

# Schnittdaten: STRX06004010-PREM

STRX060 04010 VHM-Eckenradiusfräser

Ø4Ø4h5x9x60; Z4; R1 ; Helix 35°/38°; WETS-beschichtet; Freistellung Ø3,8x15

## Umfangfräsen

|   |                                       |                |
|---|---------------------------------------|----------------|
|   | Schnitttiefe                          | ap = 8 mm      |
|   | Schnittbreite                         | ae = 0,6 mm    |
| P | Stahl <750N/mm <sup>2</sup> (20 HRC)  | Vc = 250 m/min |
| P | Stahl <1000N/mm <sup>2</sup> (32 HRC) | Vc = 200 m/min |
| P | Stahl <1400N/mm <sup>2</sup> (44 HRC) | Vc = 180 m/min |
| P | Stahl <1800N/mm <sup>2</sup> (52 HRC) | Vc = 160 m/min |
| M | rostfrei < 700 N/mm <sup>2</sup>      | Vc = 140 m/min |
| M | rostfrei > 700 N/mm <sup>2</sup>      | Vc = 120 m/min |
| P | Stahl - Vorschub pro Zahn             | fz = 0,055 mm  |
| M | rostfrei - Vorschub pro Zahn          | fz = 0,05 mm   |
| K | Gusseisen - Vorschub pro Zahn         | fz = 0,055 mm  |
| K | Gusseisen                             | Vc = 180 m/min |

## Vollnutfräsen

|   |                                       |                |
|---|---------------------------------------|----------------|
|   | Schnitttiefe                          | ap = 4 mm      |
|   | Schnittbreite                         | ae = 4 mm      |
| P | Stahl <750N/mm <sup>2</sup> (20 HRC)  | Vc = 160 m/min |
| P | Stahl <1000N/mm <sup>2</sup> (32 HRC) | Vc = 140 m/min |
| P | Stahl <1400N/mm <sup>2</sup> (44 HRC) | Vc = 130 m/min |
| P | Stahl <1800N/mm <sup>2</sup> (52 HRC) | Vc = 100 m/min |
| M | rostfrei < 700 N/mm <sup>2</sup>      | Vc = 100 m/min |
| M | rostfrei > 700 N/mm <sup>2</sup>      | Vc = 80 m/min  |
| P | Stahl - Vorschub pro Zahn             | fz = 0,028 mm  |
| M | rostfrei - Vorschub pro Zahn          | fz = 0,025 mm  |
| K | Gusseisen - Vorschub pro Zahn         | fz = 0,028 mm  |
| K | Gusseisen                             | Vc = 126 m/min |