

# Schnittdaten: SUH16532004-PREM

SUH165 32004 VHM-Schaftfräser

Ø32Ø32h5x85x165; Z4 ; Helix50°; WECX-beschichtet

## Umfangfräsen

|   |                                       |                |
|---|---------------------------------------|----------------|
|   | Schnitttiefe                          | ap = 44,8 mm   |
|   | Schnittbreite                         | ae = 9,6 mm    |
| P | Stahl <750N/mm <sup>2</sup> (20 HRC)  | Vc = 240 m/min |
| P | Stahl <1000N/mm <sup>2</sup> (32 HRC) | Vc = 190 m/min |
| P | Stahl <1400N/mm <sup>2</sup> (44 HRC) | Vc = 160 m/min |
| P | Stahl <1800N/mm <sup>2</sup> (52 HRC) | Vc = 130 m/min |
| P | Stahl - Vorschub pro Zahn             | fz = 0,18 mm   |
| K | Gusseisen - Vorschub pro Zahn         | fz = 0,18 mm   |
| K | Gusseisen                             | Vc = 171 m/min |

## Vollnutfräsen

|   |                                       |                |
|---|---------------------------------------|----------------|
|   | Schnitttiefe                          | ap = 19,2 mm   |
|   | Schnittbreite                         | ae = 32 mm     |
| P | Stahl <750N/mm <sup>2</sup> (20 HRC)  | Vc = 170 m/min |
| P | Stahl <1000N/mm <sup>2</sup> (32 HRC) | Vc = 150 m/min |
| P | Stahl <1400N/mm <sup>2</sup> (44 HRC) | Vc = 120 m/min |
| P | Stahl <1800N/mm <sup>2</sup> (52 HRC) | Vc = 90 m/min  |
| P | Stahl - Vorschub pro Zahn             | fz = 0,1 mm    |
| K | Gusseisen - Vorschub pro Zahn         | fz = 0,1 mm    |
| K | Gusseisen                             | Vc = 135 m/min |