.4	1.17	0.13	0.20
40°	18	35.0	79.4	1.17	0.11	0.16
45°	20	35.0	76.0	1.18	0.09	0.14
50°	22	35.0	72.4	1.18	0.08	0.12
55°	23	35.0	68.4	1.20	0.08	0.11
60°	25	35.0	64.1	1.20	0.07	0.09
25°	12	45.0	97.3	1.18	0.23	0.34
30°	14	45.0	95.0	1.18	0.18	0.26
35°	16	45.0	92.4	1.19	0.15	0.21
40°	18	45.0	89.5	1.19	0.12	0.17
45°	20	45.0	86.0	1.20	0.11	0.15
50°	22	45.0	82.4	1.21	0.09	0.13

	a_p	DC	DCX	X.V	f_{min}	f_{max}
55°	23	45.0	78.4	1.22	0.09	0.11
60°	25	45.0	74.1	1.23	0.08	0.10
75°	28	45.0	60.1	1.31	0.07	0.08

Cutters with setting angle 15°can be used as HFC. Use feeds from chamfers table.

FRÆSNING AF SPOR

FACE MILLING

	S90SN	S90CN(XN)	F-SCC			
	90°	90°	90°			
	APMX (mm) 4.0 – 14.0	APMX (mm) 14.0 – 30.5	APMX (mm) 11.0 – 18.0			
	DC (mm) 63 – 200	DC (mm) 125 – 315	DC (mm) 25 – 40			
Cylindrical shank	DC = 80 – 200 (mm)	DC = 125 – 315 (mm)				
Weldon	DC = 63 – 160 (mm)	DC = 125 – 200 (mm)				
Modular						
Shell mill						
Page	314	320	325			
ISO	P M K	P M K	P M K			
Insert shape						
Inserts	SNHQ 11 SNHQ 12	CNHQ 1005 XNHQ 1205 XNHQ 1606	CCMX			
No. of cutting edges	4	2	2			
Fræsning med dyb spor	■	■				
Dyb hjørne fræsning	◪	◪				
Planfræsning	◪	◪				
Bagsidefræsning	◪	◪	■			
T sporfræsning			■			
Overfladisk hjørnefræsning			◪			
Fræsning i lav spor			◪			

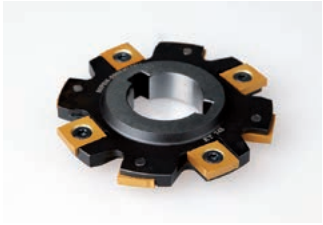
■ Primary use ◪ Possible use

S90SN

P M K

PRAMET

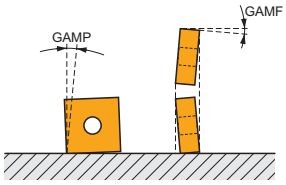
S

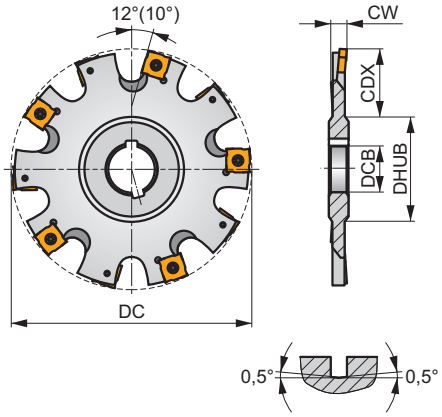


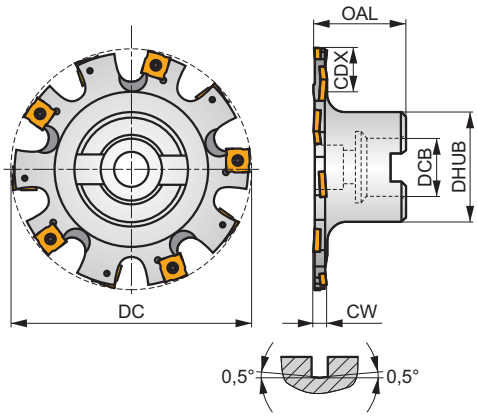
Side- og planfræser til fræsning

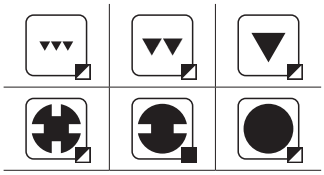
90° disc mill utilising SNHQ inserts. Suitable for slot, shoulder, rear side and face milling. Available in arbor or stub arbor style. Body treated for longer tool life.

KAPR	90°
CW	4.0 – 14.0 mm

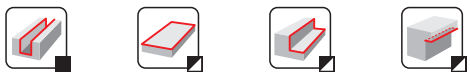








h_m	0.07 – 0.09
h_m	0.07 – 0.09



	Product	DC (mm)	OAL (mm)	DCB (mm)	DHUB (mm)	CDX (mm)	CW (mm)	x 1	GAMF (°)	GAMP (°)			max.		kg			
	80F8N-S90SN11N4	80	–	27	42	16	4.00	–	2.5	-0.5	8	–	12300	–	0.21	GI151	DI011	–
	80F8N-S90SN11N5	80	–	27	42	16	5.00	–	2.5	-0.5	8	–	12300	–	0.22	GI152	DI019	–
	80F8N-S90SN12N6	80	–	27	42	16	6.00	–	2.5	-0.5	8	–	8400	–	0.25	GI153	DI012	–
	80F8N-S90SN12N8	80	–	27	42	16	8.00	–	2.5	-0.5	8	–	8400	–	0.25	GI157	DI013	–
	100G10N-S90SN12N6	100	–	32	48	24	6.00	–	2.5	-0.5	10	–	7500	–	0.43	GI153	DI012	–
	100G10N-S90SN12N8	100	–	32	48	24	8.00	–	2.5	-0.5	10	–	7500	–	0.42	GI157	DI013	–
	100G10N-S90SN12N10	100	–	32	48	24	10.00	–	2.5	-0.5	10	–	7500	–	0.46	GI154	DI014	–
	100G10N-S90SN12N12	100	–	32	48	24	12.00	–	2.5	-0.5	10	–	7500	–	0.66	GI158	DI015	–
	125H12N-S90SN12N6	125	–	40	58	31	6.00	–	2.5	-0.5	12	–	6700	–	0.62	GI153	DI012	–
	125H12N-S90SN12N8	125	–	40	58	31	8.00	–	2.5	-0.5	12	–	6700	–	0.73	GI157	DI013	–
ISO 6462 DIN 8030	**125H12N-S90SN12N10**	125	–	40	58	31	10.00	–	2.5	-0.5	12	–	6700	–	0.66	GI154	DI014	–
	125H12N-S90SN12N12	125	–	40	58	31	12.00	–	2.5	-0.5	12	–	6700	–	0.76	GI158	DI015	–
	160H16N-S90SN12N6	160	–	40	58	43	6.00	–	2.5	-0.5	16	–	5900	–	0.86	GI153	DI012	–
	160H16N-S90SN12N8	160	–	40	58	43	8.00	–	2.5	-0.5	16	–	5900	–	1.10	GI157	DI013	–
	160H16N-S90SN12N10	160	–	40	58	43	10.00	–	2.5	-0.5	16	–	5900	–	1.14	GI154	DI014	–
	160H16N-S90SN12N12	160	–	40	58	43	12.00	–	2.5	-0.5	16	–	5900	–	1.30	GI158	DI015	–
	160H15N-S90SN12N14	160	–	40	58	43	14.00	–	2.5	-0.5	15	–	5900	–	1.40	GI158	DI015	–
	200J18N-S90SN12N6	200	–	50	72	62	6.00	–	2.5	-0.5	18	–	5300	–	1.40	GI153	DI012	–
	200J18N-S90SN12N8	200	–	50	72	62	8.00	–	2.5	-0.5	18	–	5300	–	1.78	GI157	DI013	–
	200J18N-S90SN12N10	200	–	50	72	62	10.00	–	2.5	-0.5	18	–	5300	–	1.89	GI154	DI014	–
	200J18N-S90SN12N12	200	–	50	72	62	12.00	–	2.5	-0.5	18	–	5300	–	2.23	GI158	DI015	–
	200J18N-S90SN12N14	200	–	50	72	62	14.00	–	2.5	-0.5	18	–	5300	–	2.67	GI158	DI015	–
	63A03R-S90SN11N4	63	40	16	34	10.5	4.00	3	2.5	-0.5	6	–	13900	–	0.37	GI151	DI021	–
	63A03R-S90SN11N5	63	40	16	34	10.5	5.00	3	2.5	-0.5	6	–	13900	–	0.36	GI152	DI021	–
ISO 6462 DIN 8030	**63A03R-S90SN12N6**	63	40	16	34	10.5	6.00	3	2.5	-0.5	6	–	9500	–	0.37	GI153	DI022	–
	80A04R-S90SN11N5	80	40	22	40	17.5	5.00	4	2.5	-0.5	8	–	12300	–	0.48	GI152	DI023	–
	80A04R-S90SN12N6	80	40	22	40	17.5	6.00	4	2.5	-0.5	8	–	8400	–	0.50	GI153	DI024	–

	Product	DC (mm)	OAL (mm)	DCB (mm)	DHUB (mm)	CDX (mm)	CW (mm)		GAMF (°)	GAMP (°)			max.		kg			
ISO 6462 DIN 8030	**100A05R-S90SN12N6**	100	50	27	48	23.5	6.00	5	2.5	-0.5	10	–	7500	–	0.86	GI153	DI025	–
	125B06R-S90SN12N6	125	50	40	56	24	6.00	6	2.5	-0.5	12	–	6700	–	1.20	GI153	DI012	AC003
	160B08R-S90SN12N10	160	50	40	70	41	10.00	8	2.5	-0.5	16	–	5900	–	1.83	GI154	DI014	–

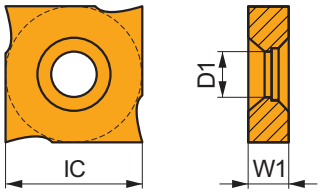
GI151	SNHQ 1102..
GI152	SNHQ 1103..
GI153	SNHQ 1203..
GI154	SNHQ 1205..
GI157	SNHQ 1204..
GI158	SNHQ 1207

		Nm					
DI011	US 3504-T09P	3.0	M 3.5	4	D-T07P/T09P	FG-15	–
DI012	US 70	5.0	M 4	5	D-T07/T15	FG-15	–
DI013	US 71	5.0	M 4	7	D-T07/T15	FG-15	–
DI014	US 72	5.0	M 4	9	D-T07/T15	FG-15	–
DI015	US 73	5.0	M 4	11	D-T07/T15	FG-15	–
DI019	US 3505-T09P	3.0	M 3.5	5	D-T07P/T09P	FG-15	HS 0830
DI021	US 3504-T09P	3.0	M 3.5	4	D-T07P/T09P	FG-15	HS 0830
DI022	US 70	5.0	M 4	5	D-T07/T15	FG-15	HS 0830
DI023	US 3505-T09P	3.0	M 3.5	5	D-T07P/T09P	FG-15	HS 1030
DI024	US 70	5.0	M 4	5	D-T07/T15	FG-15	HS 1030
DI025	US 70	5.0	M 4	5	D-T07/T15	FG-15	HS 1230

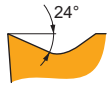
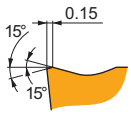
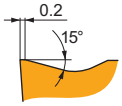
AC003	KS 2040	K.FMH40

SNHQ AZ

	IC (mm)	D1 (mm)	W1 (mm)
1102	11.000	4.30	2.300
1103	11.000	4.30	2.700
1203	12.700	5.00	3.200
1204	12.700	5.00	4.500
1205	12.700	5.00	5.400
1207	12.700	5.00	7.000
12T3	12.700	5.00	3.400

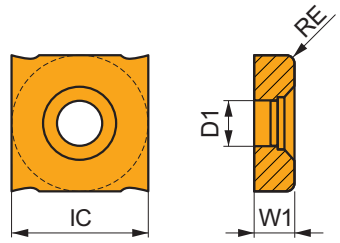


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

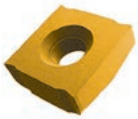
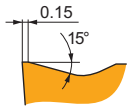
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
EN geometri med specielt design til fræsning af not.																			
SNHQ 1203AZEN:8215	–	415	0.10	–	245	0.10	–	390	0.10	–	–	–	–	–	–	–	–	–	–
SNHQ 1203AZEN:M8340	–	370	0.10	–	220	0.10	–	350	0.10	–	–	–	–	–	–	–	–	–	–
SNHQ 1204AZEN:8215	–	405	0.10	–	240	0.10	–	380	0.10	–	–	–	–	–	–	–	–	–	–
SNHQ 1204AZEN:M8340	–	355	0.10	–	210	0.10	–	335	0.10	–	–	–	–	–	–	–	–	–	–
SNHQ 1205AZEN:8215	–	390	0.10	–	230	0.10	–	370	0.10	–	–	–	–	–	–	–	–	–	–
SNHQ 1205AZEN:M8340	–	345	0.10	–	205	0.10	–	325	0.10	–	–	–	–	–	–	–	–	–	–
SNHQ 1207AZEN:8215	–	380	0.10	–	225	0.10	–	360	0.10	–	–	–	–	–	–	–	–	–	–
SNHQ 1207AZEN:M8340	–	335	0.10	–	200	0.10	–	315	0.10	–	–	–	–	–	–	–	–	–	–
																			
TN geometri med specielt design til sporfræsning.																			
SNHQ 1102AZTN:M8330	–	365	0.20	–	215	0.18	–	345	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 1102AZTN:M8340	–	335	0.20	–	200	0.18	–	315	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 1103AZTN:M8330	–	345	0.20	–	205	0.18	–	325	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 1103AZTN:M8340	–	315	0.20	–	185	0.18	–	295	0.20	–	–	–	–	–	–	–	–	–	–
																			
TN geometri med specielt design til sporfræsning.																			
SNHQ 1203AZTN:M8330	–	345	0.20	–	205	0.18	–	325	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 1203AZTN:M8340	–	315	0.20	–	185	0.18	–	295	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 1204AZTN:M8330	–	335	0.20	–	200	0.20	–	315	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 1204AZTN:M8340	–	300	0.20	–	180	0.20	–	285	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 1205AZTN:M8330	–	330	0.20	–	195	0.20	–	310	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 1205AZTN:M8340	–	295	0.20	–	175	0.20	–	280	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 1207AZTN:M8330	–	320	0.20	–	190	0.20	–	300	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 1207AZTN:M8340	–	290	0.20	–	170	0.20	–	275	0.20	–	–	–	–	–	–	–	–	–	–
SNHQ 12T3AZTN:M8340	–	300	0.20	–	180	0.18	–	285	0.20	–	–	–	–	–	–	–	–	–	–

SNHQ TRL

	IC	D1	L	W1
	(mm)	(mm)	(mm)	(mm)
1203	12.700	5.00	12.70	3.200
1204	12.700	5.00	12.70	4.500
1205	12.700	5.00	12.70	5.400
1207	12.700	5.00	12.70	7.000



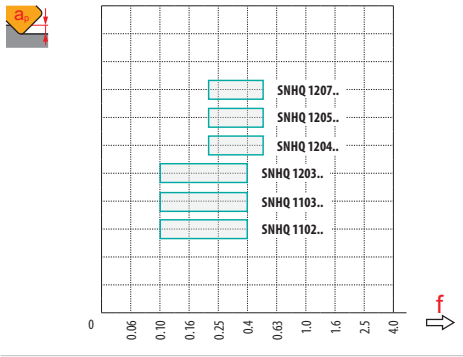
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

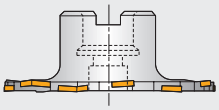
Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																			
SNHQ 120305TRL:M8340	0.5	■	230	0.20	–	◪	135	0.18	–	◪	215	0.20	–	–	–	–	–	–	–	–	–	–	–
SNHQ 120310TRL:M8340	1.0	■	285	0.20	–	◪	170	0.18	–	◪	270	0.20	–	–	–	–	–	–	–	–	–	–	–
SNHQ 120315TRL:M8340	1.5	■	300	0.20	–	◪	180	0.18	–	◪	285	0.20	–	–	–	–	–	–	–	–	–	–	–
SNHQ 120405TRL:M8340	0.5	■	220	0.20	–	◪	130	0.20	–	◪	205	0.20	–	–	–	–	–	–	–	–	–	–	–
SNHQ 120415TRL:M8340	1.5	■	290	0.20	–	◪	170	0.20	–	◪	275	0.20	–	–	–	–	–	–	–	–	–	–	–
SNHQ 120505TRL:M8340	0.5	■	215	0.20	–	◪	125	0.20	–	◪	200	0.20	–	–	–	–	–	–	–	–	–	–	–
SNHQ 120515TRL:M8340	1.5	■	280	0.20	–	◪	165	0.20	–	◪	265	0.20	–	–	–	–	–	–	–	–	–	–	–
SNHQ 120705TRL:M8340	0.5	■	210	0.20	–	◪	125	0.20	–	◪	195	0.20	–	–	–	–	–	–	–	–	–	–	–
SNHQ 120710TRL:M8340	1.0	■	265	0.20	–	◪	155	0.20	–	◪	250	0.20	–	–	–	–	–	–	–	–	–	–	–

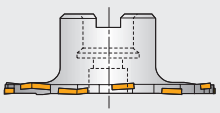
TRL geometri med specielt design til fræsning af spor.

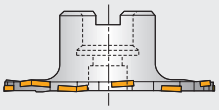
a_e / DC	0.05	0.10	0.15	0.20	0.25	0.30	0.40	0.50	0.60	0.70	0.75	0.80	0.90	1.00
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00

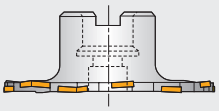
	SNHQ AZEN	SNHQ AZTN	SNHQ 12TRL
RE	–	–	0.5 – 1.5
BS	–	–	–



	DC		CDX	$a_{e\,max}$
	80	4	16	16
	100	5	24	24
	125	6	31	31
	160	5	43	43
	200	9	62	62
	63	3	10.5	63
	80	4	17.5	80
	100	5	23.5	100
	125	6	24	125
	160	8	41	160

	a_e	5		10		15		20		25	
	DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
	80	0.28	0.36	0.20	0.26	0.17	0.21	–	–	–	–
	100	0.32	0.41	0.23	0.29	0.19	0.24	0.16	0.21	–	–
	125	0.35	0.45	0.25	0.32	0.21	0.27	0.18	0.23	0.16	0.21
	160	0.40	0.51	0.28	0.36	0.23	0.30	0.20	0.26	0.18	0.23
	200	0.44	0.57	0.32	0.41	0.26	0.33	0.23	0.29	0.20	0.26
	63	0.25	0.32	0.18	0.23	0.15	0.19	0.13	0.17	0.12	0.15
	80	0.28	0.36	0.20	0.26	0.17	0.21	0.15	0.19	0.13	0.17
	100	0.32	0.41	0.23	0.29	0.19	0.24	0.16	0.21	0.15	0.19
	125	0.35	0.45	0.25	0.32	0.21	0.27	0.18	0.23	0.16	0.21
	160	0.40	0.51	0.28	0.36	0.23	0.30	0.20	0.26	0.18	0.23

	a_e	32		40		50		63		80	
	DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
	80	–	–	–	–	–	–	–	–	–	–
	100	–	–	–	–	–	–	–	–	–	–
	125	–	–	–	–	–	–	–	–	–	–
	160	0.16	0.21	0.15	0.19	–	–	–	–	–	–
	200	0.18	0.23	0.16	0.21	0.15	0.19	–	–	–	–
	63	0.11	0.14	0.10	0.13	0.10	0.12	0.10	0.11	–	–
	80	0.12	0.15	0.11	0.14	0.10	0.13	0.10	0.12	0.10	0.11
	100	0.13	0.17	0.12	0.15	0.11	0.14	0.10	0.13	0.10	0.12
	125	0.15	0.19	0.13	0.17	0.12	0.15	0.11	0.14	0.10	0.13
	160	0.16	0.21	0.15	0.19	0.13	0.17	0.12	0.16	0.11	0.14

	a_e	100		125		160	
	DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
	80	–	–	–	–	–	–
	100	–	–	–	–	–	–
	125	–	–	–	–	–	–
	160	–	–	–	–	–	–
	200	–	–	–	–	–	–
	63	–	–	–	–	–	–
	80	–	–	–	–	–	–
	100	0.10	0.11	–	–	–	–
	125	0.10	0.12	0.10	0.11	–	–
	160	0.10	0.13	0.10	0.12	0.10	0.11

S90CN(XN)

P M K

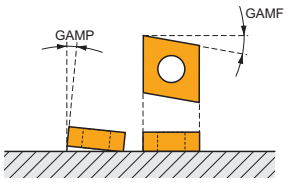
PRAMET

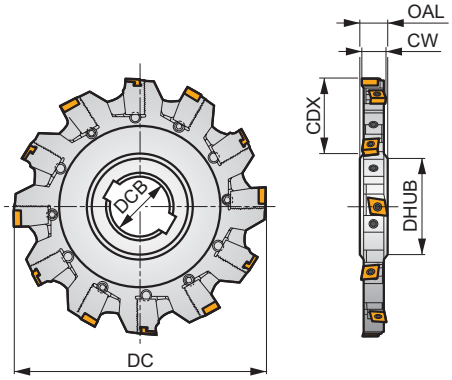
S

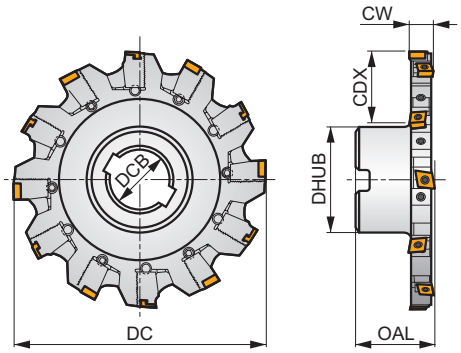
Side- og planfræser med justerbar bredde

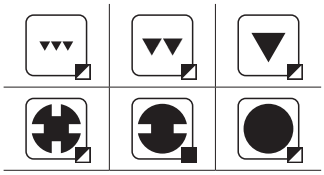
90° disc mill utilising CNHQ and XNHQ inserts. Suitable for slot, shoulder, rear side and face milling. Available in arbor or stub arbor style. Body treated for longer tool life.

KAPR	90°
CW	14.0 – 30.5 mm

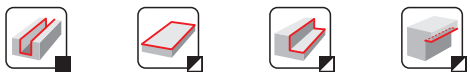








h_m	0.07 – 0.09
h_m	0.07 – 0.09



	Product	DC (mm)	OAL (mm)	DCB (mm)	DHUB (mm)	CDX (mm)	CW (mm)	GAMF (°)	GAMP (°)	x/1			max.		kg			
	125H04N-S90CN10N18	125	18	40	56	34	14.0 – 18.5	-10	4	4	8	–	7800	–	1.19	GI195	DI051	–
	160H06N-S90CN10N18	160	18	40	56	50	14.0 – 18.5	-8	4	6	12	–	6900	–	1.80	GI195	DI052	–
	160H05N-S90XN12N24	160	24	40	56	50	19.0 – 24.3	-8	5	5	10	–	5200	–	2.50	GI196	DI056	–
	200J07N-S90CN10N18	200	18	50	71	60	14.0 – 18.5	-8	4	7	14	–	6100	–	2.85	GI195	DI053	–
	200J06N-S90XN12N24	200	24	50	71	60	19.0 – 24.3	-8	5	6	12	–	4700	–	3.60	GI196	DI057	–
ISO 6462 DIN 8030	**200J06N-S90XN16N30**	200	30	50	71	60	24.5 – 30.5	-9	5	6	12	–	4000	–	6.00	GI197	DI060	–
	250J09N-S90CN10N18	250	18	50	71	85	14.0 – 18.5	-8	4	9	18	–	5500	–	5.30	GI195	DI054	–
	250J08N-S90XN12N24	250	24	50	71	85	19.0 – 24.3	-8	5	8	16	–	4200	–	7.50	GI196	DI058	–
	250J08N-S90XN16N30	250	30	50	71	85	24.5 – 30.5	-8	5	8	16	–	3600	–	8.00	GI197	DI061	–
	315J12N-S90CN10N18	315	18	50	71	110	14.0 – 18.5	-8	4	12	24	–	4900	–	7.80	GI195	DI055	–
	315J10N-S90XN12N24	315	24	50	71	110	19.0 – 24.3	-8	5	10	20	–	3700	–	10.70	GI196	DI059	–
	315K10N-S90XN16N30	315	30	60	85	110	24.5 – 30.5	-8	5	10	20	–	3200	–	13.00	GI197	DI062	–
	125B04R-S90CN10N18	125	50	40	70	25	14.0 – 18.5	-10	4	4	8	–	7800	–	1.65	GI195	DI071	AC003
ISO 6462 DIN 8030	**160B06R-S90CN10N18**	160	50	40	70	44	14.0 – 18.5	-8	5	6	12	–	6900	–	2.55	GI195	DI072	–
	160B05R-S90XN12N24	160	50	40	70	44	19.0 – 24.3	-8	5	5	10	–	5200	–	2.50	GI196	DI074	–
	200C06R-S90XN12N24	200	50	40	90	52	19.0 – 24.3	-8	5	6	12	–	6100	–	4.70	GI196	DI075	–
ISO 6462 DIN 8030	**200C07R-S90CN10N18**	200	50	40	90	52	14.0 – 18.5	-8	4	7	14	–	6100	–	4.05	GI195	DI073	–

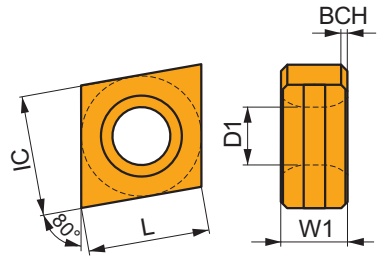
GI195	CNHQ 1005..
GI196	XNHQ 1205..
GI197	XNHQ 1606..

DI051	125H04N-S-14-08	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	–
DI052	160H06N-S-14-12	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	–
DI053	200J07N-S-14-14	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	–
DI054	250J09N-S-14-18	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	–
DI055	315J12N-S-14-24	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	–
DI056	160H05N-S-19-10	KL-1924-XN12	KR-1924-XN12	KS 617M	DS 6500	–	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXK 4
DI057	200J06N-S-19-12	KL-1924-XN12	KR-1924-XN12	KS 617M	DS 6500	–	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXK 4
DI058	250J08N-S-19-16	KL-1924-XN12	KR-1924-XN12	KS 617M	DS 6500	–	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXK 4
DI059	315J10N-S-19-20	KL-1924-XN12	KR-1924-XN12	KS 617M	DS 6500	–	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXK 4
DI060	200J06N-S-25-12	KL-2530-XN16	KR-2530-XN16	KS 623M	DS 6500	–	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXK 4
DI061	250J08N-S-25-16	KL-2530-XN16	KR-2530-XN16	KS 623M	DS 6500	–	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXK 4
DI062	315K10N-S-25-20	KL-2530-XN16	KR-2530-XN16	KS 623M	DS 6500	–	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXK 4
DI071	125B04R-S-14-08	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	–
DI072	160B06R-S-14-12	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	–
DI073	200C07R-S-14-14	KL-1418-CN10	KR-1418-CN10	KS 613F	DS 6018F	SDR T20	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	–
DI074	160B05R-S-19-10	KL-1924-XN12	KR-1924-XN12	KS 617M	DS 6500	–	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXK 4
DI075	200C06R-S-19-12	KL-1924-XN12	KR-1924-XN12	KS 617M	DS 6500	–	SS 6005-T09P	SDR T09	US 4011-T15P	3.5	M 4	10.6	SDR T15P	HXK 4

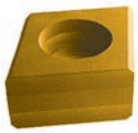
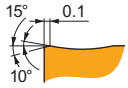
AC003	KS 2040	K.FMH40

CNHQ

	BCH (mm)	IC (mm)	D1 (mm)	L (mm)	W1 (mm)
1005	0.50	10.000	4.70	10.00	5.400



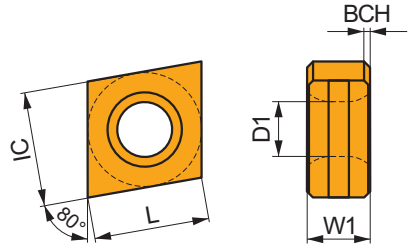
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
																			
CNHQ 1005AZTN:M8330	–	310	0.15	–	185	0.14	–	290	0.15	–	–	–	–	–	–	–	–	–	–
CNHQ 1005AZTN:M8340	–	280	0.15	–	165	0.14	–	265	0.15	–	–	–	–	–	–	–	–	–	–

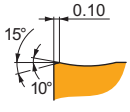
TN specielt design til sporfræsning med lette til tunge skæreforhold.

XNHQ

	BCH (mm)	IC (mm)	D1 (mm)	L (mm)	W1 (mm)
1205	0.50	10.000	4.70	12.70	5.400
1606	0.50	12.000	5.90	16.00	6.400



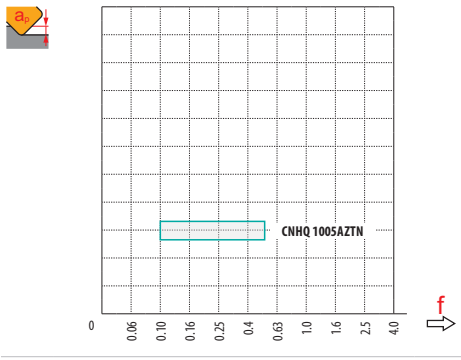
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
XNHQ 1205AZTN:M8330	–	310	0.15	–	185	0.14	–	290	0.15	–	–	–	–	–	–	–	–	–	–
XNHQ 1205AZTN:M8340	–	275	0.15	–	165	0.14	–	260	0.15	–	–	–	–	–	–	–	–	–	–
XNHQ 1606AZTN:M8330	–	300	0.15	–	180	0.14	–	285	0.15	–	–	–	–	–	–	–	–	–	–
XNHQ 1606AZTN:M8340	–	270	0.15	–	160	0.14	–	255	0.15	–	–	–	–	–	–	–	–	–	–

TN specielt design til fræsning af spor.

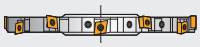
a_e / DC	0.05	0.10	0.15	0.20	0.25	0.30	0.40	0.50	0.60	0.70	0.75	0.80	0.90	1.00
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00

	XNHQ 10
RE	–
BS	–



	DC		CDX	$a_{e\,max}$
	125	4	34	34
	160	6	50	50
	200	7	60	60
	250	9	85	85
	315	12	110	110
	125	4	25	125
	160	6	44	160
	200	7	52	200

	a_e	5		10		15		20		25	
	DC	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨	f_{min} ⇨	f_{max} ⇨
	125	0.35	0.45	0.25	0.32	0.21	0.27	0.18	0.23	0.16	0.21
	160	0.40	0.51	0.28	0.36	0.23	0.30	0.20	0.26	0.18	0.23
	200	0.44	0.57	0.32	0.41	0.26	0.33	0.23	0.29	0.20	0.26
	250	0.50	0.64	0.35	0.45	0.29	0.37	0.25	0.32	0.23	0.29
	315	0.56	0.72	0.39	0.51	0.32	0.42	0.28	0.36	0.25	0.32
	125	0.35	0.45	0.25	0.32	0.21	0.27	0.18	0.23	0.16	0.21
	160	0.40	0.51	0.28	0.36	0.23	0.30	0.20	0.26	0.18	0.23
	200	0.44	0.57	0.32	0.41	0.26	0.33	0.23	0.29	0.20	0.26

	a_e	32		40		50		63		80	
	DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
	**125**	0.15	0.19	–	–	–	–	–	–	–	–
	160	0.16	0.21	0.15	0.19	–	–	–	–	–	–
	200	0.18	0.23	0.16	0.21	0.15	0.19	–	–	–	–
	250	0.20	0.26	0.18	0.23	0.16	0.21	0.15	0.19	0.13	0.17
	315	0.22	0.29	0.20	0.26	0.18	0.23	0.16	0.21	0.15	0.19
	125	0.15	0.19	0.13	0.17	0.12	0.15	0.11	0.14	0.10	0.13
	160	0.16	0.21	0.15	0.19	0.13	0.17	0.12	0.16	0.11	0.14
	200	0.18	0.23	0.16	0.21	0.15	0.19	0.13	0.17	0.12	0.15

	a_e	100		125		160		200	
	DC	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}	f_{min}	f_{max}
	125	–	–	–	–	–	–	–	–
	160	–	–	–	–	–	–	–	–
	200	–	–	–	–	–	–	–	–
	250	–	–	–	–	–	–	–	–
	315	0.13	0.17	–	–	–	–	–	–
	125	0.10	0.12	0.10	0.11	–	–	–	–
	160	0.10	0.13	0.10	0.12	0.10	0.11	–	–
	200	0.11	0.14	0.10	0.13	0.10	0.12	0.10	0.11

F-SCC

P M K

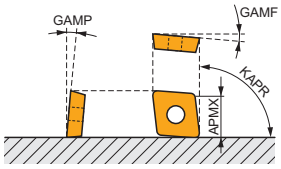
PRAMET

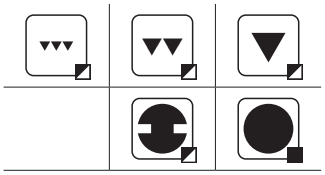
S

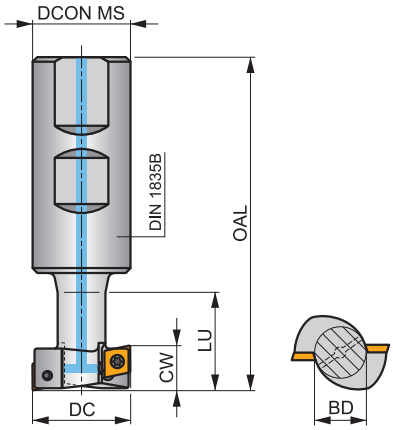
T-spor fræser til CCMX-skær med intern kølevæske

T-spor fræser med enkeltsidet CCMX skær. Intern kølevæske. Velegnet til T-spor, bagside, lav hjørne og overfladefræsning. Fås kun i weldon i udvendige Ø25, Ø32 og Ø40 mm. Krop behandlet for længere levetid på værktøjet.

KAPR	90°
APMX	11.0 – 18.0 mm







h_m 0.05 – 0.08

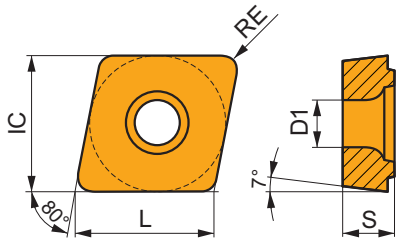
	Product	DC (mm)	BD (mm)	OAL (mm)	DCON MS (mm)	LU (mm)	CW (mm)	z			max.		kg		
DIN 1835B	**25F1R030B25-SCC06-C**	25	12	86	25	25	11.00	1	2	–	28100	✓	0.26	GI148	SQ213
	32F1R038B32-SCC08-C	32	16	98	32	33	14.00	1	2	–	19100	✓	0.50	GI149	SQ212
	40F2R046B32-SCC09-C	40	20	105	32	41	18.00	2	4	–	14900	✓	0.56	GI150	SQ212

GI148	CCMX 060304
GI149	CCMX 08T308
GI150	CCMX 09T308

		Nm			
SQ212	US 3007-T09P	2.0	M 3	7.3	Flag T09P
SQ213	US 2506-T07P	1.2	M 2.5	6.3	Flag T07P

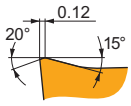
CCMX

	IC	D1	L	S
	(mm)	(mm)	(mm)	(mm)
0603	6.350	2.80	6.40	3.50
08T3	8.030	3.50	8.10	4.40
09T3	9.525	3.50	9.70	3.97



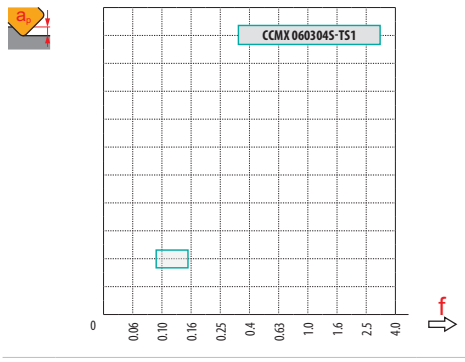
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

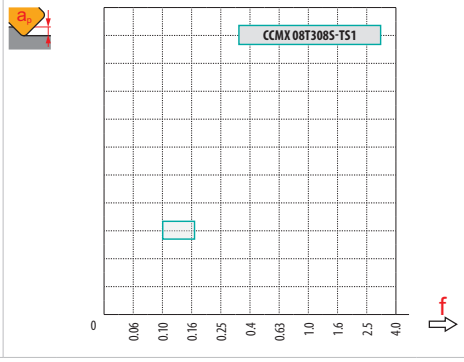
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
CCMX 060304S-TS1:M8330	●	0.4	240	0.10	–	140	0.09	–	225	0.10	–	–	–	–	–	–	–	–	–	–
CCMX 060304S-TS1:M8340	⬌	0.4	215	0.10	–	125	0.09	–	200	0.10	–	–	–	–	–	–	–	–	–	–
CCMX 08T308S-TS1:M8330	⬌	0.8	275	0.10	–	165	0.10	–	260	0.10	–	–	–	–	–	–	–	–	–	–
CCMX 09T308S-TS1:M8330	⬌	0.8	270	0.10	–	160	0.10	–	255	0.10	–	–	–	–	–	–	–	–	–	–
CCMX 09T308S-TS1:M8340	⬌	0.8	240	0.10	–	140	0.10	–	225	0.10	–	–	–	–	–	–	–	–	–	–

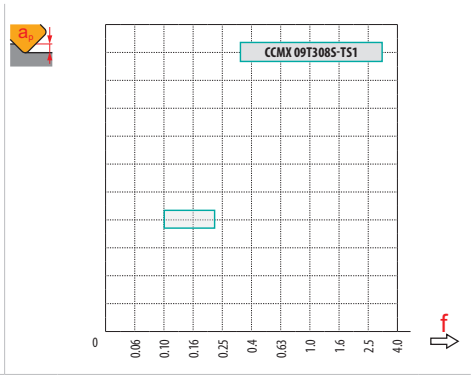


TS1 specielt design til T-Spor fræsning for + I250r lette til mellemstore skæreforhold.

	CCMX 06-TS1	CCMX 08-TS1	CCMX 09-TS1
RE	0.4	0.8	0.8
BS	–	–	–







a_e / DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	1.48	1.35	1.27	1.22	1.19	1.16	1.11	1.08	1.05	1.03	1.00	1.00	1.00	1.00

DC	a_e = 1		a_e = 2		a_e = 3		a_e = 4		a_e = 5		a_e = 8		a_e = 10	
	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹
25	0.25	0.40	0.18	0.29	0.15	0.24	0.13	0.21	0.12	0.19	0.09	0.15	0.09	0.14
32	0.28	0.45	0.20	0.32	0.17	0.27	0.14	0.23	0.13	0.21	0.10	0.17	0.09	0.15
40	0.32	0.51	0.23	0.36	0.18	0.30	0.16	0.26	0.14	0.23	0.12	0.19	0.10	0.17

DC	a_e = 12		a_e = 16		a_e = 20		a_e = 25		a_e = 32		a_e = 40	
	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹	f_{min} ⇨	f_{max} ⟹
25	0.08	0.13	0.07	0.12	0.07	0.11	0.08	0.13	–	–	–	–
32	0.09	0.14	0.08	0.13	0.07	0.12	0.07	0.11	0.08	0.13	–	–
40	0.10	0.15	0.09	0.14	0.08	0.13	0.07	0.12	0.07	0.11	0.08	0.13

Valid for T-slot milling

Valid for shoulder and inverse face milling

Valid for shoulder milling

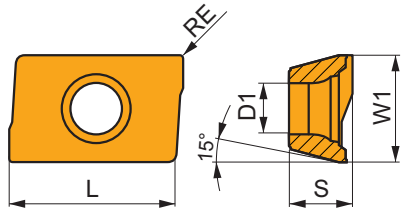
DC		$a_{p\,max}$	$a_{e\,max}$
25	1	11	6.4
32	1	14	8.0
40	2	18	9.7

ANDRE FRÆSEINDSATSER

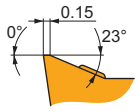
ADKT 15

PRAMET

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1505	9.525	4.40	15.55	5.60



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

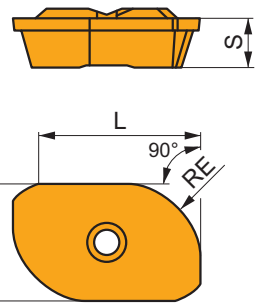
Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																			
ADKT 1505PDER-M:M8330	0.8	235	0.20	5.0	140	0.18	5.0	220	0.20	5.0	–	–	–	55	0.16	4.0	–	–	–
ADKT 1505PDER-M:M8340	0.8	210	0.20	5.0	125	0.18	5.0	195	0.20	5.0	–	–	–	50	0.16	4.0	–	–	–
ADKT 1505PDER-M:M9325	0.8	290	0.20	5.0	–	–	–	275	0.20	5.0	–	–	–	–	–	–	–	–	–

M geometri med meget positivt design til medium bearbejdning.

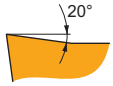
ADKX 15

PRAMET

	W1	L	S
	(mm)	(mm)	(mm)
15T3	9.525	12.20	3.97



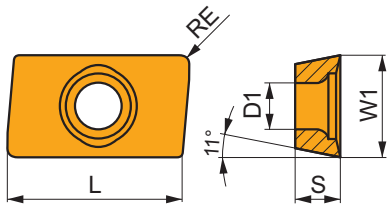
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																			
ADKX 15T308ER-F:M8345	0.8	170	0.10	10.0	100	0.09	10.0	–	–	–	–	–	–	40	0.07	8.0	–	–	–

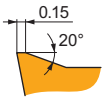
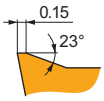
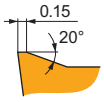
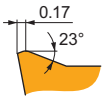
F geometri med meget skarpt positivt design til let til medium bearbejdning.

APMT 16

	W1	D1	L	S
	(mm)	(mm)	(mm)	(mm)
1604	9.600	4.50	17.00	4.76



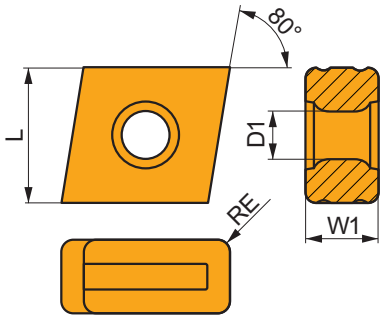
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
		**F** geometri med positivt design til let bearbejdning.																	
APMT 1604PDER-F:M8330	–	■ 320	0.10	2.0	■ 190	0.09	2.0	◪ 300	0.10	2.0	–	–	–	◪ 80	0.07	1.6	–	–	–
		**FM** geometri med positivt design til let til medium bearbejdning.																	
APMT 1604PDER-FM:M8330	–	■ 285	0.16	2.0	■ 170	0.14	2.0	◪ 270	0.16	2.0	–	–	–	◪ 70	0.13	1.6	–	–	–
APMT 1604PDER-FM:M8345	–	■ 205	0.16	2.0	■ 120	0.14	2.0	–	–	–	–	–	–	◪ 50	0.13	1.6	–	–	–
		**ER-R** geometri med positivt design til hård bearbejdning.																	
APMT 1604PDER-R:M8330	–	■ 255	0.16	5.0	–	–	–	■ 240	0.16	5.0	–	–	–	–	–	–	–	–	–
		**SR-R** geometri med positivt design til hård bearbejdning.																	
APMT 1604PDSR-R:M8330	–	■ 255	0.18	5.0	–	–	–	■ 240	0.18	5.0	–	–	–	–	–	–	–	–	–

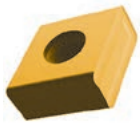
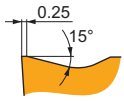
CNM

PRAMET

	D1	L	S
	(mm)	(mm)	(mm)
63	5.50	15.00	8.00



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

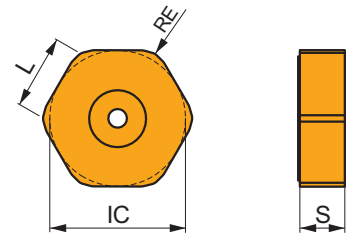
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				
CNM 563:M8330	●	1.2	185	0.30	10.0	–	–	–	175	0.30	10.0	–	–	–	–	–	–	–	–	–
CNM 563:M8340	✱	1.2	220	0.30	10.0	–	–	–	205	0.30	10.0	–	–	–	–	–	–	–	–	–

563 universel geometri.

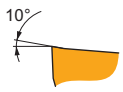
HNEF 09

PRAMET

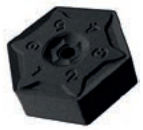
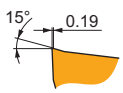
	IC	L	S
	(mm)	(mm)	(mm)
0905	16.200	9.40	5.64



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				
HNMF 090516SN-R:8215	●	1.6	–	–	–	–	–	–	380	0.15	1.5	–	–	–	–	–	–	–	–	–
HNMF 090516SN-R:M5315	✱	1.6	–	–	–	–	–	–	265	0.30	3.0	–	–	–	–	–	–	–	–	–

R geometri med negativt design til let og tung bearbejdning.

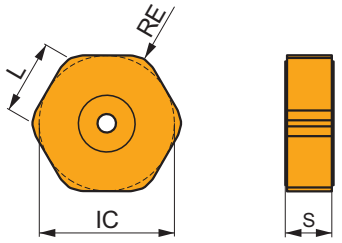
																				
HNEF 090508EN-M:M5315	✱	0.8	–	–	–	–	–	–	290	0.18	3.0	–	–	–	–	–	–	–	–	–

M geometri med positivt design til let til medium bearbejdning.

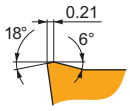
HNMF 09

PRAMET

	IC (mm)	L (mm)	S (mm)
0905	16.200	9.40	5.64



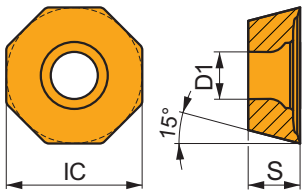
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
R geometri med negativt design til let og tung bearbejdning.																			
HNMF 090516SN-R:8215	1.6	–	–	–	–	–	–	210	0.30	3.0	–	–	–	–	–	–	–	–	–
HNMF 090516SN-R:M5315	1.6	–	–	–	–	–	–	265	0.30	3.0	–	–	–	–	–	–	–	–	–

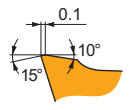
ODMT 05

PRAMET

	IC (mm)	D1 (mm)	S (mm)
0504	12.700	4.40	4.76



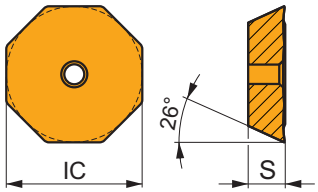
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																			
ZZN lidt positivt design til medium bearbejdning.																			
ODMT 0504ZZN:M8340	–	195	0.25	1.5	–	–	–	185	0.25	1.5	–	–	–	–	–	–	–	–	–

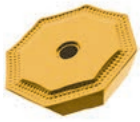
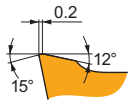
OFKR 07

PRAMET

	IC	D1	S
	(mm)	(mm)	(mm)
0704	17.845	2.65	4.56



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

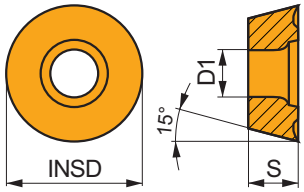
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				
OFKR 0704SN-M:M8330		–	■	235	0.25	1.5	■	140	0.23	1.5	◪	220	0.25	1.5	–	–	–	–	–	–	–	–	–
OFKR 0704SN-M:M8340		–	■	215	0.25	1.5	■	125	0.23	1.5	◪	200	0.25	1.5	–	–	–	–	–	–	–	–	–

M geometri med positivt design til let til medium bearbejdning.

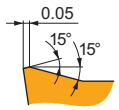
RDET

PRAMET

	INSD	D1	S
	(mm)	(mm)	(mm)
0802	8.000	3.40	2.38
1003	10.000	4.40	3.18
12T3	12.000	4.40	3.97



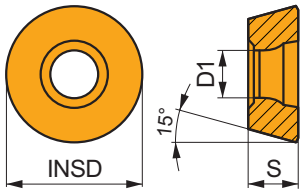
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																				
RDET 0802MOSN:M8340		–	■	335	0.15	0.5	◪	200	0.14	0.5	◪	315	0.15	0.5	–	–	–	◪	80	0.12	0.4	–	–	–
RDET 1003MOSN:M8340		–	■	310	0.15	1.0	◪	185	0.14	1.0	◪	290	0.15	1.0	–	–	–	◪	75	0.12	0.8	–	–	–
RDET 12T3MOSN:M8340		–	■	280	0.20	1.5	◪	165	0.18	1.5	◪	265	0.20	1.5	–	–	–	◪	70	0.14	1.2	–	–	–

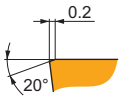
SN pM-geometri med positivt design til alle formål.

RDHX 20

	INSD (mm)	D1 (mm)	S (mm)
2006	20.000	5.20	6.35

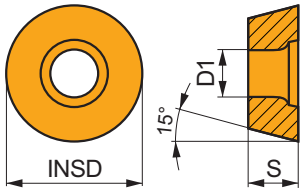


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

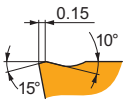
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 **MOT** nul skærvinkeldesign til bearbejdning af finish.																			
RDHX 2006MOT:M8310	–	240	0.35	3.0	–	–	–	225	0.35	3.0	–	–	–	–	–	–	45	0.18	1.3
RDHX 2006MOT:M8325	–	180	0.35	3.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

RPET 12

	INSD (mm)	D1 (mm)	S (mm)
1204	12.000	4.40	4.76

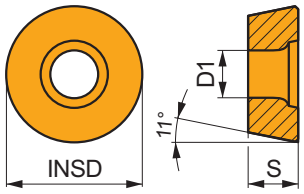


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

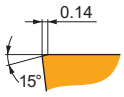
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 **MOSN** pM-geometri med positivt design til alle formål.																			
RPET 1204MOSN:8215	–	325	0.20	1.5	195	0.18	1.5	305	0.20	1.5	–	–	–	80	0.14	1.2	–	–	–
RPET 1204MOSN:M8330	–	320	0.20	1.5	190	0.18	1.5	300	0.20	1.5	–	–	–	80	0.14	1.2	–	–	–
RPET 1204MOSN:M8340	–	295	0.20	1.5	175	0.18	1.5	280	0.20	1.5	–	–	–	70	0.14	1.2	–	–	–

RPEW 12

	INSD	D1	S
	(mm)	(mm)	(mm)
1204	12.000	4.40	4.76



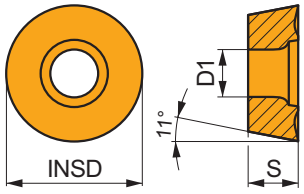
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																			
RPEW 1204M0SN:M8330	–	285	0.20	1.5	–	–	–	270	0.20	1.5	–	–	–	–	–	–	55	0.10	0.8
RPEW 1204M0SN:M8340	–	265	0.20	1.5	–	–	–	250	0.20	1.5	–	–	–	–	–	–	–	–	–

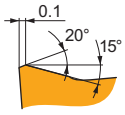
M0SN nul skærvinkeldesign til bearbejdning af finish.

RPEX

	INSD	D1	S
	(mm)	(mm)	(mm)
1204	12.000	4.40	4.76



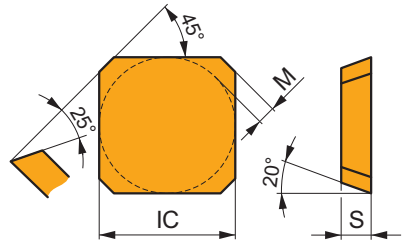
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
																			
RPEX 1204M0SN-12:M8340	–	215	0.30	1.5	125	0.27	1.5	200	0.30	1.5	–	–	–	50	0.21	1.2	–	–	–

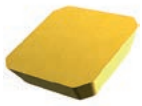
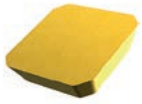
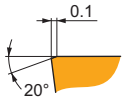
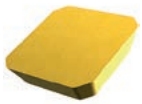
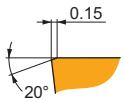
12 pM-geometri med positivt design til alle formål.

SEEN

	IC (mm)	M (mm)	S (mm)
1203	12.700	1.6	3.18
1504	15.875	2.0	4.76



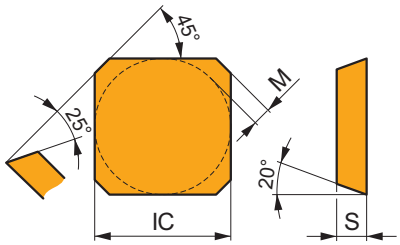
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
		**AFFN** kantforberedelse, nul skærvinkelgeometri til let til medium bearbejdning.																	
SEEN 1203AFFN:M8330	–	270	0.15	2.0	160	0.14	2.0	255	0.15	2.0	–	–	–	–	–	–	–	–	–
SEEN 1203AFFN:M8340	–	245	0.15	2.0	145	0.14	2.0	230	0.15	2.0	–	–	–	–	–	–	–	–	–
 		**AFSN** kantpræparation, nul skærvinkelgeometri til medium til tung bearbejdning.																	
SEEN 1203AFSN:8215	–	255	0.20	2.0	–	–	–	240	0.20	2.0	–	–	–	–	–	–	50	0.13	1.0
SEEN 1203AFSN:M8330	–	255	0.20	2.0	–	–	–	240	0.20	2.0	–	–	–	–	–	–	50	0.13	1.0
SEEN 1203AFSN:M8340	–	230	0.20	2.0	–	–	–	215	0.20	2.0	–	–	–	–	–	–	–	–	–
SEEN 1203AFSN:M9315	–	340	0.20	2.0	–	–	–	320	0.20	2.0	–	–	–	–	–	–	65	0.13	1.0
SEEN 1203AFSN:M9325	–	315	0.20	2.0	–	–	–	295	0.20	2.0	–	–	–	–	–	–	60	0.13	1.0
 		**AFSN** kantpræparation, nul skærvinkelgeometri til medium til tung bearbejdning.																	
SEEN 1504AFSN:M8330	–	240	0.20	3.0	–	–	–	225	0.20	3.0	–	–	–	–	–	–	45	0.13	1.3
SEEN 1504AFSN:M8340	–	225	0.20	3.0	–	–	–	210	0.20	3.0	–	–	–	–	–	–	–	–	–

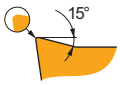
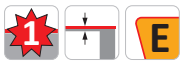
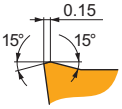
SEER

PRAMET

	IC (mm)	M (mm)	S (mm)
1203	12.700	1.6	3.18
1204	12.700	1.6	4.76
1504	15.875	2.0	4.76



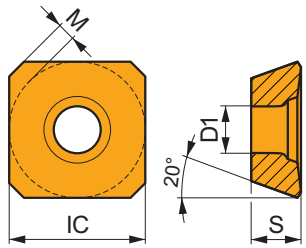
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
  **AFEN** kantforberedelse, spånbryder-geometri til mellem- til tung bearbejdning																			
SEER 1203AFEN:M8330	–	265	0.24	2.5	155	0.22	2.5	250	0.24	2.5	–	–	–	65	0.22	2.0	–	–	–
SEER 1203AFEN:M8340	–	245	0.24	2.5	145	0.22	2.5	230	0.24	2.5	–	–	–	60	0.22	2.0	–	–	–
 **AFSN** kantforberedelse, spånbrydergeometri til mellem- til tung bearbejdning.																			
SEER 1203AFSN:M8330	–	265	0.25	2.5	155	0.23	2.5	250	0.25	2.5	–	–	–	65	0.20	2.0	–	–	–
SEER 1203AFSN:M8340	–	240	0.25	2.5	140	0.23	2.5	225	0.25	2.5	–	–	–	60	0.20	2.0	–	–	–
SEER 1204AFSN:M8330	–	265	0.25	2.5	155	0.23	2.5	250	0.25	2.5	–	–	–	65	0.20	2.0	–	–	–
SEER 1504AFSN:M8330	–	255	0.25	3.5	150	0.23	3.5	240	0.25	3.5	–	–	–	60	0.20	2.8	–	–	–
SEER 1504AFSN:M8340	–	230	0.25	3.5	135	0.23	3.5	215	0.25	3.5	–	–	–	55	0.20	2.8	–	–	–

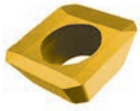
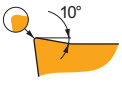
SEET 12

PRAMET

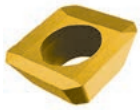
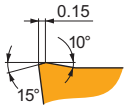
	IC (mm)	D1 (mm)	M (mm)	S (mm)
1204	12.700	5.50	1.6	4.76



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
  **AFEN** kantforberedelse, positiv geometri til alle formål.																			
SEET 1204AFEN:M8330	–	265	0.24	2.5	155	0.22	2.5	250	0.24	2.5	–	–	–	65	0.22	2.0	–	–	–

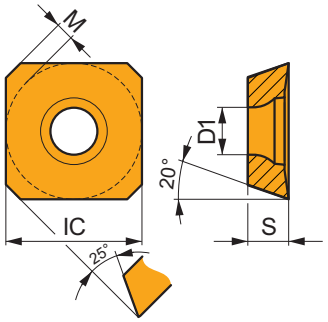
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																			
AFSN kantforberedelse, positiv geometri til alle formål.																			
SEET 1204AFSN:8215	–	265	0.23	2.5	155	0.21	2.5	250	0.23	2.5	–	–	–	65	0.21	2.0	–	–	–
SEET 1204AFSN:M8330	–	265	0.24	2.5	155	0.22	2.5	250	0.24	2.5	–	–	–	65	0.22	2.0	–	–	–
SEET 1204AFSN:M8340	–	240	0.25	2.5	140	0.23	2.5	225	0.25	2.5	–	–	–	60	0.23	2.0	–	–	–
SEET 1204AFSN:M9325	–	340	0.20	2.5	–	–	–	320	0.20	2.5	–	–	–	–	–	–	–	–	–

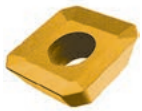
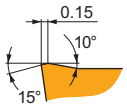
SEET 12-PM

PRAMET

	IC (mm)	D1 (mm)	M (mm)	S (mm)
12T3	13.400	4.20	1.5	3.97



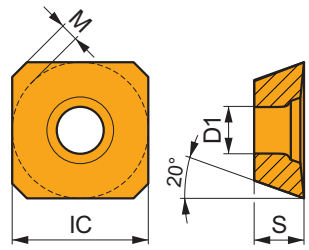
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 																			
PM geometri med positivt design til alle formål.																			
SEET 12T3M-PM:M8330	–	265	0.25	2.0	155	0.23	2.0	250	0.25	2.0	–	–	–	65	0.20	1.6	–	–	–
SEET 12T3M-PM:M8340	–	245	0.25	2.0	145	0.23	2.0	230	0.25	2.0	–	–	–	60	0.20	1.6	–	–	–
SEET 12T3M-PM:M9325	–	325	0.25	2.0	–	–	–	305	0.25	2.0	–	–	–	–	–	–	–	–	–
SEET 12T3M-PM:M9340	–	290	0.25	2.0	170	0.23	2.0	–	–	–	–	–	–	70	0.20	1.6	–	–	–

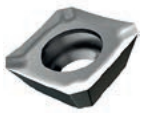
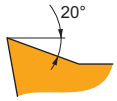
SEET 12-FA

PRAMET

	IC	D1	M	S
	(mm)	(mm)	(mm)	(mm)
1204	12.700	5.50	1.6	4.76



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

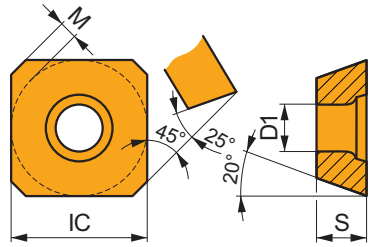
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
			**F**																	
SEET 1204AFFN-FA:HF7	●	–	–	–	–	–	–	–	–	–	–	■	330	0.18	3.0	–	–	–	–	–	–

FA geometri med meget positivt design til finbearbejdning til medium bearbejdning.

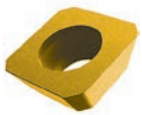
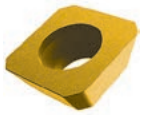
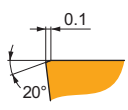
SEEW 12

PRAMET

	IC	D1	M	S
	(mm)	(mm)	(mm)	(mm)
1204	12.700	5.50	1.6	4.76



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
			**E**																	
SEEW 1204AFEN:M8330	●	–	◪	265	0.15	2.5	–	–	–	◪	250	0.15	2.5	–	–	–	–	–	–	–	–	–
SEEW 1204AFEN:M8340	●	–	◪	240	0.15	2.5	–	–	–	◪	225	0.15	2.5	–	–	–	–	–	–	–	–	–
			**S**																	
SEEW 1204AFSN:8215	●	–	◪	250	0.20	2.5	–	–	–	■	235	0.20	2.5	–	–	–	–	◪	50	0.13	1.0
SEEW 1204AFSN:M8330	●	–	◪	245	0.20	2.5	–	–	–	■	230	0.20	2.5	–	–	–	–	◪	45	0.13	1.0
SEEW 1204AFSN:M8340	●	–	◪	225	0.20	2.5	–	–	–	◪	210	0.20	2.5	–	–	–	–	–	–	–	–	–
SEEW 1204AFSN:M9325	●	–	◪	305	0.20	2.5	–	–	–	■	285	0.20	2.5	–	–	–	–	◪	60	0.13	1.0

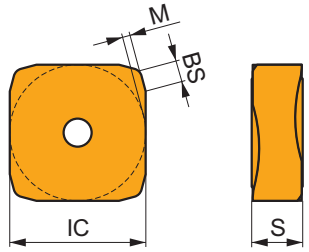
AFEN kantforberedelse med nul skærvinkelgeometri til let til medium bearbejdning.

AFSN kantforberedelse med nul skærvinkelgeometri til let til medium bearbejdning.

SNHF

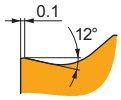
PRAMET

	BS	IC	M	S
	(mm)	(mm)	(mm)	(mm)
1204	2.00	12.700	0.5	4.76
1504	1.40	15.875	1.1	4.76



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
SNHF 1204ENSR-M:M8330	–	235	0.15	4.0	–	–	–	220	0.15	4.0	–	–	–	–	–	–	–	–	–
SNHF 1504ENSR-M:M8340	–	220	0.15	6.0	–	–	–	205	0.15	6.0	–	–	–	–	–	–	–	–	–

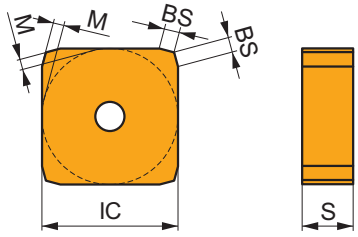


M geometri med positivt design til let til medium bearbejdning.

SNHN

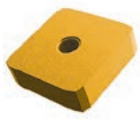
PRAMET

	BS	IC	M	S
	(mm)	(mm)	(mm)	(mm)
1204	1.40	12.700	0.9	4.76
1504	1.40	15.875	1.3	4.76



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
SNHN 1204ENEN:8215	–	275	0.15	6.0	–	–	–	260	0.15	6.0	–	–	–	–	–	–	55	0.11	1.0
SNHN 1204ENEN:M8330	–	270	0.15	6.0	–	–	–	255	0.15	6.0	–	–	–	–	–	–	50	0.11	1.0
SNHN 1204ENEN:M8340	–	245	0.15	6.0	–	–	–	230	0.15	6.0	–	–	–	–	–	–	–	–	–
SNHN 1204ENEN:S26	–	110	0.15	6.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SNHN 1504ENEN:8215	–	260	0.15	9.0	–	–	–	245	0.15	9.0	–	–	–	–	–	–	50	0.11	1.3
SNHN 1504ENEN:M8330	–	260	0.15	9.0	–	–	–	245	0.15	9.0	–	–	–	–	–	–	50	0.11	1.3
SNHN 1504ENEN:M8340	–	235	0.15	9.0	–	–	–	220	0.15	9.0	–	–	–	–	–	–	–	–	–
SNHN 1504ENEN:S26	–	105	0.15	9.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

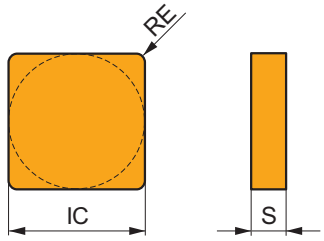


ENEN standard negativ fræsningsgeometri til 75 ° fræsning.

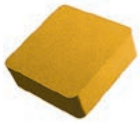
SNUN

PRAMET

	IC (mm)	S (mm)
1204	12.700	4.76
1504	15.875	4.76



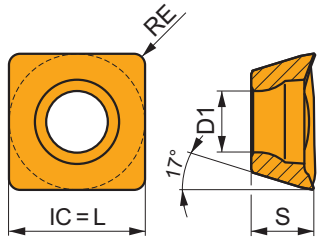
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 E																			
N negativ geometri til fræsning, kan også bruges til drejning.																			
SNUN 120408:M8330	0.8	260	0.13	4.5	–	–	–	245	0.13	4.5	–	–	–	–	–	–	50	0.10	1.0
SNUN 120412:M8330	1.2	275	0.13	4.5	–	–	–	260	0.13	4.5	–	–	–	–	–	–	55	0.10	1.0
SNUN 150412:M8330	1.2	255	0.15	6.0	–	–	–	240	0.15	6.0	–	–	–	–	–	–	50	0.12	1.3

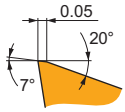
SOMT 05

PRAMET

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0502	5.570	2.50	5.57	2.63



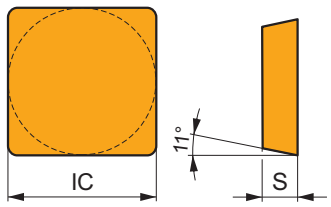
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 U S																			
M geometri med positivt design til let til medium bearbejdning.																			
SOMT 050204SR-M:M6330	0.4	255	0.05	2.5	180	0.05	2.5	–	–	–	–	–	–	75	0.04	2.0	–	–	–
SOMT 050204SR-M:M8330	0.4	290	0.05	2.5	170	0.05	2.5	275	0.05	2.5	–	–	–	70	0.04	2.0	–	–	–
SOMT 050208SR-M:M8330	0.8	350	0.05	2.5	210	0.05	2.5	330	0.05	2.5	–	–	–	85	0.04	2.0	–	–	–

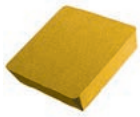
SPGN

PRAMET

	IC (mm)	S (mm)
0903	9.525	3.18
1203	12.700	3.18
1504	15.875	4.76



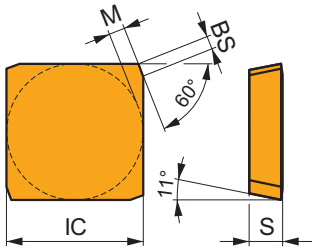
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 E																			
N nul skær vinkel design fræser, kan også bruges til drejning.																			
SPGN 090308:M8340	0.8	225	0.15	2.0	–	–	–	210	0.15	2.0	–	–	–	–	–	–	–	–	–
SPGN 120308:M8330	0.8	230	0.15	4.0	–	–	–	215	0.15	4.0	–	–	–	–	–	–	–	–	–
SPGN 150412:M8330	1.2	225	0.20	5.0	–	–	–	210	0.20	5.0	–	–	–	–	–	–	–	–	–

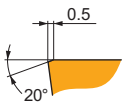
SPGN 25 DZ

PRAMET

	IC (mm)	M (mm)	S (mm)	BS (mm)
2506	25.000	3.5	6.35	2.40

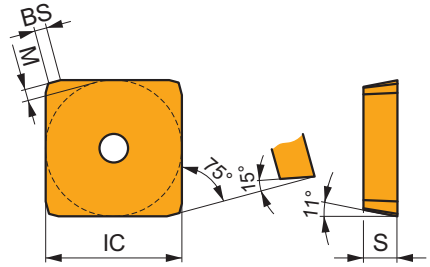


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

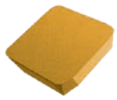
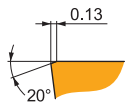
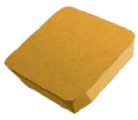
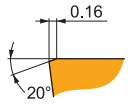
Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
 1 S																			
DZ geometri med nul skærvinkeldesign til kraftig bearbejdning.																			
SPGN 2506DZSR:M8326	–	110	0.50	12.0	–	–	–	100	0.50	12.0	–	–	–	–	–	–	–	–	–
SPGN 2506DZSR:M8346	–	90	0.50	12.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

SPKN

	IC (mm)	M (mm)	S (mm)	BS (mm)
1203	12.700	0.9	3.18	1.60
1504	15.875	1.3	4.76	1.70



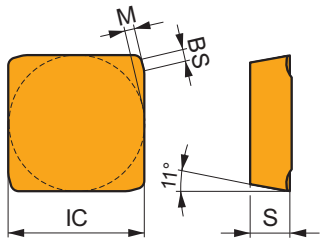
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			EDER kantforberedelse med nul skærvinkelgeometri til let til medium bearbejdning.																	
SPKN 1203EDER:M8330		–	255	0.15	4.0	–	–	–	240	0.15	4.0	–	–	–	–	–	–	–	–	–
SPKN 1203EDER:M8340		–	230	0.15	4.0	–	–	–	215	0.15	4.0	–	–	–	–	–	–	–	–	–
SPKN 1504EDER:M8330		–	235	0.20	5.0	–	–	–	220	0.20	5.0	–	–	–	–	–	–	–	–	–
SPKN 1504EDER:M8340		–	210	0.20	5.0	–	–	–	195	0.20	5.0	–	–	–	–	–	–	–	–	–
			**EDSR** kantforberedelse med nul skærvinkelgeometri til medium bearbejdning.																	
SPKN 1203EDSL:M8330		–	240	0.20	4.0	–	–	–	225	0.20	4.0	–	–	–	–	–	–	45	0.13	1.0
SPKN 1203EDSR:M8330		–	240	0.20	4.0	–	–	–	225	0.20	4.0	–	–	–	–	–	–	45	0.13	1.0
SPKN 1203EDSR:M8340		–	215	0.20	4.0	–	–	–	200	0.20	4.0	–	–	–	–	–	–	–	–	–
SPKN 1203EDSR:M9325		–	290	0.20	4.0	–	–	–	275	0.20	4.0	–	–	–	–	–	–	55	0.13	1.0
SPKN 1203EDSR:S26		–	95	0.20	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
			**EDS.** EDSR (højre hånd skær) / EDSL (venstre skær) kantforberedelse med nul skærvinkelgeometri til medium bearbejdning.																	
SPKN 1504EDSR:8215		–	220	0.25	5.0	–	–	–	205	0.25	5.0	–	–	–	–	–	–	40	0.13	1.3
SPKN 1504EDSR:M8330		–	220	0.25	5.0	–	–	–	205	0.25	5.0	–	–	–	–	–	–	40	0.13	1.3
SPKN 1504EDSR:M8340		–	205	0.25	5.0	–	–	–	190	0.25	5.0	–	–	–	–	–	–	–	–	–
SPKN 1504EDSR:M9315		–	285	0.25	5.0	–	–	–	270	0.25	5.0	–	–	–	–	–	–	55	0.13	1.3
SPKN 1504EDSR:M9325		–	270	0.25	5.0	–	–	–	255	0.25	5.0	–	–	–	–	–	–	50	0.13	1.3
SPKN 1504EDSR:S26		–	90	0.25	5.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

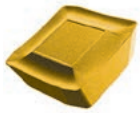
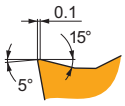
SPKR

PRAMET

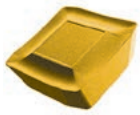
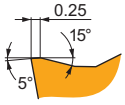
	IC (mm)	L (mm)	M (mm)	S (mm)
1203	12.700	12.70	0.9	3.18
1504	15.875	15.88	1.2	4.76



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
																				
SPKR 1203EDSR:M8330		–	265	0.20	4.0	155	0.18	4.0	250	0.20	4.0	–	–	–	–	–	–	–	–	–
SPKR 1203EDSR:M8340		–	240	0.20	4.0	140	0.18	4.0	225	0.20	4.0	–	–	–	–	–	–	–	–	–

EDSR kantforberedelse, spånbrydergeometri til medium til tung bearbejdning.

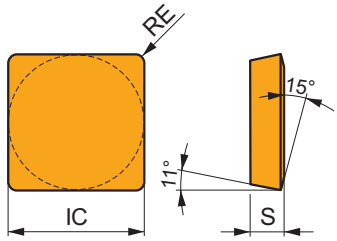
																				
SPKR 1504EDSR:M8330		–	245	0.25	5.0	145	0.25	5.0	230	0.25	5.0	–	–	–	–	–	–	–	–	–
SPKR 1504EDSR:M8340		–	225	0.25	5.0	135	0.25	5.0	210	0.25	5.0	–	–	–	–	–	–	–	–	–

EDSR kantforberedelse, spånbrydergeometri til medium til tung bearbejdning.

SPUN

PRAMET

	IC (mm)	S (mm)
1203	12.700	3.18
1504	15.875	4.76
1904	19.050	4.76
2506	25.400	6.35

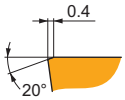


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
SPUN 120304:M8330		0.4	195	0.15	4.0	–	–	–	185	0.15	4.0	–	–	–	–	–	–	–	–	–
SPUN 120308:M8330		0.8	230	0.15	4.0	–	–	–	215	0.15	4.0	–	–	–	–	–	–	–	–	–
SPUN 120308:S26		0.8	95	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SPUN 120312:M8330		1.2	245	0.15	4.0	–	–	–	230	0.15	4.0	–	–	–	–	–	–	–	–	–

N nul skær geometri fræsning, kan også bruges til drejning.

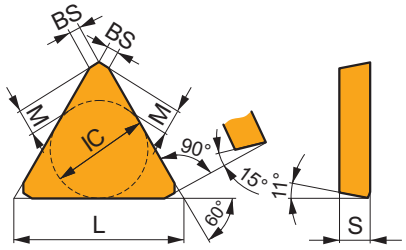
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			E																	
N nul skær geometri fræsning, kan også bruges til drejning.																				
SPUN 150412:M8330		1.2	225	0.20	5.0	–	–	–	210	0.20	5.0	–	–	–	–	–	–	–	–	–
SPUN 190408:M8330		0.8	210	0.20	6.0	–	–	–	195	0.20	6.0	–	–	–	–	–	–	–	–	–
SPUN 190412:M8330		1.2	220	0.20	6.0	–	–	–	205	0.20	6.0	–	–	–	–	–	–	–	–	–
			1		S															
N nul skær geometri fræsning, kan også bruges til drejning.																				
SPUN 250616S:M8326		1.6	115	0.40	12.0	–	–	–	105	0.40	12.0	–	–	–	–	–	–	–	–	–
SPUN 250620S:M5326		2.0	145	0.40	12.0	–	–	–	135	0.40	12.0	–	–	–	–	–	–	–	–	–
SPUN 250620S:M8326		2.0	120	0.40	12.0	–	–	–	110	0.40	12.0	–	–	–	–	–	–	–	–	–
SPUN 250620S:M8346		2.0	100	0.40	12.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
SPUN 250620S:S26		2.0	45	0.40	12.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

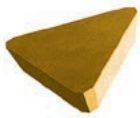
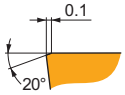
TPCN 16

PRAMET

	BS (mm)	IC (mm)	L (mm)	M (mm)	S (mm)
1603	1.20	9.530	16.10	2.5	3.18

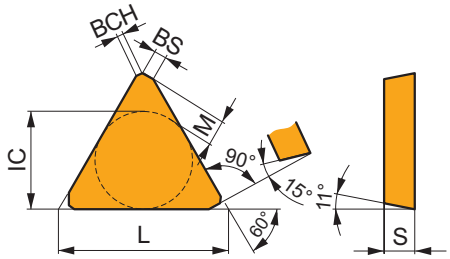


Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

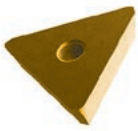
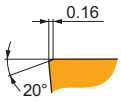
Product		RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
			U	S																
XNCB specielt design til skivefrasning.																				
TPCN 1603PDSN:M8330		–	195	0.20	–	–	–	–	185	0.20	–	–	–	–	–	–	–	–	–	–

TPKN

	IC	L	M	S	BCH	BS
	(mm)	(mm)	(mm)	(mm)	(mm)	(mm)
1603	9.530	16.50	2.5	3.18	1.20	1.30
2204	12.700	22.00	3.5	4.76	1.20	1.50



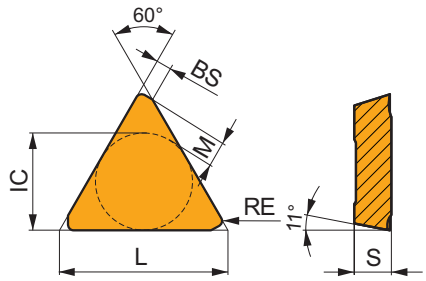
Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)
			**PDER** kantforberedelse, nul skærvinkelgeometri til let til medium bearbejdning.																	
TPKN 1603PDER:M8330	●	–	◪	195	0.15	4.0	–	–	–	◪	185	0.15	4.0	–	–	–	–	–	–	–	–	–
TPKN 1603PDER:M8340	●	–	◪	175	0.15	4.0	–	–	–	◪	165	0.15	4.0	–	–	–	–	–	–	–	–	–
TPKN 2204PDER:8215	●	–	◪	190	0.15	5.5	–	–	–	◪	180	0.15	5.5	–	–	–	–	–	–	–	–	–
TPKN 2204PDER:M8330	●	–	◪	190	0.15	5.5	–	–	–	◪	180	0.15	5.5	–	–	–	–	–	–	–	–	–
TPKN 2204PDER:M8340	●	–	◪	170	0.15	5.5	–	–	–	◪	160	0.15	5.5	–	–	–	–	–	–	–	–	–
			**PDSR** kantforberedelse, nul skærvinkelgeometri til medium bearbejdning.																	
TPKN 1603PDSR:M8330	●	–	◪	185	0.20	4.0	–	–	–	◪	175	0.20	4.0	–	–	–	–	–	–	–	◪	35	0.13	0.8
TPKN 1603PDSR:M8340	⬌	–	◪	165	0.20	4.0	–	–	–	◪	155	0.20	4.0	–	–	–	–	–	–	–		–	–	–
TPKN 1603PDSR:S26	●	–	◪	75	0.20	4.0	–	–	–		–	–	–	–	–	–	–	–	–	–		–	–	–
TPKN 2204PDSR:M8310	●	–	◪	195	0.20	5.5	–	–	–	◪	185	0.20	5.5	–	–	–	–	–	–	–	◪	35	0.13	1.0
TPKN 2204PDSR:M8330	⬌	–	◪	175	0.20	5.5	–	–	–	◪	165	0.20	5.5	–	–	–	–	–	–	–	◪	35	0.13	1.0
TPKN 2204PDSR:M8340	⬌	–	◪	160	0.20	5.5	–	–	–	◪	150	0.20	5.5	–	–	–	–	–	–	–		–	–	–
TPKN 2204PDSR:M9325	●	–	◪	220	0.20	5.5	–	–	–	◪	205	0.20	5.5	–	–	–	–	–	–	–	◪	40	0.13	1.0
TPKN 2204PDSR:S26	●	–	◪	75	0.20	5.5	–	–	–		–	–	–	–	–	–	–	–	–	–		–	–	–

TPKR

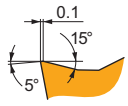
PRAMET

	IC	L	M	S	BS
	(mm)	(mm)	(mm)	(mm)	(mm)
1603	9.530	16.50	2.5	3.18	1.40
2204	12.700	22.00	3.5	4.76	1.40



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)



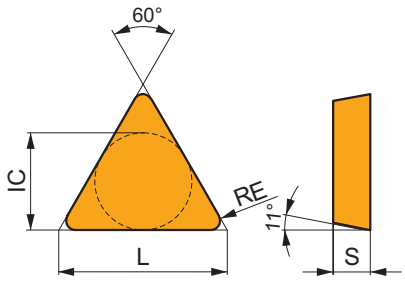
PDSR kantforberedelse, spånbryder-geometri til medium til tung bearbejdning.

TPKR 1603PDSR:M8330	●	–	185	0.20	4.0	110	0.18	4.0	175	0.20	4.0	–	–	–	–	–	–	–	–	–
TPKR 1603PDSR:M8340	●	–	165	0.20	4.0	95	0.18	4.0	155	0.20	4.0	–	–	–	–	–	–	–	–	–
TPKR 2204PDSR:M8330	●	–	175	0.20	5.5	105	0.18	5.5	165	0.20	5.5	–	–	–	–	–	–	–	–	–
TPKR 2204PDSR:M8340	●	–	160	0.20	5.5	95	0.18	5.5	150	0.20	5.5	–	–	–	–	–	–	–	–	–
TPKR 2204PDSR:M9325	●	–	220	0.20	5.5	–	–	–	205	0.20	5.5	–	–	–	–	–	–	–	–	–

TPUN

PRAMET

	IC	L	S
	(mm)	(mm)	(mm)
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18
2204	12.700	22.00	4.76



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

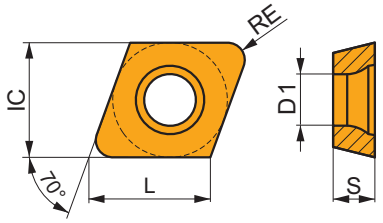
Product		RE	P			M			K			N			S			H		
			vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
		(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)	(m/min)	(mm/tooth)	(mm)

N nul skær geometri fræsning, kan også bruges til drejning.

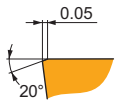
TPUN 110304:M8330	●	0.4	–	–	–	–	–	–	150	0.10	1.2	–	–	–	–	–	–	30	0.10	0.4
TPUN 160304:8215	●	0.4	155	0.15	4.0	–	–	–	145	0.15	4.0	–	–	–	–	–	–	–	–	–
TPUN 160304:H10	●	0.4	–	–	–	–	–	–	65	0.15	4.0	–	–	–	–	–	–	–	–	–
TPUN 160304:M8330	●	0.4	155	0.15	4.0	–	–	–	145	0.15	4.0	–	–	–	–	–	–	–	–	–
TPUN 160304:S26	●	0.4	65	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TPUN 160308:8215	●	0.8	185	0.15	4.0	–	–	–	175	0.15	4.0	–	–	–	–	–	–	–	–	–
TPUN 160308:M8330	●	0.8	–	–	–	–	–	–	155	0.18	1.5	–	–	–	–	–	–	30	0.11	0.6
TPUN 160312:M8330	●	1.2	–	–	–	–	–	–	155	0.20	1.5	–	–	–	–	–	–	30	0.11	0.8
TPUN 220408:M8330	●	0.8	170	0.20	5.0	–	–	–	160	0.20	5.0	–	–	–	–	–	–	–	–	–
TPUN 220412:M8330	●	1.2	–	–	–	–	–	–	155	0.20	2.0	–	–	–	–	–	–	30	0.11	1.0

XDHW

	IC (mm)	D1 (mm)	L (mm)	S (mm)
0702	6.500	2.95	6.90	2.38
10T3	10.000	3.95	10.60	3.97



Egnethed og startværdier for skærehastighed (vc), tilførsel (f) og skæredybde (ap). Se vores app til bearbejdning af yderligere beregninger.

Product	RE (mm)	P vc (m/min)	P f (mm/tooth)	P ap (mm)	M vc (m/min)	M f (mm/tooth)	M ap (mm)	K vc (m/min)	K f (mm/tooth)	K ap (mm)	N vc (m/min)	N f (mm/tooth)	N ap (mm)	S vc (m/min)	S f (mm/tooth)	S ap (mm)	H vc (m/min)	H f (mm/tooth)	H ap (mm)
EN geometri med nul rivevinkeldesign til fræsning af not.																			
XDHW 070210EN:M8310	1.0	310	0.10	1.0	–	–	–	290	0.10	1.0	–	–	–	–	–	–	60	0.05	1.0
 **SN** geometri med nul skær vinkel design til fræsning af spor																			
XDHW 070210SN:M8310	1.0	310	0.10	1.0	–	–	–	290	0.10	1.0	–	–	–	–	–	–	60	0.05	1.0
XDHW 070210SN:M8325	1.0	230	0.10	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
XDHW 10T310SN:M8310	1.0	275	0.15	1.0	–	–	–	260	0.15	1.0	–	–	–	–	–	–	55	0.08	1.0
XDHW 10T310SN:M8325	1.0	210	0.15	1.0	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–

INSTRUKTIONER

1 SAD11E

P M K N S H 2

PRAMET 3 S

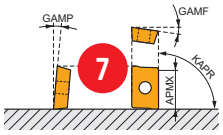
FORCE AD11 skaftfræser med indvendig kølevæske

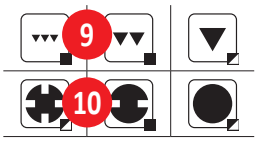
90° ende- og planfræser med positiv AD .. 11 skær med APMX på 9 mm. Velegnet til plan, hjørne, spor,spiralinterpolation , trochoidal, ramping og lommefræsning. Fås i cylindrisk, weldon, morse konisk, modulær og dorn (med differentieret tanddeling) Krop behandlet for længere værktøjslevetid. 5

FORCE AD

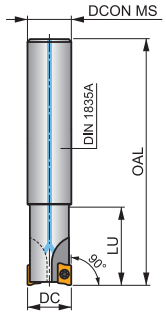
KAPR	90°
APMX	9.0 mm

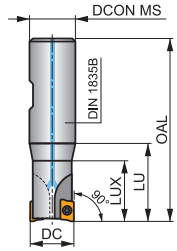
6

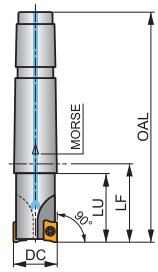


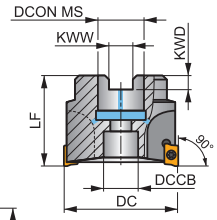


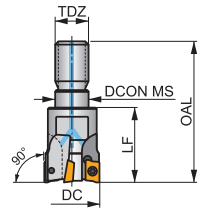
8











	Product	DC (mm)	OAL (mm)	DCON MS (mm)	DCCB (mm)	LU (mm)	LUX (mm)	LF (mm)	TDZ	CZC MS	KWW (mm)	KWD (mm)	GAMF (°)	GAMP (°)	16	17	18 max.	19	20 kg	21	22	23
	16A2R024A14-SAD11E-C	16	160	14	–	24	–	–	–	–	–	–	-12.8	4	2		30100		0.19	GI169	SQ025	
	16A2R024A16-SAD11E-C	16	135	16	–	24	–	–	–	–	–	–	-12.8	4	2		30100		0.19	GI169	SQ025	
	16A2R050A16-SAD11E-C	16	135	16	–	50	–	–	–	–	–	–	-12.8	4	2	–	30100	✓	0.20	GI169	SQ025	–
	18A2R029A20-SAD11E-C	18	150	20	–	29	–	–	–	–	–	–	-12	4.5	2	–	28400	✓	0.35	GI169	SQ025	–
	20A2R029A20-SAD11E-C	20	150	20	–	29	–	–	–	–	–	–	-11.5	5	2	–	27000	✓	0.33	GI169	SQ020	–
	20A2R07[illegible]-SAD11E-C	20	150	20	–	70	–	–	–	–	–	–	-11.5	5	2	–	27000	✓	0.32	GI169	SQ020	–
	20A3R0[illegible]-SAD11E-C	20	200	18	–	29	–	–	–	–	–	–	-11.5	5	3	–	27000	✓	0.36	GI169	SQ025	–
	20A3R029A20-SAD11E-C	20	150	20	–	29	–	–	–	–	–	–	-11.5	5	3	–	27000	✓	0.31	GI169	SQ025	–
	22A3R029A20-SAD11E-C	22	200	20	–	29	–	–	–	–	–	–	-11.5	5	3	–	25600	✓	0.45	GI169	SQ025	–
	25A3R034A25-SAD11E-C	25	170	25	–	34	–	–	–	–	–	–	-10.2	5	3	–	24100	✓	0.42	GI169	SQ020	–
	25A3R080A25-SAD11E-C	25	170	25	–	80	–	–	–	–	–	–	-10.2	5	3	–	24100	✓	0.52	GI169	SQ020	–
	25A4R034A25-SAD11E-C	25	170	25	–	34	–	–	–	–	–	–	-10.2	5	4	–	24100	✓	0.56	GI169	SQ025	–
	25A4R040A25-SAD11E-C	25	250	25	–	40	–	–	–	–	–	–	-10.2	5	4	–	24100	✓	0.85	GI169	SQ025	–
	30A3R080A32-SAD11E-C	30	200	32	–	80	–	–	–	–	–	–	-9.3	7	3	–	22000	✓	0.98	GI169	SQ020	–

13 14 15

GI169	ADMX 11T3..	24	ADEX 11T3..

					25			
SQ020	US 62506-T07P	1.2	M 2.5	6	–	–	Flag T07P	–
SQ021	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	–	–
SQ022	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	–	HS 0830C
SQ023	US 62506-T07P	1.2	M 2.5	6	D-T07P/T09P	FG-15	–	HS 1030C
SQ025	US 62505-T07P	1.2	M 2.5	5	–	–	Flag T07P	–

AC001	KS 1230	26	K.FMH27
AC002	KS 1635		K.FMH32
AC003	KS 2040		K.FMH40

Typical page with indexable mills cutter displayed – specific page details will differ.

INDEXABLE MILLS – PAGE OVERVIEW

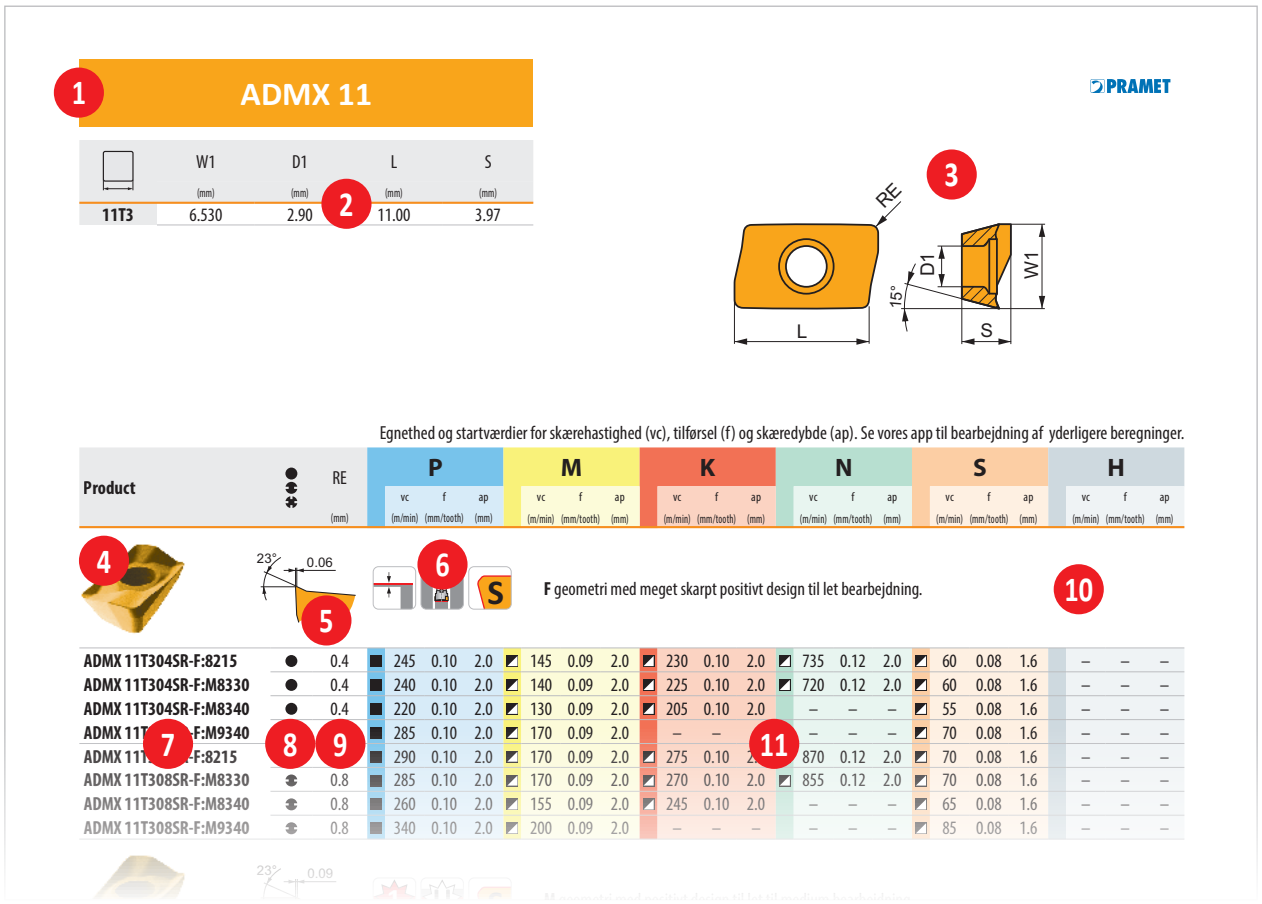
Pos.	Description
1	Designation of cutter
2	Material group recommendations
3	Clamping system of insert
4	Illustrative picture
5	Tool description
6	Setting angle and maximum theoretical depth of cut (mm)
7	Tool geometry
8	Schematic drawing of tool
9	Achievable quality of surface
10	Character of cut/working conditions
11	Maximum range of mean chip thickness (mm) for end milling cutters and/or shell milling cutters
12	Product applications
13	Shank type

Pos.	Description
14	ISO code of cutter
15	Dimensions (mm), angles [1] (°) and connection size code
16	Number of teeth
17	Irregular teeth pitch
18	Maximum revolutions of cutter
19	Internal supply of coolant
20	Weight (kg)
21	Group of compatible inserts [2]
22	Group of spare parts [2]
23	Group of special accessories [2]
24	Compatible inserts
25	Spare parts
26	Special accessories

[1] γ_f = Radial rake setting angle (GAMF) of insert pocket – see indexable mills technical information

γ_p = Axial rake setting angle (GAMP) of insert pocket – see indexable mills technical information

[2] Spare parts and special accessories icons are designed schematically for their ease of understanding. They aren't included in the list of icons. Screws are, in some cases, completed with info on torque value in Nm, length of screw and size of thread.



Pos.	Description
1	Designation of insert
2	Table with insert sizes (mm)
3	Schematic drawing of insert
4	Picture of representative insert
5	Profile of main cutting edge
6	Icons – specific features and cutting edge type

Pos.	Description
7	ISO insert code:Grade
8	Working conditions
9	Insert radii (mm)
10	Geometry description
11	Application area of insert [1]

[1] Recommendations for cutting speed corrections can be found at the end of Milling chapter in the technical section.

Technical information follows immediately after the milling cutter pages, their compatible inserts and info on starting cutting speeds. These will help you to use the tools in the correct way. If you are unsure how to use or interpret this information, either refer to the technical section at the end of the milling chapter or contact your Dormer Pramet representative.

Typical page with milling inserts displayed – specific page details will differ. Most of inserts can be found in this catalogue just immediately after the relevant milling cutter or, alternatively, in the separate inserts chapter.

ICONS OVERVIEW

General Icons

- Primary use
- Possible use
- Efterbehandling
- Mellembearbejdning
- Skrubning
- Velegnet til stabile arbejdsforhold
- Velegnet til ustabile arbejdsforhold
- Velegnet til meget ustabile arbejdsforhold

Milling operations

- Planfræsning
- Overfladisk hjørnefræsning
- Dyb hjørne fræsning
- Fræsning i lav spor
- Fræsning med dyb spor
- Dykfræsning
- Progressiv neddykning
- Ramping
- Spiralformet interpolation
- Spiralformet interpolation i et forboret hul
- Fasfræsning
- T sporfræsning
- Bagsidefræsning
- Fræsning af formflader (kopifræsning)

Features

- Første valg
- Universal bred vifte af muligheder
- Skær med Wiper geometri
- Tyndvæggede og slanke emner
- Langt udhæng
- High Feed
- Tunge arbejdsforhold

Skærekant tilstandskode (CECC)

- Skarp skær
- Afrundet skær
- Skær med facet
- Afrundet skær med dobbelt facet
- Afrundet skær med facet

Fastspændning Type kode (MTP)

- S – Skrue fastspænding gennem hul
- C – Topspænding
- System F
- System SC
- Skruens tilspændingsmoment (Nm)

ICONS OVERVIEW

Skaft

DIN 1835A	DIN 1835A Cylindrisk skaft
DIN 1835B	DIN 1835B Weldon skaft
DIN 228A	Morseskaft DIN 228-1
MODULAR	Gevindkobling

ISO/DIS 7388-1	Holder DIN 69871-2
ISO 297	Holder DIN 2080-2
JIS B 6339	Holder MAS BT (JIS-B-6339)
ISO 6462 DIN 8030	Fræser DIN 8030

ISO 6462 DIN 8030	Fræser DIN 8030 – spiralformet skivefræser
ISO 6462 DIN 8030	Fræser DIN 8030 – skivefræser

Technical parts

a_e/DC	Ratio (%) of radial width of cut to cutting diameter
a_e/DCX	Ratio (%) of radial width of cut to maximal cutting diameter
X.V	Multiplication factor for cutting speed
⇨ X.f	Multiplication factor for feed (machining on centre line)
⇨ X.f	Multiplication factor for feed (machining off centre line)
	Chipbreaker
RE	Corner radius of insert (mm)
BS	Wiper edge length (mm)
f	Feed (mm/tooth)
1 f	Starting feed (mm/tooth)
f_{min}	Minimal feed (mm/tooth)
f_{max}	Maximal feed (mm/tooth)

a_p	Depth of cut (mm)
DC	Diameter of cutter (mm)
DCX	Maximum diameter of cutter (mm)
DEF	Effective diameter of cutter (mm)
a_{emax}	Maximum width of machined area (mm)
max	Cutting depth for plunging (mm)
RPMX	Maximal angle for ramping (°)
APMX/I	Maximum cutting depthover the length of cut (mm)
SMAX DMAX	Maximal depth per revolution for maximal diameter of hole (mm)
SMAX DMIN	Maximal depth per revolution for minimal diameter of hole (mm)
FE	Contouring step in conventional milling (mm)
FE	Contouring step in up/down cross milling (mm)

	Number of teeth
APMX	Effective working length of tool (mm)
	Number of teeth (helical cutters)
CDX	Effective reach of tool (mm)
X	Effective number of teeth
	Chamfering angle (°)
	Number of edges in use
	Hole diameter (mm)
µm	Roughness of machined surface R_a (mm)
	Thread pitch
1 2 3 / 1"	Threads per inch
	Time (min)

ISO-KODEBETEGNELSE – PLANFRÆSERE

	1	2	3	4		5	6	7	8	9	10	11	12
ISO	63	A	06	R	–		S	90	A	D	16	E	
ANSI	1	2	3	4		5	6	7	8	9	10	11	12
	300	F	04	N	–	I	S	90	S	N	12	N	4

1 Skærediameter

DC

DC

DC

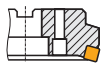
DC

DCX

2 Skæretype, betegnelse og/eller fastspændingsstørrelse

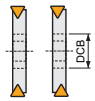
A ISO 6462/A DIN 8030/A

B ISO 6462/B DIN 8030/B

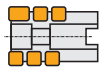


C ISO 6462/C DIN 8030/C

F	DC = 27 mm	DC = 1.000
G	DC = 32 mm	DC = 1.250
H	DC = 40 mm	–
J	DC = 50 mm	–
K	DC = 60 mm	–
M	DC = 80 mm	–



T



3 Antal skær

4 Skæreretning

R

L

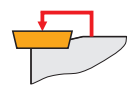
N

5 Standard

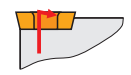
I	(")

6 Fastspændings-betegnelse

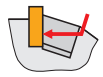
C



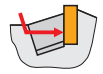
S



W



F



7 Indstillingsvinkel (KAPR)

90°

75°

60°

45°

MO

8 Vendeskærsform

H

O

P

R

S

T

C

D

E

M

V

W

L

A

B

K

9 Frivinkel

A

B

C

D

E

F

G

N

P

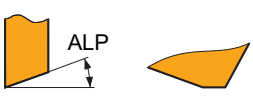
O

Special

10 Skærlængde

IC		H	O	P	S	T	C	D	E	M	V	W	R	K
(mm)	(")													
3.97					03	06		04			06	02		
	5/32"							1.2"						
4.76					04	08	04	05	04	04	08	L3		
	3/16"							1.5"						
5.56					05	09	05	06	05	05	09	03		
	7/32"							1.8"						
6.35		03	02	04	08	11	06	07	08	08	11	04	06	
	1/4"							2"						
7.94		04	03	05	07	13	08	09	06	07	13	05	07	
	5/16"							2.5"						
9.525		05	04	07	09	16	09	11	09	09	16	06	09	19
	3/8"							3"						
12.7		07	05	09	12	22	12	15	13	12	22	08	12	
	1/2"							4"						
15.875		09	06	11	15	27	16	19	16	15	27	10	15	
	5/8"							5"						
19.05		11	07	13	19	33	19	23	19	19	33	13	19	
	3/4"							6"						
25.4		14	10	18	25	44	25	31	26	25	44	17	25	
	5/1"							8"						
31.75		18	13	23	31	54	32	38	32	31	54	21	31	
	1 1/4"							10"						

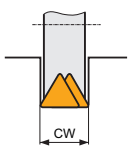
11 Frivinkel



N	ALP = 0°	C	ALP = 7°	P	ALP = 11°
D	ALP = 15°	E	ALP = 20°	F	ALP = 25°

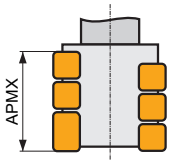
12 Skærlængde (bredde)

CW (mm) / (")



CW	1/16"
0.156	2.5
0.187	3
0.250	4
0.313	5
0.375	6

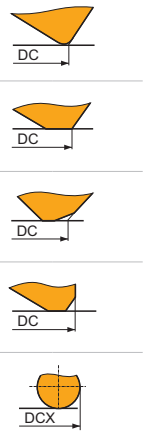
APMX



ISO-KODEBETEGNELSE – HJØRNEFRÆSER

	1	2	3	4	5	6	7		8	9	10	11	12	13
ISO	32	A	4	R	042	B	32	–		S	A	D	11	E
ANSI	125	A	4	R	150	W	125	–	I	S	A	D	11	E

1 Skærediameter



2 Fræsertype og indstillingsvinkel

A	E	J	N	H	K
45°		45°	45°	45°	

3 Antal skær

4 Skæreretning

R	L	N

5 Udhæng

(mm)
(")

6 Skaftbetegnelse

A	C	DIN 1835A	
B	W	ISO 3338-2, DIN 1835B	
E	-	ISO 296, DIN 228-1	
G	-	ISO 297, DIN 208-1	
H	-	ISO/DIS 7388-1, DIN 69871-1	
N	-	ISO 12 164-1, DIN 69893	
-	R8	R8	
X	-	MAS BT	
XC	-	CAPTO	
-	CA	ANSI B5.50	

7 Skaftstørrelse

6 – 40 mm	.250" – 1.250"
6 – 50 mm	.375" – 2.000"
1 – 6	–
40 – 50 mm	–
30 – 50 mm	–
25 – 100 mm	–
–	1.250"
30 – 50	–
3 – 10	–
–	40 / 50

10 Vendeskærsform

H	O	P	R
S	T	C 80°	D 55°
E 75°	M 86°	V 35°	W 80°
L	A 85°	B 82°	K 55°

11 Frivinkel

A 3°	B 5°
C 7°	D 15°
E 20°	F 25°
G 30°	N 0°
P 11°	O Speciel

12 Skærlængde

IC (mm)	(")	H	O	P	S	T	C	D	E	M	V	W	R	K
3.97					03	06		04			06	02		
	5/32"							1.2"						
4.76					04	08	04	05	04	04	08	L3		
	3/16"							1.5"						
5.56					05	09	05	06	05	05	09	03		
	7/32"							1.8"						
6.35		03	02	04	08	11	06	07	08	08	11	04	06	
	1/4"							2"						
7.94		04	03	05	07	13	08	09	06	07	13	05	07	
	5/16"							2.5"						
9.525		05	04	07	09	16	09	11	09	09	16	06	09	19
	3/8"							3"						
12.7		07	05	09	12	22	12	15	13	12	22	08	12	
	1/2"							4"						
15.875		09	06	11	15	27	16	19	16	15	27	10	15	
	5/8"							5"						
19.05		11	07	13	19	33	19	23	19	19	33	13	19	
	3/4"							6"						
25.4		14	10	18	25	44	25	31	26	25	44	17	25	
	5/1"							8"						
31.75		18	13	23	31	54	32	38	32	31	54	21	31	
	1 1/4"							10"						

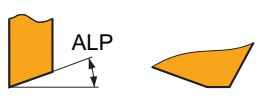
8 Standard

I	(")

9 Fastspændingsbetegnelse

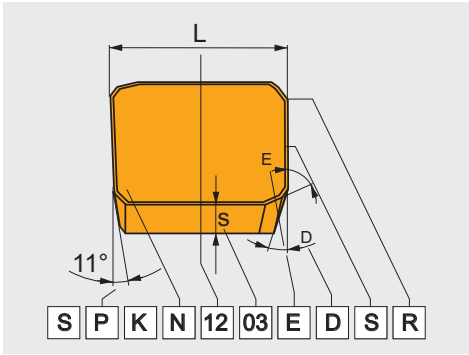
C		W	
S		F	

13 Frivinkel



N	ALP = 0°	C	ALP = 7°	P	ALP = 11°
D	ALP = 15°	E	ALP = 20°	F	ALP = 25°

ISO-KODEBETEGNELSE – VENDESKÆR



	1	2	3	4
ISO	S	P	G	N
	S	P	K	N
ANSI	1	2	3	4
	S	P	G	
	S	P	K	N

1 Vendeskærform

H	O	P	R
S	T	C 80°	D 55°
E 75°	M 86°	V 35°	W 80°
L	A 85°	B 82°	K 55°

2 Frivinkel

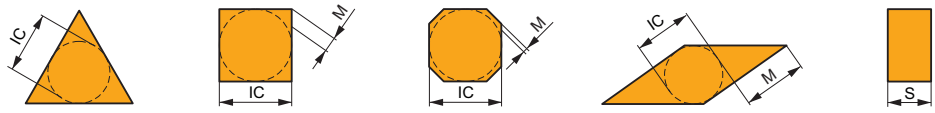
A 3°		B 5°	
C 7°		D 15°	
E 20°		F 25°	
G 30°		N 0°	
P 11°		O	Speciel

4 Skærtype

N	
R	
F	
A	
M	
G	
W	40 – 60°
T	
Q	
U	
B	70 – 90°
H	
C	
J	
X	Speciel

3 Tolerancer

	(mm)			(″)		
	M (±)	S (±)	IC (±)	M (±)	S (±)	IC (±)
A	0.005	0.025	0.025	0.0002″	0.001″	0.0010″
F	0.005	0.025	0.013	0.0002″	0.001″	0.0005″
C	0.013	0.025	0.025	0.0005″	0.001″	0.0010″
H	0.013	0.025	0.013	0.0005″	0.001″	0.0005″
E	0.025	0.025	0.025	0.0010″	0.001″	0.0010″
G	0.025	0.130	0.025	0.0010″	0.005″	0.0010″
J	0.005	0.025	0.05 – 0.13	0.0002″	0.001″	0.002″ – 0.005″
K	0.013	0.025	0.05 – 0.13	0.0005″	0.001″	0.002″ – 0.005″
L	0.025	0.025	0.05 – 0.13	0.0010″	0.001″	0.002″ – 0.005″
M	0.08 – 0.18	0.130	0.05 – 0.13	0.003″ – 0.007″	0.005″	0.002″ – 0.005″
N	0.08 – 0.18	0.025	0.05 – 0.13	0.003″ – 0.007″	0.001″	0.002″ – 0.005″
U	0.05 – 0.38	0.130	0.05 – 0.13	0.005″ – 0.015″	0.005″	0.003″ – 0.010″



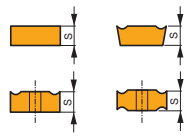
ISO-KODEBETEGNELSE – VENDESKÆR

5	6	7		8	9		10
12	03	08					
12	03	ED		S	R	-	
5a	6a	7a		8	9		
4	2	2					
4	2	ED		S	R	-	

5 – Skærlængde

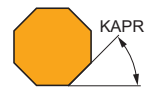
I.C. (mm)	I.C. (″)	H	O	P	S	T	C	D	E	M	V	W	R	K
3.97					03	06		04			06	02		
	5/32″	1.2″												
4.76					04	08	04	05	04	04	08	L3		
	3/16″	1.5″												
5.56					05	09	05	06	05	05	09	03		
	7/32″	1.8″												
6.35		03	02	04	08	11	06	07	08	08	11	04	06	
	1/4″	2″												
7.94		04	03	05	07	13	08	09	06	07	13	05	07	
	5/16″	2.5″												
9.525		05	04	07	09	16	09	11	09	09	16	06	09	19
	3/8″	3″												
12.7		07	05	09	12	22	12	15	13	12	22	08	12	
	1/2″	4″												
15.875		09	06	11	15	27	16	19	16	15	27	10	15	
	5/8″	5″												
19.05		11	07	13	19	33	19	23	19	19	33	13	19	
	3/4″	6″												
25.4		14	10	18	25	44	25	31	26	25	44	17	25	
	5/1″	8″												
31.75		18	13	23	31	54	32	38	32	31	54	21	31	
	1 1/4″	10″												

6 – Tykkelse



Symbol	S (mm)	S (″)
01	1.59	1/16″
T1	1.98	5/64″
02	2.38	3/32″
03	3.18	1/8″
T3	3.97	5.32″
04	4.76	3/16″
05	5.56	7/32″
06	6.35	1/4″
07	7.94	5/16″
09	9.52	3/8″

7 – Skærvinkler / Frivinkel

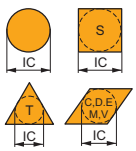


	KAPR		ALP
A	45°	A	3°
D	60°	B	5°
E	75°	C	7°
F	85°	D	15°
P	90°	E	20°
Z	Speciel	F	25°
		G	30°
		N	0°
		P	11°
		Z	Speciel

ZZ – Speciel

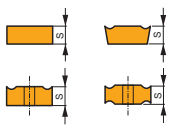
ANSI

5a – Præget cirkel



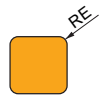
Symbol	I.C. (mm)	I.C. (″)
1	3.175	1/8″
1.2	3.969	5/32″
1.5	4.763	3/16″
1.8	5.556	7/32″
2	6.350	1/4″
2.5	7.938	5/16″
3	9.525	3/8″
4	12.700	1/2″
5	15.875	5/8″
6	19.050	3/4″
7	22.225	7/8″
8	25.400	1″
10	31.750	5/4″
12	38.100	6/4″

6a – Tykkelse



Symbol	S (mm)	S (″)
1	1.588	1/16″
1.2	1.984	5/64″
1.5	2.381	3/32″
2	3.175	1/8″
2.5	3.969	5/32″
3	4.763	3/16″
3.5	5.556	7/32″
4	6.350	1/4″
5	7.938	5/16″
6	9.525	3/8″
7	11.113	7/16″
8	12.700	1/2″
9	14.288	9/16″
10	15.875	5/8″

7a – Spidsradius

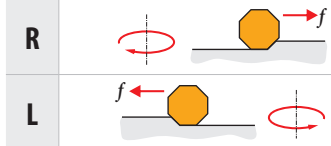


Symbol	RE (mm)	RE (″)
0	0	0″
0.2	0.099	1/256″
0.5	0.198	1/128″
1	0.397	1/64″
2	0.794	1/32″
3	1.191	3/64″
4	1.588	1/16″
5	1.984	5/64″
6	2.381	3/32″
7	2.778	7/64″
8	3.175	1/8″
10	3.969	5/32″
12	4.763	3/16″
14	5.556	7/32″
16	6.350	1/4″

8 – Skærdesign

F	Skarpe skær	E	Afrundede skær
T	Skær med facet	S	Afrundede skær med facet
K	Skær med dobbelt facet	P	Afrundede skær med dobbelt facet

9 – Tilspændingsretning



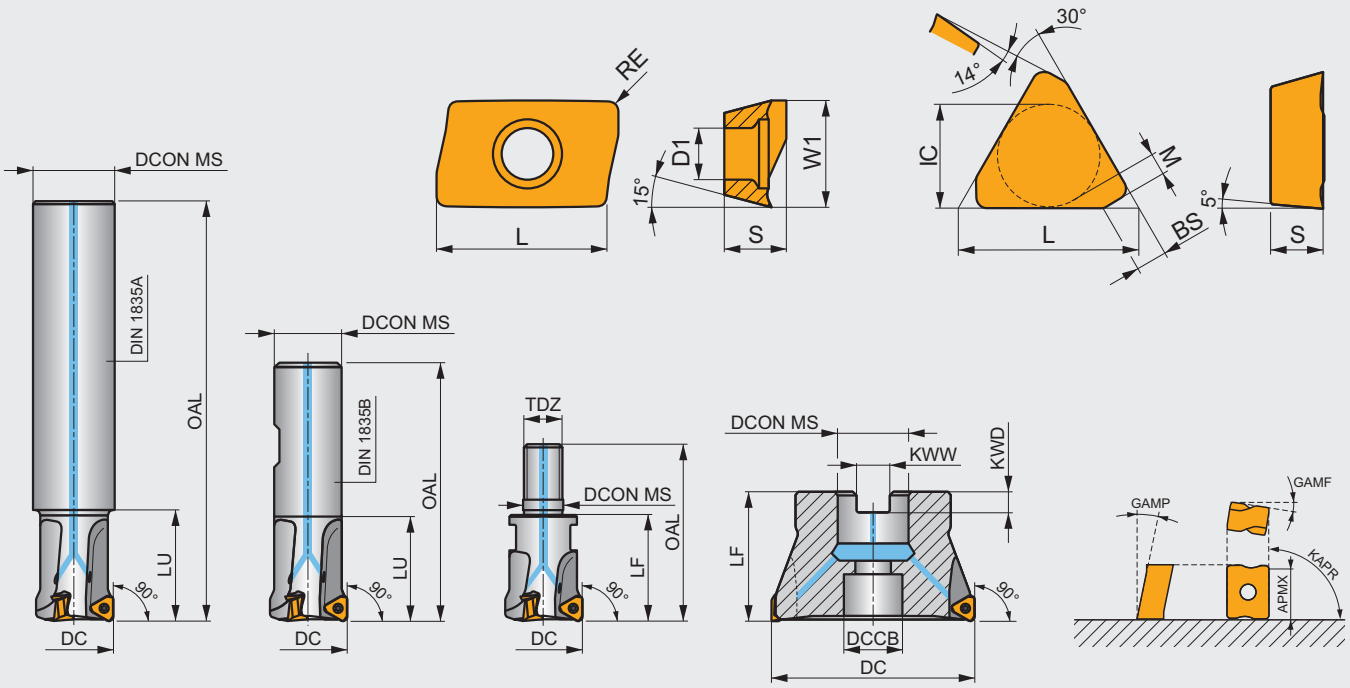
10 – Spånbryderbetegnelse

CUTTING TOOL PARAMETERS ACCORDING TO ISO 13399

All cutting tools are defined by a number of parameters according to the standard ISO 13399. This list contains all the parameters used in this catalogue and their definitions.

ISO 13399 is an international cutting tool information standard. It provides dimensions and parameters in a neutral format that is independent of any particular system or company nomenclature. When cutting tools are clearly defined according to a global standard, all types of software can process the electronic data more quickly, improving the quality of communication and helping to make the exchange of information run smoothly. Supporting a common language in our cutting tool descriptions this will assist system to system communication. It will save you a significant amount of time, providing an easier gathering of high-quality data across our 40,000 solid and indexable tools. By using an ISO 13399 compliant system, there will be no need to manually interpret data and key-enter it into your system.

EXAMPLES ONLY!

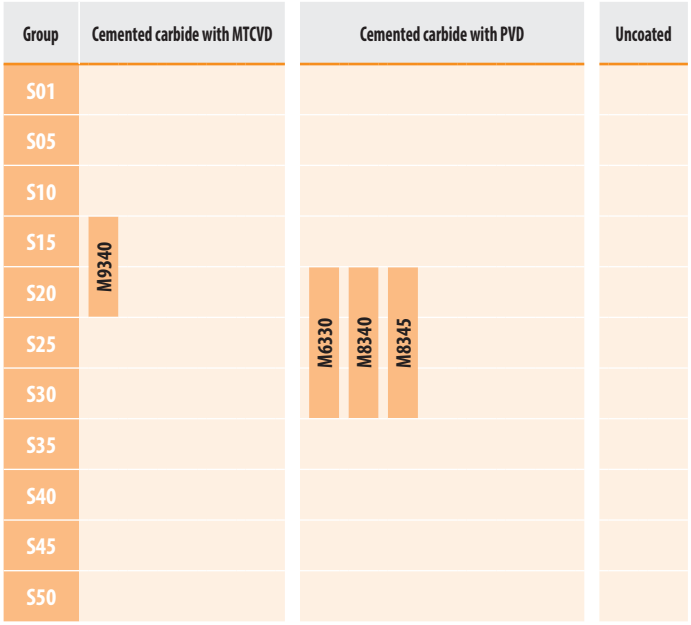


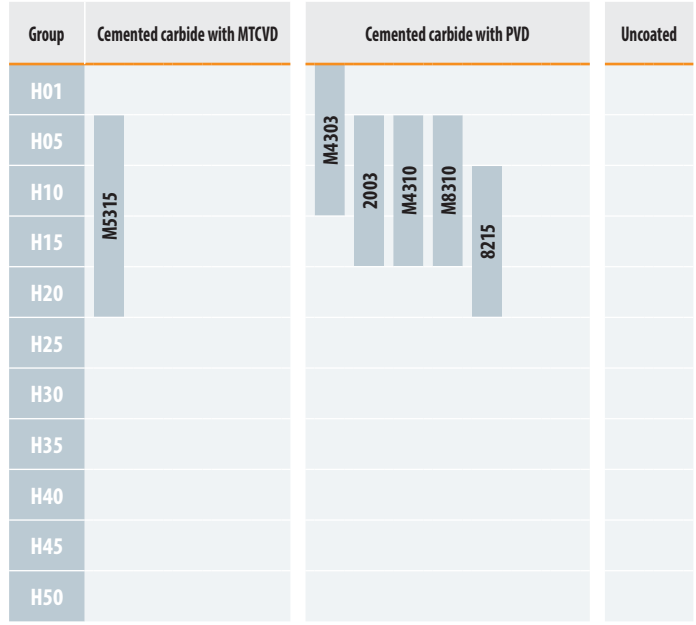
ISO 13399 code	Description
APMX	Depth of cut maximum
BD	Body diameter
BDX	Body diameter maximum
BCH	Corner chamfer length
BS	Wiper edge length
CBDP	Connection bore depth
CDI	Insert cutting diameter
CDX	Cutting depth maximum
CW	Cutting width
CZC MS	Connection size code machine side
D1	Fixing hole diameter
DAH4	Diameter access hole
DAH5	Diameter access hole
DAH6	Diameter access hole
DBC1	Diameter bolt circle 1
DBC2	Diameter bolt circle 2
DBC4	Diameter bolt circle
DBC5	Diameter bolt circle
DBC6	Diameter bolt circle

ISO 13399 code	Description
DC	Cutting diameter
DCB	Connection bore diameter
DCCB	Counterbore diameter connection bore
DCN	Cutting diameter minimum
DCON MS	Connection diameter
DCX	Cutting diameter maximum
DHUB	Hub diameter
DN	Neck diameter
GAMF	Radial rake angle
GAMP	Axial rake angle
CHW	Corner chamfer width
IC	Inscribed circle diameter
INSD	Insert diameter
INSL	Insert length
KAPR	Tool cutting edge angle
KWD	Keyway depth
KWW	Keyway width
L	Cutting edge length
LB	Body length
LE	Cutting edge effective length

ISO 13399 code	Description
LF	Functional length
LH	Head length
LU	Usable length
LUX	Usable length maximum
M	M-dimension
NOF	Number of flutes
OAL	Overall length
P	Pitch of the blade
PRFA	Profile angle
PRFRAD(2)	Profile radius
RE	Radius
S	Insert thickness
S1	Insert thickness total
TDZ	Thread diameter size
TP	Thread pitch
TPI	Threads per inch
W1	Insert width
ZNP	Number of peripheral edges in the tool

MILLING GRADES – OVERVIEW





MILLING GRADES – OVERVIEW

Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Coating	Colour	Substrate	Coolant benefit	Grade description
M8345	P30 – P50 M30 – M40	■ ■				PVD		H	-	This grade has exceptional operational reliability and is designed for heavy cuts in unfavourable conditions in difficult and tough materials.
M6330	P20 – P35 M20 – M35 S20 – S30	■ ■ ■				PVD		H	+ / -	Milling grade with extraordinary service reliability. Especially suitable for machining of hard to machine materials. Powerful in applications where unfavourable conditions and heavy cuts dominate.
M4303	P01 – P10 K01 – K10 N01 – N10 H01 – H10	◪ ■ ◪ ■				PVD		ultra submicron H	-	The most wear resistant grade for mold & die applications. Offers exceptional performance at high cutting speeds and low feeds in stable cutting conditions. Suitable for finishing operations in difficult workpiece materials.
M4310	P05 – P15 M05 – M15 K05 – K15 S05 – S10 H05 – H15	◪ ◪ ■ ■ ■				PVD		ultra submicron H	-	Universal grade for mold & die applications. Suitable for finishing as well as semi-roughing operations. This grade combines high wear resistance with extraordinary operational reliability.
2003	P01 – P10 M01 – M10 K01 – K10 S05 – S10 H05 – H15	◪ ◪ ■ ■ ◪				PVD		ultra submicron H	-	Milling grade with excellent wear resistance. Most suitable in a machining of hard and high strength materials under stable cutting conditions and moderate/higher cutting speeds. Suitable for cutting other workpiece group materials except non-ferrous metals.
M0315	N05 – N25	■				PVD		submicron H	-	Submicron grade for milling non-ferrous metals and their alloys with a balanced ratio of wear resistance and toughness. It is provided with a unique coating with excellent friction properties.
M8326	P20 – P40 M15 – M30	■ ◪				PVD		H	-	Special grade for heavy duty. The main application area of this grade is machining all kinds of steels (including stainless) in the „soft state". It can also be used for machining softer cast irons. Suitable for M15 – M30 machining at medium speeds under average cutting conditions.
M8346	P30 – P50 M30 – M40	■ ■				PVD		H	-	Special grade for heavy duty. This grade has exceptional operational reliability and is designed for heavy cuts in unfavourable conditions in difficult and tough materials.
S26	P15 – P30	■				–		S	++	Uncoated milling grade with excellent resistance to erosion of the cutting face. It is intended solely for machining carbon and alloy steels at low cutting speeds.
S45	P30 – P45	■				–		S	++	Uncoated, tough cutting grade suitable for machining applications where low cutting speed and unfavourable cutting conditions dominate
HF7	M10 – M20 K10 – K25 N10 – N25	◪ ■ ■				–		submicron H	++	Uncoated grade which is primarily designed for machining non-ferrous metals; can also be used for other machined materials (except steel). This grade can be used in turning, milling, and even boring.

MILLING GRADES – OVERVIEW

Grade Identification	Area of Application	Application	Feed	Cutting speed	Resistance to adverse Working Conditions	Coating	Colour	Substrate	Coolant benefit	Grade description
M9315	P05 – P25 K10 – K30 H10 – H20	■ ■ ◪				MT-CVD		H	---	Milling grade with high abrasion resistance even at high thermal loads, main application area is higher cutting speeds with medium or small depths of cut.
M9325	P10 – P30 K10 – K30 H15 – H20	■ ■ ◪				MT-CVD		H	---	This grade has an ideal balance between wear resistance and toughness, it is mainly designed for roughing operations. Advantages are excellent wear resistance even at relatively high cutting speeds with excellent reliability, this grade is more suitable for applications using higher speeds and lower feed rates.
M9340	P35 – P50 M30 – M40 S15 – S20	■ ■ ■				MT-CVD		H	---	A very tough grade, where the main advantage is the high strength of the cutting edge and resistance to adverse cutting conditions. Although this material has an MT-CVD M30 – M40 coating, it is possible to use emulsion cooling for its application, especially in optimum cutting conditions.
M5315	P05 – P20 K05 – K25 H05 – H20	◪ ■ ■				MT-CVD		H	---	One of the most abrasion-resistant milling grades which should be used under stable conditions. Its main advantage is the extremely high resistance to thermal stress and abrasive K05 – K25 wear. It is mainly used for machining hard and very hard materials, particularly cast iron.
M8310	P01 – P10 M01 – M10 K01 – K10 H05 – H15	■ ◪ ■ ◪				PVD		ultra submicron H	-	Grade specially developed for copy milling, featuring high resistance to abrasion. It is suitable for machining at higher cutting speeds under stable cutting conditions, and for machining virtually all groups of machined materials (particularly stronger and harder materials).
8215	P10 – P20 M10 – M20 K10 – K25 N10 – N25 S10 – S15 H10 – H15	■ ◪ ■ ■ ◪ ■				PVD		submicron H	+ / -	One of the most versatile milling grades, in terms of both the range of workpiece materials and the range of possible applications. It is characterised by high wear resistance and operational reliability. Its other advantages include excellent resistance to cracking induced by temperature shock. With its unique properties, this material is undoubtedly one of the pillars of the milling range.
M8325	P20 – P40 M15 – M30	■ ◪				PVD		S	-	The main application area of this grade is machining all kinds of steels (including stainless) in the "soft state". It can also be used for machining softer cast irons. Suitable for M15 – M30 machining at medium speeds under average cutting conditions.
M8330	P20 – P40 M20 – M35 K20 – K40 N15 – N30 S15 – S25 H15 – H25	■ ■ ■ ◪ ◪ ◪				PVD		submicron H	+ / -	This grade is universal and can be used for machining various types of materials. However, it's priority application area lies within steels and ductile cast irons. It is recommended for milling at medium speeds under unstable cutting conditions.
M8340	P25 – P50 M20 – M40 K20 – K40 S20 – S30	■ ■ ◪ ■				PVD		submicron H	+ / -	One of the toughest grade dedicated for machining with lower cutting speed and unfavorable conditions. This grade is ideal for all operations where the main requirement is for a tough cutting edge.

MILLING GRADES – OVERVIEW

Marking of grades

M	9	3	2	5
Anvendelse	Belægning/Substrat	Generation	ISO-område	

Anvendelse	
D	Boring
M	Fræsning
T	Drejning
G	Grooving and Parting off

Belægning/Substrat	
0 PVD 1 CVD	Specialanvendelse
2 PVD 3 CVD	Fri
4 PVD 5 CVD	Gruppe K, H
6 PVD 7 CVD	Gruppe M, S
8 PVD 9 CVD	Universel
B	CBN
D	PCD

Generation
1 – 9

ISO-område	
	01 – 05
	05 – 10
	10 – 20
	20 – 30
	30 – 40
	40 – 50

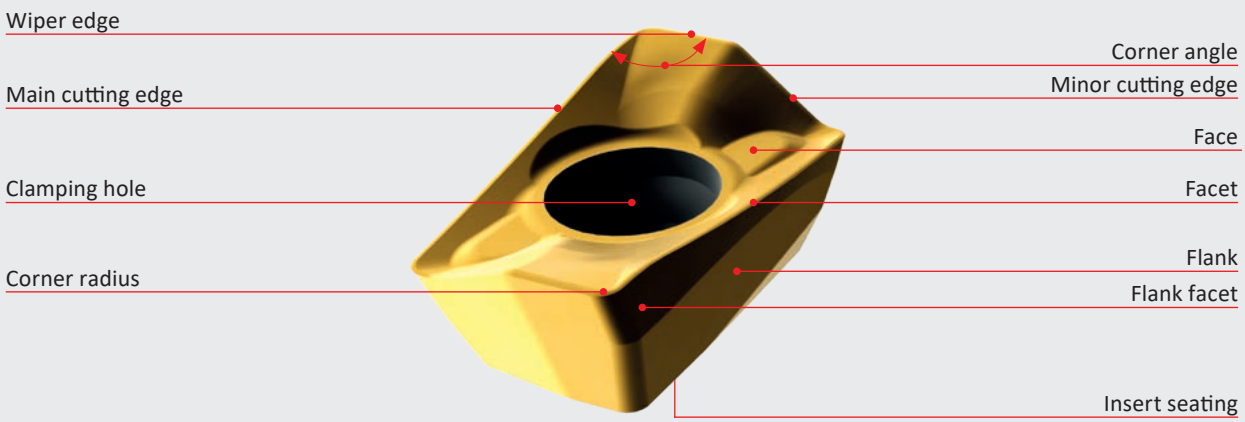
Substrate	
H	WC-Co based substrate
submicron H	WC-Co based substrate, fine-grained (< 1 µm)
ultra submicron H	WC-Co based substrate, very fine-grained (< 0.5 µm)
S	Substrate with cubic carbides

Coating	
MT-CVD	Medium-temperature chemical method of coating
PVD	Low-temperature physical method of coating
–	Uncoated grade

Coolant Benefit	
- - -	Very negative effect on tool life – cooling is not recommended
-	Slightly negative effect on tool life
+ / -	Influence of cooling may be both positive and negative – decisive factor is specific working conditions
+ +	Positive effect on tool life – cooling is recommended

Attribute Strength	
	Level 1 – 5

Parts of an Indexable Insert



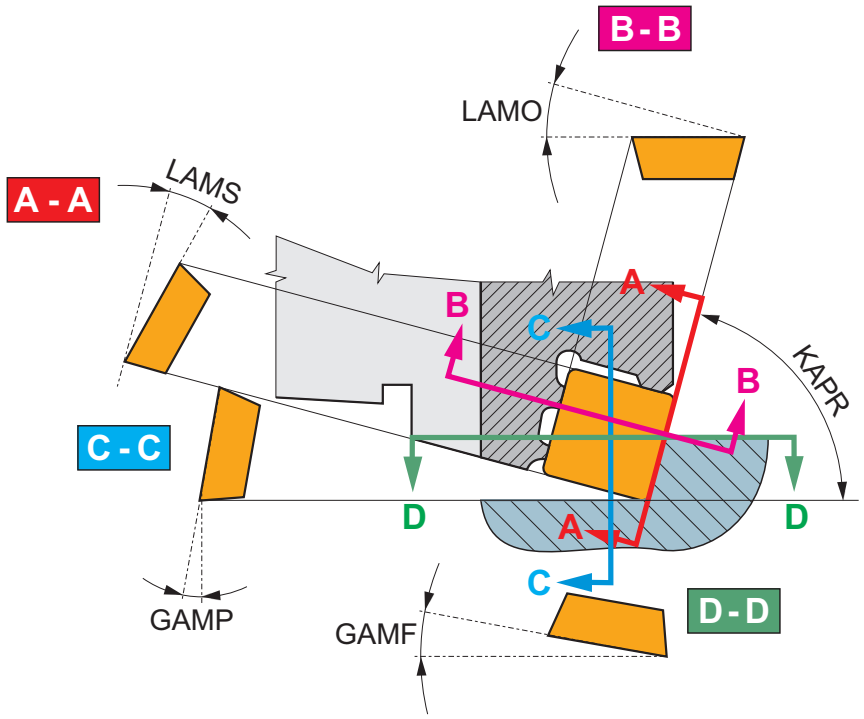
Geometry of milling tool

Constructional angles determine the basic orientation of the seat position that the cutting insert is clamped in and are therefore important for the design of the milling cutter body. There are two angles: axial face angle *GAMP* – γ_p (tool back rake) and radial face angle *GAMF* – γ_f (tool side rake) – see picture below.
Working angles are the setting angle *KAPR* – κ_r, the orthogonal face angle *GAMO* γ_o and the rake angle of the cutting edge *LAMS* – λ_s.

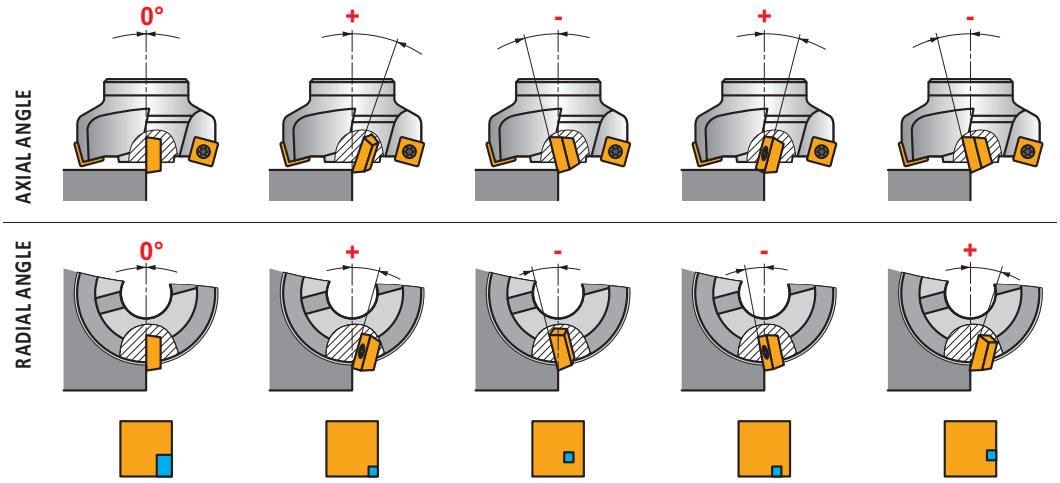
- **Orthogonal face angle** *GAMO* – γ_o affects not only the extent of plastic deformation of the cut chip but also the cutting force and temperature. The bigger the rake angle *GAMO* – γ_o, the lower the cutting force and power demand of the spindle motor (and vice versa).
- **Setting angle** *KAPR* – κ_r determines the thickness of the chip at a specific feed per tooth f_z and axial depth of cut a_p. It therefore affects cutting forces, specifically load, wear and tool service life. Reducing the setting angle *KAPR* – κ_r at a constant feed f_z causes a decrease in the chip thickness h.
- **Rake angle of cutting edge** *LAMS* – λ_s together with setting angle *KAPR* – κ_r and face angle *GAMO* – γ_o, this determines the point of first contact between the edge and work piece. That is why it affects the resistance of the edge to chipping during interrupted cut. At the same time, it affects the direction of chip evacuation.

Working angles of the tool you can determine the bed using the formulas or diagrams below.

Working and constructional angles of milling tool

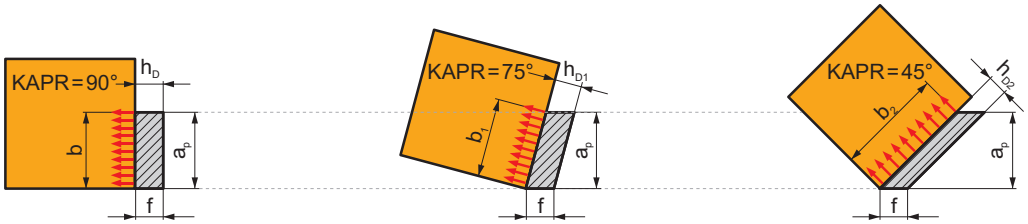


Milling Cutter Geometry



When choosing a tool, it is necessary to take many criteria into account. One of the primary requirements is that the place of first contact between the cutting wedge and the workpiece lie further away from the tip and the cutting edge. That, however, is dependent on the basic geometry of the cutting wedge i.e. angles *GAMO* – γ_o, *LAMS* – λ_s, *KAPR* – κ_r , as well as the mutual position of the milling cutter and the entry edge of the workpiece. The following figure shows individual milling cutter geometries (or rather, the combinations of radial and axial angles) at some of the most adverse engagement conditions (i.e. when the axis of the milling cutter is in line with the edge of the workpiece). At the bottom of the figure is a depiction of the indexable insert with an indication of the area where the insert makes first contact with the workpiece. The figure shows that in such adverse engagement conditions, tools with negative – negative geometry perform the best, while tools with positive – positive geometry will be the most problematic. Another criterion is chip removal. Negative – negative tools push the chip into the work surface (towards the workpiece) while positive – positive tools do the opposite, leading the chip away from the work surface, i.e. away from the workpiece. It is thus an optimal compromise to combine negative and positive angles.

Entering Angle



$h_D = f$ $k_c = 1{,}00\ k_{c1}$ $k_c/b = 1{,}00$	$h_{D1} = 0{,}97f$ $k_c = 1{,}01\ k_{c1}$ $k_c/b_1 = 0{,}98$	$h_{D2} = 0{,}71f$ $k_c = 1{,}09\ k_{c1}$ $k_c/b_2 = 0{,}77$

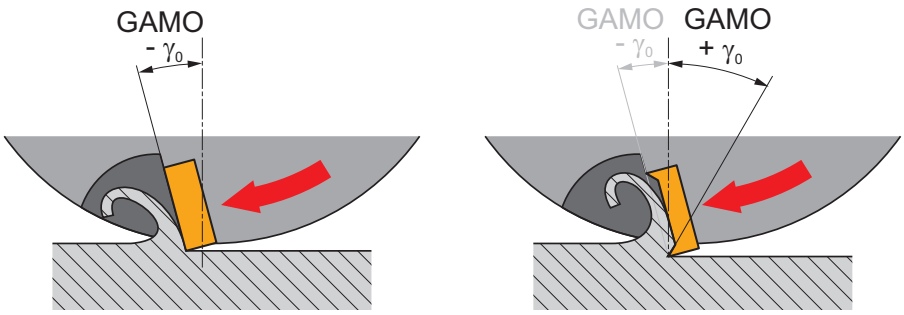
When choosing the entering angle for face milling, you should, among other things, account for the power and rigidity of the machine (size and type of tool holder), its dynamic capabilities and maximum depth of removal. For instance, if you have a high-performance (50 – 100 kW) machine at your disposal with an ISO 50 tool holder and you cut at high depth, your first choice should be a milling cutter with an entering angle between 90° – 58°. On the other hand, if you have a low-power machine (up to 10 kW) with an ISO 40 (HSK 63) tool holder and you expect to cut at 2 – 3 mm depth, you should choose a tool with an entering angle of 45° – 10° (i.e. HFC) or with round inserts. It would thus be an ideal compromise to choose a tool with an entering angle of 45°, which can also handle higher depths of cut and, when compared to a tool with an entering angle of 90°, can cut at the same depth at up to 30 % higher feed and at approximately the same load. Finally, it is important to emphasise that the lower the entering angle, the thinner the chip and the longer the engaged section of the cutting wedge, which is important with regard to heat dissipation and the distribution of force across the edge of the insert. Also worth mentioning is the change in the direction of the resultant cutting forces, which, in simplified terms, can be visualised as perpendicular to the edge. (Decreasing the entering angle increases the passive component of the cutting force leading into the spindle and decreases the active radial component of the cutting force).

CHOICE OF TOOL

The following figure shows the assortment of Pramet milling cutters with regard to the entering angle and the basic geometry of the cutter body (i.e. the axial and radial angle of the face). However, it must be pointed out that insert geometry may change the resulting geometry of the tool as indicated in the following figure.

	Negative – Negative	← Negative – Positive →	Positive – Positive
93°	SWN04C SCN05C		
90°	STN10 STN16 SLN12 SLN16 SLN12X J(T)-SLSN	SAD07D SAD11E SAD16E SAP10D SAP16D SS009 SSD12 FTB27X F-SCC S90SN S90CN(XN) J(T)-SAD11E J(T)-SAD16E J(T)-SSAP J(T)-CSD12X	SAP10D SVC22C
57° – 60°	SPN13	FSB22X	
45°	SHN06C SHN09C SSD09 N-SS009 2516	SSF13F SOD05 SOD06D SSE09 SSN12Z	
43°	SON06C		SOE06Z
12° – 20°	SBN10 SSN11	SPD09 SS012	
–	SRC10 SRC12 SRC16 SRC20 SRD10 SRD12 L2-SZP K3-CXP K2-PPH K2-SLC K2-SRC	SRD05 SRD07 SRD10 SRD12 SRD16 SZD07 SZD09 SZD12 2636 J(T)-SXP16	

Resulting Geometry (Milling Cutter + Indexable Insert)



The following table lists the three basic milling cutter geometries and the approximate priority of their use with regard to the type of machined material. More detailed information about individual tool families with consideration of insert geometries can be found in the catalogue section.

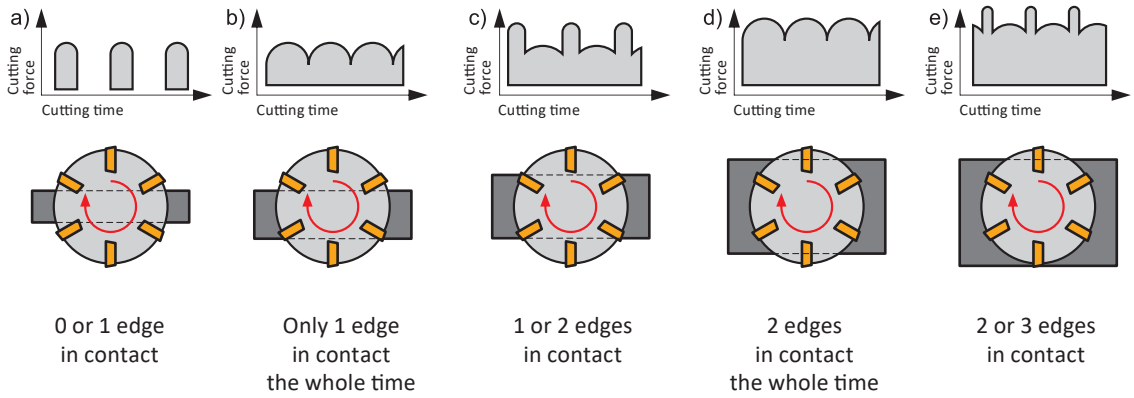
Conditions		Selection of cutter geometry according to application		
		Negative – Negative	Negative – Positive	Positive – Positive
Structural parameter of the body	*GAMP* (A.R.)	-	+	+
	GAMF (R.R.)	-	-	+
	GAMO	-	+	+
Machined material	Carbon steels, alloy steels (< 300 HB)	◪	■	■
	Stainless steels (< 300 HB)		■	◪
	Stainless steels (> 300 HB)		■	◪
	Cast iron, ductile iron	■	◪	◪
	Al alloys		◪	■
	Copper and its alloys		◪	■
	Titanium and its alloys		◪	◪
	Hardened steels (40 – 55 HRC)	◪	◪	

Number of Teeth on the Milling Cutter

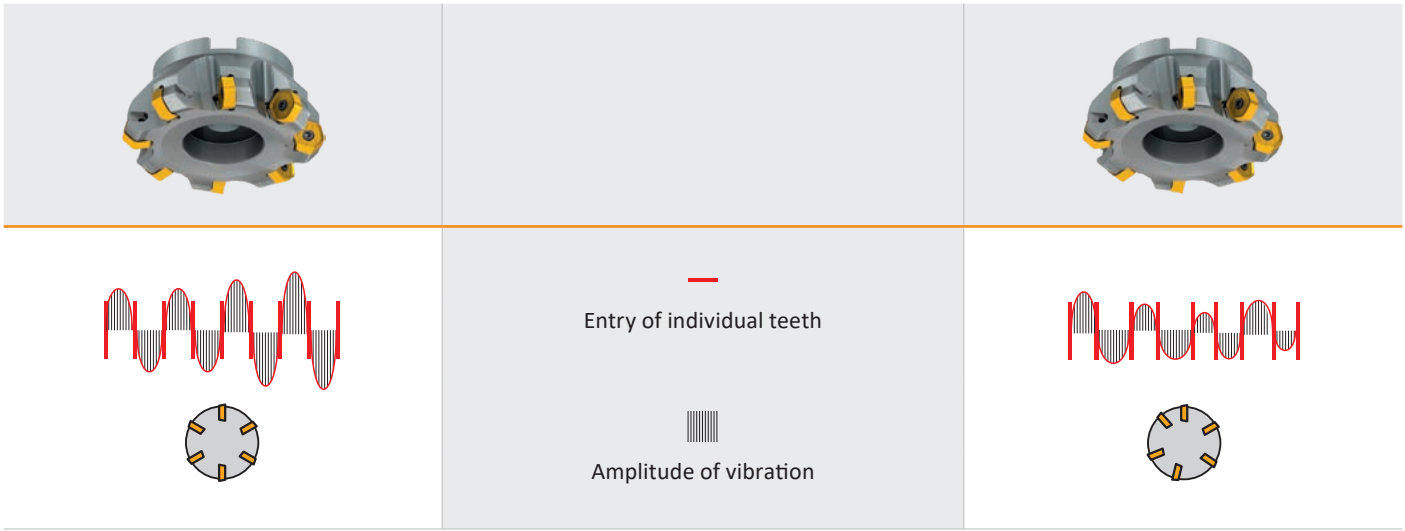
The number of teeth on the milling cutter is also important in relation to the width of the milled surface, where it determines the force (and acoustic) characteristics of the cut, as indicated in the following figure.

Feed per minute	+	++	+++
Tough materials	+++	++	+
Power requirement	+	++	+++
Resulting roughness	+++	++	+

Tooth Pitch



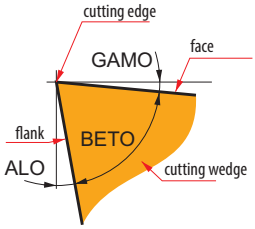
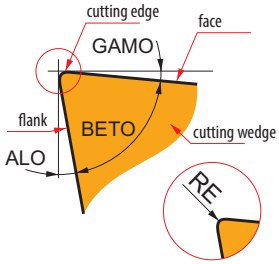
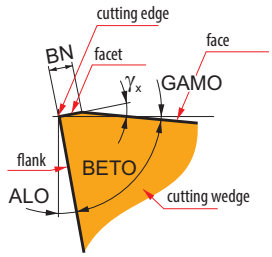
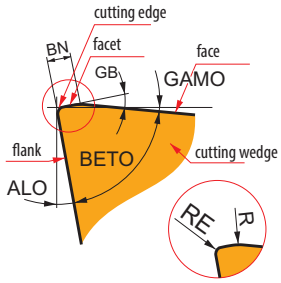
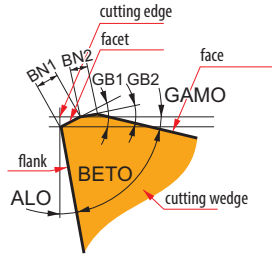
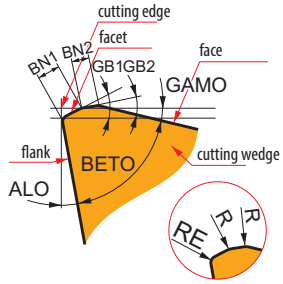
In addition, some tool families offer the option to choose between even and uneven tooth pitch. Using a tool with an uneven tooth pitch interferes with harmonic oscillation and, as a result, helps improve stability and reduce the risk of vibration. That means you should choose uneven tooth pitch if you anticipate a risk of vibration, i.e. primarily when working at higher overhang or when machining at high radial depth of cut and under conditions which are not entirely stable.



CHOICE OF CUTTING INSERT

When choosing an indexable insert, please also pay attention to its microgeometry, which is indicated by icons directly in the catalogue section. Below is an overview of the types of cutting edges you can find on our inserts.

Overview of Cutting Edge Designs

F		**Sharp cutting edges** – recommended for inserts designed for use with milling cutters for Al alloys. Sharp cutting wedges result in minimal deformation of the cut layer, reduced build-up on the edge and a lower cutting force requirement. However, the strength of the cutting wedge is lower compared to other types.
E		**Rounded cutting edges** – a slight rounding of the wedge with the aim of eliminating micro-imperfections on its surface. Rectifying the wedge at a certain very low radius (*RE*) improves the cutting edge's resistance to mechanical damage, i.e. brittle fracture or so-called micro-crumbling. This modification is currently used on all indexable inserts without a facet (F modification previously), which are used for milling almost all types of material.
T		**Faceted cutting edges** – a facet with width of x and angle of γ_x increases the angle γ_n of the cutting wedge in the immediate vicinity of the cutting edge, thus also increasing its strength, i.e. its resistance to mechanical load, brittle damage or fracture. Currently used only rarely, as it has been replaced by the S modification.
S		**Rounded edges with facet** – compared to the T modification, the insert has undergone rectification which results in rounding of the cutting edge and thickening by a facet. This modification increases the resistance of the wedge against mechanical damage to a greater degree.
K		**Edges with double facet** – double facet with widths of x_1 x_2 and angle of γ_{x1} γ_{x2} further increases the strength of the edge, i.e. its resistance to mechanical stress, brittle damage or fracture. Rarely used for milling inserts, only for the most difficult cuts.
P		**Rounded edges with double facet** – compared to the K modification, the insert has undergone rectification which results in rounding of the cutting edge and thickening by a double facet. This modification provides the wedge with maximum resistance to mechanical damage.

CORRECTION FACTORS

Correction factors for specific type of cutter and operation C_{VcO}

X.V			
Face mills with *KAPR* 45° – 60° and negative inserts (SON06C, SHN06C, SHN09C)	1.15	1.00	0.85
Face mills with *KAPR* 45° and positive inserts (SSD13F, SSE09, SSN12Z, FSB22X, SOD05, SOD06D, SOE06Z)	1.15	1.00	0.85
Shoulder mills with *KAPR* 90° (SAD07/10/16, STN10/16, SLN12/16, SAP10/16, SS009, SSD12)	1.10	1.00	0.90
Copy face mills (SRC10 – SRC20, SRD05 – SRD16, …)	1.10	1.00	0.90
Copy end mills (K2-PPH, K2-SLC, K2-SRC, K3-CXP…)	1.10	1.00	0.90
Disc mills (S90CN(XN), S90SN…)	1.10	1.00	0.90
Shoulder mills with extended flute J(T)-CSD12X, J(T)-SAD11E, J(T)-SAD16E…)	1.25	1.00	0.80
Face mills for heavy duty (FSB22X, SPN13..)	1.30	1.00	0.85
Shoulder mills for heavy duty (FTB27X..)	1.25	1.00	0.85

Correction factors for required durability C_{VcT}

minutes	15	20	30	45	60	90	120
General machining operations (fine finishing up to roughing)	1.23	1.13	1.00	0.89	0.81	0.72	–
Heavy machining operations (heavy roughing)	–	–	1.23	1.13	1.00	0.89	0.81

Additional correction factors C_{VcA}

Machining environment	C_{VcA}
Condition of the work-material (hard skin due to forging or casting)	0.70
Unstable machining conditions	0.85
Common machining conditions	1.00
Stable machining conditions	1.20

Correction factors for cutting speed when face and shoulder milling with < 100 % radial immersion C_{VcRCT}

a_e/DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
X.V	**1.48**	**1.35**	**1.27**	**1.22**	**1.19**	**1.16**	1.11	1.08	1.05	1.03	**1.00**	**1.00**	**1.00**	**1.00**

Correction factors to compensate for chip-thinning when face and shoulder milling with < 100 % radial immersion Cf_{zRCT}

a_e/DC	5 %	10 %	15 %	20 %	25 %	30 %	40 %	50 %	60 %	70 %	75 %	80 %	90 %	100 %
⇨ x.f	**2.20**	**1.60**	**1.35**	**1.20**	**1.10**	0.95	0.85	0.75	0.85	0.95	**1.00**	**1.00**	**1.00**	**1.00**
⇨ x.f	0.64	0.64	0.64	0.64	0.64	0.65	0.65	0.67	**0.68**	**0.71**	**0.72**	**0.74**	**0.79**	**1.00**

Resulting corrected cutting speed *vcc*

$v_{cc} = v_c \times kvG \times C_{VcO} \times CvcT \times C_{VcA} \times C_{VcRCT} \times Cf_{zRCT}$

k_{vG} – coefficient of used material

v_c – starting speed from catalogue page

FORMLER

Værdi	Enhed	Formel
Antal omdrejninger	(omdr/min)	$n = \frac{v_c \times 1000}{DC \times \pi}$
Skærehastighed	(m/min)	$v_c = \frac{\pi \times DC \times n}{1000}$
Tilspænding pr. omdrejning	(mm/omdrv)	$f_{rev} = \frac{f_{min}}{n} = f_z \times z$
Tilspænding pr. minut (tilspændingshastighed)	(mm/min)	$f_{min} = v_f = f_{rev} \times n = f_z \times z \times n$
Tilspænding pr. tand	(mm/tand)	$f_z = \frac{f_{rev}}{z} = \frac{f_{min}}{n \times z}$
Spåntværsnit	(mm^2)	$A = f_z \times a_p$
Spåntykkelse (for vendeskær med lige skær)	(mm)	$h = f_z \times \sin KAPR$
Spåntykkelse (for rundt vendeskær)	(mm)	$h = f_z \times \sqrt{\frac{a_p}{INSD}}$
Spånvolumen	(cm^3/min)	$Q = \frac{a_p \times a_e \times f_{min}}{1000}$
Strømforbrug	(kW)	$P_c = \frac{a_p \times a_e \times f_{min}}{60 \times 10^6 \times \eta} \times k_c \times k_\gamma$
Omtrentligt strømforbrug	(kW)	$P_c = \frac{a_p \times a_e \times f_{min}}{x}$

Bemærkning:

	Antal	Enhed
n	Antal omdrejninger	(omdr/min)
DC	Diameter (for værktøj eller arbejdsemne)	(mm)
v_c	Skærehastighed	(m/min)
f_{rev}	Tilspænding pr. omdrejning	(mm/omdr)
A	Spåntværsnit	(mm^2)
a_p	Aksial skæredybde (skæredybde)	(mm)
a_e	Radial skæredybde (skærebredde)	(mm)
$KAPR$	Hovedindstillingsvinkel for skær	(°)
f_{min}	Tilspænding pr. minut (sommetider kaldet tilspændingshastighed)	(mm/min)
f_z	Tilspænding pr. tand	(mm/tand)
z	Antal tænder	(-)
$INSD$	Diameter for vendeskær	(mm)

	Antal	Enhed
h	Spåntykkelse	(mm)
Q	Spånvolumen pr. minut	(cm^3/min)
P_c	Strømforbrug	(kW)
k_c	Skærekraft pr. mm^2	(MPa)
k_γ	Koefficient for vinkelpåvirkning γ_0	(°)
η	Maskineffektivitet vanligvis $\eta = 0.75$	(-)
x	Koefficient for påvirkning af arbejdsemnemateriale	(-)

Materiale	Stål	Støbejern	Al
Koefficient x	24 000	30 000	120 000

ANBEFALET MOMENT FOR SPÆNDESKRUER

Spændeskrue	Moment	Gevind	Længde
	(Nm)	–	(mm)
US 20	0.9	M 2	3
US 2205-T07P	0.9	M 2.2	5
US 25	1.2	M 2.5	5
US 2505-T08P	1.2	M 2.5	5
US 2506-T07P	1.2	M 2.5	6
US 3006-T09P	2	M 3	6
US 3007-T09P	2	M 3	7
US 3504-T09P	3	M 3.5	4
US 3507-T15	3	M 3.5	7
US 3509-T15	3	M 3.5	9
US 3511-T15	3	M 3.5	11
US 3512-T15P	3	M 3.5	12
US 4008-T15P	3.5	M 4	8
US 4011-T15P	3.5	M 4	11
US 4511-T20	5	M 4.5	11
US 5012-T15P	5	M 5	12
US 70	5	M 4	5
US 71	5	M 4	7
US 72	5	M 4	9
US 73	5	M 4	11
CS 3007-T08P	1.2	M 3	7
CS 4008-T15P	3	M 4	8
CS 42506-T07P	1	M 2.5	6
CS 43008-T08P	1.2	M 3	8
CS 43509-T10P	2	M 3.5	9
CS 44013-T15P	3	M 4	13
CS 45016-T20P	5	M 5	16
CS 46020-T25P	7.5	M 6	20
CS 48025-T40P	15	M 8	25
CS 5009-T20P	5	M 5	9
CS 5013-T20P	5	M 5	13
CS 5015-T20P	5	M 5	15
CS 6020-T20P	7.5	M 6	20
CS 8025-T30P	15	M 8	25
US 2505-T07P	1.2	M 2.5	5
US 2506-T07P	1.2	M 2.5	6
US 3007-T09P	2	M 3	7
US 3505-T09P	3	M 3.5	5
US 4011A-T15P	3.5	M 4	11
US 4011-T15P	3.5	M 4	11
US 44010-T15P	3.5	M 4	10
US 44012-T15P	3.5	M 4	12
US 45011-T20P	5	M 5	11
US 45012-T20P	5	M 5	12
US 5011-T20P	5	M 5	11
US 5018-T20P	5	M 5	18
US 52506-T07P	0.8	M 2.5	6
US 54511-T15P	5	M 4.5	11
US 62003A-T06P	0.6	M 2	3
US 62004A-T06P	0.6	M 2	4
US 62004-T06P	0.6	M 2	4
US 62505-T07P	1.2	M 2.5	5
US 62506-T07P	1.2	M 2.5	6
US 62506-T08P	1.2	M 2.5	6
US 62508-T08P	1.2	M 2.5	7
US 63009-T09P	1.2	M 3	9
US 63509-T15P	3	M 3.5	10
US 63510-T10P	2	M 3.5	9
US 63511D-T15P	3	M 3.5	11
US 63513-T15P	3	M 3.5	12
US 64014-T15P	3.5	M 4	14
US 65013-T20	5	M 5	13
US 65014-T20P	5	M 5	14
US 65017-T20P	5	M 5	17
US 66015-T25P	7.5	M 6	15
US 68020-T30P	15	M 8	20
US 68026-T30P	15	M 8	26
US 74016-T15P	3.5	M 4	16

Tilspændingsmoment for skruetrækkere

Tilspænd-ingsgreb	Tilspændingsmoment (Nm)	Spændeskruegevind
MR-0.8-2.0 Vario	0.5 – 2.0	M 2 – M 3
MR-1.0-5.0 Vario	0.8 – 5.0	M 2.5 – M 5
MR-0.9 fix	0.9	M 2
MR-2.0 fix	2.0	M 3
MR-3.0 fix	3.0	M 3.5
MR-3.5 fix	3.5	M 4
MR-5.0 fix	5.0	M 5

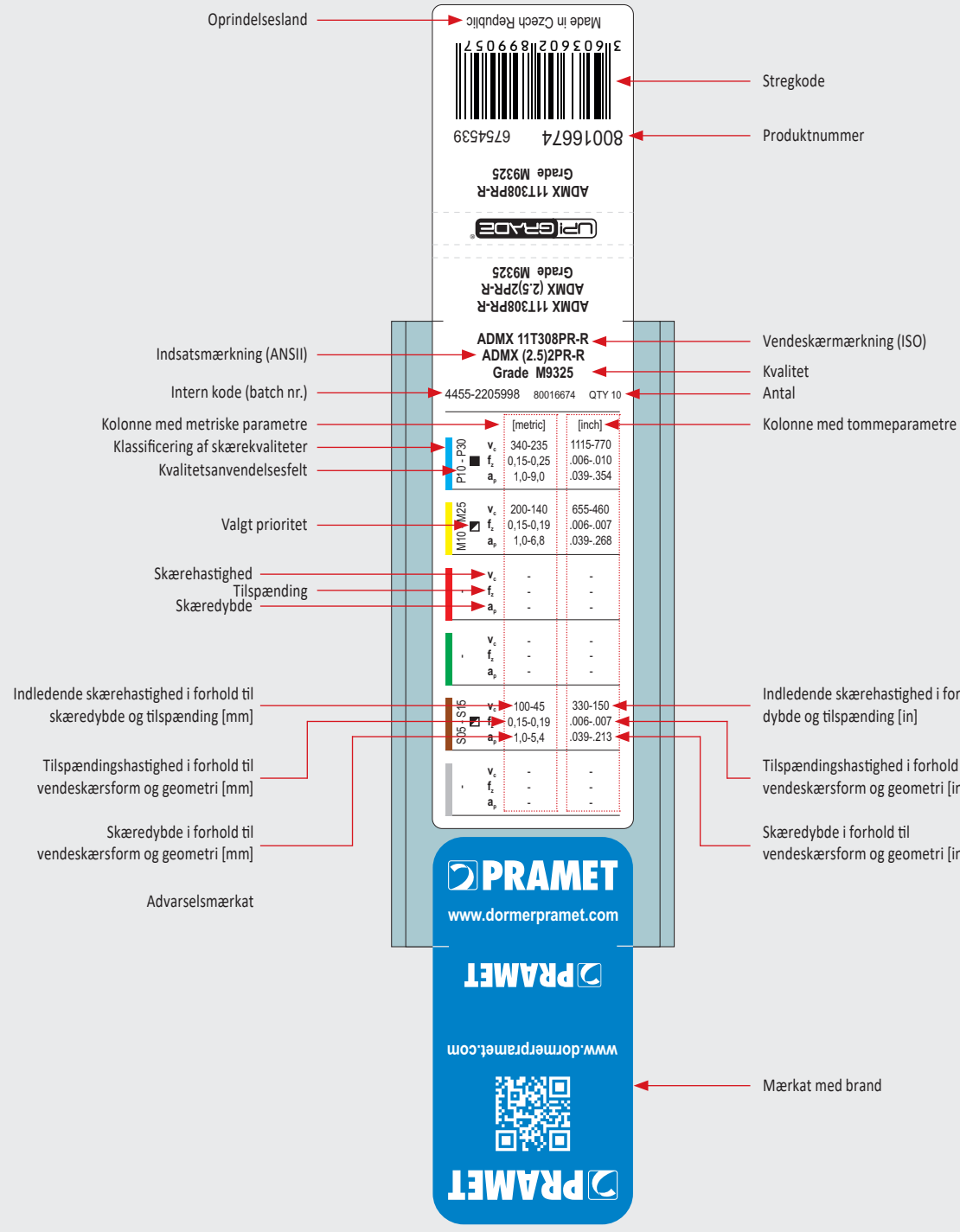
Udskiftelige skafter

Udskiftelige skafter
D-T6
D-T6P
D-T7
D-T7P
D-T8
D-T8P
D-T9
D-T9P
D-T15
D-T15P
D-T20
D-T20P

Skruesmøring

Indsatsspændeskruer udsættes for høj varmebelastning. Det anbefales, at alle skruer smøres med et middel af høj kvalitet som f. eks. MOLYCOTE 1000.

TEKNISKE OPLYSNINGER PÅ VENDESKÆRSÆSKE



WMG (WORK MATERIAL GROUP)

ISO group		WMG (Work Material Group)			Hardness (HB or HRC)	Ultimate Tensile Strength (MPa)	Correction factor *kvG*
P	P1	P1.1	Free machining steel (carbon steels with increased machinability)	Sulfurized	< 240 HB	≤ 830	1.33
		P1.2		Sulfurized and phosphorized	< 180 HB	≤ 620	1.49
		P1.3		Sulfurized/phosphorized and leaded	< 180 HB	≤ 620	1.53
	P2	P2.1	Plain carbon steel (steels comprised of mainly iron and carbon)	Containing <0.25 % C	< 180 HB	≤ 620	1.14
		P2.2		Containing <0.55 % C	< 240 HB	≤ 830	1.00
		P2.3		Containing >0.55 % C	< 300 HB	≤ 1030	0.89
	P3	P3.1	Alloy steel (carbon steels with an alloying content ≤ 10%)	Annealed	< 180 HB	≤ 620	0.92
		P3.2		Hardened and tempered	180 – 260 HB	> 620 ≤ 900	0.74
		P3.3			260 – 360 HB	> 900 ≤ 1240	0.63
	P4	P4.1	Tool steel (special alloy steel for tools, dies and molds)	Annealed	< 26 HRC	≤ 900	0.55
		P4.2		Hardened and tempered	26 – 39 HRC	> 900 ≤ 1240	0.47
		P4.3			39 – 45 HRC	> 1240 ≤ 1450	0.38
M	M1	M1.1	Ferritic stainless steel (straight chromium non-hardenable alloys)		< 160 HB	≤ 520	1.22
		M1.2			160 – 220 HB	> 520 ≤ 700	1.03
	M2	M2.1	Martensitic stainless steel (straight chromium hardenable alloys)	Annealed	< 200 HB	≤ 670	1.08
		M2.2		Quenched and tempered	200 – 280 HB	> 670 ≤ 950	0.89
		M2.3		Precipitation-hardened	280 – 380 HB	> 950 ≤ 1300	0.75
	M3	M3.1	Austenitic stainless steel (chromium-nickel and chromium-nickel-manganese alloys)		< 200 HB	≤ 750	1.00
		M3.2			200 – 260 HB	> 750 ≤ 870	0.86
		M3.3			260 – 300 HB	> 870 ≤ 1040	0.77
	M4	M4.1	Austenitic-ferritic (DUPLEX) or super-austenitic stainless steel		< 300 HB	≤ 990	0.75
		M4.2	Precipitation hardening austenitic stainless steel		300 – 380 HB	≤ 1320	0.64
K	K1	K1.1	Gray iron or Automotive Gray iron (GG) (iron-carbon castings with a lamellar graphite microstructure)	Ferritic or ferritic-pearlitic	< 180 HB	≤ 190	1.35
		K1.2		Ferritic-pearlictic or pearlitic	180 – 240 HB	> 190 ≤ 310	1.00
		K1.3		Pearlitic	240 – 280 HB	> 310 ≤ 390	0.75
	K2	K2.1	Malleable iron (GTS/GTW) (iron-carbon castings with a graphite-free microstructure)	Ferritic	< 160 HB	≤ 400	1.39
		K2.2		Ferritic or pearlitic	160 – 200 HB	> 400 ≤ 550	1.13
		K2.3		Pearlitic	200 – 240 HB	> 550 ≤ 660	0.90
	K3	K3.1	Ductile iron (GGG) (iron-carbon castings with a nodular graphite microstructure)	Ferritic	< 180 HB	≤ 560	1.23
		K3.2		Ferritic or pearlitic	180 – 220 HB	> 560 ≤ 680	0.94
		K3.3		Pearlitic	220 – 260 HB	> 680 ≤ 800	0.76
	K4	K4.1	Austenitic gray iron (ASTM A436) (iron-carbon alloy castings with an austenitic lamellar graphite microstructure)		< 180 HB	≤ 190	1.14
		K4.2	Austenitic ductile iron (ASTM A439 or ASTM A571) (iron-carbon alloy castings with an austenitic nodular graphite microstructure)		< 240 HB	≤ 740	0.86
		K4.3	Austempered ductile iron (ASTM A897) (iron-carbon alloy castings with an ausferrite microstructure)		< 280 HB	> 840 ≤ 980	0.63
		K4.4			280 – 320 HB	> 980 ≤ 1130	0.54
		K4.5			320 – 360 HB	> 1130 ≤ 1280	0.45
	K5	K5.1	Compacted graphite iron CGI (ASTM A842) (iron-carbon castings with a vermicular graphite structure)	Ferritic	< 180 HB	≤ 400	1.29
		K5.2		Ferritic-pearlitic	180 – 220 HB	> 400 ≤ 450	0.97
		K5.3		Pearlitic	220 – 260 HB	> 450 ≤ 500	0.75
N	N1	N1.1	Commercially pure wrought aluminium		< 60 HB	≤ 240	1.33
		N1.2	Wrought aluminium alloys	Half hard tempered	60 – 100 HB	> 240 ≤ 400	1.00
		N1.3		Full hard tempered	100 – 150 HB	> 400 ≤ 590	0.67
	N2	N2.1	Cast aluminium alloys		< 75 HB	≤ 240	0.67
		N2.2			75 – 90 HB	> 240 ≤ 270	0.60
		N2.3			90 – 140 HB	> 270 ≤ 440	0.43
	N3	N3.1	Free-cutting copper-alloys materials with excellent machining properties		–	–	0.70
		N3.2	Short-chip copper-alloys with good to moderate machining properties		–	–	0.41
		N3.3	Electrolytic copper and long-chip copper-alloys with moderate to poor machining properties		–	–	0.21
	N4	N4.1	Thermoplastic polymers		–	–	0.70
		N4.2	Thermosetting polymers		–	–	0.27
		N4.3	Reinforced polymers or composites		–	–	0.29
	N5	N5.1	Graphite		–	–	1.00
S	S1	S1.1	Titanium or titanium alloys		< 200 HB	≤ 660	1.94
		S1.2			200 – 280 HB	> 660 ≤ 950	1.72
		S1.3			280 – 360 HB	> 950 ≤ 1200	1.44
	S2	S2.1	Fe-based high-temperature alloys		< 200 HB	≤ 690	1.33
		S2.2			200 – 280 HB	> 690 ≤ 970	1.17
	S3	S3.1	Ni-based high-temperature alloys		< 280 HB	≤ 940	1.00
		S3.2			280 – 360 HB	> 940 ≤ 1200	0.83
	S4	S4.1	Co-based high-temperature alloys		< 240 HB	≤ 800	0.78
		S4.2			240 – 320 HB	> 800 ≤ 1070	0.67
H	H1	H1.1	Chilled cast iron		< 440 HB	–	1.52
	H2	H2.1	Hardened cast iron		< 55 HRC	–	0.90
		H2.2			> 55 HRC	–	0.77
	H3	H3.1	Hardened steel < 55 HRC		< 51 HRC	–	1.00
		H3.2			51 – 55 HRC	–	0.82
	H4	H4.1	Hardened steel > 55 HRC		55 – 59 HRC	–	0.64
		H4.2			> 59 HRC	–	0.54

OMREGNINGSTABEL FOR HÅRDHED

Styrke (MPa)	Hårdhed			
	BRINELL	VICKERS	ROCKWELL	ROCKWELL
R_m	HB	HV	HRB	HRC
285	86	**90**	1190	–
320	95	**100**	56.2	–
350	105	**110**	62.3	–
385	114	**120**	66.7	–
415	124	**130**	71.2	–
450	133	**140**	75.0	–
480	143	**150**	78.7	–
510	152	**160**	81.7	–
545	162	**170**	85.8	–
575	171	**180**	87.1	–
610	181	**190**	89.5	–
640	190	**200**	91.5	–
675	199	**210**	93.5	–
705	209	**220**	95	–
740	219	**230**	96.7	–
770	228	**240**	98.1	–
800	238	**250**	99.5	–
820	242	**255**	–	23.1
850	252	**265**	–	24.8
880	261	**275**	–	26.4
900	266	**280**	–	27.1
930	276	**290**	–	28.5
950	280	**295**	–	29.2
995	295	**310**	–	31.0
1030	304	**320**	–	32.2
1060	314	**330**	–	33.3
1095	323	**340**	–	34.4
1125	333	**350**	–	35.5
1155	342	**360**	–	36.6

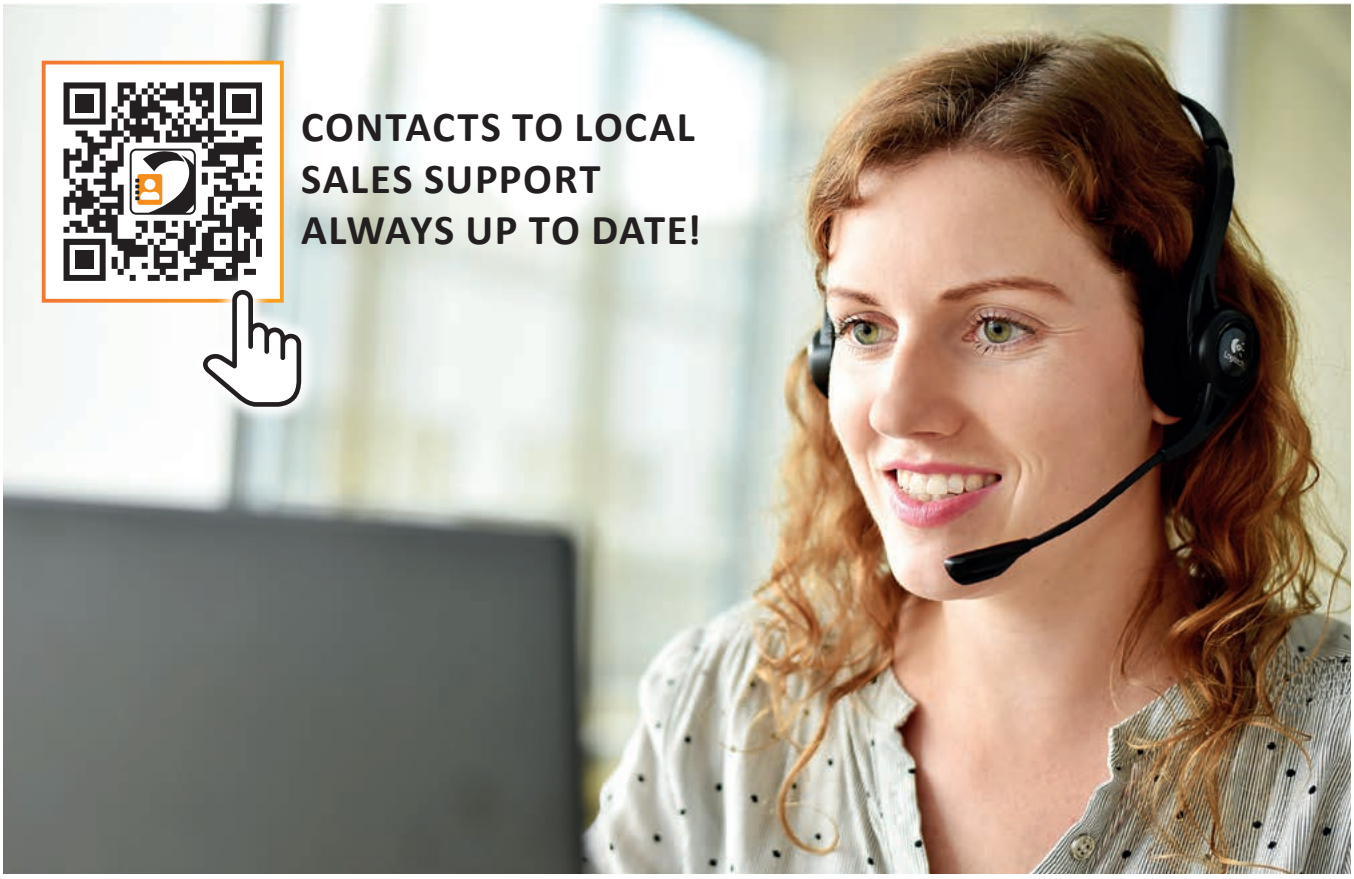
Styrke (MPa)	Hårdhed			
	BRINELL	VICKERS	ROCKWELL	ROCKWELL
R_m	HB	HV	HRB	HRC
1190	352	**370**	–	37.7
1220	361	**380**	–	38.8
1255	371	**390**	–	39.8
1290	380	**400**	–	40.8
1320	390	**410**	–	41.8
1350	399	**420**	–	42.7
1385	409	**430**	–	43.6
1420	418	**440**	–	44.5
1455	428	**450**	–	45.3
1485	437	**460**	–	46.1
1520	447	**470**	–	46.9
1555	456	**480**	–	47.7
1595	466	**490**	–	48.4
1630	475	**500**	–	49.1
1665	485	**510**	–	49.8
1700	494	**520**	–	50.5
1740	504	**530**	–	51.1
1775	513	**540**	–	51.7
1810	523	**550**	–	52.3
1845	532	**560**	–	53.0
1880	542	**570**	–	53.6
1920	551	**580**	–	54.1
1955	561	**590**	–	54.7
1995	570	**600**	–	55.2
2030	580	**610**	–	55.7
2070	589	**620**	–	56.3
2105	599	**630**	–	56.8
2145	608	**640**	–	57.3
2180	618	**650**	–	57.8

SIMPLY RELIABLE

Som en professionel kan du vurdere kvaliteten af dit arbejdet kun ved at studere metalspånen. Metalspånen har en ren og ukompliceret form, der fortæller en historie. Det er derfor, vi bruger dette symbol til at illustrere vores pålidelighed, «**Simply Reliable**».

DORMER PRAMET

www.dormerpramet.com



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