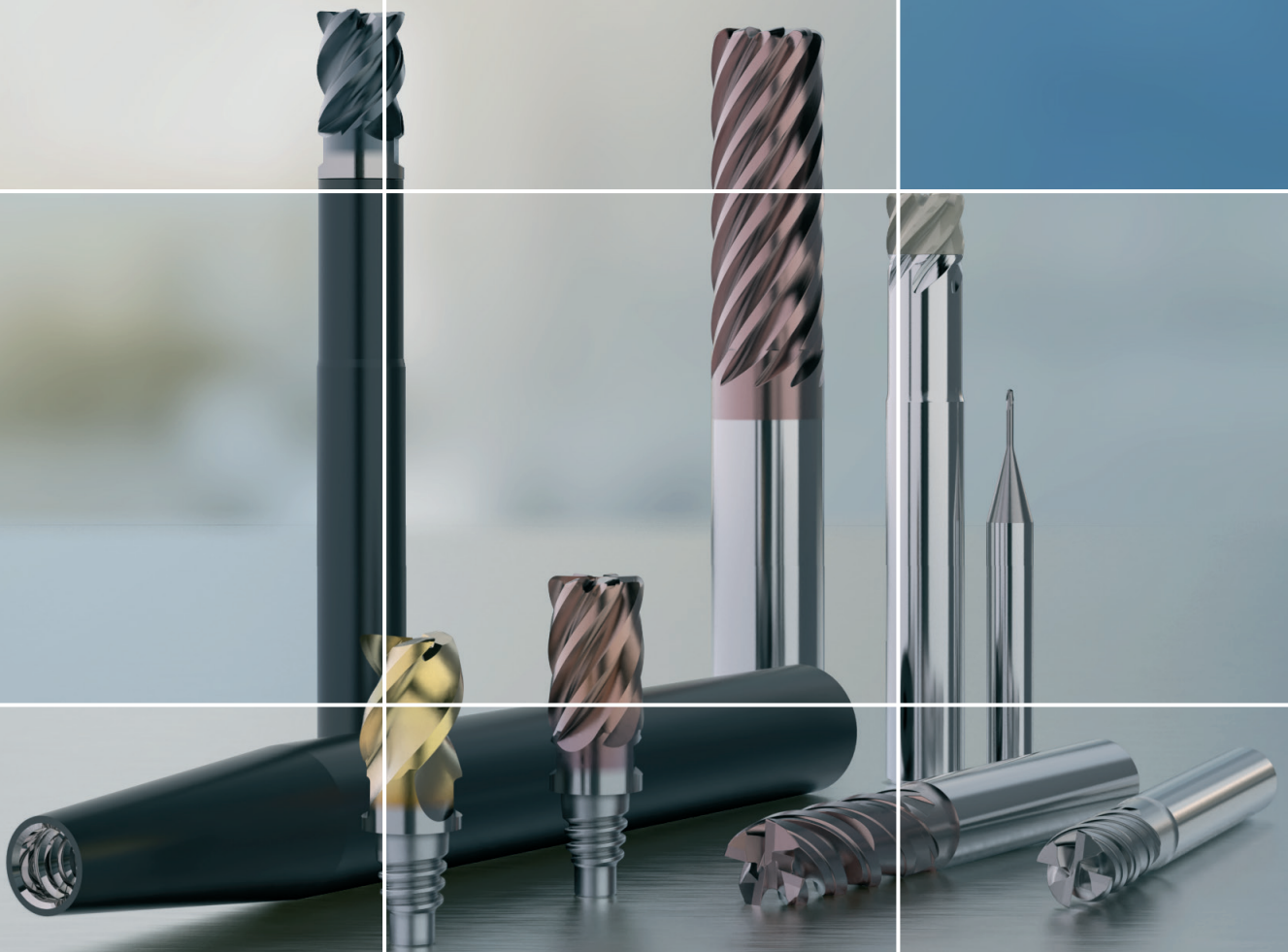


KATALOG &
TECHNISCHER
GUIDE 2023.2



FRÄSEN - VOLLHARTMETALL

>30.000

STANDARDPRODUKTE



>75

LÄNDER



>4.100

ENGAGIERTE MITARBEITER



EXZELLENT ZERSPANUNGS-LÖSUNGEN

Seco ist einer der weltweit führenden Anbieter von effizienten Zerspanungslösungen. Basierend auf umfassendem Know-how und praktischer Erfahrung optimiert Seco gemeinsam mit seinen Kunden die vielfältigen Prozesse in der spanenden Fertigung. Das Angebot umfasst leistungsstarke Präzisionswerkzeuge für alle Technologien sowie ergänzende Service- und Dienstleistungen: vom Lagermanagement über Maschinenausrüstung, digitales Datenmanagement und Webanwendungen bis hin zur Prozessanalyse der gesamten Fertigung.

VOLLHARTMETALLFRÄSER



Jabro Tools bei Lottum, Niederlande, wurde 1976 gegründet und ist seit 2001 eine Tochtergesellschaft von Seco Tools.

Durch kontinuierliche Forschung und permanente Verbesserung des Fertigungsprozesses hat sich Jabro Tools im Laufe der Jahre eine führende Position im Markt erobert.

Die Produkte erfüllen die hohen Anforderungen der High-Tech-Industrie. Seco Jabro fertigt Präzisionswerkzeuge aus Vollhartmetall, in Standard- und in Sonderausführung, für Kunden in den unterschiedlichsten Industriezweigen,

wie z. B.:

- Allgemeiner Maschinenbau
- Werkzeug- und Formenbau
- Luft- und Raumfahrt
- Medizintechnik
- Energieerzeugung
- 3C (Computer, Elektronik (Customer Electronics) und Kommunikation (Communication))

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Übersicht Produktfamilien

SOLID²



Maßstäbe in Leistungsfähigkeit

Die universell einsetzbaren Vollhartmetallfräser sind einfach in der Handhabung und bieten in nahezu allen Werkstoffen ein breites Anwendungsspektrum zu einem hervorragenden Preis-/Leistungsverhältnis.

- Leistungsoptimierte Ausführungen
 - Hochflexibler Einsatz durch Längenvielfalt
 - Typen JS1x - Hochflexible Werkzeuge für alle Bearbeitungen in Stahl, Rostfrei und Guss
 - Typen JS5x - Leistungsoptimierte Universalwerkzeuge für alle Bearbeitungen in Stahl, Rostfrei und Guss. Jabro-Solid² ist verfügbar im Durchmesserbereich von 1 bis 32 mm und in Zoll 1/32 - 1 1/4.
- Jabro-Solid² beinhaltet auch eine Reihe spezieller leistungsfähiger Fräser für dynamisches Fräsen (JS564 und JS565).

Diese Werkzeuge zeigen eine extrem hohe Leistungsfähigkeit bei klar definiertem Werkzeugweg mit konstantem Kontaktbogen, bei hohen Schnittgeschwindigkeiten und gleichzeitig großer Schnitttiefe.

Alle Fräser der JS500-Reihe verfügen über Fasen ($c^{\circ}45^{\circ}$) mit den folgenden Toleranzen: $c = DC \pm 3 = +0,01$, $3 < DC \leq 6 = +0,02$, $6 < DC \leq 10 = +0,03$, $10 < DC \leq 14 = +0,04$, $14 < DC \leq 18 = +0,05$, $18 < DC \leq 24 = +0,06$,
Alle Jabro-Solid² Produktbezeichnungen sind mit „JS“ gekennzeichnet.

Einen Überblick über alle Produkte der JS²-Reihe finden Sie auf Seite 9.

HSM/TORNADO



Diese Werkzeuge zeichnen sich aus durch hohe Maßtoleranz, kurze Schneiden, Reduzierung des Außendurchmessers und größere Kerndurchmesser für mehr Steifigkeit. Sie eignen sich speziell für Hochgeschwindigkeitsbearbeitung.

Einen Überblick über alle Produkte der HSM/TORNADO-Reihe finden Sie auf Seite 9.

HPM



Optimierte Schaftfräser sind speziell für Erstausrüster und Hauptlieferanten gedacht, die Einzelteile in großen Chargen produzieren und hohe Anforderungen an optimale Prozesse mit kurzen Zykluszeiten und niedrigen Stückkosten haben.

Einen Überblick über alle Produkte der HPM-Reihe finden Sie auf Seite 10.

HFM



Kosteneffizienter Einsatz

Ein Kompletprogramm an Vollhartmetallfräsern für die Bearbeitung mit hohen Vorschubgeschwindigkeiten.

Auch zum Tauchfräsen bestens geeignet.

- Durchmesserbereich von 1 bis 12 mm
 - Geringe Vibrationsneigung auch bei großen Werkzeugauskragungen aufgrund geringer radialer Schnittkräfte
- Hochvorschubwerkzeuge leisten hervorragende Arbeit auch beim Tauchfräsen.

Einen Überblick über alle Produkte für die Hochvorschubbearbeitung finden Sie auf Seite 10.

Übersicht Produktfamilien

MINI



Die Vollhartmetallfräser für die Mikrozerspannung von Seco umfassen Eckfräser und Kugelkopffräser mit kleinem Durchmesser. Universal-Werkzeuge eignen sich für die meisten Werkstoff-Gruppen. Spezifische Werkzeuge eignen sich für Graphite und gehärteten Stahl. Alle Werkzeuge sind mit einer dünnen Beschichtung für optimale Leistung versehen.

Einen Überblick über alle Produkte der MINI-Reihe finden Sie auf Seite 10.

DIAMOND



Verfügbar in einer großen Anzahl an Geometrien in einem großen Durchmesserbereich mit bestmöglichem Substrat für perfekte Adhäsion der Diamantbeschichtung. Insgesamt steigern diese Schafffräser erheblich die Produktivität und senken die Werkzeugkosten durch weniger Werkzeugwechsel und hohe Vorschübe bei der Bearbeitung von Präzisionsteilen.

Einen Überblick über alle diamantbeschichteten Produkte finden Sie auf Seite 10.

COMPOSITE



Das Produktprogramm besteht aus diamantbeschichteten, unbeschichteten und PKD-Fräsern mit verschiedenen Geometrien sowie Fräser mit eingelöteter PKD-Spitze. Die Werkzeuge sind speziell für schwierige Zerspanungsbedingungen in anspruchsvollen Werkstoffen optimiert.

Einen Überblick über alle Produkte der Composite-Reihe (JC) finden Sie auf Seite 10.

VHM



Beinhaltet universelle beschichtete und unbeschichtete Schafffräser speziell zur Zerspannung von Kunststoffen und Aluminium, als Fasfräser oder konisch. Die Produkte bestehen aus hochqualitativen Sorten und Beschichtungen für berechenbare Standzeiten.

Einen Überblick über alle Vollhartmetallfräser finden Sie auf Seite 11.

Übersicht Produktfamilien

CERAMIC



Zum schnellen Zerspanen der härtesten hitzeresistenten Superlegierungen (HRSA) brauchen Sie ein Werkzeug, das genauso robust und fortschrittlich ist wie die Werkstoffe selbst. Optimieren Sie Ihre Prozesse und zerspanen Sie Ihre HRSA-Werkstücke deutlich schneller mit diesen leistungsstarken Keramik-Vollhartmetallfräsern. Einen Überblick über alle CERAMIC-Produkte finden Sie auf Seite 11.

HSCO



Kobalthaltiger Schnellarbeitsstahl ist eine Premiumsorte für mehr Leistung im Vergleich zu herkömmlichen Schnellarbeitsstählen. Dank mehr Härte weisen diese HSS_Fräser eine längere Standzeit in abrasiven, wärmebeständigen und exotischen Werkstoffen auf. Das Spanntdesign, die verschleißfeste Beschichtung und optimierte Kühlschmiermittelkanäle sorgen für hohe Qualität und geringere Werkzeugkosten in diesen anspruchsvollen Werkstoffen. Einen Überblick über alle HSS-CO-Produkte finden Sie auf Seite 11.

X-Heads





Mit dem Wechselkopfsystem von Seco kann man schnell und einfach zwischen verschiedenen Vollhartmetall-Fräskopfgeometrien wechseln, um alle Fräsvorgänge zu optimieren und gleichzeitig die Herstellungskosten und den Werkzeugbestand zu reduzieren. X-Head-Schaftfräser werden für eine noch größere Vielseitigkeit auf einer Vielzahl von verfügbaren Schaftlängen montiert, mit langen Ausführungen. Der Wechsel von X-Head Köpfen erfordert nur eine einfache Drehung eines Schraubenschlüssels, wobei der Schaft in der Maschine verbleiben kann. Dank einer sicheren und zuverlässigen Verbindung, die eine Wechselgenauigkeit von 50 Mikrometern ermöglicht, müssen die Werkzeuglängen nicht mehr neu eingemessen werden. Einen Überblick über alle Produkte der X-Head-Reihe (austauschbare Köpfe) finden Sie auf Seite XX.

Übersicht Produktfamilien

| Produktfamilie | Technologie | Produkt | 1xx | 4xx | 5xx | 6xx | 7xx | 8xx | 9xx |
|---|---------------------------------|---------|-----|-----|-----|-----|-----|-----|-----|
| Jabro-Solid ² | Allgemeine Bearbeitung | JS | | ■ | ■ | | ■ | | |
| Jabro - HPM | Hochleistungsbearbeitung | JHP | ■ | ■ | | | ■ | | ■ |
| Jabro - HFM | Hochvorschubbearbeitung | JHF | ■ | | | | | | ■ |
| Jabro - Mini | Mikrofräsen | JM | ■ | ■ | ■ | ■ | | | ■ |
| Jabro - HSM/Tornado | Hochgeschwindigkeitsbearbeitung | JH | ■ | ■ | | | ■ | | ■ |
| Jabro - Ceramic | Hochleistungsbearbeitung | JCG | | | | | ■ | | |
| Jabro - Diamond | Graphitbearbeitung | JD | | | | ■ | | | |
| Jabro - Composite | Composite-Bearbeitung | JC, JPD | | | | | | ■ | |
| Jabro - VHM | Allgemeine Bearbeitung | J | | ■ | | | | | ■ |
| Jabro - HSS-E | Allgemeine Bearbeitung | JCO | | | | | ■ | | |
| X-Heads - Solid ² | Hochleistungsbearbeitung | XS | | ■ | ■ | | ■ | | |
| X-Heads - HFM | Hochvorschubbearbeitung | XHF | | | ■ | | ■ | | |
| X-Heads - HSM/Tornado | Hochgeschwindigkeitsbearbeitung | XH | | | ■ | | ■ | | |
| X-Heads - VHM | Allgemeine Bearbeitung | XV | | | ■ | | ■ | | |
| | | | | | | | | | |
| SMG | | | | | | | | | |
| P1-8 | | | | | ■ | | | | ■ |
| P11-12 | | | | | ■ | | | | ■ |
| M1-3 | | | | | ■ | | ■ | | |
| M4-5 | | | | | ■ | | ■ | | |
| K1-7 | | | | | ■ | | | | ■ |
| S1-3 | | | | | ■ | | ■ | | |
| S11-13 | | | | | ■ | | ■ | | |
| H | | | ■ | | ■ | | | | |
| N1 | | | | ■ | ■ | | | | |
| N2-3 | | | | ■ | ■ | | | | |
| N11 | | | | ■ | ■ | | | | |
| TS | | | | ■ | | | | ■ | |
| TP | | | | ■ | | | | ■ | |
| GR | | | | | | ■ | | | |
| Weitere Informationen zu SMG (Seco Werkstoff-Gruppe), siehe Seite 728 | | | | | | | | | |

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|---|----------|----------------|--------|------|--------|------|------|------|----|------|-----|------|--------|-------|-----|-------|-----|-----|-------|-----|-----------|----|---|
|  | 36 | SOLID² | JSE512 | ● | ○ | ● | ○ | ● | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 40 | | JSE513 | ● | ○ | ● | ○ | ● | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 46 | | JSE514 | ● | ○ | ● | ○ | ● | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 116 | | JSB512 | ● | ○ | ● | ○ | ● | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 56 | | JS553 | ● | ○ | ● | ○ | ● | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 76 | | JS554 | ● | ○ | ● | ○ | ● | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 330 | | JS412 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 333 | | JS413 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 336 | | JS452 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 341 | | JS453 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 109 | | JS520 | ● | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 113 | | JS522 | ● | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 118 | | JS532 | ● | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 122 | | JS533 | ● | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 126 | | JS534 | ● | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 130 | | JS506 | ● | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 134 | | JS509 | ● | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 101 | | JS564 | ● | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 105 | | JS565 | ● | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 248 | | JS720 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 261 | | JS730 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 220 | | JS754 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
| | 237 | | JS755 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ |
|  | 350 | HSM/TORNADO | JH40 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | | |
| | 207, 390 | | JH112 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 380 | | JH120 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 382 | | JH130 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 202, 387 | | JH142 | ● | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 393 | | JH150 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 395 | | JH160 | ● | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 357 | | JH410 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 353 | | JH421 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 359 | | JH440 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 361 | | JH450 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 363 | | JH460 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 304 | | JH710 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 314 | | JHB720 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 316 | | JH721 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 318 | | JH722 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 318 | | JH724 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 318 | | JH726 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 308 | | JH730 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 292 | | JH734 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 294 | | JH736 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 302 | | JH740 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 296 | | JH744 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 298 | | JH746 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 300 | | JH770 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 312 | | JH780 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| | 306 | | JH790 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | |
| 138 | JH910 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | | | |
| 142, 384 | JH930 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | | | |
| 144, 205 | JHB970 | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | ○ | | | ○ | | | ○ | | | |







● Erste Wahl, ○ Alternative

Zusammenfassung

| | Seite | Produktfamilie | | P1-8 | P11-12 | M1-3 | M4-5 | K1-7 | N1 | N2-3 | N11 | S1-3 | S11-13 | H3-31 | TS1 | TS2-3 | TP1 | TP2-3 | TS2/TP2+N1 | TS2/TP2+S12 | Honeycomb | GR | | |
|-----|------------|----------------|----------------|------|--------|------|------|------|----|------|-----|------|--------|-------|-----|-------|-----|-------|------------|-------------|-----------|----|---|--|
| | 374 | HPM | JHP170 | | | | | | | | | | | • | | | | | | | | | | |
| | 265 | | JHP751 | | | | | | | | | | • | • | | | | | | | | | | |
| | 268 | | JHP760 | | | • | • | | | | | | | | | | | | | | | | | |
| | 272 | | JHP770 | | | | | | | | | | | • | | | | | | | | | | |
| | 279 | | JHP780 | | | | | | | | | | | • | | | | | | | | | | |
| | 268 | | JHP794 | | | | • | • | | | | | | | | | | | | | | | | |
| | 346 | | JHP490 | | | | | | | • | • | | | | | | | | | | | | | |
| | 198 | | JHP951 | | • | ○ | | | | | | | | | | | | | | | | | | |
| | 192 | | JHP993 | | • | ○ | | | | • | | | | | | | | | | | | | | |
| | 310 | | JHP994 | | | | | | | | | | | | • | • | | | | | | | | |
| | 377 | HFM | JHF181 | ○ | ○ | | | • | | | | | • | • | • | | | | | | | | | |
| | 377 | | SHF712 | | | | | | | | | | | | | | | | | | | | | |
| | 146 | | JHF980 | • | ○ | • | • | • | | | | | | • | • | ○ | | | | | | | | |
| | 404 | MINI | JMB112 | | | | | | | | | | | | • | | | | | | | | | |
| | 397 | | JME142 | | | | | | | | | | | | | • | | | | | | | | |
| | 402 | | JME144 | | | | | | | | | | | | | • | | | | | | | | |
| | 367 | | JM403/404/406 | | | | | | | • | • | | | | | | | | | | | | | |
| | 369 | | JM413/416 | | | | | | | • | • | • | | | | • | | • | | | | | | |
| | 369 | | SMB413/414/416 | | | | | | | • | • | | | | | • | | • | | | | | | |
| | 180 | | JMB542 | • | • | • | • | | | ○ | ○ | ○ | | • | ○ | | | | | | | | ○ | |
| | 183 | | JMB562 | • | • | • | • | | | ○ | ○ | ○ | | • | ○ | | | | | | | | ○ | |
| | 187 | | JMB563 | • | • | • | • | | | ○ | ○ | ○ | | • | ○ | | | | | | | | ○ | |
| | 170 | | JME542 | • | • | • | • | | | ○ | ○ | ○ | | • | ○ | | | | | | | | ○ | |
| | 173 | | JME562 | • | • | • | • | | | ○ | ○ | ○ | | • | ○ | | | | | | | | ○ | |
| | 177 | | JME564 | • | • | • | • | | | ○ | ○ | ○ | | • | ○ | | | | | | | | ○ | |
| | 177 | | SMB713/714/416 | | | | | | | | | | | | | | | | | | | | | |
| | 177 | | JME714/716 | | | | | | | | | | | • | • | | | | | | | | | |
| | 476 | | JMB642/JMB662 | | | | | | | | | | | | | | | | | | | | • | |
| | 476 | | JMB662 | | | | | | | | | | | | | | | | | | | | • | |
| | 474 | | JME642 | | | | | | | | | | | | | | | | | | | | • | |
| 474 | SMB614/616 | | | | | | | | | | | | | | | | | | | | • | | | |
| | 412 | COMPOSITE | JC845 | | | | | | | | | | | | • | | • | | | | | | | |
| | 414 | | JC850 | | | | | | | | | | | | | • | | • | | | | | | |
| | 416 | | JC860 | | | | | | | | | | | | | • | | • | | | | • | | |
| | 418 | | JC870 | | | | | | | | | | | | | • | | • | | | | • | | |
| | 424 | | JC871 | | | | | | | | | | | | | • | | • | | | | • | | |
| | 430 | | JC875 | | | | | | | | | | | | | • | | • | | | | • | | |
| | 434 | | JC876 | | | | | | | | | | | | | • | | • | | | | • | | |
| | 438 | | JC877 | | | | | | | | | | | | | • | | • | | | | • | | |
| | 442 | | JC880 | | | | | | | | | | | | | • | | • | | | | • | | |
| | 444 | | JC885 | | | | | | | | | | | | | • | | • | | | | • | | |
| | 446 | | JC898 | | | | | | | | | | | | | | | | • | • | | | | |
| | 448 | | JC899 | | | | | | | | | | | | | | | | | • | • | | | |
| | 451 | | JPD850 | | | | | | | | | | | | | | • | | • | | | | | |
| | 453 | | JPD880 | | | | | | | | | | | | | | • | | • | | | | | |
| | 455 | DIAMOND | JPD890 | | | | | | | | | | | | • | | • | | | | | | | |
| | 464 | | JD620 | | | | | | | | | | | | | | | | | | | • | | |
| | 466 | | JD630 | | | | | | | | | | | | | | | | | | | | • | |
| | 468 | | JD640 | | | | | | | | | | | | | | | | | | | | • | |
| | 470 | | JD660 | | | | | | | | | | | | | | | | | | | | • | |

• Erste Wahl, ○ Alternative

Zusammenfassung

| | Seite | Produktfamilie | | P1-8 | P11-12 | M1-3 | M4-5 | K1-7 | N1 | N2-3 | N11 | S1-3 | S11-13 | H3-31 | TS1 | TS2-3 | TS4 | TP1 | TP2-3 | TP4 | Honeycomb | GR | | |
|---|---------|---------------------|----------------|------|--------|------|------|------|----|------|-----|------|--------|-------|-----|-------|-----|-----|-------|-----|-----------|----|---|---|
|  | 459 | VHM | J28 | | | | | | | | | | | | • | | | | | | | | | |
| | 153 | | J36 | ○ | • | ○ | ○ | ○ | ○ | • | • | ○ | ○ | | | ○ | | | ○ | | | | | |
| | 156 | | HK/HKM | • | | • | • | • | • | • | ○ | | • | • | • | • | • | | | • | | | | |
| | 167 | | V31 | • | ○ | • | ○ | • | • | • | • | • | • | • | • | • | • | | | • | | | • | |
| | 150 | | J29 | • | • | • | • | • | • | • | • | • | • | • | • | ○ | • | | | • | | | | • |
| | 457 | | J93F | | | | | | | | | | | | | • | | | • | | | | | |
|  | 286 | Ceramic | JCG790 | | | | | | | | | | • | | | | | | | | | | | |
|  | 488-495 | X-HEADS SOLID² | XSE550 | • | • | • | • | • | • | • | • | • | • | • | • | • | | | • | | | ○ | | |
| | 504 | | XSB540 | • | ○ | • | • | • | • | • | • | ○ | • | ○ | ○ | • | | | • | | | | ○ | |
| | 518-519 | | XSE450 | | | | | | | • | • | • | | | | • | | | • | | | | | |
| | 506-507 | | XSE720 | ○ | • | • | • | | | | | | • | • | | | | | | | | | | |
| | 512 | | XSB720 | ○ | • | • | • | | | | | | • | • | | | | | | | | | | |
|  | 296 | X-HEADS HSM/TORNADO | XHT740 | ○ | • | • | | | | | | | ○ | • | | | | | | | | | | |
|  | 525 | X-HEADS HFM | XHF580 | • | • | • | • | • | | | | | ○ | ○ | ○ | | | | | | | | | |
| | 530 | | XHF780 | ○ | ○ | • | • | | | | | | • | • | ○ | | | | | | | | | |
|  | 543 | X-HEADS VHM | XVE540 | • | • | • | • | • | • | • | • | ○ | ○ | ○ | • | | | • | | | | ○ | | |
| | 548 | | XVE510 | • | • | • | • | • | ○ | ○ | ○ | ○ | ○ | ○ | ○ | • | | | • | | | | ○ | |
| | 551-552 | | XVB510 | • | • | • | • | • | ○ | ○ | ○ | ○ | ○ | ○ | ○ | • | | | • | | | | ○ | |
| | 555 | | XVC506/509/512 | • | • | • | • | • | ○ | ○ | ○ | ○ | ○ | ○ | ○ | • | | | • | | | | ○ | |
| | 559 | | XVK310 | • | • | • | • | • | • | • | • | • | ○ | ○ | ○ | • | | | • | | | | ○ | |

• Erste Wahl, ○ Alternative

Code-Schlüssel

Vollhartmetall-Schafffräser

| | | | | | | | | | | |
|----------|-----------|------------|------------|----------|----------|-------------|-----------|-----------|----------|------------|
| R | JS | 720 | 100 | D | 2 | R050 | .0 | Z6 | C | HXT |
| 1 | 2 | 3 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 |


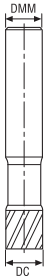
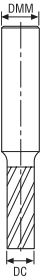
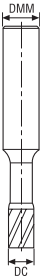
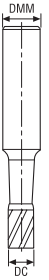


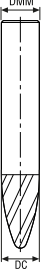

X-Heads – Köpfe

| | | | | | | | | | | |
|----------|------------|------------|------------|------------|----------|----------|-------------|-----------|----------|-------------|
| R | XSE | 550 | E10 | 100 | D | 2 | R050 | Z4 | A | SIRA |
| 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 10 | 11 | 12 |

| 1. Fräsertyp | 2. Produktprogramm | 3. Geometrie |
|---|--|---|
| Leer = Standard (Katalog) Produkt R = Nachgeschliffenes Produkt (komplett) RK = Nachgeschliffenes Produkt (stirnseitig) | J = JABRO® VHM JC = JABRO® Composites JD = JABRO® Diamond JH = JABRO® HSM/Tornado JHF = JABRO® HFM JHP = JABRO® HPM JM = JABRO® Mini JS = JABRO® SOLID ² | Eine dreistellige Zahlenkombination gibt die Schneidgeometrie an. Beispiel: 111, 951, 553, 514 usw. |

| 4. Anschlussgröße | 5. Fräsdurchmesser |
|--|--|
| Diese Abbildung zeigt die Größe der Gewindeverbindung zwischen Kopf und Adapter E10 = 10 mm E12 = 12 mm E16 = 16 mm E20 = 20 mm E25 = 25 mm | Metrisch = 3-stelliger Code (im Fall eines 4-stelligen Codes – xx,xx mm) Zöllig = ein Punkt gefolgt von einem 3-stelligen Code Beispiel: Zoll = 4-stelliger Code (0250 = 1/4") |

6. Ausführung

| (DC = DMM) | | (DC < DMM) | | | (DC > DMM) |
|--|--|---|---|--|---|
|  |  |  |  |  |  |
| D | E | F | G | J | P |
| Form | | | | | |
|  |  | | |  | |
| N | X | | | T | |

7. Werkzeuglänge

Eine einzelne Zahl gibt die Werkzeuglänge an, im Vergleich zu anderen Werkzeugen mit derselben Geometrie.

9. Aufnahmetyp

- 0 = Zylindrisch
- 3 = Weldon
- 5 = Whistle Notch
- 9 = Safe-Lock

10. Schneidenzahl

Anzahl der Schneiden des Fräsers
Beispiel: PCEDC2 = 2 Schneiden, PCEDC6 = 6 Schneiden

11. Kühlschmiermittelkanäle

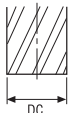
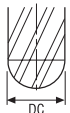
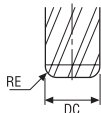
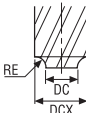
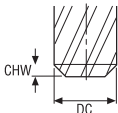
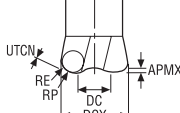
LEER = Keine interne Kühlschmiermittelzufuhr
A = Mit interner Kühlschmiermittelzufuhr
C = Spanteiler

12. Sorten

Ein 4-stelliger Code spezifiziert die Beschichtung des Fräsers.

| | | | |
|---------|-----------|--------|------|
| MEGA = | MEGA | DURA = | DURA |
| MT = | MEGA-T | NXT = | NXT |
| M64 = | MEGA-64 | HXT = | HXT |
| M64 T = | MEGA-64-T | STAX = | STAX |
| SIRA = | SIRON-A | TAN = | TAN |
| HEMI = | HEMI | M9 = | M9 |
| DIA = | DIAMOND | AXT = | AXT |

Bezeichnung




| 8. Fräserausführung | | | | | |
|--|---|---|---|---|---|
| Scharfe Schneide | Kugelkopf | Ecken-radius | Konvexradien-fräsen | Fase | Hochvorschubfräser |
|  |  |  |  |  |  |
| S | B | R... | K... | C | H |
| Radiusgröße für Produkte mit konvexem oder konkavem Radius | | | | | |
| <p>000 = Für metrische Werkzeuge ist die Ausführung in einem dreistelligen Zahlencode angegeben. Durch 100 dividiert, erhält man den tatsächlichen Eckenradius in Millimeter.</p> <p>.000 = Für Werkzeuge in Zollabmessungen ist die Ausführung in einem 4-stelligen Zahlencode angegeben (d. h. ein Punkt, gefolgt von einer dreistelligen Zahl). Die Abbildung zeigt die Größe des Eckenradius in <i>Zoll</i> (e.g. R.100 = Eckenradius 0,100").</p> | | | | | |

Code-Schlüssel

X-Heads – Schäfte

| | | | | | | | | |
|----------|------------|------------|----------|----------|----------------|-----------|-----------|----------|
| X | E10 | 100 | E | 2 | - 055 - | 00 | .0 | S |
| 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 |

| 1. Produktprogramm | 2. Anschlussgröße | 3. Schaftdurchmesser |
|---------------------------|--|--|
| X = X-Head-Zylinderschaft | Diese Abbildung zeigt die Größe der Gewindeverbindung zwischen Kopf und Adapter E10 = 10 mm E12 = 12 mm E16 = 16 mm E20 = 20 mm E25 = 25 mm | Metrisch = 3-stelliger Code Zöllig = ein Punkt gefolgt von einem 3-stelligen Code Beispiel: (050 = metrisch, 5 mm)/(.500 = zöllig, 1/2 Zoll) |

| 4. Ausführung | | |
|--|--|--|
| (DC = DMM) | (DC < DMM) | |
|  |  |  |
| E | G | J |

| 5. Werkzeuglänge | 6. Gesamtlänge |
|---|--|
| Eine einzelne Zahl gibt die Werkzeuglänge an, im Vergleich zu anderen Werkzeugen mit derselben Geometrie. | Metrisch = 3-stelliger Code Zöllig = 3-stelliger Code mit einem Punkt nach der ersten Ziffer Beispiel: (055 = metrisch, 55 mm)/(2.50 = zöllig, 2 1/2 Zoll) |

| 7. Kegelwinkel | 8. Aufnahmetyp | 9. Werkstoffarten |
|--|---|---|
| Gibt den Konuswinkel an. Beispiel: (00 = 0°; 05 = 5°; 10 = 10°) | 0 = Zylindrisch 3 = Weldon 5 = Whistle Notch 9 = Safe-Lock | Gibt die verschiedenen verfügbaren Schaftwerkstoffe an. S = Stahl DM = Densimet E = Vollhartmetall |

Ihre Vorteile

Individuelle Lösungen - Sonder- und modifizierte Werkzeuge



Falls Standardprodukte nicht für Ihre Anwendung passen, haben wir individuelle Sonderlösungen für Sie. Steigern Sie Ihre Produktivität! Zusätzlich zu unseren Standardprodukten bieten wir:

Werkzeuge nach Kundenwunsch

Modifizierte Geometrien oder Formwerkzeuge für kundenspezifische Anforderungen. Wir arbeiten mit Ihnen zusammen, um eine passende Lösung zu finden. Zum Beispiel:

- Modifizierte Werkzeuge mit Standard-Geometrie
- VHM-Formfräser für Fasen und Radien (MEP, Mechanised Edge Profiling)
- Tannenbaumfräser
- Schwalbenschwanz
- Konischer Kugelkopf
- Kondylusfräser
- Formwerkzeuge
- Tonnenfräser

Modifizierte Werkzeuge

Für spezielle Anforderungen bietet Seco die Möglichkeit einer schnellen Modifizierung auf Basis von Jabro-Werkzeugen an, wie z.B.:

- Eckenradius/Fase
- Freilegung, inkl. Verlängerung
- Beschichtung (für unbeschichtete Werkzeuge)
- Kleinerer Werkzeugdurchmesser
- Spanbrecher
- Weldon/Safelock
- Externe Kühlschmiermittelzufuhr

NOCH LANGE KEIN GRUND ZUM WEGWERFEN

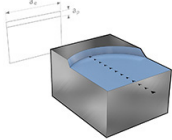
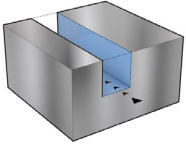
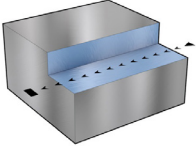
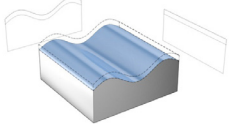
Dank ihrer hervorragenden Kombination aus Hartmetallsubstraten, hoch verschleißfesten Beschichtungen, optimierter Geometrie und kontrollierter Schneidkantenpräparation zeigen die Hartmetallwerkzeuge der neuesten Generation von Seco bemerkenswerte Leistungen.

Aber auch die hochwertigsten Werkzeuge weisen früher oder später Zeichen von Verschleiß an der Schneide auf. Bei kontrolliertem Verschleiß und rechtzeitigem Ersatz können diese Werkzeuge wieder aufbereitet werden. Dadurch reduzieren Sie Ihre Anschaffungskosten erheblich. Wir nutzen die gleichen modernen Technologien, um unsere Vollhartmetallfräser nachzuschleifen, wie um neue Fräser herzustellen.

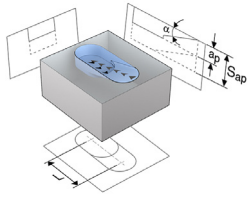
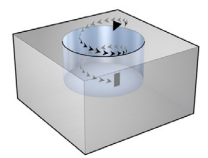
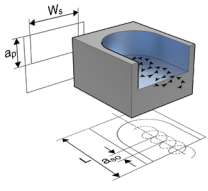
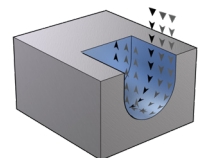
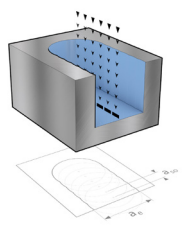
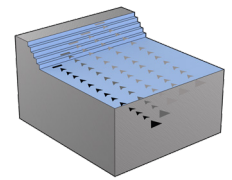
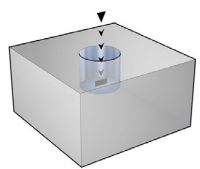
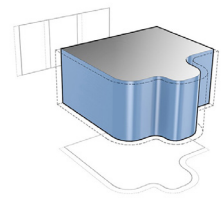
IHRE VORTEILE DURCH NACHSCHLEIFEN

- Die Werkzeuge werden in der original Jabro-Ausführung (Geometrie, Kantenpräparation und Beschichtung) wieder aufbereitet.
- Deutliche Kosteneinsparungen durch wiederholten Einsatz desselben Vollhartmetallwerkzeuges.
- Mit unserer kostenlosen Recondition-Box erhalten Sie gleichzeitig einen vorbereiteten Lieferschein.
- Kostenlose, zuverlässige Abholung am Tag, nachdem Sie Ihren Seco-Kontakt benachrichtigt haben.
- Schneller und einfacher Service - wir haben alles für Sie vorbereitet, Sie brauchen nur noch anzurufen!
- Rücklieferung über den normalen Seco-Lieferweg.
- Sichere Transport- und Lagermöglichkeit der aufbereiteten Werkzeuge durch die gleiche Verpackung wie bei Neuwerkzeugen.
- Ein neuer Versandaufkleber ist beigefügt.
- Recondition ist ein wichtiger Schritt für die Umwelt! Secos Verfahren sind weltweit zertifiziert gemäß ISO14001.
- Die Qualität der einzelnen Verfahren ist durch ISO9001 zertifiziert.

Basisbearbeitungen:

| Planfräsen: | Nutfräsen: |
|--|--|
| <p>Vorgang, bei dem das Werkzeug mit weniger als 180° Kontaktbogen eingreift. Eingriff: Kleine Schnitttiefe a_p und große Schnittbreite a_e.</p>  | <p>Volle Eingriffsbreite des Fräasers Der volle Durchmesser ist im Eingriff, d.h. a_e entspricht DC und a_p ist bis zu 2 x DC abhängig von der genutzten Zerspanungsmethode.</p>  |
| Eck-/Konturfräsen: | Kopierfräsen: |
| <p>Bei der Hauptschneide große Schnitttiefe a_p kleine Eingriffsbreite a_e</p>  | <p>Kleine Spanquerschnitte mit Werkzeugen mit großen Radien (a_p und a_e sind klein).</p>  |

Weitere Bearbeitungsstrategien:

| | |
|---|--|
| <p>Einwärtskopieren:</p> <p>Öffnen einer Tasche durch Zustellung in z unter einem Winkel.</p>  | <p>Bohrzirkularfräsen:</p> <p>Öffnen einer Bohrung durch zirkulare Zustellung in z-Richtung.</p>  |
| <p>Trochoides Fräsen:</p> <p>Öffnen einer Nut durch Überlagerung einer Kreisbewegung mit einer Linearbewegung (Trochoides Fräsen ist die Umsetzung von Nutfräsen in Konturfräsen).</p>  | <p>Bohr- und Ziehfräsen:</p> <p>Bearbeitung einer 3D-Kontur durch bohrende Zustellung.</p>  |
| <p>Tauchfräsen:</p> <p>Öffnen einer tiefen Nut durch Bohrbewegungen in z.</p>  | <p>Fräsen in Höhenlinien (Z-Linie):</p> <p>Bearbeitung einer Oberfläche durch kurze Bohr- und Tauchbewegungen in z, dann Tasche öffnen.</p>  |
| <p>Bohren:</p> <p>Zustellung in z.</p>  | <p>Dynamisches Fräsen</p> <p>Definierte Werkzeugwege mit konstantem Kontaktbogen für zuverlässige Schruppbearbeitungen von einfachen und komplexen Formen. Die großen axialen (a_p) und kleinen radialen Schnitttiefen (a_e) kombiniert mit hohen Vorschüben pro Zahn (f_z) und Schnittgeschwindigkeiten (v_c) sorgen für hohe Produktivität.</p>  |

Definitionen, Bearbeitungsstrategien:

Allgemeine Bearbeitung:

Bearbeitungsstrategie für allgemeinen Einsatz. Verhältnis a_e - a_p sehr stark abhängig von der Bearbeitung.

Werkzeugmerkmale: Werkzeuge weisen sehr große Schneidenlängen und dünne Kerndurchmesser auf. Keine hohen Toleranzanforderungen.

Maschinenanforderungen: Keine speziellen Anforderungen.

Beim Einsatz der CNC-Technologie sind keine modernen Bearbeitungsmethoden möglich.

Nur durchschnittliche Ergebnisse beim Zeitspanvolumen Q (cm^3/min).

Anwendungsgebiet ist die Kleinserienfertigung mit vielen verschiedenen Werkstoffen.

Hochleistungsbearbeitung (HPM):

Eine Bearbeitungsstrategie, bei der sehr hohe Zeitspanvolumen zu erzielen sind.

Typisch für diese Strategie ist $a_e = 1 \times \text{DC}$ und $a_p = 1$ bis $1\frac{1}{2} \times \text{DC}$ je nach zu bearbeitendem Werkstoff.

Mit HPM erzielen Sie extrem hohe Zeitspanvolumen in weit geringerer Zeit als bei der konventionellen Bearbeitung.

Werkzeugmerkmale: Speziell geformte Spankammern im Werkzeug, Beschichtung, mit oder ohne Weldon.

Maschinenanforderungen: Hohe Stabilität, hohe Energieanforderungen, CNC-Steuerung, stabiles Klemmsystem.

Anwendungsgebiet: Serienproduktion, wo Produktions-/Lieferzeit sehr wichtig ist oder bei Einzelproduktion, wo hohe Zeitspanvolumen Q (cm^3/min) gefordert sind.

Hochvorschubbearbeitung (HFM)

Bearbeitungsstrategie, bei der hohe Vorschübe mit vollem Eingriff im

Werkzeugdurchmesser (a_e) in Kombination mit einem kleinen a_p erzielt werden können.

Mit Hochvorschubbearbeitung erzielen Sie Zeitspanvolumen und/oder hohe Oberflächengüten bei einem im Vergleich zur allgemeinen Bearbeitung sehr viel höheren Vorschub.

Werkzeugmerkmale: Speziell entwickelte Schneidengeometrie, sehr kurze Schneidlänge und angepasste Beschichtung.

Maschinenanforderungen: Hohe Stabilität, Möglichkeit für hohe Vorschubgeschwindigkeiten (v_f).

Ein großer Vorteil dieser Technologie ist ihre große Bedienerfreundlichkeit; die Programmierung in CAM lässt sich einfach, sicher und schnell vornehmen. Durch Fräsen in Höhenlinien (mit konstanter Schnitttiefe) kann man ohne viel Erfahrung sogar komplexe Formen recht einfach programmieren.

Anwendungsgebiet: Das Anwendungsgebiet reicht von normalem zu gehärtetem Stahl, Titan und Rostfrei, die Bearbeitung eignet sich sehr gut zum Vorschlichten vor der HSM-Bearbeitung.

Auch für tiefe Plattensitze geeignet.

Mikrofräsen:

Bearbeitungsstrategie, bei der extrem kleine Werkzeugdurchmesser verwendet werden.

Werkzeugmerkmale: Durchmesserbereich von 0,1 bis 2,0 mm, kleine Schnittlängen, umfangreiches Programm an Freilegungen, hohe Präzision, Beschichtung.

Maschinenanforderungen: Hohe Spindelgenauigkeit, hohe Drehzahlen, CNC-Steuerung.

Anwendungsgebiet: Herstellung von Kavitäten wie Nuten, Plattensitze, Bohrungen oder Gravierungen in verschiedenen Werkstoffen.

Hochgeschwindigkeitsbearbeitung:

Bearbeitungsstrategie mit einer Kombination aus kleinen Spanquerschnitten und hohen Schnittgeschwindigkeiten sowie hohen Vorschubgeschwindigkeiten.

Je nach Bearbeitungsmethode können hohe Zeitspanvolumen und ein geringer R_a -Wert erzielt werden. Typisch für diese Strategie sind die geringen Schnittkräfte, geringe Erwärmung des Werkzeuges und Werkstückes, geringe Gratbildung und hohe Maßgenauigkeit am Werkstück.

Durch die Hochgeschwindigkeitsbearbeitung erzielen Sie Zeitspanvolumen und/oder hohe Oberflächengüten bei einer im Vergleich zur allgemeinen Bearbeitung sehr viel höheren Schnittgeschwindigkeit.

Werkzeugmerkmale: Stabile Ausführung (dicker Kerndurchmesser und kurze Schneidenlänge), durchgängig geformte Spankammern für gute Spanabfuhr, Beschichtung.

Maschinenanforderungen: Schnelle CNC-Steuerung, hohe Maximaldrehzahlen und höchste Stabilität.

Anwendungsgebiet: Werkzeug- und Formenbau vor Vorschlicht- oder Schlichtbearbeitungen in gehärtetem Stahl (48-62 HRC).

Mit dem richtigen Werkzeug und modernen Bearbeitungsmethoden kann diese Technologie bei den meisten anderen Werkstoffen ebenfalls eingesetzt werden.

Dynamisches Fräsen:

Definierte Werkzeugwege mit konstantem Kontaktbogen für zuverlässige Schruppbearbeitungen von einfachen und komplexen Formen. Die großen axialen (a_p) und kleinen radialen Schnitttiefen (a_e) kombiniert mit hohen Vorschüben pro Zahn (f_z) und Schnittgeschwindigkeiten (V_c) sorgen für hohe Produktivität.

Dieses CAM-basierte Schruppverfahren, oder Dynamisches Fräsen, legt den Fokus auf den Kontaktbogen des Werkzeuges und die mittlere Spanlast.

Durch Verringerung des Kontaktbogens, entsteht weniger Wärme bei der Schruppbearbeitung. Der Kontaktbogen wird durch geringe seitliche Zustellungen reduziert. Eine geringere Kontaktmenge führt zu weniger Reibung und somit zu weniger Wärme zwischen den Schneidkanten des Werkzeugs und dem Werkstück, das bearbeitet wird. Diese niedrigeren Bearbeitungstemperaturen wiederum ermöglichen höhere Schnittgeschwindigkeiten und kürzere Zykluszeiten.

Dynamisches Fräsen

Was versteht man unter „Dynamischem Fräsen“?

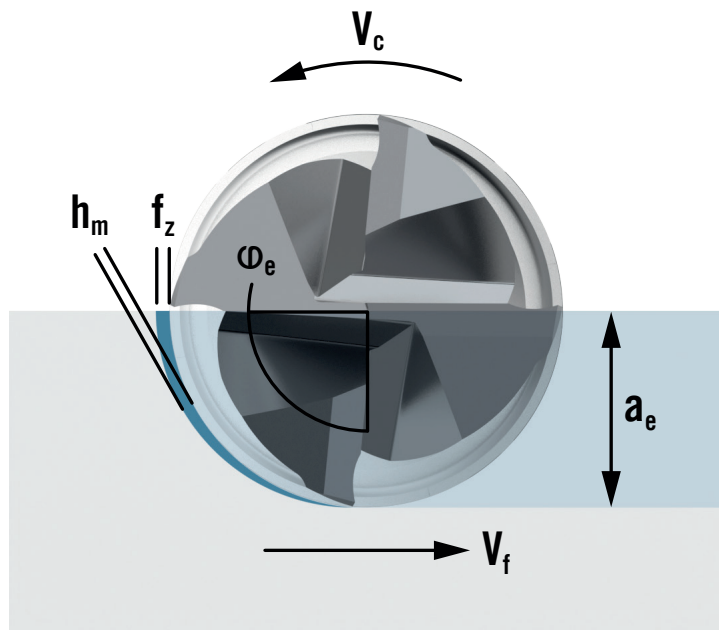
Die aktuellen CAM-Pakete bieten Werkzeugbahnen für spezifische Innen-/Außenradien an. Bei konventionellen Werkzeugbahnen ändert sich der Kontaktbogen stets. Die neuen CAM-Software-Pakete verwenden automatisch verschiedene Vorschübe, um den Kontaktbogen zu steuern und die Spanlast konsistent zu halten.

Dieses CAM-basierte Schruppverfahren, oder Dynamisches Fräsen, legt den Fokus auf den Kontaktbogen des Werkzeuges und die mittlere Spanlast. Durch Verringerung des Kontaktbogens, entsteht weniger Wärme bei der Schruppbearbeitung. Der Kontaktbogen wird durch geringe seitliche Zustellungen reduziert. Eine geringere Kontaktmenge führt zu weniger Reibung und somit zu weniger Wärme zwischen den Schneiden des Werkzeugs und dem Werkstück, das bearbeitet wird. Diese niedrigeren Bearbeitungstemperaturen wiederum ermöglichen höhere Schnittgeschwindigkeiten und kürzere Zykluszeiten. Auch die Zerspankraft ist geringer. Das ermöglicht eine größere Schnitttiefe (APMXS).

Beim Dynamischen Fräsen wird der Kontaktbogen durch Anwendung verschiedener Frässtrategien konstant gehalten.

Durch optimale Werkzeugbahnen und einen konstanten Kontaktbogen kann der Werkzeugradius den Innenradius ohne Gefahr einer Überlastung bearbeiten. Mit diesen Merkmalen können unsere Werkzeuge fürs Dynamische Fräsen (JS554-3C, JS564, JS656, JS754, JS755 und JS720) mehr Material pro Durchgang in der Schruppbearbeitung entfernen - das führt zu kürzeren Zykluszeiten und längerer Standzeit. Durch das konstante verbliebene Material kann das Schlichtwerkzeug eine höhere Oberflächengüte bei längerer Standzeit erzeugen.

Einfluss von Kontaktbogen und Vorschub pro Zahn



Ihre Vorteile

Hohe Geschwindigkeiten in Superlegierungen mit JABRO® Ceramic

SiAlON-Keramik, hochfeste Geometrien und verstärkte Stirngeometrien sind die Hauptmerkmale dieser hochoptimierten Werkzeuge. Sie ermöglichen Hochgeschwindigkeitsbearbeitung und Hochleistung. Die Werkzeuge eignen sich für Geschwindigkeiten bis zu 1.200 m/min und bieten deutlich mehr Produktivität im Vergleich zu Standard-Vollhartmetallfräsern.

Bei hohen Temperaturen ist auch eine hohe Drehzahl nötig, um die hohe Geschwindigkeit zu erreichen. Bei hohen Temperaturen werden HRSA weicher (850c +). Die Werkzeuge eignen sich für eine Vielzahl an Strategien, so lange ein konstanter Eingriff und ein konstanter Kontakt mit dem Werkstück besteht.

Das Werkzeug eignet sich zum Eckfräsen, Nutfräsen, Fräsen mit hohen Vorschüben und zum schweren Schruppen. All das ist möglich. Bei hohen Geschwindigkeiten ist auch der Rundlauf sehr wichtig.

JABRO Ceramic Werkzeuge finden Sie auf Seite 286.



Hybrid-Composite-Werkstoffe mit innovativer Geometrie meistern

Der JC899 mit patentierter Geometrie eignet sich speziell für hybride Plattenpakete, wie CFRP-Ti und CFRP-Alu. Aufgrund des Linksdralls verhindert das Werkzeug eine Beschädigung der Oberfläche durch Delamination, Absplittungen oder Spanmarken. Der JC899 mit Linksdraht und der rechtsschneidige STAX-Schlichter sorgen für eine hohe Oberflächengüte und verhindern Späne zwischen den zwei Schichten.

Nachbehandeln, Trennen, Säubern, Entgraten und Zusammenfügen der Werkstücke gehört der Vergangenheit an. Dies erhöht die Effizienz und verlängert die Standzeit.

Die Bohrungsbearbeitung kann mit dem JC898 Hochvorschub-Schruppwerkzeug ersetzt werden. Das Werkzeug wird in Bohrzirkularbearbeitung eingesetzt und ermöglicht dem JC899 einen kontinuierlichen Schnitt. Das erhöht den Ausstoß und verbessert Bohrungsgröße und Toleranz.

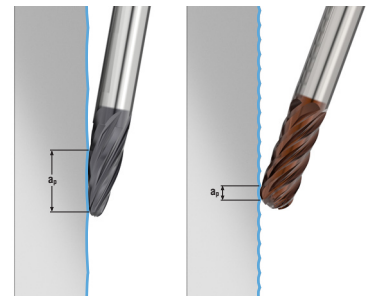
JABRO® JC898/JC899 finden Sie auf Seite 446 - 448.



Größere Stepover für schnelleres Schlichten

Für schnelle und zuverlässige Schlichtbearbeitung ermöglichen konvexe Werkzeuge durch eine innovative konische - oder „Tropfen“-Geometrie einen größeren Stepover gegenüber Kugelkopffräser. Dies ist durch Einsatz moderner CAD/CAM-Systeme möglich. Mithilfe von 5-Achs-Bewegungen bleibt die Schneide des Werkzeuges stets in einem exakten Winkel zur Werkstückoberfläche.

Zusätzlich zu unseren Standard-Tonnenfräsern bietet Seco diese auch als Sonderlösungen an, z.B. mit Linsenform.



Senken Sie das Risiko bei Mikrozerspanung

Erreichen Sie Präzision, Genauigkeit und hohe Oberflächengüten für kleinste Werkstücke mit unseren JABRO® Schafffräsern. Das Produktprogramm an Mini-Fräsern bietet längere Standzeit, mehr Stabilität und Ruhe für Bearbeitungen, die mit dem bloßen Auge kaum sichtbar sind.

Präzise Geometrien, praktisch keine Rundlaufabweichung, moderne Beschichtungen und echte Radiustoleranzen führen zu langer Standzeit und hoher Zuverlässigkeit. Mit den richtigen Zerspanungsbedingungen zeigen die Fräser ihr volles Potenzial. Mit der passenden Werkzeugaufnahme wird die Rundlaufabweichung minimiert. Auch das CAM-Programm kann mit der SECO JABRO® Vorschuboptimierung durch Berechnung der idealen Drehzahl und Vorschubgeschwindigkeit optimiert werden. Werkzeug und Aufspannung verhindern unvorhersehbare Herausforderungen während Schrupp-, Vorschlicht- und Schlichtbearbeitung.

Einen Überblick über alle JABRO® Mini Werkzeuge finden Sie auf Seite 10.



JS522 Schlichtfräser

Der JS522 Schlichtfräser erfüllt die Anforderungen der Luft- und Raumfahrtbranche nach Rechtwinkligkeit, höchsten Oberflächengüten, hohem Zeitspanvolumen und effektiver Bearbeitung.





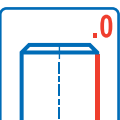
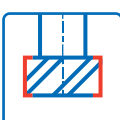
Mit einer Schneidenlänge von 5 x DC und einem größeren Kerndurchmesser um Durchbiegung zu kompensieren, eignet sich der JS522 speziell zum Schlichten hoher Wandungen in einem Durchgang. Dies spart Zeit und bietet hohe Qualität. Das Werkzeug eignet sich für Serienbearbeitungen.

Es hat sich schon oft als Kostensenker in vielen Anwendungen bewährt.

JABRO® JS522 finden Sie auf Seite 113.




Symbole

| | | | | | |
|---|---|---|---|---|---|
|  |  |  |  |  |  |
| Zentrumsschnitt PCEDC 1 | Zentrumsschnitt PCEDC 2 | Kein Zentrumsschnitt PCEDC 2 | Zentrumsschnitt PCEDC 3 | Kein Zentrumsschnitt PCEDC 3 | Zentrumsschnitt PCEDC 4 |
|  |  |  |  |  |  |
| Kein Zentrumsschnitt PCEDC 4 | Zentrumsschnitt PCEDC 5 | Kein Zentrumsschnitt PCEDC 5 | Zentrumsschnitt PCEDC 6 | Kein Zentrumsschnitt PCEDC 6 | Kein Zentrumsschnitt PCEDC 7 |
|  |  | | | | |
| Kein Zentrumsschnitt PCEDC 8 | Kein Zentrumsschnitt PCEDC 9 | | | | |
|  |  |  | | | |
| Zylindrisch | Weldon-Schaft | Safe-Lock™ Schaft | | | |
|  |  |  |  |  |  |
| Scharfe Schneide | Fase | Eckenradius | Kugelkopf | Scharfe Schneide konisch | Konischer Kugelkopf |
|  |  |  | | | |
| Fräser 250° | T-Form | Kreissegment | | | |








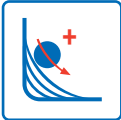
Symbole

| | | | | | | |
|---------------------------------------|---------------------------------------|---------------------------------------|---------------------------------------|---------------------------------------|---------------------------------------|---------------------------------------|
| | | | | | | |
| Drallwinkel 0° | Drallwinkel 3° | Drallwinkel 4° | Drallwinkel 10° | Drallwinkel 15° | Drallwinkel 17° | Drallwinkel 20° |
| | | | | | | |
| Drallwinkel 25° | Drallwinkel 28° | Drallwinkel 30° | Drallwinkel 35° | Drallwinkel 37,5° | Drallwinkel 38° | Drallwinkel 40° |
| | | | | | | |
| Drallwinkel 41° | Drallwinkel 42° | Drallwinkel 44° | Drallwinkel 45° | Drallwinkel 46° | Drallwinkel 48° | Drallwinkel 50° |
| | | | | | | |
| Drallwinkel Links 3° | Drallwinkel Links 10° | Drallwinkel Links 15° | | | | Doppelter Linksdrall 40° - 10° |
| | | | | | | |
| Drallwinkel links/rechts 20° - 20° | Drallwinkel links/rechts 27° - 25° | Drallwinkel links/rechts 35° - 25° | Drallwinkel links/rechts 35° - 30° | Drallwinkel links/rechts 34° - 36° | Drallwinkel links/rechts 36° - 40° | Drallwinkel links/rechts 40° - 42° |
| | | | | | | |
| Verstärkter Kern | Konischer Kern | | | | | |
| | | | | | | |
| Spanteiler | Schruppprofil | Fräserprofil | | | | |

Symbole

| | | | | | | |
|---|---|---|---|--|---|--|
|  Spanwinkel 0° Winkel |  Spanwinkel 1° Winkel |  Spanwinkel -1° Winkel |  Spanwinkel 2° Winkel |  Spanwinkel 3° Winkel |  Spanwinkel 4° Winkel |  Spanwinkel 4-6° Winkel |
|  Spanwinkel 5° Winkel |  Spanwinkel 6° Winkel |  Spanwinkel 7° Winkel |  Spanwinkel 8° Winkel |  Spanwinkel 9° Winkel |  Spanwinkel 10° Winkel |  Spanwinkel 11° Winkel |
|  Spanwinkel 12° Winkel |  Spanwinkel -12° Winkel |  Spanwinkel 14° Winkel |  Spanwinkel 15° Winkel |  Spanwinkel 16° Winkel |  Spanwinkel 18° Winkel |  Spanwinkel 20° Winkel |
|  Spanwinkel -24° Winkel | | | |  Spanwinkel 1,5° Radial |  Spanwinkel 10,5° Radial |  Spanwinkel 13° Radial |
|  Spanwinkel 0° Radial |  Spanwinkel -1° Radial |  Spanwinkel 3° Radial |  Spanwinkel 5° Radial |  Spanwinkel 6° Radial |  Spanwinkel 7° Radial |  Spanwinkel 8° Radial |
|  Spanwinkel 10° Radial |  Spanwinkel 11° Radial |  Spanwinkel 15° Radial |  Spanwinkel 16° Radial |  Spanwinkel 20° Radial |  Spanwinkel 7-11° Radial | |
|  ICC Gerade |  ICC und Y | | | | | |
|  Radial |  Radial/Einwärtskopieren |  Radial/Einwärtskopieren/ Eintauchen | | | | |

Symbole

| | | | | |
|--|---|--|--|--|
|  <p>Diamond</p> |  <p>Dura</p> |  <p>Hemi</p> |  <p>HSCO</p> |  <p>HXT</p> |
|  <p>Mega</p> |  <p>Mega-T</p> |  <p>Mega-64</p> |  <p>Mega-64-T</p> |  <p>NXT</p> |
|  <p>Stax</p> |  <p>SIRA</p> |  <p>TAN</p> |  <p>AXT</p> |  <p>Keramik</p> |
|  <p>PCD</p> |  <p>M9</p> | | | |
|  <p>Nachschleifen möglich</p> |  <p>Dynamisches Fräsen</p> | | | |

Attribute Vollhartmetallfräsen und X-Heads

| ISO-Attribute | Erklärung |
|---------------|---|
| AP1 | Teilweise Schnitttiefe |
| APMXS | Maximale axiale Schnitttiefe |
| BHTA | Konuswinkel |
| CA | Kollisionswinkel |
| CHW | Fasbreite |
| CSP | Kühlschmiermittelzufuhreigenschaft |
| CZCMS | Maschinenseitiger Code der Anschlussgröße |
| CZCWS | Werkstückseitiger Code der Anschlussgröße |
| DC | Werkzeughdurchmesser |
| DCSFMS | Werkzeug-Auflagedurchmesser |
| DCSFWS | Werkstückseitiger Kontaktflächendurchmesser |
| DCX | Maximaler Werkzeughdurchmesser |
| DMM | Schaftdurchmesser |
| DN | Hinterer Schneidkopf-Durchmesser |
| FCEDC | Stirnschneiden |
| ICC | interne Kühlschmiermittelkanäle |
| L | Schneidenlänge |
| L2 | Schneidenlänge 2 |
| LF | Funktionale Länge |
| LN | Freilegung |
| LN2 | Freilegung 2 |
| LSCN | Länge der Pratte min. |
| NA | Winkel an der Freilegung |
| OAL | Gesamtlänge |
| PCEDC | Anzahl Peripherischneiden |
| PRFA/2 | Halber Profilwinkel |
| PRFRAD1 | Profilradius 1 |
| PRFRAD2 | Profilradius 2 |
| PRFRAD3 | Profilradius 3 |
| PSIR | Werkzeugeinstellwinkel |
| RE | Eckenradius |
| RE2 | Eckenradius 2 |
| RP | Programmierter Radius |
| SA | Kugelsegmentwinkel |
| SIG | Spitzenwinkel |
| SW | Schlüsselgröße |
| TQ | Drehmoment |
| TQN | Mindestdrehmoment |
| TQX | Maximales Drehmoment |
| UTCN | Theoretische Abweichung |

ISO-Attribute Minimaster

| ISO-Attribute | Erklärung |
|---------------|-------------------------------------|
| APMXE | Maximale radiale Schnitttiefe |
| APMXS | Maximale axiale Schnitttiefe |
| AZ | Maximale Schneidenlänge |
| BEC | Hinterer Fasenwinkel |
| BHTA | Konuswinkel |
| CCER | Stirnschneidenradius |
| Cmax | Maximaler Bohrungsdurchmesser |
| Cmin | Minimaler Bohrungsdurchmesser |
| DC | Werkzeughdurchmesser |
| DCSFMS | Werkzeug-Auflagedurchmesser |
| DCSFWS | Aufnahmedurchmesser werkstückseitig |
| DCX | Maximaler Werkzeughdurchmesser |
| DMM | Schaftdurchmesser |
| DN | Hinterer Schneidkopf-Durchmesser |
| FCEDC | Stirnschneiden |
| FHA | Drallwinkel der Spankammer |
| KAPRS | Einstellwinkel |
| LE | Effektive Schneidenlänge |
| LF | Funktionale Länge |
| LPR | Länge Überstand |
| OAL | Gesamtlänge |
| RA | Freilegungswinkel |
| RE | Eckenradius |
| RMPX | Maximaler Einwärtskopierwinkel |
| RP | Programmierter Radius |
| RPMX | Maximale Drehzahl |
| SA | Kugelsegmentwinkel |
| SIG | Spitzenwinkel |
| UTCN | Theoretische Abweichung |
| ZEFP | Effektive Zähnezah |



UNIVERSAL

Das vollständige Programm an Vollhartmetall-Hochleistungsfräsern für hohe Produktivität und längere Werkzeugstandzeit besteht aus Schaftfräsern, Kugelkopffräsern und Kreissegmentfräsern. Dieses Programm umfasst universell geeignete Produkte und optimierte Schaftfräser für spezifische Werkstoffe.
















Universell geeignete Produkte bieten volle Bearbeitungsflexibilität zu einem hervorragenden Preis-Leistungs-Verhältnis.

- JSE512, JSE513, JSE514, JS553, JS554, JS564, JS565 und JS520 mit 45° Fase
- JS522, JS553, JS554, JH910, JH930, JHF980, J36, V31, JME542, JME562 und JME564 mit Eckenradius
- JS506, JS509, HK, HKM und J29 konisch
- JSB512, JS532, JS533, JS534, JHB970, JMB542, JMB562 und JMB563 Kugelkopffräser.

| Universell | | Werkzeugauswahl Universal | | | | |
|--------------------------|-------------|---------------------------|--------------------|--------------------|--------------------|--------------------|
| Stahl und Guss | | | | | | |
| Werkzeugbezeichnung | | JSE512 | JSE513 | JSE514 | JS553 | JS554 |
| Seite(n) | | 36 | 40 | 46 | 56 | 76 |
| Produktfamilie | | SOLID ² | SOLID ² | SOLID ² | SOLID ² | SOLID ² |
| Fräserausführung | | | | | | |
| Aufnahmen | Zylindrisch | ■ | ■ | ■ | ■ | ■ |
| | Weldon | ■ | ■ | ■ | ■ | ■ |
| Schneidenzahl | | 2 | 3 | 4 | 3 | 4 |
| ICC | | | | | | |
| | Metrisch | 2-12 | 2-20 | 2-25 | 2-25 | 3-25 |
| | Zoll | | | | 1/8 - 1/2 | 1/4-1 |
| Verfügbare Längen | | 2 | 2,3 | 2,3 | 1,2,3 | 1,2,3 |
| Bearbeitung | | | | | | |
| | | | | | | |
| | | | | | | |
| SMG | | | | | | |
| P1-8 | | ● | ● | ● | ● | ● |
| P11-12 | | ○ | ○ | ○ | ● | ● |
| M1-3 | | ● | ● | ● | ● | ● |
| M4-5 | | ○ | ○ | ○ | ● | ● |
| K1-7 | | ● | ● | ● | ● | ● |
| S1-3 | | ○ | ○ | ○ | ● | ● |
| S11-13 | | ○ | ○ | ○ | ● | ● |
| H3 H5 H8 H11 H12 H21 H31 | | ○ | ○ | ○ | ● | ● |
| N1 | | ○ | ○ | ○ | ● | ● |
| N2-3 | | ○ | ○ | ○ | ● | ● |
| N11 | | ○ | ○ | ○ | ● | ● |
| TS1 | | ○ | ○ | ○ | ● | ● |
| TP1 | | ○ | ○ | ○ | ● | ● |
| GR | | ○ | ○ | ○ | ○ | ○ |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
 ● Erste Wahl ○ Alternative
 *JS554 3C ist auch verfügbar. Kann für schweres Schruppen angewendet werden.

Werkzeugauswahl Universal

| | | | | | |
|--------------------------|---|---|---|---|---|
| |  |  |  |  |  |
| Werkzeugbezeichnung | JS564 | JS565 | JS520 | JS522 | JSB512 |
| Seite(n) | 101 | 105 | 109 | 113 | 116 |
| Produktfamilie | SOLID ² | SOLID ² | SOLID ² | SOLID ² | SOLID ² |
| Fräserausführung |  |  |  |  |  |
| Aufnahmen | Zylindrisch | ■ | ■ | ■ | ■ |
| | Weldon | ■ | ■ | □ | ■ |
| Schneidenzahl | 4 | 5 | 5,6,8 | 2 | 2 |
| ICC | Metrisch | 3-20 | 4-20 | 4-25 | 6-32 |
| | Zoll | | | | |
| Verfügbare Längen | 2,3 | 2,3 | 2,3 | 4 | 2 |
| Bearbeitung | | |  |  | |
| | | | | |  |
| | |  |  | | |
| SMG | | | | | |
| P1-8 | ● | ● | ● | ● | ● |
| P11-12 | ○ | ○ | ○ | ● | ○ |
| M1-3 | ● | ● | ○ | ● | ● |
| M4-5 | ● | ● | ○ | ● | ○ |
| K1-7 | ● | ● | ● | ● | ● |
| S1-3 | ● | ● | ○ | ○ | ○ |
| S11-13 | ● | ● | ● | ● | ○ |
| H3 H5 H8 H11 H12 H21 H31 | ● | ● | ○ | ● | ○ |
| N1 | ● | ● | ● | ● | ○ |
| N2-3 | ● | ● | ● | ● | ○ |
| N11 | ● | ● | ● | ● | ○ |
| TS1 | | | ● | ● | ○ |
| TP1 | | | ● | ● | ○ |
| GR | | | ○ | ○ | ○ |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads















Minimaster Plus

Minimaster

| | | Werkzeugauswahl Universal | | | | |
|-------------------------------|----------------------|---------------------------|--------------------|--------------------|--------------------|--------------------|
| Universell | | | | | | |
| | | | | | | |
| Stahl und Guss | Werkzeugbezeichnung | JS532 | JS533 | JS534 | JS506 | JS509 |
| | Seite(n) | 118 | 122 | 126 | 130 | 134 |
| Rostfrei und ISO-S-Werkstoffe | Produktfamilie | SOLID ² | SOLID ² | SOLID ² | SOLID ² | SOLID ² |
| | Fräserausführung | | | | | |
| NE-Metalle | Aufnahmen | Zylindrisch | ■ | ■ | ■ | ■ |
| | | Weldon | □ | ■ | ■ | ■ |
| | Schneidenzahl | 2 | 3 | 4 | 3-4 | 3-4 |
| | ICC | | | | | |
| | Metrisch | 1-20 | 1-20 | 2-20 | 3-12 | 3-12 |
| | | Zoll | | | | |
| Harter | Verfügbare Längen | 1,2,3 | 1,2 | 1,2,3 | 2 | 2 |
| Kunststoffe und Composite | Bearbeitung | | | | | |
| | | | | | | |
| Graphit | SMG | | | | | |
| | P1-8 | ● | ● | ● | ● | ● |
| | P11-12 | ○ | ○ | ○ | ○ | ○ |
| | M1-3 | ● | ● | ● | ● | ● |
| | M4-5 | ● | ● | ● | ● | ● |
| | K1-7 | ● | ● | ● | ● | ● |
| | S1-3 | ○ | ○ | ○ | ○ | ○ |
| S11-13 | ● | ● | ● | ● | ● | |
| X-Heads | H3 H5 H8 H11 H12 H21 | | | | ● | ● |
| | N1 | ● | ● | ● | ● | ● |
| | N2-3 | ● | ● | ● | ● | ● |
| | N11 | ● | ● | ● | ● | ● |
| | TS1 | ● | ● | ● | ● | ● |
| Minimaster Plus | TP1 | ● | ● | ● | ● | ● |
| | GR | ○ | ○ | ○ | ○ | ○ |
| | | | | | | |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
 ● Erste Wahl ○ Alternative

Werkzeugauswahl Universal

| | | | | |
|-----------------------------|---|---|---|---|
| |  |  |  |  |
| Werkzeugbezeichnung | JH910 | JH930 | JHB970 | JHF980 |
| Seite(n) | 138 | 142, 384 | 144, 205 | 146 |
| Produktfamilie | HSM/TORNADO | HSM/TORNADO | HSM/TORNADO | HFM |
| Fräserausführung |  |  |  |  |
| Aufnahmen | Zylindrisch | ■ | ■ | ■ |
| | Weldon | | | |
| Schneidenzahl | 3 | 5-6, 8 | 2 | 2,3,4,5 |
| ICC | Metrisch | 2-20 | 6-20 | 2-16 |
| | Zoll | | | |
| Verfügbare Längen | 2,3,4 | 2 | 1,2,3 | 1,2,3,4 |
| Bearbeitung |  | | |  |
| |  |  | |  |
| | | |  | |
| SMG | | | | |
| P1-8 | ● | ● | ● | ● |
| P11-12 | ○ | ○ | ○ | ○ |
| M1-3 | ● | | ● | ● |
| M4-5 | ● | | ● | ● |
| K1-7 | ● | ● | ● | ● |
| S1-3 | ● | ● | ● | ● |
| S11-13 | ● | ● | ● | ● |
| H3 H5 H7 H8 H11 H12 H21 H31 | | ● | | ○ |
| N1 | | | | |
| N2-3 | | | | |
| N11 | | | | |
| TS1 | | | | |
| TP1 | ● | | | |
| GR | ● | | | |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads
























Minimaster Plus

Minimaster

| Universell | | Werkzeugauswahl Universal | | | |
|----------------------|-------------|---------------------------|------|--------|------|
| Stahl und Guss | | | | | |
| Werkzeugbezeichnung | | J29 | J36 | HK/HKM | V31 |
| Seite(n) | | 150 | 153 | 156 | 167 |
| Produktfamilie | | VHM | VHM | VHM | VHM |
| Fräserausführung | | | | | |
| Aufnahmen | Zylindrisch | ■ | ■ | ■ | ■ |
| | Weldon | | | | |
| Schneidenzahl | | 1 | 3 | 2,3,4 | 4 |
| ICC | | | | | |
| | Metrisch | 0,2-6 | 2-20 | 1-10 | 6-28 |
| | Zoll | | | | |
| Verfügbare Längen | | 2 | 2 | 2 | 2 |
| Bearbeitung | | | | | |
| Graphit | | | | | |
| X-Heads | | | | | |
| Minimaster Plus | | | | | |
| Minimaster | | | | | |
| SMG | | | | | |
| P1-8 | | ● | ○ | ● | ● |
| P11-12 | | ● | ● | ● | ○ |
| M1-3 | | ● | ○ | ● | ● |
| M4-5 | | ● | ○ | ● | ○ |
| K1-7 | | ● | ○ | ● | ● |
| S1-3 | | ● | ○ | ● | ● |
| S11-13 | | ● | ○ | ● | ● |
| H3 H5 H8 H11 H12 H21 | | ○ | | ● | ● |
| N1 | | ● | ○ | ● | ● |
| N2-3 | | ● | ● | ○ | ● |
| N11 | | ● | ● | | ● |
| TS1 | | ● | ○ | ● | ● |
| TP1 | | ● | ○ | ● | ● |
| GR | | ● | | | ● |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
 ● Erste Wahl ○ Alternative

Werkzeugauswahl Universal

| | |  |  |  |  |  |  |
|-----------------------------|-------------|---|---|---|--|---|---|
| Werkzeugbezeichnung | | JME542 | JME562 | JME564 | JMB542 | JMB562 | JMB563 |
| Seite(n) | | 170 | 173 | 177 | 180 | 183 | 187 |
| Produktfamilie | | MINI | MINI | MINI | MINI | MINI | MINI |
| Fräserausführung | |  |  |  |  |  |  |
| Aufnahmen | Zylindrisch | ■ | ■ | ■ | ■ | ■ | ■ |
| | Weldon | | | | | | |
| Schneidenzahl | | 2 | 2 | 4 | 2 | 2 | 3 |
| ICC | | | | | | | |
| | Metrisch | 2-20 | 0,5-3,0 | 0,5-3,0 | 0,2-3,0 | 0,5-3,0 | 1,0-3,0 |
| | Zoll | | | | | | |
| Verfügbare Längen | | 1,3,4,5,6 | 2,4,5,6,7 | 2,4 | 1,3,4,5,6 | 1,2,3,4,5,6 | 2,4 |
| Bearbeitung | |  |  |  |  |  | |
| | |  |  |  | | | |
| | | | | |  |  |  |
| SMG | | | | | | | |
| P1-8 | | ● | ● | ● | ● | ● | ● |
| P11-12 | | ● | ● | ● | ● | ● | ● |
| M1-3 | | ● | ● | ● | ● | ● | ● |
| M4-5 | | ● | ● | ● | ● | ● | ● |
| K1-7 | | | | | | | |
| S1-3 | | | | | | | |
| S11-13 | | ● | ● | ● | ● | ● | ● |
| H3 H5 H7 H8 H11 H12 H21 H31 | | ○ | ○ | ○ | ○ | ○ | ○ |
| N1 | | ○ | ○ | ○ | ○ | ○ | ○ |
| N2-3 | | ○ | ○ | ○ | ○ | ○ | ○ |
| N11 | | ○ | ○ | ○ | ○ | ○ | ○ |
| TS1 | | | | | | | |
| TP1 | | | | | | | |
| GR | | ○ | ○ | ○ | ○ | ○ | ○ |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
 ● Erste Wahl ○ Alternative

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

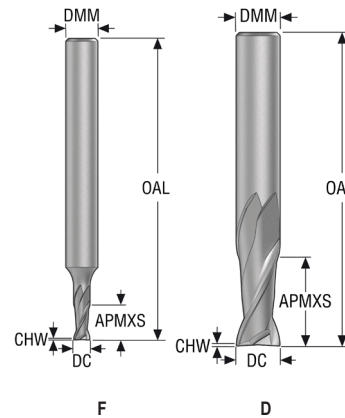
X-Heads

Minimaster Plus

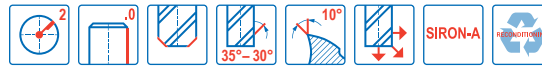
Minimaster

JSE512

Allgemeine Anwendung – Universell – Eckfräser – 2 Schneiden – Zylindrisch – Fase



- Toleranzen:
- DMM=h5
- DC=e8
- Nachschleifen möglich, wenn DC ≥ Ø10 ist



| Bezeichnung | Beschichtung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | CHW | PCEDC | Zylindrisch |
|------------------|--------------|--------------------|------------------|-------------------|------|------|-------|------|------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | | |
| JSE512021F2C.0Z2 | SIRA | 10052986 | 2 | F | 2,0 | 3,0 | 4,0 | 50,0 | 0,02 | 2 | ■ |
| JSE512020F2C.0Z2 | SIRA | 10052990 | 2 | F | 2,0 | 6,0 | 4,0 | 57,0 | 0,02 | 2 | ■ |
| JSE512030D2C.0Z2 | SIRA | 10052987 | 2 | D | 3,0 | 3,0 | 6,0 | 50,0 | 0,03 | 2 | ■ |
| JSE512030F2C.0Z2 | SIRA | 10052991 | 2 | F | 3,0 | 6,0 | 6,0 | 57,0 | 0,03 | 2 | ■ |
| JSE512040D2C.0Z2 | SIRA | 10052988 | 2 | D | 4,0 | 4,0 | 8,0 | 50,0 | 0,04 | 2 | ■ |
| JSE512040F2C.0Z2 | SIRA | 10052992 | 2 | F | 4,0 | 6,0 | 8,0 | 57,0 | 0,04 | 2 | ■ |
| JSE512050D2C.0Z2 | SIRA | 10052989 | 2 | D | 5,0 | 5,0 | 10,0 | 50,0 | 0,05 | 2 | ■ |
| JSE512060D2C.0Z2 | SIRA | 10052993 | 2 | D | 6,0 | 6,0 | 12,0 | 57,0 | 0,06 | 2 | ■ |
| JSE512080D2C.0Z2 | SIRA | 10052994 | 2 | D | 8,0 | 8,0 | 16,0 | 63,0 | 0,08 | 2 | ■ |
| JSE512100D2C.0Z2 | SIRA | 10052995 | 2 | D | 10,0 | 10,0 | 20,0 | 72,0 | 0,1 | 2 | ■ |
| JSE512120D2C.0Z2 | SIRA | 10052996 | 2 | D | 12,0 | 12,0 | 24,0 | 83,0 | 0,12 | 2 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

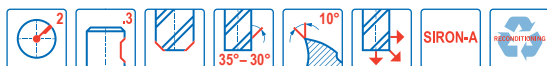
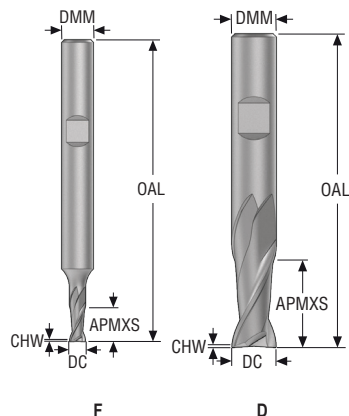
X-Heads

Minimaster Plus

Minimaster

JSE512

Allgemeine Anwendung – Universell – Eckfräser – 2 Schneiden – Weldon – Fase



- Toleranzen:
- DMM=h5
- DC=e8
- Nachschleifen möglich, wenn DC ≥ Ø10 ist

| Bezeichnung | Beschichtung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | CHW | PCEDC | Weldon |
|------------------|--------------|--------------------|------------------|-------------------|------|------|-------|------|------|-------|--------|
| | | | | | mm | mm | mm | mm | mm | | |
| JSE512020F2C.3Z2 | SIRA | 10053113 | 2 | F | 2,0 | 6,0 | 4,0 | 57,0 | 0,02 | 2 | ■ |
| JSE512030F2C.3Z2 | SIRA | 10053114 | 2 | F | 3,0 | 6,0 | 6,0 | 57,0 | 0,03 | 2 | ■ |
| JSE512040F2C.3Z2 | SIRA | 10053115 | 2 | F | 4,0 | 6,0 | 8,0 | 57,0 | 0,04 | 2 | ■ |
| JSE512060D2C.3Z2 | SIRA | 10053116 | 2 | D | 6,0 | 6,0 | 12,0 | 57,0 | 0,06 | 2 | ■ |
| JSE512080D2C.3Z2 | SIRA | 10053117 | 2 | D | 8,0 | 8,0 | 16,0 | 63,0 | 0,08 | 2 | ■ |
| JSE512100D2C.3Z2 | SIRA | 10053118 | 2 | D | 10,0 | 10,0 | 20,0 | 72,0 | 0,1 | 2 | ■ |
| JSE512120D2C.3Z2 | SIRA | 10053119 | 2 | D | 12,0 | 12,0 | 24,0 | 83,0 | 0,12 | 2 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

X-Heads

Minimaster Plus

Minimaster


Schnittdaten – JSE512 Eckfräsen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|---------|---------|--------|--------|--------|--------|--------|--------------------|
| | | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | |
| P1 | M/A/D/E | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 145 (61 – 180) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 475 (210 – 590) |
| P2 | M/A/D/E | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 145 (61 – 180) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 475 (210 – 590) |
| P3 | M/A/D/E | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 145 (61 – 180) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 475 (210 – 590) |
| P4 | M/A/D/E | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 145 (61 – 180) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 475 (210 – 590) |
| P5 | M/A/D/E | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 145 (61 – 180) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 475 (210 – 590) |
| P6 | M/A/D/E | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 145 (61 – 180) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 475 (210 – 590) |
| P7 | M/A/D/E | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 145 (61 – 180) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 475 (210 – 590) |
| P8 | M/A/D/E | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 145 (61 – 180) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 475 (210 – 590) |
| P11 | M/A/D/E | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 85 (61 – 120) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 280 (210 – 390) |
| P12 | M/A/D/E | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 85 (61 – 120) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 280 (210 – 390) |
| M1 | E/M/A | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 85 (61 – 120) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 280 (210 – 390) |
| M2 | E/M/A | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 85 (61 – 120) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 280 (210 – 390) |
| M3 | E/M/A | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 85 (61 – 120) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 280 (210 – 390) |
| M4 | E/M/A | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 85 (61 – 120) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 280 (210 – 390) |
| M5 | E/M/A | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 85 (61 – 120) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 280 (210 – 390) |
| K1 | A/D/M/E | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 145 (61 – 180) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 475 (210 – 590) |
| K2 | A/D/M/E | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 145 (61 – 180) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 475 (210 – 590) |
| K3 | A/D/M/E | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 145 (61 – 180) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 475 (210 – 590) |
| K4 | A/D/M/E | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 145 (61 – 180) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 475 (210 – 590) |
| K5 | A/D/M/E | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 145 (61 – 180) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 475 (210 – 590) |
| K6 | A/D/M/E | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 145 (61 – 180) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 475 (210 – 590) |
| K7 | A/D/M/E | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 145 (61 – 180) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 475 (210 – 590) |
| N1 | E/M/A | 0.200 | 1.5 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 500 (380 – 630) |
| | | 0,200 | 1,5 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 1650 (1300 – 2000) |
| N11 | E/M/A | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 365 (250 – 480) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 1200 (830 – 1500) |
| S11 | E | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 85 (61 – 120) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 280 (210 – 390) |
| S12 | E | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 85 (61 – 120) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 280 (210 – 390) |
| S13 | E | 0.250 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 85 (61 – 120) |
| | | 0,250 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 280 (210 – 390) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – JSE512 Nutfräsen

| SMG |  | a _p /DC | f _z | | | | | | | | v _c |
|-----|---|--------------------|----------------|---------|---------|---------|---------|---------|--------|--------|-------------------|
| | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | |
| P1 | M/A/D/E | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 120 (51 – 150) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 395 (170 – 490) |
| P2 | M/A/D/E | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 120 (50 – 140) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 395 (170 – 450) |
| P3 | M/A/D/E | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 120 (51 – 150) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 395 (170 – 490) |
| P4 | M/A/D/E | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 120 (50 – 140) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 395 (170 – 450) |
| P5 | M/A/D/E | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 120 (50 – 140) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 395 (170 – 450) |
| P6 | M/A/D/E | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 120 (50 – 140) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 395 (170 – 450) |
| P7 | M/A/D/E | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 120 (51 – 150) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 395 (170 – 490) |
| P8 | M/A/D/E | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 120 (50 – 140) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 395 (170 – 450) |
| P11 | M/A/D/E | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 70 (51 – 100) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 230 (170 – 320) |
| P12 | M/A/D/E | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 70 (50 – 99) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 230 (170 – 320) |
| M1 | E/M/A | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 70 (50 – 99) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 230 (170 – 320) |
| M2 | E/M/A | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 70 (50 – 99) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 230 (170 – 320) |
| M3 | E/M/A | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 70 (50 – 99) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 230 (170 – 320) |
| M4 | E/M/A | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 70 (50 – 99) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 230 (170 – 320) |
| M5 | E/M/A | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 70 (50 – 99) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 230 (170 – 320) |
| K1 | A/D/M/E | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 120 (50 – 140) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 395 (170 – 450) |
| K2 | A/D/M/E | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 120 (50 – 140) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 395 (170 – 450) |
| K3 | A/D/M/E | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 120 (50 – 140) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 395 (170 – 450) |
| K4 | A/D/M/E | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 120 (50 – 140) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 395 (170 – 450) |
| K5 | A/D/M/E | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 120 (50 – 140) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 395 (170 – 450) |
| K6 | A/D/M/E | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 120 (50 – 140) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 395 (170 – 450) |
| K7 | A/D/M/E | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 120 (50 – 140) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 395 (170 – 450) |
| N1 | E/M/A | 0.40 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 400 (300 – 500) |
| | | 0,40 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1300 (990 – 1600) |
| N11 | E/M/A | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 300 (200 – 390) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 980 (660 – 1200) |
| S11 | E | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 70 (50 – 99) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 230 (170 – 320) |
| S12 | E | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 70 (50 – 99) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 230 (170 – 320) |
| S13 | E | 0.60 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 70 (50 – 99) |
| | | 0,60 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 230 (170 – 320) |

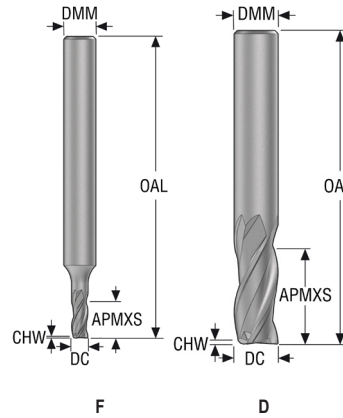
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_g = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

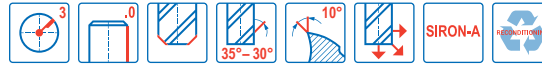
Universell
Stahl und Guss
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Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

JSE513

Allgemeine Anwendung – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Fase



- Toleranzen:
- DMM=h5
- DC=e8
- Nachschleifen möglich, wenn DC ≥ Ø10 ist

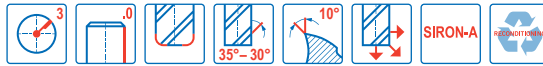
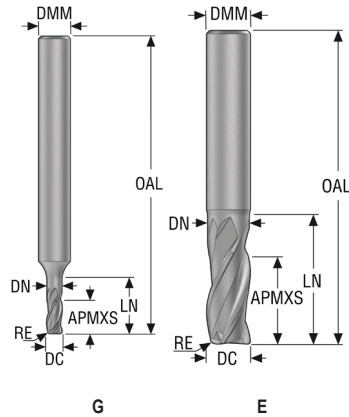


| Bezeichnung | Beschichtung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | CHW | PCEDC | Zylindrisch |
|------------------|--------------|--------------------|------------------|-------------------|------|------|-------|-------|-------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | | |
| JSE513020F2C.0Z3 | SIRA | 10053000 | 2 | F | 2,0 | 6,0 | 4,0 | 57,0 | 0,02 | 3 | ■ |
| JSE513025F2C.0Z3 | SIRA | 10053001 | 2 | F | 2,5 | 6,0 | 5,0 | 57,0 | 0,025 | 3 | ■ |
| JSE513030D2C.0Z3 | SIRA | 10052998 | 2 | D | 3,0 | 3,0 | 6,0 | 50,0 | 0,03 | 3 | ■ |
| JSE513030F2C.0Z3 | SIRA | 10053002 | 2 | F | 3,0 | 6,0 | 6,0 | 57,0 | 0,03 | 3 | ■ |
| JSE513040D2C.0Z3 | SIRA | 10052999 | 2 | D | 4,0 | 4,0 | 8,0 | 50,0 | 0,04 | 3 | ■ |
| JSE513040F2C.0Z3 | SIRA | 10053003 | 2 | F | 4,0 | 6,0 | 8,0 | 57,0 | 0,04 | 3 | ■ |
| JSE513050F2C.0Z3 | SIRA | 10053004 | 2 | F | 5,0 | 6,0 | 10,0 | 57,0 | 0,05 | 3 | ■ |
| JSE513060D2C.0Z3 | SIRA | 10053005 | 2 | D | 6,0 | 6,0 | 12,0 | 57,0 | 0,06 | 3 | ■ |
| JSE513070F2C.0Z3 | SIRA | 10053006 | 2 | F | 7,0 | 8,0 | 14,0 | 63,0 | 0,07 | 3 | ■ |
| JSE513080D2C.0Z3 | SIRA | 10053007 | 2 | D | 8,0 | 8,0 | 16,0 | 63,0 | 0,08 | 3 | ■ |
| JSE513090F2C.0Z3 | SIRA | 10053008 | 2 | F | 9,0 | 10,0 | 18,0 | 72,0 | 0,09 | 3 | ■ |
| JSE513100D2C.0Z3 | SIRA | 10053009 | 2 | D | 10,0 | 10,0 | 20,0 | 72,0 | 0,1 | 3 | ■ |
| JSE513110F2C.0Z3 | SIRA | 10053010 | 2 | F | 11,0 | 12,0 | 22,0 | 83,0 | 0,11 | 3 | ■ |
| JSE513120D2C.0Z3 | SIRA | 10053011 | 2 | D | 12,0 | 12,0 | 24,0 | 83,0 | 0,12 | 3 | ■ |
| JSE513140D2C.0Z3 | SIRA | 10053012 | 2 | D | 14,0 | 14,0 | 28,0 | 80,0 | 0,14 | 3 | ■ |
| JSE513160D2C.0Z3 | SIRA | 10053013 | 2 | D | 16,0 | 16,0 | 32,0 | 92,0 | 0,16 | 3 | ■ |
| JSE513180D2C.0Z3 | SIRA | 10053014 | 2 | D | 18,0 | 18,0 | 35,0 | 100,0 | 0,18 | 3 | ■ |
| JSE513200D2C.0Z3 | SIRA | 10053015 | 2 | D | 20,0 | 20,0 | 35,0 | 104,0 | 0,2 | 3 | ■ |
| JSE513030F3C.0Z3 | SIRA | 10053038 | 3 | F | 3,0 | 6,0 | 10,0 | 57,0 | 0,03 | 3 | ■ |
| JSE513040F3C.0Z3 | SIRA | 10053039 | 3 | F | 4,0 | 6,0 | 14,0 | 57,0 | 0,04 | 3 | ■ |
| JSE513050F3C.0Z3 | SIRA | 10053040 | 3 | F | 5,0 | 6,0 | 18,0 | 57,0 | 0,05 | 3 | ■ |
| JSE513060D3C.0Z3 | SIRA | 10053046 | 3 | D | 6,0 | 6,0 | 20,0 | 63,0 | 0,06 | 3 | ■ |
| JSE513080D3C.0Z3 | SIRA | 10053047 | 3 | D | 8,0 | 8,0 | 28,0 | 80,0 | 0,08 | 3 | ■ |
| JSE513100D3C.0Z3 | SIRA | 10053048 | 3 | D | 10,0 | 10,0 | 35,0 | 89,0 | 0,1 | 3 | ■ |
| JSE513120D3C.0Z3 | SIRA | 10053049 | 3 | D | 12,0 | 12,0 | 42,0 | 100,0 | 0,12 | 3 | ■ |
| JSE513160D3C.0Z3 | SIRA | 10053050 | 3 | D | 16,0 | 16,0 | 50,0 | 115,0 | 0,16 | 3 | ■ |
| JSE513200D3C.0Z3 | SIRA | 10053052 | 3 | D | 20,0 | 20,0 | 60,0 | 125,0 | 0,2 | 3 | ■ |
| JSE513030F4C.0Z3 | SIRA | 10201454 | 4 | F | 3,0 | 6,0 | 15,0 | 57,0 | 0,03 | 3 | ■ |
| JSE513040F4C.0Z3 | SIRA | 10201455 | 4 | F | 4,0 | 6,0 | 20,0 | 63,0 | 0,04 | 3 | ■ |
| JSE513050F4C.0Z3 | SIRA | 10201456 | 4 | F | 5,0 | 6,0 | 25,0 | 75,0 | 0,05 | 3 | ■ |
| JSE513060D4C.0Z3 | SIRA | 10201457 | 4 | D | 6,0 | 6,0 | 30,0 | 75,0 | 0,06 | 3 | ■ |
| JSE513080D4C.0Z3 | SIRA | 10201458 | 4 | D | 8,0 | 8,0 | 40,0 | 87,0 | 0,08 | 3 | ■ |
| JSE513100D4C.0Z3 | SIRA | 10201459 | 4 | D | 10,0 | 10,0 | 50,0 | 104,0 | 0,1 | 3 | ■ |
| JSE513120D4C.0Z3 | SIRA | 10201460 | 4 | D | 12,0 | 12,0 | 60,0 | 125,0 | 0,12 | 3 | ■ |
| JSE513160D4C.0Z3 | SIRA | 10201461 | 4 | D | 16,0 | 16,0 | 80,0 | 150,0 | 0,16 | 3 | ■ |
| JSE513200D4C.0Z3 | SIRA | 10201462 | 4 | D | 20,0 | 20,0 | 100,0 | 170,0 | 0,2 | 3 | ■ |

■ Lagerstandard.

JSE513

Allgemeine Anwendung – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,05 mm
- Nachschleifen möglich, wenn DC ≥ Ø10 ist

| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|---------------------|--------------|----------------|--------------|---------------|------|------|-------|-------|------|------|-----|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JSE513030G2R050.0Z3 | SIRA | 10053023 | 2 | G | 3,0 | 6,0 | 6,0 | 57,0 | 10,0 | 2,85 | 0,5 | 3 | ■ |
| JSE513040G2R050.0Z3 | SIRA | 10053024 | 2 | G | 4,0 | 6,0 | 8,0 | 57,0 | 13,0 | 3,8 | 0,5 | 3 | ■ |
| JSE513050G2R050.0Z3 | SIRA | 10053025 | 2 | G | 5,0 | 6,0 | 10,0 | 57,0 | 16,0 | 4,75 | 0,5 | 3 | ■ |
| JSE513060E2R050.0Z3 | SIRA | 10053026 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,5 | 3 | ■ |
| JSE513060E2R100.0Z3 | SIRA | 10053032 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 1,0 | 3 | ■ |
| JSE513080E2R050.0Z3 | SIRA | 10053027 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 0,5 | 3 | ■ |
| JSE513080E2R100.0Z3 | SIRA | 10053033 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 1,0 | 3 | ■ |
| JSE513100E2R050.0Z3 | SIRA | 10053028 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,5 | 3 | ■ |
| JSE513100E2R100.0Z3 | SIRA | 10053034 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 1,0 | 3 | ■ |
| JSE513120E2R050.0Z3 | SIRA | 10053029 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,5 | 3 | ■ |
| JSE513120E2R100.0Z3 | SIRA | 10053035 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 1,0 | 3 | ■ |
| JSE513160E2R050.0Z3 | SIRA | 10053030 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 0,5 | 3 | ■ |
| JSE513160E2R100.0Z3 | SIRA | 10053036 | 2 | E | 16,0 | 16,0 | 28,0 | 92,0 | 42,0 | 15,2 | 1,0 | 3 | ■ |
| JSE513200E2R050.0Z3 | SIRA | 10053031 | 2 | E | 20,0 | 20,0 | 35,0 | 104,0 | 51,0 | 19,0 | 0,5 | 3 | ■ |
| JSE513200E2R100.0Z3 | SIRA | 10053037 | 2 | E | 20,0 | 20,0 | 35,0 | 104,0 | 51,0 | 19,0 | 1,0 | 3 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

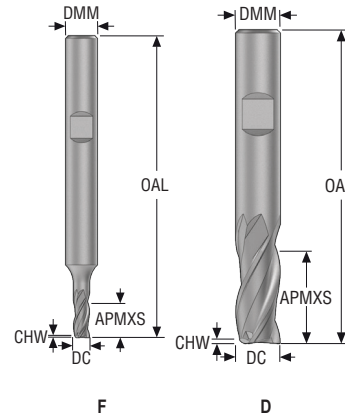
X-Heads

Minimaster Plus

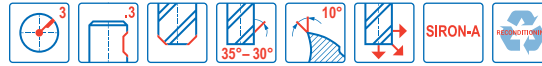
Minimaster

JSE513

Allgemeine Anwendung – Universell – Eckfräser – 3 Schneiden – Weldon – Fase



- Toleranzen:
- DMM=h5
- DC=e8
- Nachschleifen möglich, wenn DC ≥ Ø10 ist

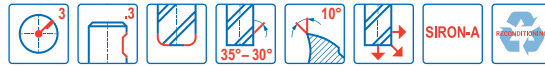
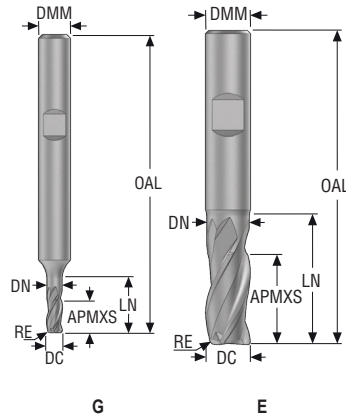


| Bezeichnung | Beschichtung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | CHW | PCEDC | Weldon |
|------------------|--------------|--------------------|------------------|-------------------|------|------|-------|-------|-------|-------|--------|
| | | | | | mm | mm | mm | mm | mm | | |
| JSE513020F2C.3Z3 | SIRA | 10053120 | 2 | F | 2,0 | 6,0 | 4,0 | 57,0 | 0,02 | 3 | ■ |
| JSE513025F2C.3Z3 | SIRA | 10053121 | 2 | F | 2,5 | 6,0 | 5,0 | 57,0 | 0,025 | 3 | ■ |
| JSE513030F2C.3Z3 | SIRA | 10053122 | 2 | F | 3,0 | 6,0 | 6,0 | 57,0 | 0,03 | 3 | ■ |
| JSE513040F2C.3Z3 | SIRA | 10053123 | 2 | F | 4,0 | 6,0 | 8,0 | 57,0 | 0,04 | 3 | ■ |
| JSE513050F2C.3Z3 | SIRA | 10053124 | 2 | F | 5,0 | 6,0 | 10,0 | 57,0 | 0,05 | 3 | ■ |
| JSE513060D2C.3Z3 | SIRA | 10053125 | 2 | D | 6,0 | 6,0 | 12,0 | 57,0 | 0,06 | 3 | ■ |
| JSE513070F2C.3Z3 | SIRA | 10053126 | 2 | F | 7,0 | 8,0 | 14,0 | 63,0 | 0,07 | 3 | ■ |
| JSE513080D2C.3Z3 | SIRA | 10053127 | 2 | D | 8,0 | 8,0 | 16,0 | 63,0 | 0,08 | 3 | ■ |
| JSE513090F2C.3Z3 | SIRA | 10053128 | 2 | F | 9,0 | 10,0 | 18,0 | 72,0 | 0,09 | 3 | ■ |
| JSE513100D2C.3Z3 | SIRA | 10053129 | 2 | D | 10,0 | 10,0 | 20,0 | 72,0 | 0,1 | 3 | ■ |
| JSE513110F2C.3Z3 | SIRA | 10053130 | 2 | F | 11,0 | 12,0 | 22,0 | 83,0 | 0,11 | 3 | ■ |
| JSE513120D2C.3Z3 | SIRA | 10053131 | 2 | D | 12,0 | 12,0 | 24,0 | 83,0 | 0,12 | 3 | ■ |
| JSE513140D2C.3Z3 | SIRA | 10053132 | 2 | D | 14,0 | 14,0 | 28,0 | 80,0 | 0,14 | 3 | ■ |
| JSE513160D2C.3Z3 | SIRA | 10053133 | 2 | D | 16,0 | 16,0 | 32,0 | 92,0 | 0,16 | 3 | ■ |
| JSE513180D2C.3Z3 | SIRA | 10053258 | 2 | D | 18,0 | 18,0 | 35,0 | 100,0 | 0,18 | 3 | ■ |
| JSE513200D2C.3Z3 | SIRA | 10053259 | 2 | D | 20,0 | 20,0 | 35,0 | 104,0 | 0,2 | 3 | ■ |
| JSE513030F3C.3Z3 | SIRA | 10053275 | 3 | F | 3,0 | 6,0 | 10,0 | 57,0 | 0,03 | 3 | ■ |
| JSE513040F3C.3Z3 | SIRA | 10053276 | 3 | F | 4,0 | 6,0 | 14,0 | 57,0 | 0,04 | 3 | ■ |
| JSE513050F3C.3Z3 | SIRA | 10053277 | 3 | F | 5,0 | 6,0 | 18,0 | 57,0 | 0,05 | 3 | ■ |
| JSE513060D3C.3Z3 | SIRA | 10053283 | 3 | D | 6,0 | 6,0 | 20,0 | 63,0 | 0,06 | 3 | ■ |
| JSE513080D3C.3Z3 | SIRA | 10053284 | 3 | D | 8,0 | 8,0 | 28,0 | 80,0 | 0,08 | 3 | ■ |
| JSE513100D3C.3Z3 | SIRA | 10053285 | 3 | D | 10,0 | 10,0 | 35,0 | 89,0 | 0,1 | 3 | ■ |
| JSE513120D3C.3Z3 | SIRA | 10053286 | 3 | D | 12,0 | 12,0 | 42,0 | 100,0 | 0,12 | 3 | ■ |
| JSE513160D3C.3Z3 | SIRA | 10053287 | 3 | D | 16,0 | 16,0 | 50,0 | 115,0 | 0,16 | 3 | ■ |
| JSE513200D3C.3Z3 | SIRA | 10053288 | 3 | D | 20,0 | 20,0 | 60,0 | 125,0 | 0,2 | 3 | ■ |
| JSE513030F4C.3Z3 | SIRA | 10201463 | 4 | F | 3,0 | 6,0 | 15,0 | 57,0 | 0,03 | 3 | ■ |
| JSE513040F4C.3Z3 | SIRA | 10201464 | 4 | F | 4,0 | 6,0 | 20,0 | 63,0 | 0,04 | 3 | ■ |
| JSE513050F4C.3Z3 | SIRA | 10201465 | 4 | F | 5,0 | 6,0 | 25,0 | 75,0 | 0,05 | 3 | ■ |
| JSE513060D4C.3Z3 | SIRA | 10201466 | 4 | D | 6,0 | 6,0 | 30,0 | 75,0 | 0,06 | 3 | ■ |
| JSE513080D4C.3Z3 | SIRA | 10201467 | 4 | D | 8,0 | 8,0 | 40,0 | 87,0 | 0,08 | 3 | ■ |
| JSE513100D4C.3Z3 | SIRA | 10201468 | 4 | D | 10,0 | 10,0 | 50,0 | 104,0 | 0,1 | 3 | ■ |
| JSE513120D4C.3Z3 | SIRA | 10201469 | 4 | D | 12,0 | 12,0 | 60,0 | 125,0 | 0,12 | 3 | ■ |
| JSE513160D4C.3Z3 | SIRA | 10201470 | 4 | D | 16,0 | 16,0 | 80,0 | 150,0 | 0,16 | 3 | ■ |
| JSE513200D4C.3Z3 | SIRA | 10201471 | 4 | D | 20,0 | 20,0 | 100,0 | 170,0 | 0,2 | 3 | ■ |

■ Lagerstandard.

JSE513

Allgemeine Anwendung – Universell – Eckfräser – 3 Schneiden – Weldon – Eckenradius



- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,05 mm
- Nachschleifen möglich, wenn DC ≥ Ø10 ist

| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Weldon |
|---------------------|--------------|----------------|--------------|---------------|------|------|-------|-------|------|------|-----|-------|--------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JSE513030G2R050.3Z3 | SIRA | 10053260 | 2 | G | 3,0 | 6,0 | 6,0 | 57,0 | 10,0 | 2,85 | 0,5 | 3 | ■ |
| JSE513040G2R050.3Z3 | SIRA | 10053261 | 2 | G | 4,0 | 6,0 | 8,0 | 57,0 | 13,0 | 3,8 | 0,5 | 3 | ■ |
| JSE513050G2R050.3Z3 | SIRA | 10053262 | 2 | G | 5,0 | 6,0 | 10,0 | 57,0 | 16,0 | 4,75 | 0,5 | 3 | ■ |
| JSE513060E2R050.3Z3 | SIRA | 10053263 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,5 | 3 | ■ |
| JSE513060E2R100.3Z3 | SIRA | 10053269 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 1,0 | 3 | ■ |
| JSE513080E2R050.3Z3 | SIRA | 10053264 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 0,5 | 3 | ■ |
| JSE513080E2R100.3Z3 | SIRA | 10053270 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 1,0 | 3 | ■ |
| JSE513100E2R050.3Z3 | SIRA | 10053265 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,5 | 3 | ■ |
| JSE513100E2R100.3Z3 | SIRA | 10053271 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 1,0 | 3 | ■ |
| JSE513120E2R050.3Z3 | SIRA | 10053266 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,5 | 3 | ■ |
| JSE513120E2R100.3Z3 | SIRA | 10053272 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 1,0 | 3 | ■ |
| JSE513160E2R050.3Z3 | SIRA | 10053267 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 0,5 | 3 | ■ |
| JSE513160E2R100.3Z3 | SIRA | 10053273 | 2 | E | 16,0 | 16,0 | 28,0 | 92,0 | 42,0 | 15,2 | 1,0 | 3 | ■ |
| JSE513200E2R050.3Z3 | SIRA | 10053268 | 2 | E | 20,0 | 20,0 | 35,0 | 104,0 | 51,0 | 19,0 | 0,5 | 3 | ■ |
| JSE513200E2R100.3Z3 | SIRA | 10053274 | 2 | E | 20,0 | 20,0 | 35,0 | 104,0 | 51,0 | 19,0 | 1,0 | 3 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

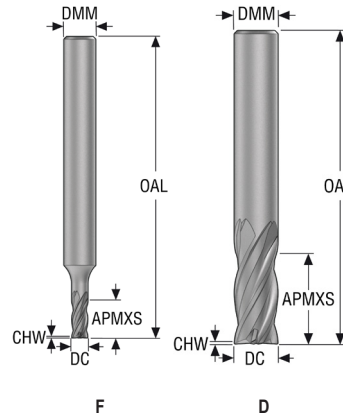
X-Heads

Minimaster Plus

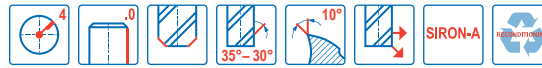
Minimaster

JSE514

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Fase



- Toleranzen:
- DMM=h5
- DC=e8
- Nachschleifen möglich, wenn DC ≥ Ø10 ist

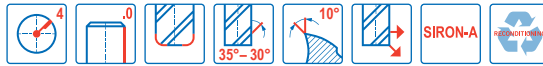
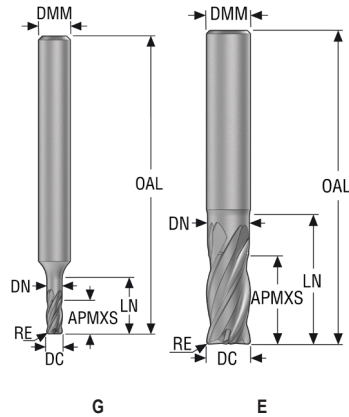


| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | CHW | PCEDC | Zylindrisch |
|------------------|--------------|----------------|--------------|---------------|------|------|-------|-------|------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | | |
| JSE514021F2C.0Z4 | SIRA | 10053053 | 2 | F | 2,0 | 3,0 | 4,0 | 50,0 | 0,02 | 4 | ■ |
| JSE514020F2C.0Z4 | SIRA | 10053057 | 2 | F | 2,0 | 6,0 | 4,0 | 57,0 | 0,02 | 4 | ■ |
| JSE514030D2C.0Z4 | SIRA | 10053054 | 2 | D | 3,0 | 3,0 | 6,0 | 50,0 | 0,03 | 4 | ■ |
| JSE514030F2C.0Z4 | SIRA | 10053058 | 2 | F | 3,0 | 6,0 | 6,0 | 57,0 | 0,03 | 4 | ■ |
| JSE514040D2C.0Z4 | SIRA | 10053055 | 2 | D | 4,0 | 4,0 | 8,0 | 50,0 | 0,04 | 4 | ■ |
| JSE514040F2C.0Z4 | SIRA | 10053059 | 2 | F | 4,0 | 6,0 | 8,0 | 57,0 | 0,04 | 4 | ■ |
| JSE514050D2C.0Z4 | SIRA | 10053056 | 2 | D | 5,0 | 5,0 | 10,0 | 50,0 | 0,05 | 4 | ■ |
| JSE514050F2C.0Z4 | SIRA | 10053060 | 2 | F | 5,0 | 6,0 | 10,0 | 57,0 | 0,05 | 4 | ■ |
| JSE514060D2C.0Z4 | SIRA | 10053061 | 2 | D | 6,0 | 6,0 | 12,0 | 57,0 | 0,06 | 4 | ■ |
| JSE514080D2C.0Z4 | SIRA | 10053062 | 2 | D | 8,0 | 8,0 | 16,0 | 63,0 | 0,08 | 4 | ■ |
| JSE514100D2C.0Z4 | SIRA | 10053063 | 2 | D | 10,0 | 10,0 | 20,0 | 72,0 | 0,1 | 4 | ■ |
| JSE514120D2C.0Z4 | SIRA | 10053064 | 2 | D | 12,0 | 12,0 | 24,0 | 83,0 | 0,12 | 4 | ■ |
| JSE514160D2C.0Z4 | SIRA | 10053067 | 2 | D | 16,0 | 16,0 | 32,0 | 92,0 | 0,16 | 4 | ■ |
| JSE514180D2C.0Z4 | SIRA | 10053068 | 2 | D | 18,0 | 18,0 | 35,0 | 100,0 | 0,18 | 4 | ■ |
| JSE514200D2C.0Z4 | SIRA | 10053069 | 2 | D | 20,0 | 20,0 | 35,0 | 104,0 | 0,2 | 4 | ■ |
| JSE514250D2C.0Z4 | SIRA | 10053070 | 2 | D | 25,0 | 25,0 | 40,0 | 125,0 | 0,25 | 4 | ■ |
| JSE514030F3C.0Z4 | SIRA | 10053090 | 3 | F | 3,0 | 6,0 | 10,0 | 57,0 | 0,03 | 4 | ■ |
| JSE514040F3C.0Z4 | SIRA | 10053091 | 3 | F | 4,0 | 6,0 | 14,0 | 57,0 | 0,04 | 4 | ■ |
| JSE514050F3C.0Z4 | SIRA | 10053092 | 3 | F | 5,0 | 6,0 | 18,0 | 57,0 | 0,05 | 4 | ■ |
| JSE514060D3C.0Z4 | SIRA | 10053093 | 3 | D | 6,0 | 6,0 | 20,0 | 63,0 | 0,06 | 4 | ■ |
| JSE514080D3C.0Z4 | SIRA | 10053094 | 3 | D | 8,0 | 8,0 | 28,0 | 80,0 | 0,08 | 4 | ■ |
| JSE514100D3C.0Z4 | SIRA | 10053095 | 3 | D | 10,0 | 10,0 | 35,0 | 89,0 | 0,1 | 4 | ■ |
| JSE514120D3C.0Z4 | SIRA | 10053096 | 3 | D | 12,0 | 12,0 | 42,0 | 100,0 | 0,12 | 4 | ■ |
| JSE514160D3C.0Z4 | SIRA | 10053097 | 3 | D | 16,0 | 16,0 | 50,0 | 115,0 | 0,16 | 4 | ■ |
| JSE514200D3C.0Z4 | SIRA | 10053098 | 3 | D | 20,0 | 20,0 | 60,0 | 125,0 | 0,2 | 4 | ■ |
| JSE514030F4C.0Z4 | SIRA | 10201472 | 4 | F | 3,0 | 6,0 | 15,0 | 57,0 | 0,03 | 4 | ■ |
| JSE514040F4C.0Z4 | SIRA | 10201473 | 4 | F | 4,0 | 6,0 | 20,0 | 63,0 | 0,04 | 4 | ■ |
| JSE514050F4C.0Z4 | SIRA | 10201474 | 4 | F | 5,0 | 6,0 | 25,0 | 75,0 | 0,05 | 4 | ■ |
| JSE514060D4C.0Z4 | SIRA | 10201475 | 4 | D | 6,0 | 6,0 | 30,0 | 75,0 | 0,06 | 4 | ■ |
| JSE514080D4C.0Z4 | SIRA | 10201476 | 4 | D | 8,0 | 8,0 | 40,0 | 87,0 | 0,08 | 4 | ■ |
| JSE514100D4C.0Z4 | SIRA | 10201477 | 4 | D | 10,0 | 10,0 | 50,0 | 104,0 | 0,1 | 4 | ■ |
| JSE514120D4C.0Z4 | SIRA | 10201478 | 4 | D | 12,0 | 12,0 | 60,0 | 125,0 | 0,12 | 4 | ■ |
| JSE514160D4C.0Z4 | SIRA | 10201479 | 4 | D | 16,0 | 16,0 | 80,0 | 150,0 | 0,16 | 4 | ■ |
| JSE514200D4C.0Z4 | SIRA | 10201480 | 4 | D | 20,0 | 20,0 | 100,0 | 170,0 | 0,2 | 4 | ■ |

■ Lagerstandard.

JSE514

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,05 mm
- Nachschleifen möglich, wenn DC ≥ Ø10 ist

| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|---------------------|--------------|----------------|--------------|---------------|------|------|-------|-------|------|------|-----|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JSE514030G2R050.0Z4 | SIRA | 10053071 | 2 | G | 3,0 | 6,0 | 6,0 | 57,0 | 10,0 | 2,85 | 0,5 | 4 | ■ |
| JSE514040G2R050.0Z4 | SIRA | 10053072 | 2 | G | 4,0 | 6,0 | 8,0 | 57,0 | 13,0 | 3,8 | 0,5 | 4 | ■ |
| JSE514050G2R050.0Z4 | SIRA | 10053073 | 2 | G | 5,0 | 6,0 | 10,0 | 57,0 | 16,0 | 4,75 | 0,5 | 4 | ■ |
| JSE514060E2R050.0Z4 | SIRA | 10053074 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,5 | 4 | ■ |
| JSE514060E2R100.0Z4 | SIRA | 10053081 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 1,0 | 4 | ■ |
| JSE514080E2R050.0Z4 | SIRA | 10053075 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 0,5 | 4 | ■ |
| JSE514080E2R100.0Z4 | SIRA | 10053082 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 1,0 | 4 | ■ |
| JSE514100E2R050.0Z4 | SIRA | 10053076 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,5 | 4 | ■ |
| JSE514100E2R100.0Z4 | SIRA | 10053083 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 1,0 | 4 | ■ |
| JSE514120E2R050.0Z4 | SIRA | 10053077 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,5 | 4 | ■ |
| JSE514120E2R100.0Z4 | SIRA | 10053084 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 1,0 | 4 | ■ |
| JSE514160E2R050.0Z4 | SIRA | 10053078 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 0,5 | 4 | ■ |
| JSE514160E2R100.0Z4 | SIRA | 10053087 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 1,0 | 4 | ■ |
| JSE514200E2R050.0Z4 | SIRA | 10053079 | 2 | E | 20,0 | 20,0 | 35,0 | 104,0 | 51,0 | 19,0 | 0,5 | 4 | ■ |
| JSE514200E2R100.0Z4 | SIRA | 10053088 | 2 | E | 20,0 | 20,0 | 35,0 | 104,0 | 51,0 | 19,0 | 1,0 | 4 | ■ |
| JSE514250E2R050.0Z4 | SIRA | 10053080 | 2 | E | 25,0 | 25,0 | 40,0 | 125,0 | 66,0 | 23,8 | 0,5 | 4 | ■ |
| JSE514250E2R100.0Z4 | SIRA | 10053089 | 2 | E | 25,0 | 25,0 | 40,0 | 125,0 | 66,0 | 23,8 | 1,0 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

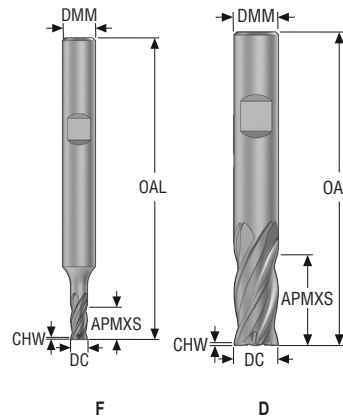
X-Heads

Minimaster Plus

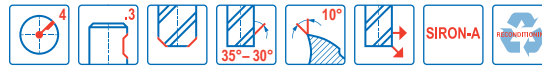
Minimaster

JSE514

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Weldon – Fase



- Toleranzen:
- DMM=h5
- DC=e8
- Nachschleifen möglich, wenn DC ≥ Ø10 ist



| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | CHW | PCEDC | Weldon |
|------------------|--------------|----------------|--------------|---------------|------|------|-------|-------|------|-------|--------|
| | | | | | mm | mm | mm | mm | mm | | |
| JSE514020F2C.3Z4 | SIRA | 10053289 | 2 | F | 2,0 | 6,0 | 4,0 | 57,0 | 0,02 | 4 | ■ |
| JSE514030F2C.3Z4 | SIRA | 10053290 | 2 | F | 3,0 | 6,0 | 6,0 | 57,0 | 0,03 | 4 | ■ |
| JSE514040F2C.3Z4 | SIRA | 10053291 | 2 | F | 4,0 | 6,0 | 8,0 | 57,0 | 0,04 | 4 | ■ |
| JSE514050F2C.3Z4 | SIRA | 10053292 | 2 | F | 5,0 | 6,0 | 10,0 | 57,0 | 0,05 | 4 | ■ |
| JSE514060D2C.3Z4 | SIRA | 10053293 | 2 | D | 6,0 | 6,0 | 12,0 | 57,0 | 0,06 | 4 | ■ |
| JSE514080D2C.3Z4 | SIRA | 10053294 | 2 | D | 8,0 | 8,0 | 16,0 | 63,0 | 0,08 | 4 | ■ |
| JSE514100D2C.3Z4 | SIRA | 10053295 | 2 | D | 10,0 | 10,0 | 20,0 | 72,0 | 0,1 | 4 | ■ |
| JSE514120D2C.3Z4 | SIRA | 10053296 | 2 | D | 12,0 | 12,0 | 24,0 | 83,0 | 0,12 | 4 | ■ |
| JSE514160D2C.3Z4 | SIRA | 10053297 | 2 | D | 16,0 | 16,0 | 32,0 | 92,0 | 0,16 | 4 | ■ |
| JSE514180D2C.3Z4 | SIRA | 10053298 | 2 | D | 18,0 | 18,0 | 35,0 | 100,0 | 0,18 | 4 | ■ |
| JSE514200D2C.3Z4 | SIRA | 10053299 | 2 | D | 20,0 | 20,0 | 35,0 | 104,0 | 0,2 | 4 | ■ |
| JSE514250D2C.3Z4 | SIRA | 10053300 | 2 | D | 25,0 | 25,0 | 40,0 | 125,0 | 0,25 | 4 | ■ |
| JSE514030F3C.3Z4 | SIRA | 10053321 | 3 | F | 3,0 | 6,0 | 10,0 | 57,0 | 0,03 | 4 | ■ |
| JSE514040F3C.3Z4 | SIRA | 10053322 | 3 | F | 4,0 | 6,0 | 14,0 | 57,0 | 0,04 | 4 | ■ |
| JSE514050F3C.3Z4 | SIRA | 10053323 | 3 | F | 5,0 | 6,0 | 18,0 | 57,0 | 0,05 | 4 | ■ |
| JSE514060D3C.3Z4 | SIRA | 10053324 | 3 | D | 6,0 | 6,0 | 20,0 | 63,0 | 0,06 | 4 | ■ |
| JSE514080D3C.3Z4 | SIRA | 10053325 | 3 | D | 8,0 | 8,0 | 28,0 | 80,0 | 0,08 | 4 | ■ |
| JSE514100D3C.3Z4 | SIRA | 10053326 | 3 | D | 10,0 | 10,0 | 35,0 | 89,0 | 0,1 | 4 | ■ |
| JSE514120D3C.3Z4 | SIRA | 10053327 | 3 | D | 12,0 | 12,0 | 42,0 | 100,0 | 0,12 | 4 | ■ |
| JSE514160D3C.3Z4 | SIRA | 10053328 | 3 | D | 16,0 | 16,0 | 50,0 | 115,0 | 0,16 | 4 | ■ |
| JSE514200D3C.3Z4 | SIRA | 10053329 | 3 | D | 20,0 | 20,0 | 60,0 | 125,0 | 0,2 | 4 | ■ |
| JSE514030F4C.3Z4 | SIRA | 10201481 | 4 | F | 3,0 | 6,0 | 15,0 | 57,0 | 0,03 | 4 | ■ |
| JSE514040F4C.3Z4 | SIRA | 10201482 | 4 | F | 4,0 | 6,0 | 20,0 | 63,0 | 0,04 | 4 | ■ |
| JSE514050F4C.3Z4 | SIRA | 10201483 | 4 | F | 5,0 | 6,0 | 25,0 | 75,0 | 0,05 | 4 | ■ |
| JSE514060D4C.3Z4 | SIRA | 10201484 | 4 | D | 6,0 | 6,0 | 30,0 | 75,0 | 0,06 | 4 | ■ |
| JSE514080D4C.3Z4 | SIRA | 10201485 | 4 | D | 8,0 | 8,0 | 40,0 | 87,0 | 0,08 | 4 | ■ |
| JSE514100D4C.3Z4 | SIRA | 10201486 | 4 | D | 10,0 | 10,0 | 50,0 | 104,0 | 0,1 | 4 | ■ |
| JSE514120D4C.3Z4 | SIRA | 10201487 | 4 | D | 12,0 | 12,0 | 60,0 | 125,0 | 0,12 | 4 | ■ |
| JSE514160D4C.3Z4 | SIRA | 10201488 | 4 | D | 16,0 | 16,0 | 80,0 | 150,0 | 0,16 | 4 | ■ |
| JSE514200D4C.3Z4 | SIRA | 10201489 | 4 | D | 20,0 | 20,0 | 100,0 | 170,0 | 0,2 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und Composite

Graphit

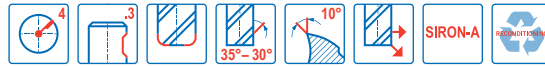
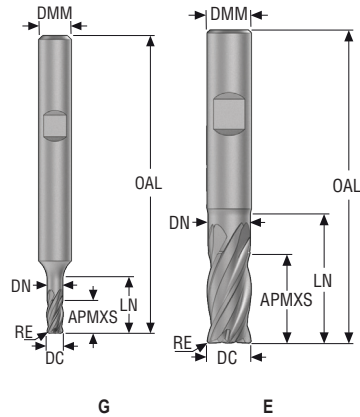
X-Heads

Minimaster Plus

Minimaster

JSE514

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Weldon – Eckenradius



- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,05 mm
- Nachschleifen möglich, wenn DC ≥ Ø10 ist

| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Weldon |
|---------------------|--------------|----------------|--------------|---------------|------|------|-------|-------|------|------|-----|-------|--------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JSE514030G2R050.3Z4 | SIRA | 10053301 | 2 | G | 3,0 | 6,0 | 6,0 | 57,0 | 10,0 | 2,85 | 0,5 | 4 | ■ |
| JSE514040G2R050.3Z4 | SIRA | 10053302 | 2 | G | 4,0 | 6,0 | 8,0 | 57,0 | 13,0 | 3,8 | 0,5 | 4 | ■ |
| JSE514050G2R050.3Z4 | SIRA | 10053306 | 2 | G | 5,0 | 6,0 | 10,0 | 57,0 | 16,0 | 4,75 | 0,5 | 4 | ■ |
| JSE514060E2R050.3Z4 | SIRA | 10053307 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,5 | 4 | ■ |
| JSE514060E2R100.3Z4 | SIRA | 10053314 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 1,0 | 4 | ■ |
| JSE514080E2R050.3Z4 | SIRA | 10053308 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 0,5 | 4 | ■ |
| JSE514080E2R100.3Z4 | SIRA | 10053315 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 1,0 | 4 | ■ |
| JSE514100E2R050.3Z4 | SIRA | 10053309 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,5 | 4 | ■ |
| JSE514100E2R100.3Z4 | SIRA | 10053316 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 1,0 | 4 | ■ |
| JSE514120E2R050.3Z4 | SIRA | 10053310 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,5 | 4 | ■ |
| JSE514120E2R100.3Z4 | SIRA | 10053317 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 1,0 | 4 | ■ |
| JSE514160E2R050.3Z4 | SIRA | 10053311 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 0,5 | 4 | ■ |
| JSE514160E2R100.3Z4 | SIRA | 10053318 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 1,0 | 4 | ■ |
| JSE514200E2R050.3Z4 | SIRA | 10053312 | 2 | E | 20,0 | 20,0 | 35,0 | 104,0 | 51,0 | 19,0 | 0,5 | 4 | ■ |
| JSE514200E2R100.3Z4 | SIRA | 10053319 | 2 | E | 20,0 | 20,0 | 35,0 | 104,0 | 51,0 | 19,0 | 1,0 | 4 | ■ |
| JSE514250E2R050.3Z4 | SIRA | 10053313 | 2 | E | 25,0 | 25,0 | 40,0 | 125,0 | 66,0 | 23,8 | 0,5 | 4 | ■ |
| JSE514250E2R100.3Z4 | SIRA | 10053320 | 2 | E | 25,0 | 25,0 | 40,0 | 125,0 | 66,0 | 23,8 | 1,0 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

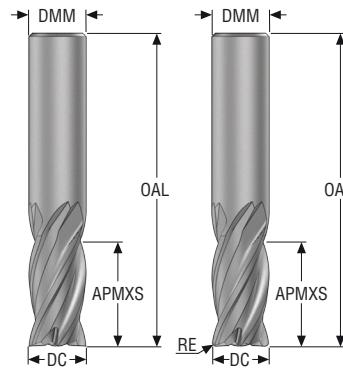
X-Heads

Minimaster Plus

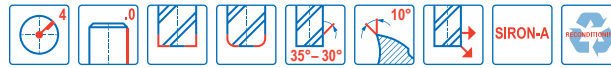
Minimaster

JSE514

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Zylindrisch – scharf oder Eckenradius – Zoll



- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±.002 Zoll
- Nachschleifen möglich, wenn DC ≥ Ø.375 ist



| Bezeichnung | Beschichtung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | RE | PCEDC | Zylindrisch |
|----------------------|--------------|--------------------|------------------|-------------------|-------|-------|-------|-------|-------|-------|-------------|
| | | | | | Zoll | Zoll | Zoll | Zoll | Zoll | | |
| JSE514.250D1S.0Z4 | SIRA | 10201805 | 1 | D | 0.250 | 0.250 | 0.375 | 2.000 | – | 4 | ■ |
| JSE514.250D1R030.0Z4 | SIRA | 10201812 | 1 | D | 0.250 | 0.250 | 0.375 | 2.000 | 0.030 | 4 | ■ |
| JSE514.375D1S.0Z4 | SIRA | 10201806 | 1 | D | 0.375 | 0.375 | 0.500 | 2.000 | – | 4 | ■ |
| JSE514.375D1R030.0Z4 | SIRA | 10201813 | 1 | D | 0.375 | 0.375 | 0.500 | 2.000 | 0.030 | 4 | ■ |
| JSE514.500D1S.0Z4 | SIRA | 10201807 | 1 | D | 0.500 | 0.500 | 0.625 | 2.500 | – | 4 | ■ |
| JSE514.500D1R030.0Z4 | SIRA | 10201814 | 1 | D | 0.500 | 0.500 | 0.625 | 2.500 | 0.030 | 4 | ■ |
| JSE514.500D1R060.0Z4 | SIRA | 10201815 | 1 | D | 0.500 | 0.500 | 0.625 | 2.500 | 0.060 | 4 | ■ |
| JSE514.625D1S.0Z4 | SIRA | 10201808 | 1 | D | 0.625 | 0.625 | 0.750 | 3.000 | – | 4 | ■ |
| JSE514.625D1R030.0Z4 | SIRA | 10201816 | 1 | D | 0.625 | 0.625 | 0.750 | 3.000 | 0.030 | 4 | ■ |
| JSE514.625D1R060.0Z4 | SIRA | 10201817 | 1 | D | 0.625 | 0.625 | 0.750 | 3.000 | 0.060 | 4 | ■ |
| JSE514.750D1S.0Z4 | SIRA | 10201809 | 1 | D | 0.750 | 0.750 | 0.875 | 3.000 | – | 4 | ■ |
| JSE514.750D1R030.0Z4 | SIRA | 10201818 | 1 | D | 0.750 | 0.750 | 0.875 | 3.000 | 0.030 | 4 | ■ |
| JSE514.750D1R060.0Z4 | SIRA | 10201819 | 1 | D | 0.750 | 0.750 | 0.875 | 3.000 | 0.060 | 4 | ■ |
| JSE514.125D2S.0Z4 | SIRA | 10201803 | 2 | D | 0.125 | 0.125 | 0.250 | 1.500 | – | 4 | ■ |
| JSE514.125D2R015.0Z4 | SIRA | 10201810 | 2 | D | 0.125 | 0.125 | 0.250 | 1.500 | 0.015 | 4 | ■ |
| JSE514.188D2S.0Z4 | SIRA | 10201804 | 2 | D | 0.188 | 0.188 | 0.375 | 2.000 | – | 4 | ■ |
| JSE514.188D2R020.0Z4 | SIRA | 10201811 | 2 | D | 0.188 | 0.188 | 0.375 | 2.000 | 0.020 | 4 | ■ |
| JSE514.250D2S.0Z4 | SIRA | 10201822 | 2 | D | 0.250 | 0.250 | 0.500 | 2.000 | – | 4 | ■ |
| JSE514.250D2R030.0Z4 | SIRA | 10201829 | 2 | D | 0.250 | 0.250 | 0.500 | 2.000 | 0.030 | 4 | ■ |
| JSE514.375D2S.0Z4 | SIRA | 10201823 | 2 | D | 0.375 | 0.375 | 0.625 | 2.000 | – | 4 | ■ |
| JSE514.375D2R030.0Z4 | SIRA | 10201830 | 2 | D | 0.375 | 0.375 | 0.625 | 2.000 | 0.030 | 4 | ■ |
| JSE514.500D2S.0Z4 | SIRA | 10201824 | 2 | D | 0.500 | 0.500 | 1.000 | 3.000 | – | 4 | ■ |
| JSE514.500D2R030.0Z4 | SIRA | 10201831 | 2 | D | 0.500 | 0.500 | 1.000 | 3.000 | 0.030 | 4 | ■ |
| JSE514.500D2R060.0Z4 | SIRA | 10201832 | 2 | D | 0.500 | 0.500 | 1.000 | 3.000 | 0.060 | 4 | ■ |
| JSE514.625D2S.0Z4 | SIRA | 10201825 | 2 | D | 0.625 | 0.625 | 0.049 | 3.500 | – | 4 | ■ |
| JSE514.625D2R030.0Z4 | SIRA | 10201833 | 2 | D | 0.625 | 0.625 | 1.250 | 3.500 | 0.030 | 4 | ■ |
| JSE514.625D2R060.0Z4 | SIRA | 10201834 | 2 | D | 0.625 | 0.625 | 1.250 | 3.500 | 0.060 | 4 | ■ |
| JSE514.750D2S.0Z4 | SIRA | 10201826 | 2 | D | 0.750 | 0.750 | 1.500 | 4.000 | – | 4 | ■ |
| JSE514.750D2R030.0Z4 | SIRA | 10201835 | 2 | D | 0.750 | 0.750 | 1.500 | 4.000 | 0.030 | 4 | ■ |
| JSE514.750D2R060.0Z4 | SIRA | 10201836 | 2 | D | 0.750 | 0.750 | 1.500 | 4.000 | 0.060 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und Composite

Graphit

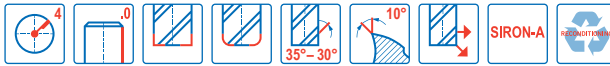
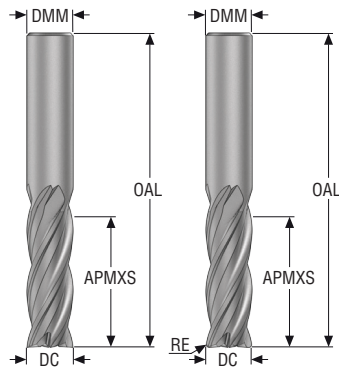
X-Heads

Minimaster Plus

Minimaster

JSE514

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Zylindrisch – scharf oder Eckenradius – Zoll



- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±.002 Zoll
- Nachschleifen möglich, wenn DC ≥ Ø.375 ist

| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | RE | PCEDC | Zylindrisch |
|----------------------|--------------|----------------|--------------|---------------|-------|-------|-------|-------|-------|-------|-------------|
| | | | | | Zoll | Zoll | Zoll | Zoll | Zoll | | |
| JSE514.125D3S.0Z4 | SIRA | 10201820 | 3 | D | 0.125 | 0.125 | 0.500 | 1.500 | - | 4 | ■ |
| JSE514.125D3R015.0Z4 | SIRA | 10201827 | 3 | D | 0.125 | 0.125 | 0.500 | 1.500 | 0.015 | 4 | ■ |
| JSE514.188D3S.0Z4 | SIRA | 10201821 | 3 | D | 0.188 | 0.188 | 0.625 | 2.000 | - | 4 | ■ |
| JSE514.188D3R020.0Z4 | SIRA | 10201828 | 3 | D | 0.188 | 0.188 | 0.625 | 2.000 | 0.020 | 4 | ■ |
| JSE514.250D3S.0Z4 | SIRA | 10201837 | 3 | D | 0.250 | 0.250 | 0.750 | 2.500 | - | 4 | ■ |
| JSE514.250D3R030.0Z4 | SIRA | 10201842 | 3 | D | 0.250 | 0.250 | 0.750 | 2.500 | 0.030 | 4 | ■ |
| JSE514.375D3S.0Z4 | SIRA | 10201838 | 3 | D | 0.375 | 0.375 | 1.000 | 2.500 | - | 4 | ■ |
| JSE514.375D3R030.0Z4 | SIRA | 10201843 | 3 | D | 0.375 | 0.375 | 1.000 | 2.500 | 0.030 | 4 | ■ |
| JSE514.500D3S.0Z4 | SIRA | 10201839 | 3 | D | 0.500 | 0.500 | 2.000 | 4.000 | - | 4 | ■ |
| JSE514.500D3R030.0Z4 | SIRA | 10201844 | 3 | D | 0.500 | 0.500 | 2.000 | 4.000 | 0.030 | 4 | ■ |
| JSE514.500D3R060.0Z4 | SIRA | 10201845 | 3 | D | 0.500 | 0.500 | 2.000 | 4.000 | 0.060 | 4 | ■ |
| JSE514.625D3S.0Z4 | SIRA | 10201840 | 3 | D | 0.625 | 0.625 | 2.250 | 5.000 | - | 4 | ■ |
| JSE514.625D3R030.0Z4 | SIRA | 10201846 | 3 | D | 0.625 | 0.625 | 2.250 | 5.000 | 0.030 | 4 | ■ |
| JSE514.625D3R060.0Z4 | SIRA | 10201847 | 3 | D | 0.625 | 0.625 | 2.250 | 5.000 | 0.060 | 4 | ■ |
| JSE514.750D3S.0Z4 | SIRA | 10201841 | 3 | D | 0.750 | 0.750 | 2.250 | 5.000 | - | 4 | ■ |
| JSE514.750D3R030.0Z4 | SIRA | 10201848 | 3 | D | 0.750 | 0.750 | 2.250 | 5.000 | 0.030 | 4 | ■ |
| JSE514.750D3R060.0Z4 | SIRA | 10201849 | 3 | D | 0.750 | 0.750 | 2.250 | 5.000 | 0.060 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster


Schnittdaten – JSE514 Eckfräsen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|---------|---------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 18 | 20 | 25 | |
| P1 | M/A/D/E | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 165 (69 – 200) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 540 (230 – 650) |
| P2 | M/A/D/E | 0.150 | 1.5 | 0.014 | 0.020 | 0.028 | 0.034 | 0.040 | 0.055 | 0.070 | 0.080 | 0.10 | 0.11 | 0.11 | 0.13 | 160 (67 – 190) |
| | | 0,150 | 1,5 | 0,00055 | 0,00080 | 0,0011 | 0,0013 | 0,0016 | 0,0022 | 0,0028 | 0,0032 | 0,0040 | 0,0044 | 0,0044 | 0,0050 | 520 (220 – 620) |
| P3 | M/A/D/E | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 165 (69 – 200) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 540 (230 – 650) |
| P4 | M/A/D/E | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 165 (69 – 200) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 540 (230 – 650) |
| P5 | M/A/D/E | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 165 (69 – 200) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 540 (230 – 650) |
| P6 | M/A/D/E | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 165 (69 – 200) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 540 (230 – 650) |
| P7 | M/A/D/E | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 165 (69 – 200) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 540 (230 – 650) |
| P8 | M/A/D/E | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 165 (69 – 200) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 540 (230 – 650) |
| P11 | M/A/D/E | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 95 (69 – 130) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 310 (230 – 420) |
| P12 | M/A/D/E | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 95 (69 – 130) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 310 (230 – 420) |
| M1 | E/M/A | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 95 (69 – 130) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 310 (230 – 420) |
| M2 | E/M/A | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 95 (69 – 130) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 310 (230 – 420) |
| M3 | E/M/A | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 95 (69 – 130) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 310 (230 – 420) |
| M4 | E/M/A | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 95 (69 – 130) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 310 (230 – 420) |
| M5 | E/M/A | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 95 (69 – 130) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 310 (230 – 420) |
| K1 | A/D/M/E | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 165 (69 – 200) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 540 (230 – 650) |
| K2 | A/D/M/E | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 165 (69 – 200) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 540 (230 – 650) |
| K3 | A/D/M/E | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 165 (69 – 200) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 540 (230 – 650) |
| K4 | A/D/M/E | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 165 (69 – 200) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 540 (230 – 650) |
| K5 | A/D/M/E | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 165 (69 – 200) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 540 (230 – 650) |
| K6 | A/D/M/E | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 165 (69 – 200) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 540 (230 – 650) |
| K7 | A/D/M/E | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 165 (69 – 200) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 540 (230 – 650) |
| N1 | E/M/A | 0.150 | 1.5 | 0.015 | 0.024 | 0.030 | 0.038 | 0.046 | 0.060 | 0.075 | 0.090 | 0.11 | 0.12 | 0.13 | 0.15 | 520 (400 – 650) |
| | | 0,150 | 1,5 | 0,00060 | 0,00095 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 0,0048 | 0,0050 | 0,0060 | 1700 (1400 – 2100) |
| N11 | E/M/A | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 410 (280 – 540) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 1350 (920 – 1700) |
| S11 | E | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 95 (69 – 130) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 310 (230 – 420) |
| S12 | E | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 95 (69 – 130) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 310 (230 – 420) |
| S13 | E | 0.150 | 1.5 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.095 | 0.10 | 0.12 | 95 (69 – 130) |
| | | 0,150 | 1,5 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0038 | 0,0040 | 0,0048 | 310 (230 – 420) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – JSE514 Nutfräsen

| SMG |  | a _p /DC | f _z | | | | | | | | | | | | v _c |
|-----|---|--------------------|----------------|---------|---------|---------|---------|---------|--------|--------|--------|--------|--------|--------|-------------------|
| | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 18 | 20 | 25 | |
| P1 | M/A/D/E | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 120 (51 – 150) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 395 (170 – 490) |
| P2 | M/A/D/E | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 120 (51 – 150) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 395 (170 – 490) |
| P3 | M/A/D/E | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 120 (51 – 150) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 395 (170 – 490) |
| P4 | M/A/D/E | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 120 (51 – 150) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 395 (170 – 450) |
| P5 | M/A/D/E | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 120 (51 – 150) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 395 (170 – 490) |
| P6 | M/A/D/E | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 120 (50 – 140) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 395 (170 – 450) |
| P7 | M/A/D/E | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 120 (51 – 150) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 395 (170 – 490) |
| P8 | M/A/D/E | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 120 (51 – 150) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 395 (170 – 490) |
| P11 | M/A/D/E | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 70 (51 – 100) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 230 (170 – 320) |
| P12 | M/A/D/E | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 70 (50 – 99) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 230 (170 – 320) |
| M1 | E/M/A | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 70 (50 – 99) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 230 (170 – 320) |
| M2 | E/M/A | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 70 (50 – 99) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 230 (170 – 320) |
| M3 | E/M/A | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 70 (50 – 99) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 230 (170 – 320) |
| M4 | E/M/A | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 70 (50 – 99) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 230 (170 – 320) |
| M5 | E/M/A | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 70 (50 – 99) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 230 (170 – 320) |
| K1 | A/D/M/E | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 120 (50 – 150) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 395 (170 – 490) |
| K2 | A/D/M/E | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 120 (50 – 150) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 395 (170 – 490) |
| K3 | A/D/M/E | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 120 (50 – 150) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 395 (170 – 490) |
| K4 | A/D/M/E | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 120 (50 – 150) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 395 (170 – 490) |
| K5 | A/D/M/E | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 120 (50 – 150) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 395 (170 – 490) |
| K6 | A/D/M/E | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 120 (50 – 150) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 395 (170 – 490) |
| K7 | A/D/M/E | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 120 (50 – 150) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 395 (170 – 490) |
| N1 | E/M/A | 0.30 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 400 (300 – 500) |
| | | 0,30 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 1300 (990 – 1600) |
| N11 | E/M/A | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 300 (200 – 390) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 980 (660 – 1200) |
| S11 | E | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 70 (50 – 99) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 230 (170 – 320) |
| S12 | E | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 70 (50 – 99) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 230 (170 – 320) |
| S13 | E | 0.40 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.055 | 0.060 | 0.075 | 70 (50 – 99) |
| | | 0,40 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0022 | 0,0024 | 0,0030 | 230 (170 – 320) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_s = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Universell
Stahl und Guss
Stahlwerkstoffe
ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

Schnittdaten – JS514 Eckfräsen – Zoll

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 1/8 | 3/16 | 1.4 | 3/8 | 1/2 | 5/8 | 3/4 | |
| P1 | M/A/D/E | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 165 (69 — 200) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 540 (230 — 650) |
| P2 | M/A/D/E | 0,15 | 1,2 | 0,022 | 0,032 | 0,042 | 0,065 | 0,085 | 0,10 | 0,11 | 160 (67 — 200) |
| | | 0,15 | 1,2 | 0,00085 | 0,0013 | 0,0017 | 0,0026 | 0,0034 | 0,0040 | 0,0044 | 520 (220 — 650) |
| P3 | M/A/D/E | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 165 (68 — 200) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 540 (230 — 650) |
| P4 | M/A/D/E | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 165 (68 — 200) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 540 (230 — 650) |
| P5 | M/A/D/E | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 165 (68 — 200) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 540 (230 — 650) |
| P6 | M/A/D/E | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 165 (68 — 200) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 540 (230 — 650) |
| P7 | M/A/D/E | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 165 (68 — 200) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 540 (230 — 650) |
| P8 | M/A/D/E | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 165 (68 — 200) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 540 (230 — 650) |
| P11 | M/A/D/E | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 95 (68 — 130) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 310 (230 — 420) |
| P12 | M/A/D/E | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 95 (68 — 130) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 310 (230 — 420) |
| M1 | E/M/A | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 95 (68 — 130) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 310 (230 — 420) |
| M2 | E/M/A | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 95 (68 — 130) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 310 (230 — 420) |
| M3 | E/M/A | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 95 (68 — 130) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 310 (230 — 420) |
| M4 | E/M/A | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 95 (68 — 130) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 310 (230 — 420) |
| M5 | E/M/A | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 95 (68 — 130) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 310 (230 — 420) |
| K1 | A/D/M/E | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 165 (68 — 200) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 540 (230 — 650) |
| K2 | A/D/M/E | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 165 (68 — 200) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 540 (230 — 650) |
| K3 | A/D/M/E | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 165 (68 — 200) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 540 (230 — 650) |
| K4 | A/D/M/E | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 165 (68 — 200) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 540 (230 — 650) |
| K5 | A/D/M/E | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 165 (68 — 200) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 540 (230 — 650) |
| K6 | A/D/M/E | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 165 (68 — 200) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 540 (230 — 650) |
| K7 | A/D/M/E | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 165 (68 — 200) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 540 (230 — 650) |
| N1 | E/M/A | 0,15 | 1,2 | 0,025 | 0,036 | 0,050 | 0,075 | 0,095 | 0,11 | 0,13 | 520 (400 — 650) |
| | | 0,15 | 1,2 | 0,0010 | 0,0014 | 0,0020 | 0,0030 | 0,0038 | 0,0044 | 0,0050 | 1700 (1400 — 2100) |
| N11 | E/M/A | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 410 (280 — 540) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 1350 (920 — 1700) |
| S11 | E | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 95 (68 — 130) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 310 (230 — 420) |
| S12 | E | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 95 (68 — 130) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 310 (230 — 420) |
| S13 | E | 0,15 | 1,2 | 0,019 | 0,028 | 0,038 | 0,060 | 0,075 | 0,090 | 0,10 | 95 (68 — 130) |
| | | 0,15 | 1,2 | 0,00075 | 0,0011 | 0,0015 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 310 (230 — 420) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)


f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Schnittdaten – JS514 Nutfräsen – Zoll

| SMG |  | a _p /DC | f _z | | | | | | | v _c |
|-----|---|--------------------|----------------|---------|---------|--------|--------|--------|--------|--------------------|
| | | | 1/8 | 3/16 | 1/4 | 3/8 | 1/2 | 5/8 | 3/4 | |
| P1 | M/A/D/E | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 120 (51 – 150) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 395 (170 – 490) |
| P2 | M/A/D/E | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 120 (51 – 150) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 395 (170 – 490) |
| P3 | M/A/D/E | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 120 (51 – 150) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 395 (170 – 490) |
| P4 | M/A/D/E | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 120 (51 – 150) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 395 (170 – 490) |
| P5 | M/A/D/E | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 120 (51 – 150) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 395 (170 – 490) |
| P6 | M/A/D/E | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 120 (51 – 150) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 395 (170 – 490) |
| P7 | M/A/D/E | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 120 (51 – 150) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 395 (170 – 490) |
| P8 | M/A/D/E | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 120 (51 – 150) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 395 (170 – 490) |
| P11 | M/A/D/E | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 70 (51 – 100) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 230 (170 – 320) |
| P12 | M/A/D/E | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 70 (51 – 100) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 230 (170 – 320) |
| M1 | E/M/A | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 70 (51 – 100) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 230 (170 – 320) |
| M2 | E/M/A | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 70 (51 – 100) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 230 (170 – 320) |
| M3 | E/M/A | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 70 (51 – 100) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 230 (170 – 320) |
| M4 | E/M/A | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 70 (51 – 100) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 230 (170 – 320) |
| M5 | E/M/A | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 70 (51 – 100) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 230 (170 – 320) |
| K1 | A/D/I/E | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 120 (51 – 150) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 395 (170 – 490) |
| K2 | A/D/I/E | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 120 (51 – 150) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 395 (170 – 490) |
| K3 | A/D/I/E | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 120 (51 – 150) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 395 (170 – 490) |
| K4 | A/D/I/E | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 120 (51 – 150) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 395 (170 – 490) |
| K5 | A/D/I/E | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 120 (51 – 150) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 395 (170 – 490) |
| K6 | A/D/I/E | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 120 (51 – 150) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 395 (170 – 490) |
| K7 | A/D/I/E | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 120 (51 – 150) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 395 (170 – 490) |
| N1 | E/M/A | 0,30 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 400 (310 – 500) |
| | | 0,30 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 1300 (1100 – 1600) |
| N11 | E/M/A | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 300 (210 – 400) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 980 (690 – 1300) |
| S11 | E | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 70 (51 – 100) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 230 (170 – 320) |
| S12 | E | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 70 (51 – 100) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 230 (170 – 320) |
| S13 | E | 0,40 | 0,0095 | 0,014 | 0,019 | 0,028 | 0,038 | 0,048 | 0,055 | 70 (51 – 100) |
| | | 0,40 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 230 (170 – 320) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_g = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

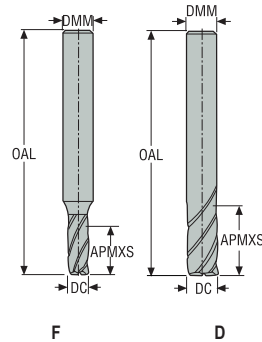
X-Heads

Minimaster Plus

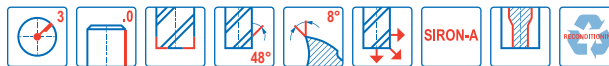
Minimaster

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Scharfe Schneide



- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | PCEDC | Zylindrisch |
|---------------------|----------------|--------------|---------------|------|------|-------|------|-------|-------------|
| | | | | mm | mm | mm | mm | | |
| 553020SZ3.0-SIRON-A | 02733903 | 2 | F | 2,0 | 6,0 | 5,0 | 50,0 | 3 | ■ |
| 553030SZ3.0-SIRON-A | 02733906 | 2 | F | 3,0 | 6,0 | 7,0 | 50,0 | 3 | ■ |
| 553040SZ3.0-SIRON-A | 02733910 | 2 | F | 4,0 | 6,0 | 10,0 | 55,0 | 3 | ■ |
| 553050SZ3.0-SIRON-A | 02733912 | 2 | F | 5,0 | 6,0 | 12,0 | 55,0 | 3 | ■ |
| 553060SZ3.0-SIRON-A | 02733914 | 2 | D | 6,0 | 6,0 | 14,0 | 55,0 | 3 | ■ |
| 553080SZ3.0-SIRON-A | 02733918 | 2 | D | 8,0 | 8,0 | 18,0 | 60,0 | 3 | ■ |
| 553100SZ3.0-SIRON-A | 02733922 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | 3 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

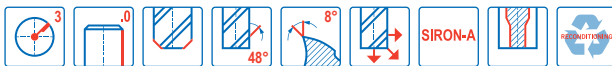
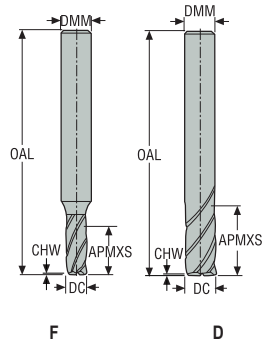
X-Heads

Minimaster Plus

Minimaster

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Fase



- Toleranzen:
- DMM= h5
- DC= e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | CHW | PCEDC | Zylindrisch |
|----------------------|----------------|--------------|---------------|------|------|-------|-------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | | |
| JS553020F1C.0Z3-SIRA | 10041466 | 1 | F | 2,0 | 6,0 | 3,0 | 40,0 | 0,025 | 3 | ■ |
| JS553030F1C.0Z3-SIRA | 10041467 | 1 | F | 3,0 | 6,0 | 4,0 | 40,0 | 0,035 | 3 | ■ |
| JS553040F1C.0Z3-SIRA | 10041468 | 1 | F | 4,0 | 6,0 | 6,0 | 40,0 | 0,045 | 3 | ■ |
| JS553045F1C.0Z3-SIRA | 10041469 | 1 | F | 4,5 | 6,0 | 6,0 | 40,0 | 0,045 | 3 | ■ |
| JS553050F1C.0Z3-SIRA | 10041470 | 1 | F | 5,0 | 6,0 | 7,0 | 40,0 | 0,055 | 3 | ■ |
| JS553055F1C.0Z3-SIRA | 10041472 | 1 | F | 5,5 | 6,0 | 8,0 | 40,0 | 0,055 | 3 | ■ |
| JS553060D1C.0Z3-SIRA | 10041473 | 1 | D | 6,0 | 6,0 | 8,0 | 40,0 | 0,075 | 3 | ■ |
| JS553080D1C.0Z3-SIRA | 10041474 | 1 | D | 8,0 | 8,0 | 11,0 | 50,0 | 0,1 | 3 | ■ |
| JS553100D1C.0Z3-SIRA | 10041475 | 1 | D | 10,0 | 10,0 | 13,0 | 57,0 | 0,125 | 3 | ■ |
| JS553120D1C.0Z3-SIRA | 10041476 | 1 | D | 12,0 | 12,0 | 15,0 | 65,0 | 0,15 | 3 | ■ |
| 553020Z3.0-SIRON-A | 02679241 | 2 | F | 2,0 | 6,0 | 5,0 | 50,0 | 0,025 | 3 | ■ |
| 553025Z3.0-SIRON-A | 02679352 | 2 | F | 2,5 | 6,0 | 7,0 | 50,0 | 0,025 | 3 | ■ |
| 553030Z3.0-SIRON-A | 02679353 | 2 | F | 3,0 | 6,0 | 7,0 | 50,0 | 0,035 | 3 | ■ |
| 553035Z3.0-SIRON-A | 02679359 | 2 | F | 3,5 | 6,0 | 9,0 | 55,0 | 0,035 | 3 | ■ |
| 553040Z3.0-SIRON-A | 02679360 | 2 | F | 4,0 | 6,0 | 10,0 | 55,0 | 0,045 | 3 | ■ |
| 553045Z3.0-SIRON-A | 02679361 | 2 | F | 4,5 | 6,0 | 12,0 | 55,0 | 0,045 | 3 | ■ |
| 553050Z3.0-SIRON-A | 02679364 | 2 | F | 5,0 | 6,0 | 12,0 | 55,0 | 0,055 | 3 | ■ |
| 553055Z3.0-SIRON-A | 02679365 | 2 | F | 5,5 | 6,0 | 14,0 | 55,0 | 0,055 | 3 | ■ |
| 553060Z3.0-SIRON-A | 02679368 | 2 | D | 6,0 | 6,0 | 14,0 | 55,0 | 0,075 | 3 | ■ |
| 553075Z3.0-SIRON-A | 02733916 | 2 | F | 7,5 | 8,0 | 18,0 | 60,0 | 0,1 | 3 | ■ |
| 553080Z3.0-SIRON-A | 02679371 | 2 | D | 8,0 | 8,0 | 18,0 | 60,0 | 0,1 | 3 | ■ |
| 553095Z3.0-SIRON-A | 02733920 | 2 | F | 9,5 | 10,0 | 22,0 | 70,0 | 0,125 | 3 | ■ |
| 553100Z3.0-SIRON-A | 02679374 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | 0,125 | 3 | ■ |
| 553115Z3.0-SIRON-A | 02733925 | 2 | F | 11,5 | 12,0 | 26,0 | 80,0 | 0,15 | 3 | ■ |
| 553120Z3.0-SIRON-A | 02679380 | 2 | D | 12,0 | 12,0 | 26,0 | 80,0 | 0,15 | 3 | ■ |
| 553140Z3.0-SIRON-A | 02733932 | 2 | D | 14,0 | 14,0 | 30,0 | 85,0 | 0,175 | 3 | ■ |
| 553160Z3.0-SIRON-A | 02679384 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | 0,2 | 3 | ■ |
| 553200Z3.0-SIRON-A | 02679389 | 2 | D | 20,0 | 20,0 | 42,0 | 110,0 | 0,25 | 3 | ■ |
| 553250Z3.0-SIRON-A | 02679393 | 2 | D | 25,0 | 25,0 | 52,0 | 125,0 | 0,3 | 3 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

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Harter

Kunststoffe und Composite

Graphit

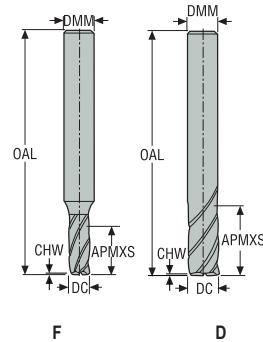
X-Heads

Minimaster Plus

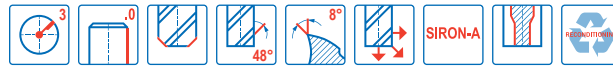
Minimaster

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Fase



- Toleranzen:
- DMM= h5
- DC= e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | CHW | PCEDC | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|------|------|-------|-------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | | |
| 553L020Z3.0-SIRON-A | 02733962 | 3 | F | 2,0 | 6,0 | 7,0 | 50,0 | 0,025 | 3 | ■ |
| 553L030Z3.0-SIRON-A | 02733971 | 3 | F | 3,0 | 6,0 | 10,0 | 55,0 | 0,035 | 3 | ■ |
| 553L040Z3.0-SIRON-A | 02733972 | 3 | F | 4,0 | 6,0 | 14,0 | 60,0 | 0,045 | 3 | ■ |
| 553L050Z3.0-SIRON-A | 02733974 | 3 | F | 5,0 | 6,0 | 18,0 | 60,0 | 0,055 | 3 | ■ |
| 553L060Z3.0-SIRON-A | 02733982 | 3 | D | 6,0 | 6,0 | 20,0 | 65,0 | 0,075 | 3 | ■ |
| 553L080Z3.0-SIRON-A | 02733986 | 3 | D | 8,0 | 8,0 | 28,0 | 70,0 | 0,1 | 3 | ■ |
| 553L100Z3.0-SIRON-A | 02733992 | 3 | D | 10,0 | 10,0 | 35,0 | 85,0 | 0,125 | 3 | ■ |
| 553L120Z3.0-SIRON-A | 02733994 | 3 | D | 12,0 | 12,0 | 40,0 | 95,0 | 0,15 | 3 | ■ |
| 553L160Z3.0-SIRON-A | 02733996 | 3 | D | 16,0 | 16,0 | 50,0 | 110,0 | 0,2 | 3 | ■ |
| 553L200Z3.0-SIRON-A | 02733998 | 3 | D | 20,0 | 20,0 | 60,0 | 125,0 | 0,25 | 3 | ■ |
| 553L250Z3.0-SIRON-A | 02734000 | 3 | D | 25,0 | 25,0 | 75,0 | 150,0 | 0,3 | 3 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

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ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

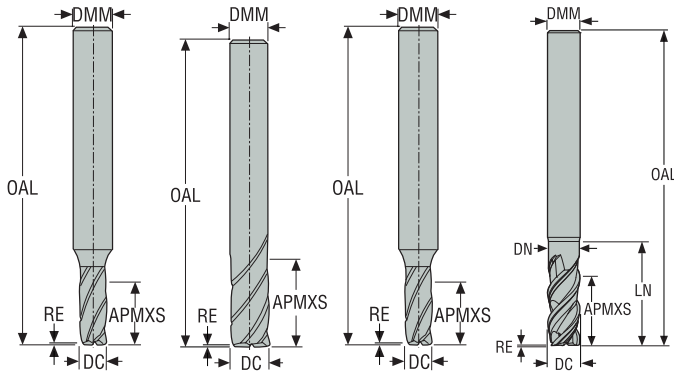
X-Heads

Minimaster Plus

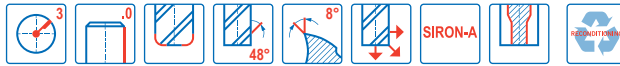
Minimaster

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius



F



- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|-------------------------|--------------------|------------------|-------------------|------|------|-------|------|------|------|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS553020F1R020.0Z3-SIRA | 10194458 | 1 | F | 2,0 | 6,0 | 3,0 | 40,0 | 5,0 | 2,05 | 0,2 | 3 | ■ |
| JS553030F1R020.0Z3-SIRA | 10194459 | 1 | F | 3,0 | 6,0 | 4,0 | 40,0 | 6,0 | 3,05 | 0,2 | 3 | ■ |
| JS553040F1R020.0Z3-SIRA | 10194460 | 1 | F | 4,0 | 6,0 | 6,0 | 40,0 | 9,0 | 4,05 | 0,2 | 3 | ■ |
| JS553050F1R020.0Z3-SIRA | 10194461 | 1 | F | 5,0 | 6,0 | 7,0 | 40,0 | 10,0 | 5,05 | 0,2 | 3 | ■ |
| JS553060D1R020.0Z3-SIRA | 10194462 | 1 | D | 6,0 | 6,0 | 8,0 | 40,0 | – | – | 0,2 | 3 | ■ |
| JS553060D1R050.0Z3-SIRA | 10194463 | 1 | D | 6,0 | 6,0 | 8,0 | 40,0 | – | – | 0,5 | 3 | ■ |
| JS553080D1R050.0Z3-SIRA | 10194464 | 1 | D | 8,0 | 8,0 | 11,0 | 50,0 | – | – | 0,5 | 3 | ■ |
| JS553100D1R050.0Z3-SIRA | 10194465 | 1 | D | 10,0 | 10,0 | 13,0 | 57,0 | – | – | 0,5 | 3 | ■ |
| JS553100D1R100.0Z3-SIRA | 10194466 | 1 | D | 10,0 | 10,0 | 13,0 | 57,0 | – | – | 1,0 | 3 | ■ |
| JS553120D1R050.0Z3-SIRA | 10194467 | 1 | D | 12,0 | 12,0 | 15,0 | 65,0 | – | – | 0,5 | 3 | ■ |
| JS553120D1R100.0Z3-SIRA | 10194468 | 1 | D | 12,0 | 12,0 | 15,0 | 65,0 | – | – | 1,0 | 3 | ■ |
| JS553020G2R050.0Z3-SIRA | 02881683 | 2 | G | 2,0 | 6,0 | 5,0 | 57,0 | 8,0 | 1,9 | 0,5 | 3 | ■ |
| 553030R015Z3.0-SIRON-A | 02733908 | 2 | F | 3,0 | 6,0 | 7,0 | 50,0 | 8,5 | 3,0 | 0,15 | 3 | ■ |
| JS553030G2R050.0Z3-SIRA | 02881684 | 2 | G | 3,0 | 6,0 | 7,0 | 57,0 | 11,0 | 2,85 | 0,5 | 3 | ■ |
| 553040R020Z3.0-SIRON-A | 02733911 | 2 | F | 4,0 | 6,0 | 10,0 | 55,0 | 11,7 | 4,0 | 0,2 | 3 | ■ |
| JS553040G2R050.0Z3-SIRA | 02881685 | 2 | G | 4,0 | 6,0 | 10,0 | 57,0 | 13,0 | 3,8 | 0,5 | 3 | ■ |
| 553050R020Z3.0-SIRON-A | 02687282 | 2 | F | 5,0 | 6,0 | 12,0 | 55,0 | 14,7 | 5,0 | 0,2 | 3 | ■ |
| JS553050G2R050.0Z3-SIRA | 02881686 | 2 | G | 5,0 | 6,0 | 10,0 | 57,0 | 15,0 | 4,75 | 0,5 | 3 | ■ |
| 553060R020Z3.0-SIRON-A | 02679369 | 2 | D | 6,0 | 6,0 | 14,0 | 55,0 | – | – | 0,2 | 3 | ■ |
| JS553060E2R050.0Z3-SIRA | 02881687 | 2 | E | 6,0 | 6,0 | 14,0 | 57,0 | 19,0 | 5,7 | 0,5 | 3 | ■ |
| JS553060E2R100.0Z3-SIRA | 02881688 | 2 | E | 6,0 | 6,0 | 14,0 | 57,0 | 19,0 | 5,7 | 1,0 | 3 | ■ |
| 553080R050Z3.0-SIRON-A | 02679372 | 2 | D | 8,0 | 8,0 | 18,0 | 60,0 | – | – | 0,5 | 3 | ■ |
| 553100R050Z3.0-SIRON-A | 02679375 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | – | – | 0,5 | 3 | ■ |
| 553100R100Z3.0-SIRON-A | 02679376 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | – | – | 1,0 | 3 | ■ |
| 553100R200Z3.0-SIRON-A | 02810364 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | – | – | 2,0 | 3 | ■ |
| 553100R250Z3.0-SIRON-A | 02810365 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | – | – | 2,5 | 3 | ■ |
| 553100R310Z3.0-SIRON-A | 02810366 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | – | – | 3,1 | 3 | ■ |
| 553120R050Z3.0-SIRON-A | 02679381 | 2 | D | 12,0 | 12,0 | 26,0 | 80,0 | – | – | 0,5 | 3 | ■ |
| 553120R100Z3.0-SIRON-A | 02679382 | 2 | D | 12,0 | 12,0 | 26,0 | 80,0 | – | – | 1,0 | 3 | ■ |
| 553120R200Z3.0-SIRON-A | 02810367 | 2 | D | 12,0 | 12,0 | 26,0 | 80,0 | – | – | 2,0 | 3 | ■ |
| 553120R250Z3.0-SIRON-A | 02810368 | 2 | D | 12,0 | 12,0 | 26,0 | 80,0 | – | – | 2,5 | 3 | ■ |
| 553120R310Z3.0-SIRON-A | 02810369 | 2 | D | 12,0 | 12,0 | 26,0 | 80,0 | – | – | 3,1 | 3 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

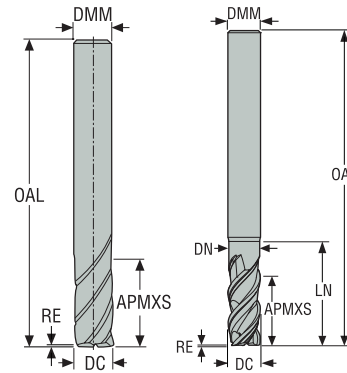
X-Heads

Minimaster Plus

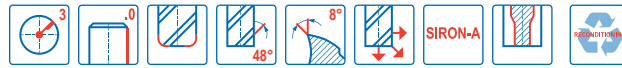
Minimaster

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|-------------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| 553160R050Z3.0-SIRON-A | 02679385 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | – | – | 0,5 | 3 | ■ |
| 553160R100Z3.0-SIRON-A | 02679386 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | – | – | 1,0 | 3 | ■ |
| 553160R200Z3.0-SIRON-A | 02810370 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | – | – | 2,0 | 3 | ■ |
| 553160R250Z3.0-SIRON-A | 02810371 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | – | – | 2,5 | 3 | ■ |
| 553160R310Z3.0-SIRON-A | 02810372 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | – | – | 3,1 | 3 | ■ |
| 553160R400Z3.0-SIRON-A | 02810373 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | – | – | 4,0 | 3 | ■ |
| 553200R050Z3.0-SIRON-A | 02679390 | 2 | D | 20,0 | 20,0 | 42,0 | 110,0 | – | – | 0,5 | 3 | ■ |
| 553200R100Z3.0-SIRON-A | 02679391 | 2 | D | 20,0 | 20,0 | 42,0 | 110,0 | – | – | 1,0 | 3 | ■ |
| JS553200E2R200.0Z3-SIRA | 02881689 | 2 | E | 20,0 | 20,0 | 42,0 | 110,0 | 54,0 | 19,0 | 2,0 | 3 | ■ |
| 553250R050Z3.0-SIRON-A | 02679395 | 2 | D | 25,0 | 25,0 | 52,0 | 125,0 | – | – | 0,5 | 3 | ■ |
| 553250R100Z3.0-SIRON-A | 02679396 | 2 | D | 25,0 | 25,0 | 52,0 | 125,0 | – | – | 1,0 | 3 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

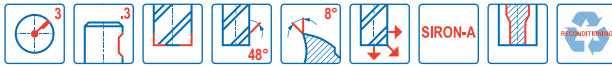
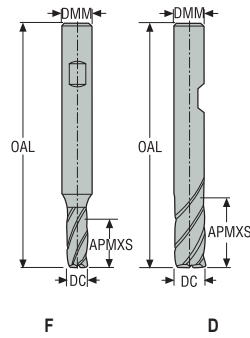
X-Heads

Minimaster Plus

Minimaster

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Weldon – Scharfe Schneide



- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | PCEDC | Weldon |
|----------------------|--------------------|------------------|-------------------|------|------|-------|------|-------|--------|
| | | | | mm | mm | mm | mm | | |
| 553020SZ3.0-SIRON-AW | 02733936 | 2 | F | 2,0 | 6,0 | 5,0 | 50,0 | 3 | ■ |
| 553030SZ3.0-SIRON-AW | 02733939 | 2 | F | 3,0 | 6,0 | 7,0 | 50,0 | 3 | ■ |
| 553040SZ3.0-SIRON-AW | 02733943 | 2 | F | 4,0 | 6,0 | 10,0 | 55,0 | 3 | ■ |
| 553050SZ3.0-SIRON-AW | 02733945 | 2 | F | 5,0 | 6,0 | 12,0 | 55,0 | 3 | ■ |
| 553060SZ3.0-SIRON-AW | 02733946 | 2 | D | 6,0 | 6,0 | 14,0 | 55,0 | 3 | ■ |
| 553080SZ3.0-SIRON-AW | 02733950 | 2 | D | 8,0 | 8,0 | 18,0 | 60,0 | 3 | ■ |
| 553100SZ3.0-SIRON-AW | 02733952 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | 3 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und
Composite

Graphit

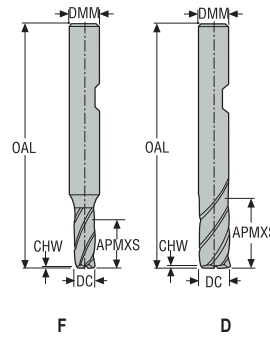
X-Heads

Minimaster Plus

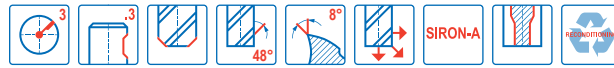
Minimaster

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Weldon – Fase



- Toleranzen:
- DMM= h5
- DC= e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

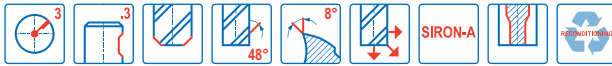
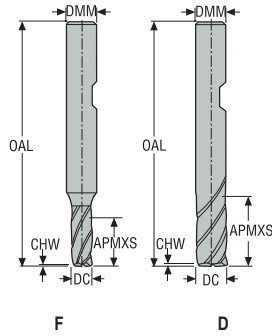


| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | CHW | PCEDC | Weldon |
|----------------------|--------------------|------------------|-------------------|------|------|-------|-------|-------|-------|--------|
| | | | | mm | mm | mm | mm | mm | | |
| JS553020F1C.3Z3-SIRA | 10041477 | 1 | F | 2,0 | 6,0 | 3,0 | 40,0 | 0,025 | 3 | ■ |
| JS553030F1C.3Z3-SIRA | 10041478 | 1 | F | 3,0 | 6,0 | 4,0 | 40,0 | 0,035 | 3 | ■ |
| JS553040F1C.3Z3-SIRA | 10041479 | 1 | F | 4,0 | 6,0 | 6,0 | 40,0 | 0,045 | 3 | ■ |
| JS553045F1C.3Z3-SIRA | 10041480 | 1 | F | 4,5 | 6,0 | 6,0 | 40,0 | 0,045 | 3 | ■ |
| JS553050F1C.3Z3-SIRA | 10041481 | 1 | F | 5,0 | 6,0 | 7,0 | 40,0 | 0,055 | 3 | ■ |
| JS553055F1C.3Z3-SIRA | 10041482 | 1 | F | 5,5 | 6,0 | 8,0 | 40,0 | 0,055 | 3 | ■ |
| JS553060D1C.3Z3-SIRA | 10041483 | 1 | D | 6,0 | 6,0 | 8,0 | 40,0 | 0,075 | 3 | ■ |
| JS553080D1C.3Z3-SIRA | 10041484 | 1 | D | 8,0 | 8,0 | 11,0 | 50,0 | 0,1 | 3 | □ |
| JS553100D1C.3Z3-SIRA | 10041485 | 1 | D | 10,0 | 10,0 | 13,0 | 57,0 | 0,125 | 3 | □ |
| JS553120D1C.3Z3-SIRA | 10041486 | 1 | D | 12,0 | 12,0 | 15,0 | 65,0 | 0,15 | 3 | □ |
| 553020Z3.0-SIRON-AW | 02697423 | 2 | F | 2,0 | 6,0 | 5,0 | 50,0 | 0,025 | 3 | □ |
| 553025Z3.0-SIRON-AW | 02700354 | 2 | F | 2,5 | 6,0 | 7,0 | 50,0 | 0,025 | 3 | ■ |
| 553030Z3.0-SIRON-AW | 02700355 | 2 | F | 3,0 | 6,0 | 7,0 | 50,0 | 0,035 | 3 | ■ |
| 553035Z3.0-SIRON-AW | 02700357 | 2 | F | 3,5 | 6,0 | 9,0 | 55,0 | 0,035 | 3 | ■ |
| 553040Z3.0-SIRON-AW | 02700358 | 2 | F | 4,0 | 6,0 | 10,0 | 55,0 | 0,045 | 3 | ■ |
| 553045Z3.0-SIRON-AW | 02700359 | 2 | F | 4,5 | 6,0 | 12,0 | 55,0 | 0,045 | 3 | □ |
| 553050Z3.0-SIRON-AW | 02700360 | 2 | F | 5,0 | 6,0 | 12,0 | 55,0 | 0,055 | 3 | ■ |
| 553055Z3.0-SIRON-AW | 02700361 | 2 | F | 5,5 | 6,0 | 14,0 | 55,0 | 0,055 | 3 | □ |
| 553060Z3.3-SIRON-A | 02679367 | 2 | D | 6,0 | 6,0 | 14,0 | 55,0 | 0,075 | 3 | ■ |
| 553075Z3.3-SIRON-A | 02733915 | 2 | F | 7,5 | 8,0 | 18,0 | 60,0 | 0,1 | 3 | ■ |
| 553080Z3.3-SIRON-A | 02679370 | 2 | D | 8,0 | 8,0 | 18,0 | 60,0 | 0,1 | 3 | ■ |
| 553095Z3.3-SIRON-A | 02733919 | 2 | F | 9,5 | 10,0 | 22,0 | 70,0 | 0,125 | 3 | ■ |
| 553100Z3.3-SIRON-A | 02679373 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | 0,125 | 3 | ■ |
| 553115Z3.3-SIRON-A | 02733923 | 2 | F | 11,5 | 12,0 | 26,0 | 80,0 | 0,15 | 3 | ■ |
| 553120Z3.3-SIRON-A | 02679379 | 2 | D | 12,0 | 12,0 | 26,0 | 80,0 | 0,15 | 3 | ■ |
| 553140Z3.3-SIRON-A | 02733929 | 2 | D | 14,0 | 14,0 | 30,0 | 85,0 | 0,175 | 3 | ■ |
| 553160Z3.3-SIRON-A | 02679383 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | 0,2 | 3 | ■ |
| 553200Z3.3-SIRON-A | 02679388 | 2 | D | 20,0 | 20,0 | 42,0 | 110,0 | 0,25 | 3 | ■ |
| 553250Z3.3-SIRON-A | 02679392 | 2 | D | 25,0 | 25,0 | 52,0 | 125,0 | 0,3 | 3 | ■ |

□ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Weldon – Fase



- Toleranzen:
- DMM= h5
- DC= e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | CHW | PCEDC | Weldon |
|----------------------|----------------|--------------|---------------|------|------|-------|-------|-------|-------|--------|
| | | | | mm | mm | mm | mm | mm | | |
| 553L020Z3.0-SIRON-AW | 02734001 | 3 | F | 2,0 | 6,0 | 7,0 | 50,0 | 0,025 | 3 | ☐ |
| 553L030Z3.0-SIRON-AW | 02734006 | 3 | F | 3,0 | 6,0 | 10,0 | 55,0 | 0,035 | 3 | ■ |
| 553L040Z3.0-SIRON-AW | 02734007 | 3 | F | 4,0 | 6,0 | 14,0 | 60,0 | 0,045 | 3 | ■ |
| 553L050Z3.0-SIRON-AW | 02734008 | 3 | F | 5,0 | 6,0 | 18,0 | 60,0 | 0,055 | 3 | ☐ |
| 553L060Z3.3-SIRON-A | 02733980 | 3 | D | 6,0 | 6,0 | 20,0 | 65,0 | 0,075 | 3 | ■ |
| 553L080Z3.3-SIRON-A | 02733984 | 3 | D | 8,0 | 8,0 | 28,0 | 70,0 | 0,1 | 3 | ■ |
| 553L100Z3.3-SIRON-A | 02733988 | 3 | D | 10,0 | 10,0 | 35,0 | 85,0 | 0,125 | 3 | ■ |
| 553L120Z3.3-SIRON-A | 02733993 | 3 | D | 12,0 | 12,0 | 40,0 | 95,0 | 0,15 | 3 | ■ |
| 553L160Z3.3-SIRON-A | 02733995 | 3 | D | 16,0 | 16,0 | 50,0 | 110,0 | 0,2 | 3 | ■ |
| 553L200Z3.3-SIRON-A | 02733997 | 3 | D | 20,0 | 20,0 | 60,0 | 125,0 | 0,25 | 3 | ■ |
| 553L250Z3.3-SIRON-A | 02733999 | 3 | D | 25,0 | 25,0 | 75,0 | 150,0 | 0,3 | 3 | ■ |

☐ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

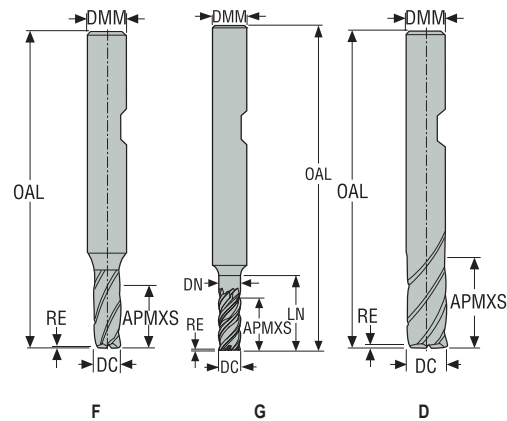
X-Heads

Minimaster Plus

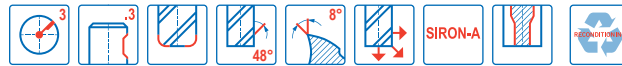
Minimaster

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Weldon – Eckenradius



- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Weldon |
|-------------------------|--------------------|------------------|-------------------|------|------|-------|------|------|------|------|-------|-------------------------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS553080D1R050.3Z3-SIRA | 10194469 | 1 | D | 8,0 | 8,0 | 11,0 | 50,0 | – | – | 0,5 | 3 | <input type="checkbox"/> |
| JS553100D1R050.3Z3-SIRA | 10194470 | 1 | D | 10,0 | 10,0 | 13,0 | 57,0 | – | – | 0,5 | 3 | <input type="checkbox"/> |
| JS553100D1R100.3Z3-SIRA | 10194471 | 1 | D | 10,0 | 10,0 | 13,0 | 57,0 | – | – | 1,0 | 3 | <input type="checkbox"/> |
| JS553120D1R050.3Z3-SIRA | 10194472 | 1 | D | 12,0 | 12,0 | 15,0 | 65,0 | – | – | 0,5 | 3 | <input type="checkbox"/> |
| JS553120D1R100.3Z3-SIRA | 10194474 | 1 | D | 12,0 | 12,0 | 15,0 | 65,0 | – | – | 1,0 | 3 | <input type="checkbox"/> |
| JS553020G2R050.3Z3-SIRA | 02881690 | 2 | G | 2,0 | 6,0 | 5,0 | 57,0 | 8,0 | 1,9 | 0,5 | 3 | <input type="checkbox"/> |
| 553030R015Z3.0-SIRON-AW | 02733941 | 2 | F | 3,0 | 6,0 | 7,0 | 50,0 | 8,5 | 3,0 | 0,15 | 3 | <input type="checkbox"/> |
| JS553030G2R050.3Z3-SIRA | 02881691 | 2 | G | 3,0 | 6,0 | 7,0 | 57,0 | 11,0 | 2,85 | 0,5 | 3 | <input type="checkbox"/> |
| 553040R020Z3.0-SIRON-AW | 02733944 | 2 | F | 4,0 | 6,0 | 10,0 | 55,0 | 11,7 | 4,0 | 0,2 | 3 | <input type="checkbox"/> |
| JS553040G2R050.3Z3-SIRA | 02881692 | 2 | G | 4,0 | 6,0 | 10,0 | 57,0 | 13,0 | 3,8 | 0,5 | 3 | <input type="checkbox"/> |
| 553050R020Z3.0-SIRON-AW | 02703763 | 2 | F | 5,0 | 6,0 | 12,0 | 55,0 | 14,7 | 5,0 | 0,2 | 3 | <input type="checkbox"/> |
| JS553050G2R050.3Z3-SIRA | 02881693 | 2 | G | 5,0 | 6,0 | 10,0 | 57,0 | 15,0 | 4,75 | 0,5 | 3 | <input type="checkbox"/> |
| 553060R020Z3.0-SIRON-AW | 02700364 | 2 | D | 6,0 | 6,0 | 14,0 | 55,0 | – | – | 0,2 | 3 | <input type="checkbox"/> |
| JS553060E2R050.3Z3-SIRA | 02881694 | 2 | E | 6,0 | 6,0 | 14,0 | 57,0 | 19,0 | 5,7 | 0,5 | 3 | <input type="checkbox"/> |
| JS553060E2R100.3Z3-SIRA | 02881695 | 2 | E | 6,0 | 6,0 | 14,0 | 57,0 | 19,0 | 5,7 | 1,0 | 3 | <input checked="" type="checkbox"/> |
| 553080R050Z3.0-SIRON-AW | 02700366 | 2 | D | 8,0 | 8,0 | 18,0 | 60,0 | – | – | 0,5 | 3 | <input checked="" type="checkbox"/> |
| 553100R050Z3.0-SIRON-AW | 02700369 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | – | – | 0,5 | 3 | <input type="checkbox"/> |
| 553100R100Z3.0-SIRON-AW | 02700371 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | – | – | 1,0 | 3 | <input type="checkbox"/> |
| 553100R200Z3.3-SIRON-A | 02810422 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | – | – | 2,0 | 3 | <input type="checkbox"/> |
| 553100R250Z3.3-SIRON-A | 02810423 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | – | – | 2,5 | 3 | <input type="checkbox"/> |
| 553100R310Z3.3-SIRON-A | 02810424 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | – | – | 3,1 | 3 | <input type="checkbox"/> |
| 553120R050Z3.0-SIRON-AW | 02700373 | 2 | D | 12,0 | 12,0 | 26,0 | 80,0 | – | – | 0,5 | 3 | <input type="checkbox"/> |
| 553120R100Z3.0-SIRON-AW | 02700374 | 2 | D | 12,0 | 12,0 | 26,0 | 80,0 | – | – | 1,0 | 3 | <input type="checkbox"/> |
| 553120R200Z3.3-SIRON-A | 02810425 | 2 | D | 12,0 | 12,0 | 26,0 | 80,0 | – | – | 2,0 | 3 | <input type="checkbox"/> |
| 553120R250Z3.3-SIRON-A | 02810426 | 2 | D | 12,0 | 12,0 | 26,0 | 80,0 | – | – | 2,5 | 3 | <input type="checkbox"/> |
| 553120R310Z3.3-SIRON-A | 02810427 | 2 | D | 12,0 | 12,0 | 26,0 | 80,0 | – | – | 3,1 | 3 | <input type="checkbox"/> |

■ Lagerstandard. □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und Composite

Graphit

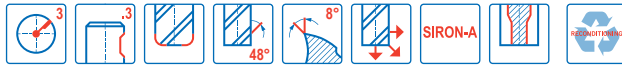
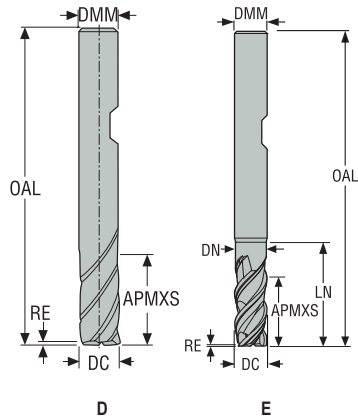
X-Heads

Minimaster Plus

Minimaster

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Weldon – Eckenradius



- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | RE | PCEDC | Weldon |
|-------------------------|--------------------|------------------|-------------------|------|------|-------|-------|-----|-------|-------------------------------------|
| | | | | mm | mm | mm | mm | mm | | |
| 553160R050Z3.0-SIRON-AW | 02700378 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | 0,5 | 3 | <input type="checkbox"/> |
| 553160R100Z3.0-SIRON-AW | 02700381 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | 1,0 | 3 | <input type="checkbox"/> |
| 553160R200Z3.3-SIRON-A | 02810428 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | 2,0 | 3 | <input type="checkbox"/> |
| 553160R250Z3.3-SIRON-A | 02810429 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | 2,5 | 3 | <input type="checkbox"/> |
| 553160R310Z3.3-SIRON-A | 02810430 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | 3,1 | 3 | <input type="checkbox"/> |
| 553160R400Z3.3-SIRON-A | 02810431 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | 4,0 | 3 | <input type="checkbox"/> |
| 553200R050Z3.0-SIRON-AW | 02700383 | 2 | D | 20,0 | 20,0 | 42,0 | 110,0 | 0,5 | 3 | <input checked="" type="checkbox"/> |
| 553200R100Z3.0-SIRON-AW | 02700384 | 2 | D | 20,0 | 20,0 | 42,0 | 110,0 | 1,0 | 3 | <input type="checkbox"/> |
| JS553200E2R200.3Z3-SIRA | 02881696 | 2 | E | 20,0 | 20,0 | 42,0 | 110,0 | 2,0 | 3 | <input type="checkbox"/> |
| 553250R050Z3.0-SIRON-AW | 02700386 | 2 | D | 25,0 | 25,0 | 52,0 | 125,0 | 0,5 | 3 | <input type="checkbox"/> |
| 553250R100Z3.0-SIRON-AW | 02700385 | 2 | D | 25,0 | 25,0 | 52,0 | 125,0 | 1,0 | 3 | <input type="checkbox"/> |

■ Lagerstandard. Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

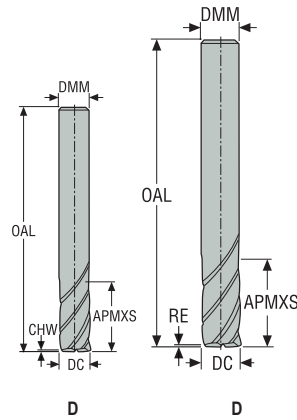
X-Heads

Minimaster Plus

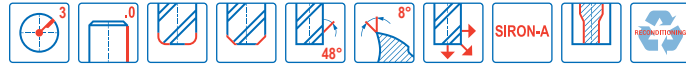
Minimaster

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius oder Fase – Zoll



- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø.375 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | CHW | RE | PCEDC | Zylindrisch |
|-------------------------|--------------------|------------------|-------------------|-------|-------|-------|-------|-------|-------|-------|-------------|
| | | | | Zoll | Zoll | Zoll | Zoll | Zoll | Zoll | | |
| 5530125Z3.0-SIRON-A | 02712684 | 2 | D | 0.125 | 0.125 | 0.250 | 2.000 | 0.001 | – | 3 | ■ |
| 5530187Z3.0-SIRON-A | 02712687 | 2 | D | 0.188 | 0.188 | 0.375 | 2.000 | 0.001 | – | 3 | ■ |
| 5530250Z3.0-SIRON-A | 02712688 | 2 | D | 0.250 | 0.250 | 0.500 | 2.500 | 0.003 | – | 3 | ■ |
| 5530250R015Z3.0-SIRON-A | 02712689 | 2 | D | 0.250 | 0.250 | 0.500 | 2.500 | – | 0.015 | 3 | ■ |
| 5530312Z3.0-SIRON-A | 02712690 | 2 | D | 0.313 | 0.313 | 0.625 | 2.500 | 0.004 | – | 3 | ■ |
| 5530312R015Z3.0-SIRON-A | 02712693 | 2 | D | 0.313 | 0.313 | 0.625 | 2.500 | – | 0.015 | 3 | ■ |
| 5530375Z3.0-SIRON-A | 02712694 | 2 | D | 0.375 | 0.375 | 0.750 | 3.000 | 0.005 | – | 3 | ■ |
| 5530375R015Z3.0-SIRON-A | 02712695 | 2 | D | 0.375 | 0.375 | 0.750 | 3.000 | – | 0.015 | 3 | ■ |
| 5530375R030Z3.0-SIRON-A | 02712696 | 2 | D | 0.375 | 0.375 | 0.750 | 3.000 | – | 0.030 | 3 | ■ |
| 5530500Z3.0-SIRON-A | 02712699 | 2 | D | 0.500 | 0.500 | 1.000 | 3.500 | 0.006 | – | 3 | ■ |
| 5530500R015Z3.0-SIRON-A | 02712701 | 2 | D | 0.500 | 0.500 | 1.000 | 3.500 | – | 0.015 | 3 | ■ |
| 5530500R030Z3.0-SIRON-A | 02712703 | 2 | D | 0.500 | 0.500 | 1.000 | 3.500 | – | 0.030 | 3 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

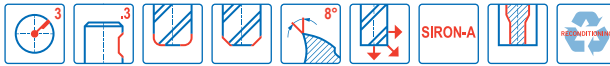
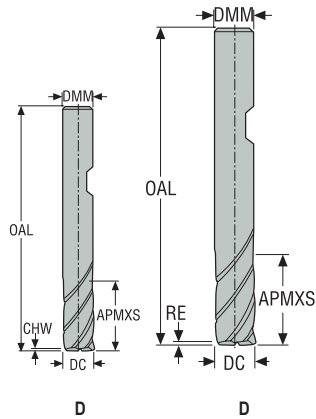
X-Heads

Minimaster Plus

Minimaster

JS553

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Weldon – Eckenradius oder Fase – Zoll



- Toleranzen:
- DMM=h5
- DC=e7

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | CHW | RE | PCEDC | Weldon |
|-------------------------|--------------------|------------------|-------------------|-------|-------|-------|-------|-------|-------|-------|--------|
| | | | | Zoll | Zoll | Zoll | Zoll | Zoll | Zoll | Zoll | |
| 5530500Z3.3-SIRON-A | 02712697 | 2 | D | 0.500 | 0.500 | 1.000 | 3.500 | 0.006 | – | 3 | ■ |
| 5530500R015Z3.3-SIRON-A | 02712700 | 2 | D | 0.500 | 0.500 | 1.000 | 3.500 | – | 0.015 | 3 | ■ |
| 5530500R030Z3.3-SIRON-A | 02712702 | 2 | D | 0.500 | 0.500 | 1.000 | 3.500 | – | 0.030 | 3 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

X-Heads

Minimaster Plus

Minimaster


Schnittdaten – JS553 Eckfräsen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|---------|---------|---------|--------|--------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 14 | 16 | 20 | 25 | |
| P1 | M/A/D/E | 0.400 | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.13 | 0.15 | 0.17 | 0.19 | 225 (200 – 250) |
| | | 0.400 | 1.0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 0,0065 | 0,0075 | 740 (660 – 820) |
| P2 | M/A/D/E | 0.400 | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.13 | 0.15 | 0.17 | 0.19 | 220 (190 – 240) |
| | | 0.400 | 1.0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 0,0065 | 0,0075 | 720 (630 – 780) |
| P3 | M/A/D/E | 0.400 | 1.0 | 0.019 | 0.028 | 0.038 | 0.048 | 0.055 | 0.075 | 0.095 | 0.11 | 0.13 | 0.14 | 0.16 | 0.18 | 190 (170 – 210) |
| | | 0.400 | 1.0 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0050 | 0,0055 | 0,0065 | 0,0070 | 620 (560 – 680) |
| P4 | M/A/D/E | 0.400 | 1.0 | 0.019 | 0.028 | 0.038 | 0.046 | 0.055 | 0.075 | 0.095 | 0.11 | 0.13 | 0.14 | 0.16 | 0.18 | 165 (150 – 190) |
| | | 0.400 | 1.0 | 0,00075 | 0,0011 | 0,0015 | 0,0018 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0050 | 0,0055 | 0,0065 | 0,0070 | 540 (500 – 620) |
| P5 | M/A/D/E | 0.400 | 1.0 | 0.018 | 0.028 | 0.036 | 0.046 | 0.055 | 0.075 | 0.090 | 0.11 | 0.12 | 0.13 | 0.16 | 0.18 | 160 (140 – 180) |
| | | 0.400 | 1.0 | 0,00070 | 0,0011 | 0,0014 | 0,0018 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0070 | 520 (460 – 590) |
| P6 | M/A/D/E | 0.400 | 1.0 | 0.018 | 0.028 | 0.036 | 0.046 | 0.055 | 0.075 | 0.090 | 0.11 | 0.12 | 0.13 | 0.15 | 0.17 | 180 (160 – 200) |
| | | 0.400 | 1.0 | 0,00070 | 0,0011 | 0,0014 | 0,0018 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0048 | 0,0050 | 0,0060 | 0,0065 | 590 (530 – 650) |
| P7 | M/A/D/E | 0.400 | 1.0 | 0.018 | 0.028 | 0.036 | 0.046 | 0.055 | 0.075 | 0.090 | 0.11 | 0.12 | 0.13 | 0.15 | 0.17 | 170 (150 – 190) |
| | | 0.400 | 1.0 | 0,00070 | 0,0011 | 0,0014 | 0,0018 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0048 | 0,0050 | 0,0060 | 0,0065 | 560 (500 – 620) |
| P8 | M/A/D/E | 0.400 | 1.0 | 0.019 | 0.028 | 0.038 | 0.048 | 0.055 | 0.075 | 0.095 | 0.11 | 0.13 | 0.14 | 0.16 | 0.18 | 160 (140 – 180) |
| | | 0.400 | 1.0 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0050 | 0,0055 | 0,0065 | 0,0070 | 520 (460 – 590) |
| P11 | M/A/D/E | 0.400 | 1.0 | 0.018 | 0.026 | 0.036 | 0.044 | 0.055 | 0.070 | 0.090 | 0.11 | 0.12 | 0.13 | 0.15 | 0.17 | 145 (130 – 160) |
| | | 0.400 | 1.0 | 0,00070 | 0,0010 | 0,0014 | 0,0017 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0048 | 0,0050 | 0,0060 | 0,0065 | 475 (430 – 520) |
| P12 | M/A/D/E | 0.400 | 1.0 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.12 | 95 (82 – 100) |
| | | 0.400 | 1.0 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0048 | 310 (270 – 320) |
| M1 | E | 0.400 | 1.0 | 0.013 | 0.020 | 0.026 | 0.034 | 0.040 | 0.055 | 0.065 | 0.080 | 0.090 | 0.10 | 0.11 | 0.13 | 115 (100 – 120) |
| | | 0.400 | 1.0 | 0,00050 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0050 | 375 (330 – 390) |
| M2 | E | 0.400 | 1.0 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.12 | 95 (82 – 100) |
| | | 0.400 | 1.0 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0048 | 310 (270 – 320) |
| M3 | E | 0.400 | 1.0 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.075 | 0.085 | 0.10 | 60 (47 – 69) |
| | | 0.400 | 1.0 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0030 | 0,0034 | 0,0040 | 195 (160 – 220) |
| M4 | E | 0.400 | 1.0 | 0.0090 | 0.013 | 0.018 | 0.022 | 0.026 | 0.036 | 0.044 | 0.055 | 0.060 | 0.065 | 0.075 | 0.085 | 45 (36 – 53) |
| | | 0.400 | 1.0 | 0,00036 | 0,00050 | 0,00070 | 0,00085 | 0,0010 | 0,0014 | 0,0017 | 0,0022 | 0,0024 | 0,0026 | 0,0030 | 0,0034 | 150 (120 – 170) |
| M5 | E | 0.400 | 1.0 | 0.0090 | 0.013 | 0.018 | 0.022 | 0.026 | 0.036 | 0.044 | 0.055 | 0.060 | 0.065 | 0.075 | 0.085 | 37 (30 – 44) |
| | | 0.400 | 1.0 | 0,00036 | 0,00050 | 0,00070 | 0,00085 | 0,0010 | 0,0014 | 0,0017 | 0,0022 | 0,0024 | 0,0026 | 0,0030 | 0,0034 | 120 (99 – 140) |
| K1 | E | 0.400 | 1.2 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.16 | 165 (160 – 190) |
| | | 0.400 | 1.2 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0065 | 540 (530 – 620) |
| K2 | E | 0.400 | 1.2 | 0.015 | 0.022 | 0.030 | 0.038 | 0.044 | 0.060 | 0.075 | 0.090 | 0.10 | 0.11 | 0.13 | 0.14 | 145 (140 – 170) |
| | | 0.400 | 1.2 | 0,00060 | 0,00085 | 0,0012 | 0,0015 | 0,0017 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 0,0044 | 0,0050 | 0,0055 | 475 (460 – 550) |
| K3 | E | 0.400 | 1.2 | 0.015 | 0.022 | 0.030 | 0.038 | 0.044 | 0.060 | 0.075 | 0.090 | 0.10 | 0.11 | 0.13 | 0.14 | 125 (120 – 140) |
| | | 0.400 | 1.2 | 0,00060 | 0,00085 | 0,0012 | 0,0015 | 0,0017 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 0,0044 | 0,0050 | 0,0055 | 410 (400 – 450) |
| K4 | E | 0.400 | 1.2 | 0.015 | 0.022 | 0.030 | 0.038 | 0.044 | 0.060 | 0.075 | 0.090 | 0.10 | 0.11 | 0.13 | 0.14 | 120 (110 – 140) |
| | | 0.400 | 1.2 | 0,00060 | 0,00085 | 0,0012 | 0,0015 | 0,0017 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 0,0044 | 0,0050 | 0,0055 | 395 (370 – 450) |
| K5 | E | 0.400 | 1.1 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.16 | 155 (140 – 170) |
| | | 0.400 | 1.1 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0065 | 510 (460 – 550) |
| K6 | E | 0.400 | 1.1 | 0.018 | 0.028 | 0.036 | 0.046 | 0.055 | 0.070 | 0.090 | 0.11 | 0.12 | 0.13 | 0.15 | 0.17 | 220 (190 – 250) |
| | | 0.400 | 1.1 | 0,00070 | 0,0011 | 0,0014 | 0,0018 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0048 | 0,0050 | 0,0060 | 0,0065 | 720 (630 – 820) |
| K7 | E | 0.400 | 1.1 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.16 | 195 (170 – 220) |
| | | 0.400 | 1.1 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0065 | 640 (560 – 720) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – JS553 Eckfräsen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 14 | 16 | 20 | 25 | |
| N1 | E | 0.500 | 1.0 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 620 (520 – 720) |
| | | 0,500 | 1,0 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 2025 (1800 – 2300) |
| N2 | E | 0.500 | 1.0 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 400 (340 – 460) |
| | | 0,500 | 1,0 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 1300 (1200 – 1500) |
| N3 | E | 0.500 | 1.0 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 265 (230 – 300) |
| | | 0,500 | 1,0 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 870 (760 – 980) |
| N11 | E | 0.500 | 1.1 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.13 | 0.15 | 310 (260 – 350) |
| | | 0,500 | 1,1 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0050 | 0,0060 | 1025 (860 – 1100) |
| S1 | E | 0.150 | 0.50 | 0.017 | 0.026 | 0.034 | 0.044 | 0.050 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 0.15 | 0.17 | 43 (26 – 60) |
| | | 0,150 | 0,50 | 0,00065 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 0,0065 | 140 (86 – 190) |
| S2 | E | 0.150 | 0.50 | 0.017 | 0.026 | 0.034 | 0.044 | 0.050 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 0.15 | 0.17 | 35 (21 – 48) |
| | | 0,150 | 0,50 | 0,00065 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 0,0065 | 115 (69 – 150) |
| S3 | E | 0.150 | 0.50 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 30 (19 – 42) |
| | | 0,150 | 0,50 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 100 (63 – 130) |
| S11 | E | 0.400 | 1.0 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.12 | 110 (78 – 130) |
| | | 0,400 | 1,0 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0048 | 360 (260 – 420) |
| S12 | E | 0.400 | 1.0 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.12 | 85 (60 – 100) |
| | | 0,400 | 1,0 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0048 | 280 (200 – 320) |
| S13 | E | 0.400 | 1.0 | 0.011 | 0.016 | 0.022 | 0.026 | 0.032 | 0.042 | 0.055 | 0.065 | 0.070 | 0.080 | 0.090 | 0.10 | 65 (48 – 84) |
| | | 0,400 | 1,0 | 0,00044 | 0,00065 | 0,00085 | 0,0010 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 215 (160 – 270) |
| H5 | M/A/D | 0.200 | 0.90 | 0.013 | 0.020 | 0.026 | 0.032 | 0.040 | 0.050 | 0.065 | 0.075 | 0.085 | 0.095 | 0.11 | 0.12 | 75 (62 – 91) |
| | | 0,200 | 0,90 | 0,00050 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 0,0026 | 0,0030 | 0,0034 | 0,0038 | 0,0044 | 0,0048 | 245 (210 – 290) |
| H8 | M/A/D | 0.200 | 0.90 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.065 | 0.075 | 0.085 | 0.095 | 80 (65 – 96) |
| | | 0,200 | 0,90 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0026 | 0,0030 | 0,0034 | 0,0038 | 260 (220 – 310) |
| H21 | M/A/D | 0.200 | 0.90 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.065 | 0.075 | 0.085 | 0.095 | 80 (65 – 96) |
| | | 0,200 | 0,90 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0026 | 0,0030 | 0,0034 | 0,0038 | 260 (220 – 310) |
| H31 | M/A/D | 0.200 | 0.90 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.065 | 0.075 | 0.085 | 0.095 | 60 (49 – 72) |
| | | 0,200 | 0,90 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0026 | 0,0030 | 0,0034 | 0,0038 | 195 (170 – 230) |
| TS1 | A | 0.500 | 1.2 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.13 | 0.15 | 0.17 | 0.19 | 290 (180 – 400) |
| | | 0,500 | 1,2 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 0,0065 | 0,0075 | 950 (600 – 1300) |
| TP1 | A | 0.500 | 1.2 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.13 | 0.15 | 0.17 | 0.19 | 300 (180 – 410) |
| | | 0,500 | 1,2 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 0,0065 | 0,0075 | 980 (600 – 1300) |
| GR1 | A | 0.500 | 1.2 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.13 | 0.15 | 0.17 | 0.19 | 580 (470 – 690) |
| | | 0,500 | 1,2 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 0,0065 | 0,0075 | 1900 (1600 – 2200) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster


Schnittdaten – JS553 Nutfräsen

| SMG | | a _p /DC | f _z | | | | | | | | | | | | v _c |
|-----|---------|--------------------|----------------|---------|---------|---------|--------|--------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 14 | 16 | 20 | 25 | |
| P1 | M/A/D/E | 1.0 | 0.014 | 0.020 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.11 | 0.14 | 0.17 | 195 (170 – 220) |
| | | 1,0 | 0,00055 | 0,00080 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 0,0055 | 0,0065 | 640 (560 – 720) |
| P2 | M/A/D/E | 1.0 | 0.014 | 0.020 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.11 | 0.14 | 0.17 | 190 (170 – 210) |
| | | 1,0 | 0,00055 | 0,00080 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 0,0055 | 0,0065 | 620 (560 – 680) |
| P3 | M/A/D/E | 1.0 | 0.014 | 0.020 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.11 | 0.14 | 0.17 | 165 (140 – 180) |
| | | 1,0 | 0,00055 | 0,00080 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 0,0055 | 0,0065 | 540 (460 – 590) |
| P4 | M/A/D/E | 1.0 | 0.014 | 0.020 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.11 | 0.14 | 0.17 | 145 (130 – 160) |
| | | 1,0 | 0,00055 | 0,00080 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 0,0055 | 0,0065 | 475 (430 – 520) |
| P5 | M/A/D/E | 1.0 | 0.014 | 0.020 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.11 | 0.14 | 0.17 | 135 (120 – 150) |
| | | 1,0 | 0,00055 | 0,00080 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 0,0055 | 0,0065 | 445 (400 – 490) |
| P6 | M/A/D/E | 1.0 | 0.014 | 0.020 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.11 | 0.14 | 0.17 | 155 (140 – 170) |
| | | 1,0 | 0,00055 | 0,00080 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 0,0055 | 0,0065 | 510 (460 – 550) |
| P7 | M/A/D/E | 1.0 | 0.014 | 0.020 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.11 | 0.14 | 0.17 | 145 (130 – 160) |
| | | 1,0 | 0,00055 | 0,00080 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 0,0055 | 0,0065 | 475 (430 – 520) |
| P8 | M/A/D/E | 1.0 | 0.014 | 0.020 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.11 | 0.14 | 0.17 | 135 (120 – 150) |
| | | 1,0 | 0,00055 | 0,00080 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 0,0055 | 0,0065 | 445 (400 – 490) |
| P11 | M/A/D/E | 0.80 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.10 | 0.13 | 130 (120 – 140) |
| | | 0,80 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0040 | 0,0050 | 425 (400 – 450) |
| P12 | M/A/D/E | 0.80 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.10 | 0.11 | 80 (69 – 87) |
| | | 0,80 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0040 | 0,0044 | 260 (230 – 280) |
| M1 | E | 0.80 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.10 | 0.13 | 95 (85 – 100) |
| | | 0,80 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0040 | 0,0050 | 310 (280 – 320) |
| M2 | E | 0.80 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.10 | 0.11 | 80 (69 – 87) |
| | | 0,80 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0040 | 0,0044 | 260 (230 – 280) |
| M3 | E | 0.70 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.040 | 0.050 | 0.055 | 0.065 | 0.080 | 0.095 | 48 (39 – 58) |
| | | 0,70 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 0,0022 | 0,0026 | 0,0032 | 0,0038 | 155 (130 – 190) |
| M4 | E | 0.70 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.040 | 0.050 | 0.055 | 0.065 | 0.075 | 0.085 | 36 (30 – 43) |
| | | 0,70 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 0,0022 | 0,0026 | 0,0030 | 0,0034 | 120 (99 – 140) |
| M5 | E | 0.70 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.040 | 0.050 | 0.055 | 0.065 | 0.075 | 0.085 | 30 (25 – 36) |
| | | 0,70 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 0,0022 | 0,0026 | 0,0030 | 0,0034 | 100 (83 – 110) |
| K1 | E | 1.0 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.10 | 0.13 | 145 (140 – 170) |
| | | 1,0 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0040 | 0,0050 | 475 (460 – 550) |
| K2 | E | 1.0 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.10 | 0.13 | 125 (120 – 150) |
| | | 1,0 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0040 | 0,0050 | 410 (400 – 490) |
| K3 | E | 1.0 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.10 | 0.13 | 110 (110 – 120) |
| | | 1,0 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0040 | 0,0050 | 360 (370 – 390) |
| K4 | E | 1.0 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.10 | 0.13 | 105 (96 – 120) |
| | | 1,0 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0040 | 0,0050 | 345 (320 – 390) |
| K5 | E | 0.80 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.10 | 0.13 | 135 (120 – 150) |
| | | 0,80 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0040 | 0,0050 | 445 (400 – 490) |
| K6 | E | 0.80 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.10 | 0.13 | 200 (180 – 230) |
| | | 0,80 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0040 | 0,0050 | 660 (600 – 750) |
| K7 | E | 0.80 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.10 | 0.13 | 175 (150 – 190) |
| | | 0,80 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0040 | 0,0050 | 570 (500 – 620) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – JS553 Nutfräsen

| SMG |  | a _p /DC | f _z | | | | | | | | | | | | v _c |
|-----|---|--------------------|----------------|---------|---------|---------|---------|---------|---------|--------|--------|--------|--------|--------|--------------------|
| | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 14 | 16 | 20 | 25 | |
| N1 | E | 0.70 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.10 | 0.13 | 580 (490 – 670) |
| | | 0,70 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0040 | 0,0050 | 1900 (1700 – 2100) |
| N2 | E | 0.70 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.10 | 0.13 | 375 (320 – 430) |
| | | 0,70 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0040 | 0,0050 | 1225 (1100 – 1400) |
| N3 | E | 0.70 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.10 | 0.13 | 250 (210 – 290) |
| | | 0,70 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0040 | 0,0050 | 820 (690 – 950) |
| N11 | E | 0.60 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.10 | 0.13 | 290 (250 – 330) |
| | | 0,60 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0040 | 0,0050 | 950 (830 – 1000) |
| S1 | E | 0.30 | 0.0065 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.025 | 0.032 | 0.038 | 0.044 | 0.050 | 0.065 | 0.080 | 34 (21 – 47) |
| | | 0,30 | 0,00026 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0017 | 0,0020 | 0,0026 | 0,0032 | 110 (69 – 150) |
| S2 | E | 0.30 | 0.0065 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.025 | 0.032 | 0.038 | 0.044 | 0.050 | 0.065 | 0.080 | 27 (17 – 38) |
| | | 0,30 | 0,00026 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0017 | 0,0020 | 0,0026 | 0,0032 | 90 (56 – 120) |
| S3 | E | 0.30 | 0.0065 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.025 | 0.032 | 0.038 | 0.044 | 0.050 | 0.065 | 0.080 | 23 (15 – 32) |
| | | 0,30 | 0,00026 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0017 | 0,0020 | 0,0026 | 0,0032 | 75 (50 – 100) |
| S11 | E | 0.50 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 85 (63 – 110) |
| | | 0,50 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 280 (210 – 360) |
| S12 | E | 0.50 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 65 (48 – 86) |
| | | 0,50 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 215 (160 – 280) |
| S13 | E | 0.50 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 0.070 | 0.075 | 0.090 | 0.10 | 55 (39 – 69) |
| | | 0,50 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 0,0028 | 0,0030 | 0,0036 | 0,0040 | 180 (130 – 220) |
| H5 | M/A/D | 0.50 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.025 | 0.028 | 0.032 | 0.040 | 0.050 | 65 (52 – 77) |
| | | 0,50 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0011 | 0,0013 | 0,0016 | 0,0020 | 215 (180 – 250) |
| H8 | M/A/D | 0.50 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.025 | 0.028 | 0.032 | 0.040 | 0.050 | 65 (52 – 77) |
| | | 0,50 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0011 | 0,0013 | 0,0016 | 0,0020 | 215 (180 – 250) |
| H11 | M/A/D | 0.50 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.025 | 0.028 | 0.032 | 0.040 | 0.050 | 80 (66 – 98) |
| | | 0,50 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0011 | 0,0013 | 0,0016 | 0,0020 | 260 (220 – 320) |
| H12 | M/A/D | 1.0 | 0.0095 | 0.014 | 0.019 | 0.024 | 0.028 | 0.038 | 0.046 | 0.055 | 0.060 | 0.070 | 0.080 | 0.090 | 65 (52 – 77) |
| | | 1,0 | 0,00038 | 0,00055 | 0,00075 | 0,00095 | 0,0011 | 0,0015 | 0,0018 | 0,0022 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 215 (180 – 250) |
| H21 | M/A/D | 0.50 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.025 | 0.028 | 0.032 | 0.040 | 0.050 | 65 (52 – 77) |
| | | 0,50 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0011 | 0,0013 | 0,0016 | 0,0020 | 215 (180 – 250) |
| TS1 | A | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.13 | 0.15 | 0.17 | 0.19 | 245 (150 – 340) |
| | | 1,0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 0,0065 | 0,0075 | 800 (500 – 1100) |
| TP1 | A | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.13 | 0.15 | 0.17 | 0.19 | 250 (160 – 350) |
| | | 1,0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 0,0065 | 0,0075 | 820 (530 – 1100) |
| GR1 | A | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.13 | 0.15 | 0.17 | 0.19 | 490 (400 – 580) |
| | | 1,0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 0,0065 | 0,0075 | 1600 (1400 – 1900) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Universell
Stahl und Guss
Stahlwerkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster


Schnittdaten – JS553 Eckfräsen – Zoll

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|---------|--------|--------|--------|--------|-----------------|
| | | | | 1/8 | 3/16 | 1/4 | 5/16 | 3/8 | 1/2 | |
| P1 | M/A/D/E | 0.400 | 1.0 | 0.032 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 225 (200 – 250) |
| | | 0,400 | 1,0 | 0,0013 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 740 (660 – 820) |
| P2 | M/A/D/E | 0.400 | 1.0 | 0.032 | 0.048 | 0.065 | 0.080 | 0.095 | 0.13 | 220 (190 – 240) |
| | | 0,400 | 1,0 | 0,0013 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 720 (630 – 780) |
| P3 | M/A/D/E | 0.400 | 1.0 | 0.030 | 0.046 | 0.060 | 0.075 | 0.090 | 0.12 | 190 (170 – 210) |
| | | 0,400 | 1,0 | 0,0012 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 620 (560 – 680) |
| P4 | M/A/D/E | 0.400 | 1.0 | 0.030 | 0.044 | 0.060 | 0.075 | 0.090 | 0.12 | 165 (150 – 190) |
| | | 0,400 | 1,0 | 0,0012 | 0,0017 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 540 (500 – 620) |
| P5 | M/A/D/E | 0.400 | 1.0 | 0.030 | 0.044 | 0.060 | 0.075 | 0.085 | 0.11 | 160 (140 – 180) |
| | | 0,400 | 1,0 | 0,0012 | 0,0017 | 0,0024 | 0,0030 | 0,0034 | 0,0044 | 520 (460 – 590) |
| P6 | M/A/D/E | 0.400 | 1.0 | 0.028 | 0.044 | 0.060 | 0.070 | 0.085 | 0.11 | 180 (160 – 200) |
| | | 0,400 | 1,0 | 0,0011 | 0,0017 | 0,0024 | 0,0028 | 0,0034 | 0,0044 | 590 (530 – 650) |
| P7 | M/A/D/E | 0.400 | 1.0 | 0.028 | 0.044 | 0.060 | 0.070 | 0.085 | 0.11 | 170 (150 – 190) |
| | | 0,400 | 1,0 | 0,0011 | 0,0017 | 0,0024 | 0,0028 | 0,0034 | 0,0044 | 560 (500 – 620) |
| P8 | M/A/D/E | 0.400 | 1.0 | 0.030 | 0.046 | 0.060 | 0.075 | 0.090 | 0.12 | 160 (140 – 180) |
| | | 0,400 | 1,0 | 0,0012 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 520 (460 – 590) |
| P11 | M/A/D/E | 0.400 | 1.0 | 0.028 | 0.042 | 0.055 | 0.070 | 0.085 | 0.11 | 145 (130 – 160) |
| | | 0,400 | 1,0 | 0,0011 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0044 | 475 (430 – 520) |
| P12 | M/A/D/E | 0.400 | 1.0 | 0.019 | 0.030 | 0.038 | 0.048 | 0.060 | 0.075 | 95 (82 – 100) |
| | | 0,400 | 1,0 | 0,00075 | 0,0012 | 0,0015 | 0,0019 | 0,0024 | 0,0030 | 310 (270 – 320) |
| M1 | E | 0.400 | 1.0 | 0.022 | 0.032 | 0.042 | 0.055 | 0.065 | 0.085 | 115 (100 – 120) |
| | | 0,400 | 1,0 | 0,00085 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0034 | 375 (330 – 390) |
| M2 | E | 0.400 | 1.0 | 0.019 | 0.030 | 0.038 | 0.048 | 0.060 | 0.075 | 95 (82 – 100) |
| | | 0,400 | 1,0 | 0,00075 | 0,0012 | 0,0015 | 0,0019 | 0,0024 | 0,0030 | 310 (270 – 320) |
| M3 | E | 0.400 | 1.0 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 60 (47 – 69) |
| | | 0,400 | 1,0 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 195 (160 – 220) |
| M4 | E | 0.400 | 1.0 | 0.014 | 0.022 | 0.028 | 0.036 | 0.042 | 0.055 | 45 (36 – 53) |
| | | 0,400 | 1,0 | 0,00055 | 0,00085 | 0,0011 | 0,0014 | 0,0017 | 0,0022 | 150 (120 – 170) |
| M5 | E | 0.400 | 1.0 | 0.014 | 0.022 | 0.028 | 0.036 | 0.042 | 0.055 | 37 (30 – 44) |
| | | 0,400 | 1,0 | 0,00055 | 0,00085 | 0,0011 | 0,0014 | 0,0017 | 0,0022 | 120 (99 – 140) |
| K1 | E | 0.400 | 1.2 | 0.026 | 0.038 | 0.050 | 0.065 | 0.080 | 0.10 | 165 (160 – 190) |
| | | 0,400 | 1,2 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 540 (530 – 620) |
| K2 | E | 0.400 | 1.2 | 0.024 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 145 (140 – 170) |
| | | 0,400 | 1,2 | 0,00095 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 475 (460 – 550) |
| K3 | E | 0.400 | 1.2 | 0.024 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 125 (120 – 140) |
| | | 0,400 | 1,2 | 0,00095 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 410 (400 – 450) |
| K4 | E | 0.400 | 1.2 | 0.024 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 120 (110 – 140) |
| | | 0,400 | 1,2 | 0,00095 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 395 (370 – 450) |
| K5 | E | 0.400 | 1.1 | 0.026 | 0.038 | 0.050 | 0.065 | 0.080 | 0.10 | 155 (140 – 170) |
| | | 0,400 | 1,1 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 510 (460 – 550) |
| K6 | E | 0.400 | 1.1 | 0.028 | 0.044 | 0.060 | 0.070 | 0.085 | 0.11 | 220 (190 – 250) |
| | | 0,400 | 1,1 | 0,0011 | 0,0017 | 0,0024 | 0,0028 | 0,0034 | 0,0044 | 720 (630 – 820) |
| K7 | E | 0.400 | 1.1 | 0.026 | 0.038 | 0.050 | 0.065 | 0.080 | 0.10 | 195 (170 – 220) |
| | | 0,400 | 1,1 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 640 (560 – 720) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – JS553 Eckfräsen – Zoll

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|--------|--------|--------|--------|--------------------|
| | | | | 1/8 | 3/16 | 1/4 | 5/16 | 3/8 | 1/2 | |
| N1 | E | 0.500 | 1.0 | 0.025 | 0.038 | 0.050 | 0.065 | 0.075 | 0.10 | 620 (520 – 720) |
| | | 0,500 | 1,0 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 0,0040 | 2025 (1800 – 2300) |
| N2 | E | 0.500 | 1.0 | 0.025 | 0.038 | 0.050 | 0.065 | 0.075 | 0.10 | 400 (340 – 460) |
| | | 0,500 | 1,0 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 0,0040 | 1300 (1200 – 1500) |
| N3 | E | 0.500 | 1.0 | 0.025 | 0.038 | 0.050 | 0.065 | 0.075 | 0.10 | 265 (230 – 300) |
| | | 0,500 | 1,0 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 0,0040 | 870 (760 – 980) |
| N11 | E | 0.500 | 1.1 | 0.025 | 0.038 | 0.050 | 0.065 | 0.075 | 0.10 | 310 (260 – 350) |
| | | 0,500 | 1,1 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 0,0040 | 1025 (860 – 1100) |
| S1 | E | 0.150 | 0.50 | 0.028 | 0.042 | 0.055 | 0.070 | 0.085 | 0.11 | 43 (26 – 60) |
| | | 0,150 | 0,50 | 0,0011 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0044 | 140 (86 – 190) |
| S2 | E | 0.150 | 0.50 | 0.028 | 0.042 | 0.055 | 0.070 | 0.085 | 0.11 | 35 (21 – 48) |
| | | 0,150 | 0,50 | 0,0011 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0044 | 115 (69 – 150) |
| S3 | E | 0.150 | 0.50 | 0.026 | 0.038 | 0.050 | 0.065 | 0.075 | 0.10 | 30 (19 – 42) |
| | | 0,150 | 0,50 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 0,0040 | 100 (63 – 130) |
| S11 | E | 0.400 | 1.0 | 0.019 | 0.030 | 0.038 | 0.048 | 0.060 | 0.075 | 110 (78 – 130) |
| | | 0,400 | 1,0 | 0,00075 | 0,0012 | 0,0015 | 0,0019 | 0,0024 | 0,0030 | 360 (260 – 420) |
| S12 | E | 0.400 | 1.0 | 0.019 | 0.030 | 0.038 | 0.048 | 0.060 | 0.075 | 85 (60 – 100) |
| | | 0,400 | 1,0 | 0,00075 | 0,0012 | 0,0015 | 0,0019 | 0,0024 | 0,0030 | 280 (200 – 320) |
| S13 | E | 0.400 | 1.0 | 0.017 | 0.025 | 0.034 | 0.042 | 0.050 | 0.065 | 65 (48 – 84) |
| | | 0,400 | 1,0 | 0,00065 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0026 | 215 (160 – 270) |
| H5 | M/A/D | 0.200 | 0.90 | 0.020 | 0.032 | 0.042 | 0.050 | 0.060 | 0.080 | 75 (62 – 91) |
| | | 0,200 | 0,90 | 0,00080 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 0,0032 | 245 (210 – 290) |
| H8 | M/A/D | 0.200 | 0.90 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 80 (65 – 96) |
| | | 0,200 | 0,90 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 260 (220 – 310) |
| H21 | M/A/D | 0.200 | 0.90 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 80 (65 – 96) |
| | | 0,200 | 0,90 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 260 (220 – 310) |
| H31 | M/A/D | 0.200 | 0.90 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 60 (49 – 72) |
| | | 0,200 | 0,90 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 195 (170 – 230) |
| TS1 | A | 0.500 | 1.2 | 0.032 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 290 (180 – 400) |
| | | 0,500 | 1,2 | 0,0013 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 950 (600 – 1300) |
| TP1 | A | 0.500 | 1.2 | 0.032 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 300 (180 – 410) |
| | | 0,500 | 1,2 | 0,0013 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 980 (600 – 1300) |
| GR1 | A | 0.500 | 1.2 | 0.032 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 580 (470 – 690) |
| | | 0,500 | 1,2 | 0,0013 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 1900 (1600 – 2200) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JS553 Nutfräsen – Zoll

| SMG | | a _p /DC | f _z | | | | | | v _c |
|-----|---------|--------------------|----------------|---------|--------|--------|--------|--------|-----------------|
| | | | 1/8 | 3/16 | 1/4 | 5/16 | 3/8 | 1/2 | |
| P1 | M/A/D/E | 1.0 | 0.022 | 0.034 | 0.044 | 0.055 | 0.065 | 0.090 | 195 (170 – 220) |
| | | 1,0 | 0,00085 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0036 | 640 (560 – 720) |
| P2 | M/A/D/E | 1.0 | 0.022 | 0.034 | 0.044 | 0.055 | 0.065 | 0.090 | 190 (170 – 210) |
| | | 1,0 | 0,00085 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0036 | 620 (560 – 680) |
| P3 | M/A/D/E | 1.0 | 0.022 | 0.034 | 0.044 | 0.055 | 0.065 | 0.090 | 165 (140 – 180) |
| | | 1,0 | 0,00085 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0036 | 540 (460 – 590) |
| P4 | M/A/D/E | 1.0 | 0.022 | 0.034 | 0.044 | 0.055 | 0.065 | 0.090 | 145 (130 – 160) |
| | | 1,0 | 0,00085 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0036 | 475 (430 – 520) |
| P5 | M/A/D/E | 1.0 | 0.022 | 0.034 | 0.044 | 0.055 | 0.065 | 0.090 | 135 (120 – 150) |
| | | 1,0 | 0,00085 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0036 | 445 (400 – 490) |
| P6 | M/A/D/E | 1.0 | 0.022 | 0.034 | 0.044 | 0.055 | 0.065 | 0.090 | 155 (140 – 170) |
| | | 1,0 | 0,00085 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0036 | 510 (460 – 550) |
| P7 | M/A/D/E | 1.0 | 0.022 | 0.034 | 0.044 | 0.055 | 0.065 | 0.090 | 145 (130 – 160) |
| | | 1,0 | 0,00085 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0036 | 475 (430 – 520) |
| P8 | M/A/D/E | 1.0 | 0.022 | 0.034 | 0.044 | 0.055 | 0.065 | 0.090 | 135 (120 – 150) |
| | | 1,0 | 0,00085 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0036 | 445 (400 – 490) |
| P11 | M/A/D/E | 0.80 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 130 (120 – 140) |
| | | 0,80 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 425 (400 – 450) |
| P12 | M/A/D/E | 0.80 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 80 (69 – 87) |
| | | 0,80 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 260 (230 – 280) |
| M1 | E | 0.80 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 95 (85 – 100) |
| | | 0,80 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 310 (280 – 320) |
| M2 | E | 0.80 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 80 (69 – 87) |
| | | 0,80 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 260 (230 – 280) |
| M3 | E | 0.70 | 0.013 | 0.019 | 0.026 | 0.032 | 0.038 | 0.050 | 48 (39 – 58) |
| | | 0,70 | 0,00050 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 155 (130 – 190) |
| M4 | E | 0.70 | 0.013 | 0.019 | 0.026 | 0.032 | 0.038 | 0.050 | 36 (30 – 43) |
| | | 0,70 | 0,00050 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 120 (99 – 140) |
| M5 | E | 0.70 | 0.013 | 0.019 | 0.026 | 0.032 | 0.038 | 0.050 | 30 (25 – 36) |
| | | 0,70 | 0,00050 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 100 (83 – 110) |
| K1 | E | 1.0 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 145 (140 – 170) |
| | | 1,0 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 475 (460 – 550) |
| K2 | E | 1.0 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 125 (120 – 150) |
| | | 1,0 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 410 (400 – 490) |
| K3 | E | 1.0 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 110 (110 – 120) |
| | | 1,0 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 360 (370 – 390) |
| K4 | E | 1.0 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 105 (96 – 120) |
| | | 1,0 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 345 (320 – 390) |
| K5 | E | 0.80 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 135 (120 – 150) |
| | | 0,80 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 445 (400 – 490) |
| K6 | E | 0.80 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 200 (180 – 230) |
| | | 0,80 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 660 (600 – 750) |
| K7 | E | 0.80 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 175 (150 – 190) |
| | | 0,80 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 570 (500 – 620) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – JS553 Nutfräsen – Zoll

| SMG |  | a _p /DC | f _z | | | | | | v _c |
|-----|---|--------------------|----------------|---------|---------|---------|---------|--------|--------------------|
| | | | 1/8 | 3/16 | 1/4 | 5/16 | 3/8 | 1/2 | |
| N1 | E | 0.70 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 580 (490 – 670) |
| | | 0.70 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 1900 (1700 – 2100) |
| N2 | E | 0.70 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 375 (320 – 430) |
| | | 0.70 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 1225 (1100 – 1400) |
| N3 | E | 0.70 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 250 (210 – 290) |
| | | 0.70 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 820 (690 – 950) |
| N11 | E | 0.60 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 290 (250 – 330) |
| | | 0.60 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 950 (830 – 1000) |
| S1 | E | 0.30 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 34 (21 – 47) |
| | | 0.30 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 110 (69 – 150) |
| S2 | E | 0.30 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 27 (17 – 38) |
| | | 0.30 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 90 (56 – 120) |
| S3 | E | 0.30 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 23 (15 – 32) |
| | | 0.30 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 75 (50 – 100) |
| S11 | E | 0.50 | 0.019 | 0.028 | 0.038 | 0.048 | 0.055 | 0.075 | 85 (63 – 110) |
| | | 0.50 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 0,0030 | 280 (210 – 360) |
| S12 | E | 0.50 | 0.019 | 0.028 | 0.038 | 0.048 | 0.055 | 0.075 | 65 (48 – 86) |
| | | 0.50 | 0,00075 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 0,0030 | 215 (160 – 280) |
| S13 | E | 0.50 | 0.017 | 0.025 | 0.034 | 0.042 | 0.050 | 0.065 | 55 (39 – 69) |
| | | 0.50 | 0,00065 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0026 | 180 (130 – 220) |
| H5 | M/A/D | 0.50 | 0.0065 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.026 | 65 (52 – 77) |
| | | 0.50 | 0,00026 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 215 (180 – 250) |
| H8 | M/A/D | 0.50 | 0.0065 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.026 | 65 (52 – 77) |
| | | 0.50 | 0,00026 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 215 (180 – 250) |
| H21 | M/A/D | 0.50 | 0.0065 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.026 | 65 (52 – 77) |
| | | 0.50 | 0,00026 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 215 (180 – 250) |
| H31 | M/A/D | 0.50 | 0.0065 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.026 | 49 (39 – 58) |
| | | 0.50 | 0,00026 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 160 (130 – 190) |
| TS1 | A | 1.0 | 0.032 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 245 (150 – 340) |
| | | 1.0 | 0,0013 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 800 (500 – 1100) |
| TP1 | A | 1.0 | 0.032 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 250 (160 – 350) |
| | | 1.0 | 0,0013 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 820 (530 – 1100) |
| GR1 | A | 1.0 | 0.032 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 490 (400 – 580) |
| | | 1.0 | 0,0013 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 1600 (1400 – 1900) |

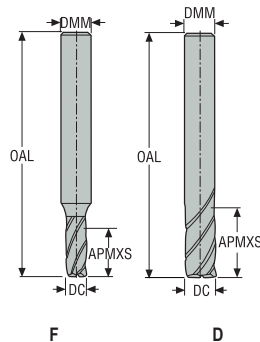
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

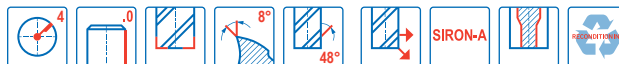
| |
|-------------------------------|
| Universell |
| Stahl und Guss |
| Stahl und Guss |
| Rostfrei und ISO-S-Werkstoffe |
| Rostfrei und ISO-S-Werkstoffe |
| NE-Metalle |
| NE-Metalle |
| Harter |
| Harter |
| Kunststoffe und Composite |
| Kunststoffe und Composite |
| Graphit |
| Graphit |
| X-Heads |
| X-Heads |
| Minimaster Plus |
| Minimaster Plus |
| Minimaster |
| Minimaster |

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Scharfe Schneide



- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | PCEDC | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|------|------|-------|------|-------|-------------|
| | | | | mm | mm | mm | mm | | |
| 554030SZ4.0-SIRON-A | 02733453 | 2 | F | 3,0 | 6,0 | 7,0 | 50,0 | 4 | ■ |
| 554040SZ4.0-SIRON-A | 02733458 | 2 | F | 4,0 | 6,0 | 10,0 | 55,0 | 4 | ■ |
| 554050SZ4.0-SIRON-A | 02733812 | 2 | F | 5,0 | 6,0 | 12,0 | 55,0 | 4 | ■ |
| 554060SZ4.0-SIRON-A | 02733814 | 2 | D | 6,0 | 6,0 | 14,0 | 55,0 | 4 | ■ |
| 554080SZ4.0-SIRON-A | 02733815 | 2 | D | 8,0 | 8,0 | 18,0 | 60,0 | 4 | ■ |
| 554100SZ4.0-SIRON-A | 02733816 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

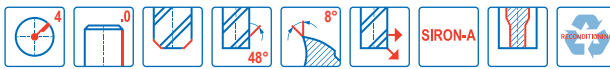
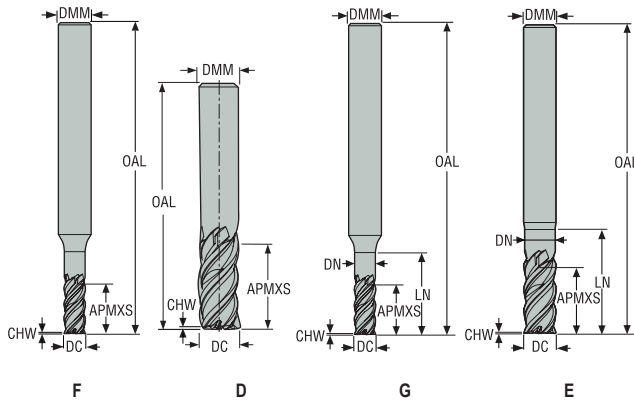
X-Heads

Minimaster Plus

Minimaster

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Fase



- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Zylindrisch |
|----------------------|----------------|--------------|---------------|------|------|-------|-------|------|------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS554030F1C.0Z4-SIRA | 10194615 | 1 | F | 3,0 | 6,0 | 4,0 | 40,0 | 6,0 | 3,05 | 0,035 | 4 | ■ |
| JS554040F1C.0Z4-SIRA | 10041454 | 1 | F | 4,0 | 6,0 | 6,0 | 40,0 | 9,0 | 4,05 | 0,045 | 4 | ■ |
| JS554050F1C.0Z4-SIRA | 10194616 | 1 | F | 5,0 | 6,0 | 7,0 | 40,0 | 10,0 | 5,05 | 0,055 | 4 | ■ |
| JS554060D1C.0Z4-SIRA | 10041455 | 1 | D | 6,0 | 6,0 | 8,0 | 40,0 | – | – | 0,075 | 4 | ■ |
| JS554080D1C.0Z4-SIRA | 10041456 | 1 | D | 8,0 | 8,0 | 11,0 | 50,0 | – | – | 0,1 | 4 | ■ |
| JS554100D1C.0Z4-SIRA | 10041457 | 1 | D | 10,0 | 10,0 | 13,0 | 57,0 | – | – | 0,125 | 4 | ■ |
| JS554120D1C.0Z4-SIRA | 10041458 | 1 | D | 12,0 | 12,0 | 15,0 | 65,0 | – | – | 0,15 | 4 | ■ |
| JS554160D1C.0Z4-SIRA | 10041459 | 1 | D | 16,0 | 16,0 | 19,0 | 75,0 | – | – | 0,2 | 4 | ■ |
| 554030Z4.0-SIRON-A | 02733455 | 2 | F | 3,0 | 6,0 | 7,0 | 50,0 | 8,7 | 3,0 | 0,035 | 4 | ■ |
| JS554030G2C.0Z4-SIRA | 03029956 | 2 | G | 3,0 | 6,0 | 8,0 | 57,0 | 10,0 | 2,85 | 0,035 | 4 | ■ |
| 554040Z4.0-SIRON-A | 02733459 | 2 | F | 4,0 | 6,0 | 10,0 | 55,0 | 11,7 | 4,0 | 0,045 | 4 | ■ |
| JS554040G2C.0Z4-SIRA | 03029957 | 2 | G | 4,0 | 6,0 | 10,0 | 57,0 | 13,0 | 3,8 | 0,045 | 4 | ■ |
| 554050Z4.0-SIRON-A | 02733813 | 2 | F | 5,0 | 6,0 | 12,0 | 55,0 | 13,7 | 5,0 | 0,055 | 4 | ■ |
| JS554050G2C.0Z4-SIRA | 03029958 | 2 | G | 5,0 | 6,0 | 12,0 | 57,0 | 16,0 | 4,75 | 0,055 | 4 | ■ |
| 554060Z4.0-SIRON-A | 02679503 | 2 | D | 6,0 | 6,0 | 14,0 | 55,0 | – | – | 0,075 | 4 | ■ |
| JS554060E2C.0Z4-SIRA | 03029959 | 2 | E | 6,0 | 6,0 | 14,0 | 57,0 | 18,0 | 5,7 | 0,075 | 4 | ■ |
| 554080Z4.0-SIRON-A | 02679512 | 2 | D | 8,0 | 8,0 | 18,0 | 60,0 | – | – | 0,1 | 4 | ■ |
| JS554080E2C.0Z4-SIRA | 03029961 | 2 | E | 8,0 | 8,0 | 18,0 | 63,0 | 25,0 | 7,6 | 0,1 | 4 | ■ |
| 554100Z4.0-SIRON-A | 02679537 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | – | – | 0,125 | 4 | ■ |
| JS554100E2C.0Z4-SIRA | 03029963 | 2 | E | 10,0 | 10,0 | 22,0 | 72,0 | 29,0 | 9,5 | 0,125 | 4 | ■ |
| 554120Z4.0-SIRON-A | 02679548 | 2 | D | 12,0 | 12,0 | 26,0 | 80,0 | – | – | 0,15 | 4 | ■ |
| JS554120E2C.0Z4-SIRA | 03029966 | 2 | E | 12,0 | 12,0 | 26,0 | 83,0 | 35,0 | 11,4 | 0,15 | 4 | ■ |
| 554160Z4.0-SIRON-A | 02679560 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | – | – | 0,2 | 4 | ■ |
| JS554160E2C.0Z4-SIRA | 03029970 | 2 | E | 16,0 | 16,0 | 34,0 | 92,0 | 42,0 | 15,2 | 0,2 | 4 | ■ |
| 554200Z4.0-SIRON-A | 02679566 | 2 | D | 20,0 | 20,0 | 42,0 | 100,0 | – | – | 0,25 | 4 | ■ |
| JS554200E2C.0Z4-SIRA | 03029972 | 2 | E | 20,0 | 20,0 | 42,0 | 109,0 | 54,0 | 19,0 | 0,25 | 4 | ■ |
| 554250Z4.0-SIRON-A | 02679573 | 2 | D | 25,0 | 25,0 | 52,0 | 125,0 | – | – | 0,3 | 4 | ■ |

■ Lagerstandard.

Universell

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Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

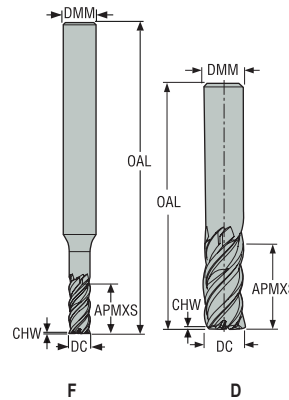
X-Heads

Minimaster Plus

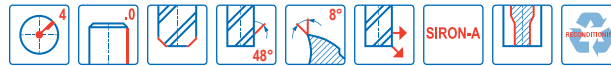
Minimaster

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Fase



- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|-----|-------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| 554L030Z4.0-SIRON-A | 02733818 | 3 | F | 3,0 | 6,0 | 12,0 | 55,0 | 13,7 | 3,0 | 0,035 | 4 | ■ |
| 554L040Z4.0-SIRON-A | 02733823 | 3 | F | 4,0 | 6,0 | 16,0 | 60,0 | 17,7 | 4,0 | 0,045 | 4 | ■ |
| 554L050Z4.0-SIRON-A | 02733825 | 3 | F | 5,0 | 6,0 | 20,0 | 65,0 | 21,7 | 5,0 | 0,055 | 4 | ■ |
| 554L060Z4.0-SIRON-A | 02733828 | 3 | D | 6,0 | 6,0 | 23,0 | 65,0 | – | – | 0,075 | 4 | ■ |
| 554L080Z4.0-SIRON-A | 02733830 | 3 | D | 8,0 | 8,0 | 32,0 | 75,0 | – | – | 0,1 | 4 | ■ |
| 554L100Z4.0-SIRON-A | 02733832 | 3 | D | 10,0 | 10,0 | 40,0 | 85,0 | – | – | 0,125 | 4 | ■ |
| 554L120Z4.0-SIRON-A | 02733834 | 3 | D | 12,0 | 12,0 | 45,0 | 100,0 | – | – | 0,15 | 4 | ■ |
| 554L160Z4.0-SIRON-A | 02733836 | 3 | D | 16,0 | 16,0 | 55,0 | 115,0 | – | – | 0,2 | 4 | ■ |
| 554L200Z4.0-SIRON-A | 02733838 | 3 | D | 20,0 | 20,0 | 65,0 | 125,0 | – | – | 0,25 | 4 | ■ |
| 554L250Z4.0-SIRON-A | 02733841 | 3 | D | 25,0 | 25,0 | 85,0 | 150,0 | – | – | 0,3 | 4 | ■ |

■ Lagerstandard.

Universell

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Rostfrei und
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NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

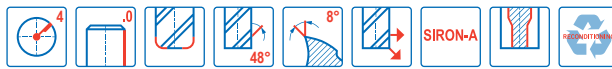
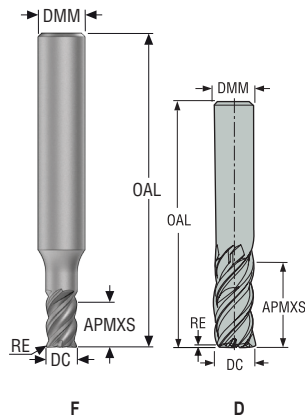
X-Heads

Minimaster Plus

Minimaster

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | RE | PCEDC | Zylindrisch |
|-------------------------|--------------------|------------------|-------------------|------|------|-------|-------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | | |
| JS554030F1R020.0Z4-SIRA | 10194617 | 1 | F | 3,0 | 6,0 | 4,0 | 40,0 | 0,2 | 4 | ■ |
| JS554040F1R020.0Z4-SIRA | 10194618 | 1 | F | 4,0 | 6,0 | 6,0 | 40,0 | 0,2 | 4 | ■ |
| JS554050F1R020.0Z4-SIRA | 10194619 | 1 | F | 5,0 | 6,0 | 7,0 | 40,0 | 0,2 | 4 | ■ |
| JS554060D1R020.0Z4-SIRA | 10194620 | 1 | D | 6,0 | 6,0 | 8,0 | 40,0 | 0,2 | 4 | ■ |
| JS554060D1R050.0Z4-SIRA | 10194621 | 1 | D | 6,0 | 6,0 | 8,0 | 40,0 | 0,5 | 4 | ■ |
| JS554080D1R050.0Z4-SIRA | 10194622 | 1 | D | 8,0 | 8,0 | 11,0 | 50,0 | 0,5 | 4 | ■ |
| JS554100D1R050.0Z4-SIRA | 10194623 | 1 | D | 10,0 | 10,0 | 13,0 | 57,0 | 0,5 | 4 | ■ |
| JS554100D1R100.0Z4-SIRA | 10194624 | 1 | D | 10,0 | 10,0 | 13,0 | 57,0 | 1,0 | 4 | ■ |
| JS554120D1R050.0Z4-SIRA | 10194625 | 1 | D | 12,0 | 12,0 | 15,0 | 65,0 | 0,5 | 4 | ■ |
| JS554120D1R100.0Z4-SIRA | 10194626 | 1 | D | 12,0 | 12,0 | 15,0 | 65,0 | 1,0 | 4 | ■ |
| JS554160D1R050.0Z4-SIRA | 10194627 | 1 | D | 16,0 | 16,0 | 19,0 | 75,0 | 0,5 | 4 | ■ |
| JS554160D1R100.0Z4-SIRA | 10194628 | 1 | D | 16,0 | 16,0 | 19,0 | 75,0 | 1,0 | 4 | ■ |
| 554060R020Z4.0-SIRON-A | 02679507 | 2 | D | 6,0 | 6,0 | 14,0 | 55,0 | 0,2 | 4 | ■ |
| 554080R050Z4.0-SIRON-A | 02679514 | 2 | D | 8,0 | 8,0 | 18,0 | 60,0 | 0,5 | 4 | ■ |
| 554100R050Z4.0-SIRON-A | 02679540 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | 0,5 | 4 | ■ |
| 554100R100Z4.0-SIRON-A | 02679544 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | 1,0 | 4 | ■ |
| 554120R050Z4.0-SIRON-A | 02679552 | 2 | D | 12,0 | 12,0 | 26,0 | 80,0 | 0,5 | 4 | ■ |
| 554120R100Z4.0-SIRON-A | 02679557 | 2 | D | 12,0 | 12,0 | 26,0 | 80,0 | 1,0 | 4 | ■ |
| 554160R050Z4.0-SIRON-A | 02679562 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | 0,5 | 4 | ■ |
| 554160R100Z4.0-SIRON-A | 02679564 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | 1,0 | 4 | ■ |
| 554160R200Z4.0-SIRON-A | 02810437 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | 2,0 | 4 | ■ |
| 554160R310Z4.0-SIRON-A | 02810439 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | 3,1 | 4 | ■ |
| 554160R400Z4.0-SIRON-A | 02810441 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | 4,0 | 4 | ■ |
| 554200R050Z4.0-SIRON-A | 02679568 | 2 | D | 20,0 | 20,0 | 42,0 | 100,0 | 0,5 | 4 | ■ |
| 554200R100Z4.0-SIRON-A | 02679571 | 2 | D | 20,0 | 20,0 | 42,0 | 100,0 | 1,0 | 4 | ■ |
| 554200R250Z4.0-SIRON-A | 02810443 | 2 | D | 20,0 | 20,0 | 42,0 | 100,0 | 2,5 | 4 | ■ |
| 554200R310Z4.0-SIRON-A | 02810445 | 2 | D | 20,0 | 20,0 | 42,0 | 100,0 | 3,1 | 4 | ■ |
| 554200R400Z4.0-SIRON-A | 02810447 | 2 | D | 20,0 | 20,0 | 42,0 | 100,0 | 4,0 | 4 | ■ |
| 554250R050Z4.0-SIRON-A | 02679575 | 2 | D | 25,0 | 25,0 | 52,0 | 125,0 | 0,5 | 4 | ■ |
| 554250R100Z4.0-SIRON-A | 02679577 | 2 | D | 25,0 | 25,0 | 52,0 | 125,0 | 1,0 | 4 | ■ |
| 554250R310Z4.0-SIRON-A | 02810449 | 2 | D | 25,0 | 25,0 | 52,0 | 125,0 | 3,1 | 4 | ■ |
| 554250R400Z4.0-SIRON-A | 02810452 | 2 | D | 25,0 | 25,0 | 52,0 | 125,0 | 4,0 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

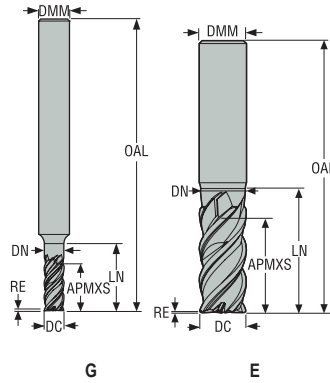
X-Heads

Minimaster Plus

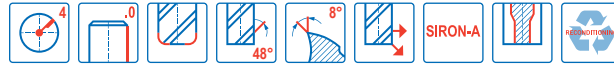
Minimaster

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|-------------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS554030G2R015.0Z4-SIRA | 02881697 | 2 | G | 3,0 | 6,0 | 7,0 | 57,0 | 10,0 | 2,85 | 0,15 | 4 | ■ |
| JS554040G2R020.0Z4-SIRA | 02881698 | 2 | G | 4,0 | 6,0 | 10,0 | 57,0 | 13,0 | 3,8 | 0,2 | 4 | ■ |
| JS554050G2R020.0Z4-SIRA | 02881699 | 2 | G | 5,0 | 6,0 | 12,0 | 57,0 | 16,0 | 4,75 | 0,2 | 4 | ■ |
| JS554060E2R020.0Z4-SIRA | 03029960 | 2 | E | 6,0 | 6,0 | 14,0 | 57,0 | 18,0 | 5,7 | 0,2 | 4 | ■ |
| JS554060E2R050.0Z4-SIRA | 02881700 | 2 | E | 6,0 | 6,0 | 14,0 | 57,0 | 18,0 | 5,7 | 0,5 | 4 | ■ |
| JS554060E2R100.0Z4-SIRA | 03029948 | 2 | E | 6,0 | 6,0 | 14,0 | 57,0 | 18,0 | 5,7 | 1,0 | 4 | ■ |
| JS554080E2R050.0Z4-SIRA | 03029962 | 2 | E | 8,0 | 8,0 | 18,0 | 63,0 | 25,0 | 7,6 | 0,5 | 4 | ■ |
| JS554080E2R100.0Z4-SIRA | 02881701 | 2 | E | 8,0 | 8,0 | 18,0 | 63,0 | 25,0 | 7,6 | 1,0 | 4 | ■ |
| JS554100E2R050.0Z4-SIRA | 03029964 | 2 | E | 10,0 | 10,0 | 22,0 | 72,0 | 29,0 | 9,5 | 0,5 | 4 | ■ |
| JS554100E2R100.0Z4-SIRA | 03029965 | 2 | E | 10,0 | 10,0 | 22,0 | 72,0 | 29,0 | 9,5 | 1,0 | 4 | ■ |
| JS554100E2R200.0Z4-SIRA | 02881702 | 2 | E | 10,0 | 10,0 | 22,0 | 72,0 | 29,0 | 9,5 | 2,0 | 4 | ■ |
| JS554100E2R250.0Z4-SIRA | 03029949 | 2 | E | 10,0 | 10,0 | 22,0 | 72,0 | 29,0 | 9,5 | 2,5 | 4 | ■ |
| JS554120E2R050.0Z4-SIRA | 03029968 | 2 | E | 12,0 | 12,0 | 26,0 | 83,0 | 35,0 | 11,4 | 0,5 | 4 | ■ |
| JS554120E2R100.0Z4-SIRA | 03029969 | 2 | E | 12,0 | 12,0 | 26,0 | 83,0 | 35,0 | 11,4 | 1,0 | 4 | ■ |
| JS554120E2R200.0Z4-SIRA | 02881703 | 2 | E | 12,0 | 12,0 | 26,0 | 83,0 | 35,0 | 11,4 | 2,0 | 4 | ■ |
| JS554120E2R250.0Z4-SIRA | 02881704 | 2 | E | 12,0 | 12,0 | 26,0 | 83,0 | 35,0 | 11,4 | 2,5 | 4 | ■ |
| JS554120E2R300.0Z4-SIRA | 03029950 | 2 | E | 12,0 | 12,0 | 26,0 | 83,0 | 35,0 | 11,4 | 3,0 | 4 | ■ |
| JS554160E2R050.0Z4-SIRA | 03029971 | 2 | E | 16,0 | 16,0 | 34,0 | 92,0 | 42,0 | 15,2 | 0,5 | 4 | ■ |
| JS554160E2R600.0Z4-SIRA | 03093685 | 2 | E | 16,0 | 16,0 | 34,0 | 92,0 | 42,0 | 15,2 | 6,0 | 4 | ■ |
| JS554200E2R200.0Z4-SIRA | 02881705 | 2 | E | 20,0 | 20,0 | 42,0 | 110,0 | 54,0 | 19,0 | 2,0 | 4 | ■ |
| JS554200E2R600.0Z4-SIRA | 03029951 | 2 | E | 20,0 | 20,0 | 42,0 | 109,0 | 54,0 | 19,0 | 6,0 | 4 | ■ |
| JS554250E2R600.0Z4-SIRA | 03093686 | 2 | E | 25,0 | 25,0 | 52,0 | 125,0 | 65,0 | 23,8 | 6,0 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und
Composite

Graphit

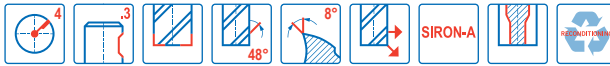
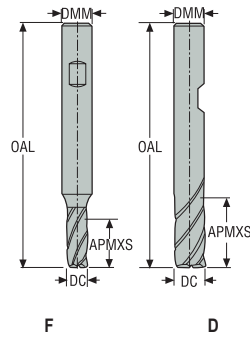
X-Heads

Minimaster Plus

Minimaster

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Weldon – Scharfe Schneide



- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | PCEDC | Weldon |
|----------------------|--------------------|------------------|-------------------|------|------|-------|------|-------|--------------------------|
| | | | | mm | mm | mm | mm | | |
| 554030SZ4.0-SIRON-AW | 02733844 | 2 | F | 3,0 | 6,0 | 7,0 | 50,0 | 4 | <input type="checkbox"/> |
| 554040SZ4.0-SIRON-AW | 02733846 | 2 | F | 4,0 | 6,0 | 10,0 | 55,0 | 4 | <input type="checkbox"/> |
| 554050SZ4.0-SIRON-AW | 02733847 | 2 | F | 5,0 | 6,0 | 12,0 | 55,0 | 4 | <input type="checkbox"/> |
| 554060SZ4.0-SIRON-AW | 02733848 | 2 | D | 6,0 | 6,0 | 14,0 | 55,0 | 4 | <input type="checkbox"/> |
| 554080SZ4.0-SIRON-AW | 02733849 | 2 | D | 8,0 | 8,0 | 18,0 | 60,0 | 4 | <input type="checkbox"/> |
| 554100SZ4.0-SIRON-AW | 02733850 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | 4 | <input type="checkbox"/> |

Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

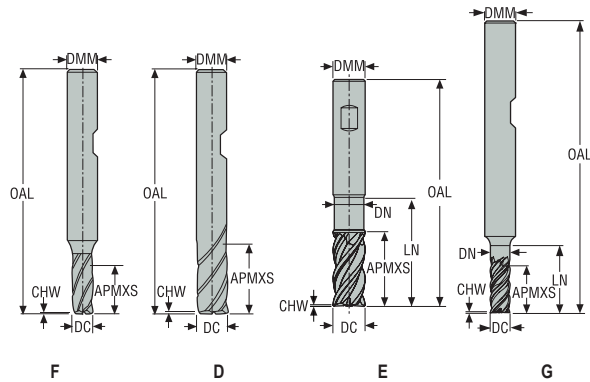
X-Heads

Minimaster Plus

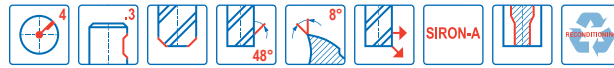
Minimaster

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Weldon – Fase



- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

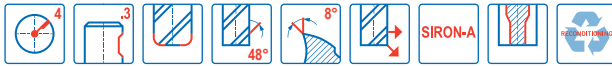
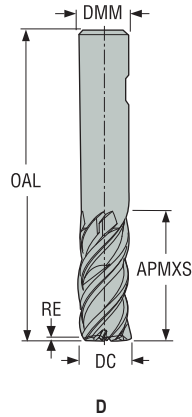


| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Weldon |
|----------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-------|-------|--------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS554040F1C.3Z4-SIRA | 10041460 | 1 | F | 4,0 | 6,0 | 6,0 | 40,0 | 9,0 | 4,05 | 0,045 | 4 | ■ |
| JS554060D1C.3Z4-SIRA | 10041461 | 1 | D | 6,0 | 6,0 | 8,0 | 40,0 | - | - | 0,075 | 4 | ■ |
| JS554080D1C.3Z4-SIRA | 10041462 | 1 | D | 8,0 | 8,0 | 11,0 | 50,0 | - | - | 0,1 | 4 | □ |
| JS554100D1C.3Z4-SIRA | 10041463 | 1 | D | 10,0 | 10,0 | 13,0 | 57,0 | - | - | 0,125 | 4 | □ |
| JS554120D1C.3Z4-SIRA | 10041464 | 1 | D | 12,0 | 12,0 | 15,0 | 65,0 | - | - | 0,15 | 4 | □ |
| JS554160D1C.3Z4-SIRA | 10041465 | 1 | D | 16,0 | 16,0 | 19,0 | 75,0 | - | - | 0,2 | 4 | □ |
| 554030Z4.3-SIRON-A | 02733450 | 2 | F | 3,0 | 6,0 | 7,0 | 50,0 | 8,7 | 3,0 | 0,035 | 4 | ■ |
| JS554030G2C.3Z4-SIRA | 03029973 | 2 | G | 3,0 | 6,0 | 8,0 | 57,0 | 10,0 | 2,85 | 0,035 | 4 | □ |
| 554040Z4.3-SIRON-A | 02733456 | 2 | F | 4,0 | 6,0 | 10,0 | 55,0 | 11,7 | 4,0 | 0,045 | 4 | ■ |
| JS554040G2C.3Z4-SIRA | 03029974 | 2 | G | 4,0 | 6,0 | 10,0 | 57,0 | 13,0 | 3,8 | 0,045 | 4 | □ |
| 554050Z4.3-SIRON-A | 02733461 | 2 | F | 5,0 | 6,0 | 12,0 | 55,0 | 13,7 | 5,0 | 0,055 | 4 | ■ |
| JS554050G2C.3Z4-SIRA | 03029975 | 2 | G | 5,0 | 6,0 | 12,0 | 57,0 | 16,0 | 4,75 | 0,055 | 4 | □ |
| 554060Z4.3-SIRON-A | 02679502 | 2 | D | 6,0 | 6,0 | 14,0 | 55,0 | - | - | 0,075 | 4 | ■ |
| JS554060E2C.3Z4-SIRA | 03029976 | 2 | E | 6,0 | 6,0 | 14,0 | 57,0 | 18,0 | 5,7 | 0,075 | 4 | □ |
| 554080Z4.3-SIRON-A | 02679511 | 2 | D | 8,0 | 8,0 | 18,0 | 60,0 | - | - | 0,1 | 4 | ■ |
| JS554080E2C.3Z4-SIRA | 03029978 | 2 | E | 8,0 | 8,0 | 18,0 | 63,0 | 25,0 | 7,6 | 0,1 | 4 | □ |
| JS554100E2C.3Z4-SIRA | 03029980 | 2 | E | 10,0 | 10,0 | 22,0 | 72,0 | 29,0 | 9,5 | 0,125 | 4 | □ |
| 554100Z4.3-SIRON-A | 02679535 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | - | - | 0,125 | 4 | ■ |
| JS554120E2C.3Z4-SIRA | 03029983 | 2 | E | 12,0 | 12,0 | 26,0 | 83,0 | 35,0 | 11,4 | 0,15 | 4 | □ |
| 554120Z4.3-SIRON-A | 02679547 | 2 | D | 12,0 | 12,0 | 26,0 | 80,0 | - | - | 0,15 | 4 | ■ |
| JS554160E2C.3Z4-SIRA | 03029986 | 2 | E | 16,0 | 16,0 | 34,0 | 92,0 | 42,0 | 15,2 | 0,2 | 4 | □ |
| 554160Z4.3-SIRON-A | 02679559 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | - | - | 0,2 | 4 | ■ |
| JS554200E2C.3Z4-SIRA | 03029988 | 2 | E | 20,0 | 20,0 | 42,0 | 109,0 | 54,0 | 19,0 | 0,25 | 4 | □ |
| 554200Z4.3-SIRON-A | 02679565 | 2 | D | 20,0 | 20,0 | 42,0 | 100,0 | - | - | 0,25 | 4 | ■ |
| 554250Z4.3-SIRON-A | 02679572 | 2 | D | 25,0 | 25,0 | 52,0 | 125,0 | - | - | 0,3 | 4 | ■ |
| 554L030Z4.3-SIRON-A | 02733817 | 3 | F | 3,0 | 6,0 | 12,0 | 55,0 | 13,7 | 3,0 | 0,035 | 4 | ■ |
| 554L040Z4.3-SIRON-A | 02733820 | 3 | F | 4,0 | 6,0 | 16,0 | 60,0 | 17,7 | 4,0 | 0,045 | 4 | ■ |
| 554L050Z4.3-SIRON-A | 02733824 | 3 | F | 5,0 | 6,0 | 20,0 | 65,0 | 21,7 | 5,0 | 0,055 | 4 | ■ |
| 554L060Z4.3-SIRON-A | 02733827 | 3 | D | 6,0 | 6,0 | 23,0 | 65,0 | - | - | 0,075 | 4 | ■ |
| 554L080Z4.3-SIRON-A | 02733829 | 3 | D | 8,0 | 8,0 | 32,0 | 75,0 | - | - | 0,1 | 4 | ■ |
| 554L100Z4.3-SIRON-A | 02733831 | 3 | D | 10,0 | 10,0 | 40,0 | 85,0 | - | - | 0,125 | 4 | ■ |
| 554L120Z4.3-SIRON-A | 02733833 | 3 | D | 12,0 | 12,0 | 45,0 | 100,0 | - | - | 0,15 | 4 | ■ |
| 554L160Z4.3-SIRON-A | 02733835 | 3 | D | 16,0 | 16,0 | 55,0 | 115,0 | - | - | 0,2 | 4 | ■ |
| 554L200Z4.3-SIRON-A | 02733837 | 3 | D | 20,0 | 20,0 | 65,0 | 125,0 | - | - | 0,25 | 4 | ■ |
| 554L250Z4.3-SIRON-A | 02733839 | 3 | D | 25,0 | 25,0 | 85,0 | 150,0 | - | - | 0,3 | 4 | ■ |

■ Lagerstandard. □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Weldon – Eckenradius



- Toleranzen:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | RE | PCEDC | Weldon |
|-------------------------|--------------------|------------------|-------------------|------|------|-------|-------|-----|-------|--------|
| | | | | mm | mm | mm | mm | mm | | |
| JS554080D1R050.3Z4-SIRA | 10194629 | 1 | D | 8,0 | 8,0 | 11,0 | 50,0 | 0,5 | 4 | ☐ |
| JS554100D1R050.3Z4-SIRA | 10194630 | 1 | D | 10,0 | 10,0 | 13,0 | 57,0 | 0,5 | 4 | ☐ |
| JS554100D1R100.3Z4-SIRA | 10194631 | 1 | D | 10,0 | 10,0 | 13,0 | 57,0 | 1,0 | 4 | ☐ |
| JS554120D1R050.3Z4-SIRA | 10194632 | 1 | D | 12,0 | 12,0 | 15,0 | 65,0 | 0,5 | 4 | ☐ |
| JS554120D1R100.3Z4-SIRA | 10194633 | 1 | D | 12,0 | 12,0 | 15,0 | 65,0 | 1,0 | 4 | ☐ |
| JS554160D1R050.3Z4-SIRA | 10194634 | 1 | D | 16,0 | 16,0 | 19,0 | 75,0 | 0,5 | 4 | ☐ |
| JS554160D1R100.3Z4-SIRA | 10194635 | 1 | D | 16,0 | 16,0 | 19,0 | 75,0 | 1,0 | 4 | ☐ |
| 554060R020Z4.3-SIRON-A | 02679506 | 2 | D | 6,0 | 6,0 | 14,0 | 55,0 | 0,2 | 4 | ■ |
| 554080R050Z4.3-SIRON-A | 02679513 | 2 | D | 8,0 | 8,0 | 18,0 | 60,0 | 0,5 | 4 | ■ |
| 554100R050Z4.3-SIRON-A | 02679539 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | 0,5 | 4 | ■ |
| 554100R100Z4.3-SIRON-A | 02679542 | 2 | D | 10,0 | 10,0 | 22,0 | 70,0 | 1,0 | 4 | ■ |
| 554120R050Z4.3-SIRON-A | 02679549 | 2 | D | 12,0 | 12,0 | 26,0 | 80,0 | 0,5 | 4 | ■ |
| 554120R100Z4.3-SIRON-A | 02679554 | 2 | D | 12,0 | 12,0 | 26,0 | 80,0 | 1,0 | 4 | ■ |
| 554160R050Z4.3-SIRON-A | 02679561 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | 0,5 | 4 | ■ |
| 554160R100Z4.3-SIRON-A | 02679563 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | 1,0 | 4 | ■ |
| 554160R200Z4.3-SIRON-A | 02810436 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | 2,0 | 4 | ■ |
| 554160R310Z4.3-SIRON-A | 02810438 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | 3,1 | 4 | ■ |
| 554160R400Z4.3-SIRON-A | 02810440 | 2 | D | 16,0 | 16,0 | 34,0 | 90,0 | 4,0 | 4 | ■ |
| 554200R050Z4.3-SIRON-A | 02679567 | 2 | D | 20,0 | 20,0 | 42,0 | 100,0 | 0,5 | 4 | ■ |
| 554200R100Z4.3-SIRON-A | 02679570 | 2 | D | 20,0 | 20,0 | 42,0 | 100,0 | 1,0 | 4 | ■ |
| 554200R250Z4.3-SIRON-A | 02810442 | 2 | D | 20,0 | 20,0 | 42,0 | 100,0 | 2,5 | 4 | ■ |
| 554200R310Z4.3-SIRON-A | 02810444 | 2 | D | 20,0 | 20,0 | 42,0 | 100,0 | 3,1 | 4 | ■ |
| 554200R400Z4.3-SIRON-A | 02810446 | 2 | D | 20,0 | 20,0 | 42,0 | 100,0 | 4,0 | 4 | ■ |
| 554250R050Z4.3-SIRON-A | 02679574 | 2 | D | 25,0 | 25,0 | 52,0 | 125,0 | 0,5 | 4 | ■ |
| 554250R100Z4.3-SIRON-A | 02679576 | 2 | D | 25,0 | 25,0 | 52,0 | 125,0 | 1,0 | 4 | ■ |
| 554250R310Z4.3-SIRON-A | 02810448 | 2 | D | 25,0 | 25,0 | 52,0 | 125,0 | 3,1 | 4 | ■ |
| 554250R400Z4.3-SIRON-A | 02810451 | 2 | D | 25,0 | 25,0 | 52,0 | 125,0 | 4,0 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

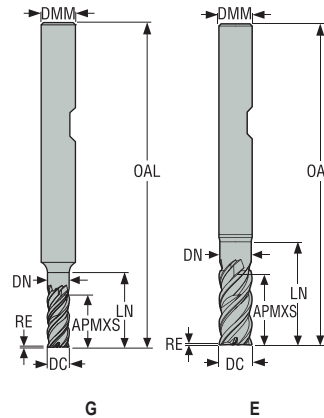
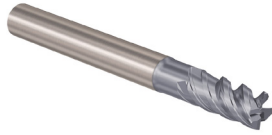
X-Heads

Minimaster Plus

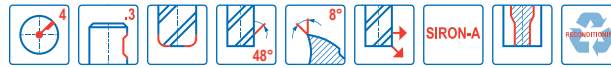
Minimaster

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Weldon – Eckenradius



- Toleranzen:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Weldon |
|-------------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|------|-------|-------------------------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS554030G2R015.3Z4-SIRA | 02881706 | 2 | G | 3,0 | 6,0 | 7,0 | 57,0 | 10,0 | 2,85 | 0,15 | 4 | <input type="checkbox"/> |
| JS554040G2R020.3Z4-SIRA | 02881946 | 2 | G | 4,0 | 6,0 | 10,0 | 57,0 | 13,0 | 3,8 | 0,2 | 4 | <input type="checkbox"/> |
| JS554050G2R020.3Z4-SIRA | 02881708 | 2 | G | 5,0 | 6,0 | 12,0 | 57,0 | 16,0 | 4,75 | 0,2 | 4 | <input type="checkbox"/> |
| JS554060E2R020.3Z4-SIRA | 03029977 | 2 | E | 6,0 | 6,0 | 14,0 | 57,0 | 18,0 | 5,7 | 0,2 | 4 | <input type="checkbox"/> |
| JS554060E2R050.3Z4-SIRA | 02881709 | 2 | E | 6,0 | 6,0 | 14,0 | 57,0 | 18,0 | 5,7 | 0,5 | 4 | <input type="checkbox"/> |
| JS554060E2R100.3Z4-SIRA | 03029952 | 2 | E | 6,0 | 6,0 | 14,0 | 57,0 | 18,0 | 5,7 | 1,0 | 4 | <input type="checkbox"/> |
| JS554080E2R050.3Z4-SIRA | 03029979 | 2 | E | 8,0 | 8,0 | 18,0 | 63,0 | 25,0 | 7,6 | 0,5 | 4 | <input type="checkbox"/> |
| JS554080E2R100.3Z4-SIRA | 02881710 | 2 | E | 8,0 | 8,0 | 18,0 | 63,0 | 25,0 | 7,6 | 1,0 | 4 | <input type="checkbox"/> |
| JS554100E2R050.3Z4-SIRA | 03029981 | 2 | E | 10,0 | 10,0 | 22,0 | 72,0 | 29,0 | 9,5 | 0,5 | 4 | <input type="checkbox"/> |
| JS554100E2R100.3Z4-SIRA | 03029982 | 2 | E | 10,0 | 10,0 | 22,0 | 72,0 | 29,0 | 9,5 | 1,0 | 4 | <input type="checkbox"/> |
| JS554100E2R200.3Z4-SIRA | 02881711 | 2 | E | 10,0 | 10,0 | 22,0 | 72,0 | 29,0 | 9,5 | 2,0 | 4 | <input type="checkbox"/> |
| JS554100E2R250.3Z4-SIRA | 03029953 | 2 | E | 10,0 | 10,0 | 22,0 | 72,0 | 29,0 | 9,5 | 2,5 | 4 | <input type="checkbox"/> |
| JS554120E2R050.3Z4-SIRA | 03029984 | 2 | E | 12,0 | 12,0 | 26,0 | 83,0 | 35,0 | 11,4 | 0,5 | 4 | <input checked="" type="checkbox"/> |
| JS554120E2R100.3Z4-SIRA | 03029985 | 2 | E | 12,0 | 12,0 | 26,0 | 83,0 | 35,0 | 11,4 | 1,0 | 4 | <input type="checkbox"/> |
| JS554120E2R200.3Z4-SIRA | 02881712 | 2 | E | 12,0 | 12,0 | 26,0 | 83,0 | 35,0 | 11,4 | 2,0 | 4 | <input type="checkbox"/> |
| JS554120E2R250.3Z4-SIRA | 02881713 | 2 | E | 12,0 | 12,0 | 26,0 | 83,0 | 35,0 | 11,4 | 2,5 | 4 | <input type="checkbox"/> |
| JS554120E2R300.3Z4-SIRA | 03029954 | 2 | E | 12,0 | 12,0 | 26,0 | 83,0 | 35,0 | 11,4 | 3,0 | 4 | <input type="checkbox"/> |
| JS554160E2R050.3Z4-SIRA | 03029987 | 2 | E | 16,0 | 16,0 | 34,0 | 92,0 | 42,0 | 15,2 | 0,5 | 4 | <input type="checkbox"/> |
| JS554160E2R600.3Z4-SIRA | 03093687 | 2 | E | 16,0 | 16,0 | 34,0 | 92,0 | 42,0 | 15,2 | 6,0 | 4 | <input type="checkbox"/> |
| JS554200E2R200.3Z4-SIRA | 02881714 | 2 | E | 20,0 | 20,0 | 42,0 | 110,0 | 54,0 | 19,0 | 2,0 | 4 | <input type="checkbox"/> |
| JS554200E2R600.3Z4-SIRA | 03029955 | 2 | E | 20,0 | 20,0 | 42,0 | 109,0 | 54,0 | 19,0 | 6,0 | 4 | <input type="checkbox"/> |
| JS554250E2R600.3Z4-SIRA | 03093688 | 2 | E | 25,0 | 25,0 | 52,0 | 125,0 | 65,0 | 23,8 | 6,0 | 4 | <input type="checkbox"/> |

■ Lagerstandard. □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und
Composite

Graphit

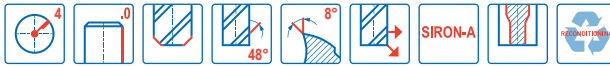
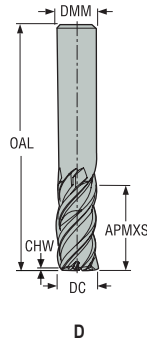
X-Heads

Minimaster Plus

Minimaster

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Fase – Zoll



- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø.375 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | CHW | PCEDC | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|-------|-------|-------|-------|-------|-------|-------------|
| | | | | Zoll | Zoll | Zoll | Zoll | Zoll | | |
| 5540250Z4.0-SIRON-A | 02711329 | 2 | D | 0.250 | 0.250 | 0.500 | 2.500 | 0.003 | 4 | ■ |
| 5540312Z4.0-SIRON-A | 02711340 | 2 | D | 0.313 | 0.313 | 0.625 | 2.500 | 0.004 | 4 | ■ |
| 5540375Z4.0-SIRON-A | 02711344 | 2 | D | 0.375 | 0.375 | 0.750 | 3.000 | 0.005 | 4 | ■ |
| 5540500Z4.0-SIRON-A | 02711611 | 2 | D | 0.500 | 0.500 | 1.000 | 3.500 | 0.006 | 4 | ■ |
| 5540625Z4.0-SIRON-A | 02711626 | 2 | D | 0.625 | 0.625 | 1.250 | 3.750 | 0.008 | 4 | ■ |
| 5540750Z4.0-SIRON-A | 02711643 | 2 | D | 0.750 | 0.750 | 1.500 | 4.000 | 0.010 | 4 | ■ |
| 5541000Z4.0-SIRON-A | 02711660 | 2 | D | 1.000 | 1.000 | 2.000 | 5.000 | 0.012 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und
Composite

Graphit

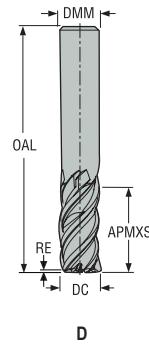
X-Heads

Minimaster Plus

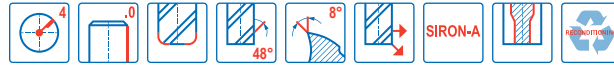
Minimaster

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius – Zoll



- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±.0008 Zoll
- Nachschleifen möglich, wenn DC ≥ Ø.375 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | RE | PCEDC | Zylindrisch |
|-------------------------|--------------------|------------------|-------------------|-------|-------|-------|-------|-------|-------|-------------|
| | | | | Zoll | Zoll | Zoll | Zoll | Zoll | | |
| 5540250R015Z4.0-SIRON-A | 02711335 | 2 | D | 0.250 | 0.250 | 0.500 | 2.500 | 0.015 | 4 | ■ |
| 5540312R015Z4.0-SIRON-A | 02711341 | 2 | D | 0.313 | 0.313 | 0.625 | 2.500 | 0.015 | 4 | ■ |
| 5540375R015Z4.0-SIRON-A | 02711588 | 2 | D | 0.375 | 0.375 | 0.750 | 3.000 | 0.015 | 4 | ■ |
| 5540375R030Z4.0-SIRON-A | 02711589 | 2 | D | 0.375 | 0.375 | 0.750 | 3.000 | 0.030 | 4 | ■ |
| 5540500R015Z4.0-SIRON-A | 02711614 | 2 | D | 0.500 | 0.500 | 1.000 | 3.500 | 0.015 | 4 | ■ |
| 5540500R030Z4.0-SIRON-A | 02711616 | 2 | D | 0.500 | 0.500 | 1.000 | 3.500 | 0.030 | 4 | ■ |
| 5540500R125Z4.0-SIRON-A | 02842370 | 2 | D | 0.500 | 0.500 | 1.000 | 3.500 | 0.125 | 4 | ■ |
| 5540625R015Z4.0-SIRON-A | 02711629 | 2 | D | 0.625 | 0.625 | 1.250 | 3.750 | 0.015 | 4 | ■ |
| 5540625R030Z4.0-SIRON-A | 02711631 | 2 | D | 0.625 | 0.625 | 1.250 | 3.750 | 0.030 | 4 | ■ |
| 5540625R125Z4.0-SIRON-A | 02842371 | 2 | D | 0.625 | 0.625 | 1.250 | 3.750 | 0.125 | 4 | ■ |
| 5540750R030Z4.0-SIRON-A | 02711647 | 2 | D | 0.750 | 0.750 | 1.500 | 4.000 | 0.030 | 4 | ■ |
| 5540750R060Z4.0-SIRON-A | 02711655 | 2 | D | 0.750 | 0.750 | 1.500 | 4.000 | 0.060 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

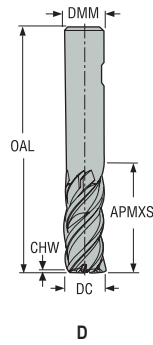
X-Heads

Minimaster Plus

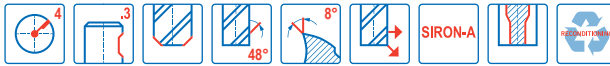
Minimaster

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Weldon – Fase – Zoll



D



- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | CHW | PCEDC | Weldon |
|---------------------|--------------------|------------------|-------------------|-------|-------|-------|-------|-------|-------|--------|
| | | | | Zoll | Zoll | Zoll | Zoll | Zoll | | |
| 5540500Z4.3-SIRON-A | 02711608 | 2 | D | 0.500 | 0.500 | 1.000 | 3.500 | 0.006 | 4 | ■ |
| 5540750Z4.3-SIRON-A | 02711632 | 2 | D | 0.750 | 0.750 | 1.500 | 4.000 | 0.010 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

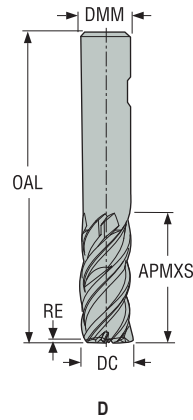
X-Heads

Minimaster Plus

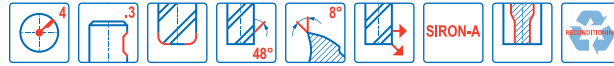
Minimaster

JS554

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Weldon – Eckenradius – Zoll



- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±.0008 Zoll
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | RE | PCEDC | Weldon |
|-------------------------|--------------------|------------------|-------------------|-------|-------|-------|-------|-------|-------|--------|
| | | | | Zoll | Zoll | Zoll | Zoll | Zoll | | |
| 5540500R015Z4.3-SIRON-A | 02711613 | 2 | D | 0.500 | 0.500 | 1.000 | 3.500 | 0.015 | 4 | ■ |
| 5540500R030Z4.3-SIRON-A | 02711615 | 2 | D | 0.500 | 0.500 | 1.000 | 3.500 | 0.030 | 4 | ■ |
| 5540500R125Z4.3-SIRON-A | 02856456 | 2 | D | 0.500 | 0.500 | 1.000 | 3.500 | 0.125 | 4 | □ |
| 5540625R125Z4.3-SIRON-A | 02856457 | 2 | D | 0.625 | 0.625 | 1.250 | 3.750 | 0.125 | 4 | □ |
| 5541000R060Z4.3-SIRON-A | 02711663 | 2 | D | 1.000 | 1.000 | 2.000 | 5.000 | 0.060 | 4 | ■ |

■ Lagerstandard. □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite


Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JS554 Eckfräsen/Schruppen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|--------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | 25 | |
| P1 | M/A/D/E | 0.400 | 1.0 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 215 (190 – 240) |
| | | 0,400 | 1,0 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 710 (630 – 780) |
| P2 | M/A/D/E | 0.400 | 1.0 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 210 (190 – 240) |
| | | 0,400 | 1,0 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 690 (630 – 780) |
| P3 | M/A/D/E | 0.400 | 1.0 | 0.028 | 0.038 | 0.048 | 0.055 | 0.075 | 0.095 | 0.11 | 0.14 | 0.16 | 0.18 | 185 (160 – 200) |
| | | 0,400 | 1,0 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0055 | 0,0065 | 0,0070 | 610 (530 – 650) |
| P4 | M/A/D/E | 0.400 | 1.0 | 0.028 | 0.038 | 0.046 | 0.055 | 0.075 | 0.095 | 0.11 | 0.14 | 0.16 | 0.18 | 160 (140 – 180) |
| | | 0,400 | 1,0 | 0,0011 | 0,0015 | 0,0018 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0055 | 0,0065 | 0,0070 | 520 (460 – 590) |
| P5 | M/A/D/E | 0.400 | 1.0 | 0.028 | 0.036 | 0.046 | 0.055 | 0.075 | 0.090 | 0.11 | 0.13 | 0.16 | 0.18 | 155 (140 – 170) |
| | | 0,400 | 1,0 | 0,0011 | 0,0014 | 0,0018 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0065 | 0,0070 | 510 (460 – 550) |
| P6 | M/A/D/E | 0.400 | 1.0 | 0.028 | 0.036 | 0.046 | 0.055 | 0.075 | 0.090 | 0.11 | 0.13 | 0.15 | 0.17 | 175 (160 – 200) |
| | | 0,400 | 1,0 | 0,0011 | 0,0014 | 0,0018 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 570 (530 – 650) |
| P7 | M/A/D/E | 0.400 | 1.0 | 0.028 | 0.036 | 0.046 | 0.055 | 0.075 | 0.090 | 0.11 | 0.13 | 0.15 | 0.17 | 165 (150 – 180) |
| | | 0,400 | 1,0 | 0,0011 | 0,0014 | 0,0018 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 540 (500 – 590) |
| P8 | M/A/D/E | 0.400 | 1.0 | 0.028 | 0.038 | 0.048 | 0.055 | 0.075 | 0.095 | 0.11 | 0.14 | 0.16 | 0.18 | 155 (140 – 170) |
| | | 0,400 | 1,0 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0055 | 0,0065 | 0,0070 | 510 (460 – 550) |
| P11 | M/A/D/E | 0.400 | 1.0 | 0.026 | 0.036 | 0.044 | 0.055 | 0.070 | 0.090 | 0.11 | 0.13 | 0.15 | 0.17 | 140 (130 – 150) |
| | | 0,400 | 1,0 | 0,0010 | 0,0014 | 0,0017 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 460 (430 – 490) |
| P12 | M/A/D/E | 0.400 | 1.0 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 0.12 | 90 (79 – 100) |
| | | 0,400 | 1,0 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0048 | 295 (260 – 320) |
| M1 | E | 0.400 | 1.0 | 0.020 | 0.026 | 0.034 | 0.040 | 0.055 | 0.065 | 0.080 | 0.10 | 0.11 | 0.13 | 110 (96 – 120) |
| | | 0,400 | 1,0 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0022 | 0,0026 | 0,0032 | 0,0040 | 0,0044 | 0,0050 | 360 (320 – 390) |
| M2 | E | 0.400 | 1.0 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 0.12 | 90 (79 – 100) |
| | | 0,400 | 1,0 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0048 | 295 (260 – 320) |
| M3 | E | 0.400 | 0.90 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 0.095 | 55 (45 – 66) |
| | | 0,400 | 0,90 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 0,0038 | 180 (150 – 210) |
| M4 | E | 0.400 | 0.90 | 0.013 | 0.018 | 0.022 | 0.026 | 0.036 | 0.044 | 0.055 | 0.065 | 0.075 | 0.085 | 43 (35 – 51) |
| | | 0,400 | 0,90 | 0,00050 | 0,00070 | 0,00085 | 0,0010 | 0,0014 | 0,0017 | 0,0022 | 0,0026 | 0,0030 | 0,0034 | 140 (120 – 160) |
| M5 | E | 0.400 | 0.90 | 0.013 | 0.018 | 0.022 | 0.026 | 0.036 | 0.044 | 0.055 | 0.065 | 0.075 | 0.085 | 36 (29 – 42) |
| | | 0,400 | 0,90 | 0,00050 | 0,00070 | 0,00085 | 0,0010 | 0,0014 | 0,0017 | 0,0022 | 0,0026 | 0,0030 | 0,0034 | 120 (96 – 130) |
| K1 | E | 0.400 | 1.2 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 0.14 | 0.16 | 175 (160 – 190) |
| | | 0,400 | 1,2 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0065 | 570 (530 – 620) |
| K2 | E | 0.400 | 1.2 | 0.022 | 0.030 | 0.038 | 0.044 | 0.060 | 0.075 | 0.090 | 0.11 | 0.13 | 0.14 | 155 (140 – 170) |
| | | 0,400 | 1,2 | 0,00085 | 0,0012 | 0,0015 | 0,0017 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0055 | 510 (460 – 550) |
| K3 | E | 0.400 | 1.2 | 0.022 | 0.030 | 0.038 | 0.044 | 0.060 | 0.075 | 0.090 | 0.11 | 0.13 | 0.14 | 130 (120 – 140) |
| | | 0,400 | 1,2 | 0,00085 | 0,0012 | 0,0015 | 0,0017 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0055 | 425 (400 – 450) |
| K4 | E | 0.400 | 1.2 | 0.022 | 0.030 | 0.038 | 0.044 | 0.060 | 0.075 | 0.090 | 0.11 | 0.13 | 0.14 | 125 (110 – 140) |
| | | 0,400 | 1,2 | 0,00085 | 0,0012 | 0,0015 | 0,0017 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0055 | 410 (370 – 450) |
| K5 | E | 0.400 | 1.0 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 0.14 | 0.16 | 155 (140 – 170) |
| | | 0,400 | 1,0 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0065 | 510 (460 – 550) |
| K6 | E | 0.400 | 1.0 | 0.028 | 0.036 | 0.046 | 0.055 | 0.070 | 0.090 | 0.11 | 0.13 | 0.15 | 0.17 | 220 (190 – 250) |
| | | 0,400 | 1,0 | 0,0011 | 0,0014 | 0,0018 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 720 (630 – 820) |
| K7 | E | 0.400 | 1.0 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 0.14 | 0.16 | 195 (170 – 220) |
| | | 0,400 | 1,0 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0065 | 640 (560 – 720) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

Schnittdaten – JS554 Eckfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|---------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | 25 | |
| N1 | E | 0.500 | 0.90 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 0.13 | 0.15 | 610 (510 – 710) |
| | | 0,500 | 0,90 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0050 | 0,0060 | 2000 (1700 – 2300) |
| N2 | E | 0.500 | 0.90 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 0.13 | 0.15 | 390 (330 – 450) |
| | | 0,500 | 0,90 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0050 | 0,0060 | 1275 (1100 – 1400) |
| N11 | E | 0.500 | 1.1 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 0.13 | 0.15 | 320 (270 – 370) |
| | | 0,500 | 1,1 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0050 | 0,0060 | 1050 (890 – 1200) |
| S11 | E | 0.400 | 0.70 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 0.12 | 100 (72 – 120) |
| | | 0,400 | 0,70 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0048 | 330 (240 – 390) |
| S12 | E | 0.400 | 0.70 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 0.12 | 75 (56 – 99) |
| | | 0,400 | 0,70 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0048 | 245 (190 – 320) |
| S13 | E | 0.400 | 0.70 | 0.016 | 0.022 | 0.026 | 0.032 | 0.042 | 0.055 | 0.065 | 0.080 | 0.090 | 0.10 | 60 (44 – 78) |
| | | 0,400 | 0,70 | 0,00065 | 0,00085 | 0,0010 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 0,0040 | 195 (150 – 250) |
| H5 | M/A/D | 0.200 | 0.90 | 0.022 | 0.030 | 0.038 | 0.046 | 0.060 | 0.075 | 0.090 | 0.11 | 0.13 | 0.14 | 75 (59 – 88) |
| | | 0,200 | 0,90 | 0,00085 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0055 | 245 (200 – 280) |
| H8 | M/A/D | 0.200 | 0.90 | 0.017 | 0.022 | 0.028 | 0.034 | 0.046 | 0.055 | 0.070 | 0.085 | 0.095 | 0.11 | 80 (63 – 93) |
| | | 0,200 | 0,90 | 0,00065 | 0,00085 | 0,0011 | 0,0013 | 0,0018 | 0,0022 | 0,0028 | 0,0034 | 0,0038 | 0,0044 | 260 (210 – 300) |
| H11 | M/A/D | 0.200 | 0.90 | 0.022 | 0.030 | 0.038 | 0.046 | 0.060 | 0.075 | 0.090 | 0.11 | 0.13 | 0.14 | 95 (75 – 110) |
| | | 0,200 | 0,90 | 0,00085 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0055 | 310 (250 – 360) |
| H12 | M/A/D | 0.200 | 0.90 | 0.017 | 0.022 | 0.028 | 0.034 | 0.046 | 0.055 | 0.070 | 0.085 | 0.095 | 0.11 | 90 (73 – 100) |
| | | 0,200 | 0,90 | 0,00065 | 0,00085 | 0,0011 | 0,0013 | 0,0018 | 0,0022 | 0,0028 | 0,0034 | 0,0038 | 0,0044 | 295 (240 – 320) |
| H21 | M/A/D | 0.200 | 0.90 | 0.017 | 0.022 | 0.028 | 0.034 | 0.046 | 0.055 | 0.070 | 0.085 | 0.095 | 0.11 | 155 (110 – 190) |
| | | 0,200 | 0,90 | 0,00065 | 0,00085 | 0,0011 | 0,0013 | 0,0018 | 0,0022 | 0,0028 | 0,0034 | 0,0038 | 0,0044 | 510 (370 – 620) |
| TS1 | A | 0.500 | 1.0 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 285 (180 – 400) |
| | | 0,500 | 1,0 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 940 (600 – 1300) |
| TP1 | A | 0.500 | 1.0 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 295 (180 – 410) |
| | | 0,500 | 1,0 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 970 (600 – 1300) |
| GR1 | A | 0.500 | 1.1 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 580 (470 – 690) |
| | | 0,500 | 1,1 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 1900 (1600 – 2200) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)


f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Schnittdaten – JS554 Nutfräsen

| SMG |  | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|----------------|---------|---------|---------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | 25 | |
| P1 | M/A/D/E | 1,0 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.15 | 195 (170 – 220) |
| | | 1,0 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0060 | 640 (560 – 720) |
| P2 | M/A/D/E | 1,0 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.15 | 190 (170 – 210) |
| | | 1,0 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0060 | 620 (560 – 680) |
| P3 | M/A/D/E | 1,0 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.15 | 165 (140 – 180) |
| | | 1,0 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0060 | 540 (460 – 590) |
| P4 | M/A/D/E | 1,0 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.15 | 145 (130 – 160) |
| | | 1,0 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0060 | 475 (430 – 520) |
| P5 | M/A/D/E | 1,0 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.15 | 135 (120 – 150) |
| | | 1,0 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0060 | 445 (400 – 490) |
| P6 | M/A/D/E | 1,0 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.15 | 155 (140 – 170) |
| | | 1,0 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0060 | 510 (460 – 550) |
| P7 | M/A/D/E | 1,0 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.15 | 145 (130 – 160) |
| | | 1,0 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0060 | 475 (430 – 520) |
| P8 | M/A/D/E | 1,0 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.15 | 135 (120 – 150) |
| | | 1,0 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0060 | 445 (400 – 490) |
| P11 | M/A/D/E | 0,80 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.10 | 130 (120 – 140) |
| | | 0,80 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0040 | 425 (400 – 450) |
| P12 | M/A/D/E | 0,80 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.10 | 80 (69 – 87) |
| | | 0,80 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0040 | 260 (230 – 280) |
| M1 | E | 0,80 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.10 | 95 (85 – 100) |
| | | 0,80 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0040 | 310 (280 – 320) |
| M2 | E | 0,80 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.10 | 80 (69 – 87) |
| | | 0,80 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0040 | 260 (230 – 280) |
| M3 | E | 0,60 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.025 | 0.032 | 0.038 | 0.050 | 0.065 | 0.080 | 48 (39 – 57) |
| | | 0,60 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 0,0026 | 0,0032 | 155 (130 – 180) |
| M4 | E | 0,60 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.025 | 0.032 | 0.038 | 0.050 | 0.065 | 0.080 | 36 (29 – 43) |
| | | 0,60 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 0,0026 | 0,0032 | 120 (96 – 140) |
| M5 | E | 0,60 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.025 | 0.032 | 0.038 | 0.050 | 0.065 | 0.080 | 30 (25 – 36) |
| | | 0,60 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 0,0026 | 0,0032 | 100 (83 – 110) |
| K1 | E | 1,0 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.13 | 155 (140 – 170) |
| | | 1,0 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0050 | 510 (460 – 550) |
| K2 | E | 1,0 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.13 | 135 (120 – 150) |
| | | 1,0 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0050 | 445 (400 – 490) |
| K3 | E | 1,0 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.13 | 115 (110 – 120) |
| | | 1,0 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0050 | 375 (370 – 390) |
| K4 | E | 1,0 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.13 | 110 (96 – 120) |
| | | 1,0 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0050 | 360 (320 – 390) |
| K5 | E | 0,70 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.13 | 135 (120 – 150) |
| | | 0,70 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0050 | 445 (400 – 490) |
| K6 | E | 0,70 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.13 | 200 (180 – 220) |
| | | 0,70 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0050 | 660 (600 – 720) |
| K7 | E | 0,70 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.13 | 175 (150 – 190) |
| | | 0,70 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0050 | 570 (500 – 620) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JS554 Nutfräsen

| SMG | | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|-------|--------------------|----------------|---------|---------|---------|---------|---------|--------|--------|--------|--------|--------------------|
| | | | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | 25 | |
| N1 | E | 0.50 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.13 | 570 (480 – 670) |
| | | 0.50 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0050 | 1875 (1600 – 2100) |
| N2 | E | 0.50 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.13 | 370 (310 – 430) |
| | | 0.50 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0050 | 1225 (1100 – 1400) |
| N3 | E | 0.50 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.13 | 245 (210 – 280) |
| | | 0.50 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0050 | 800 (690 – 910) |
| N11 | E | 0.60 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.15 | 290 (250 – 330) |
| | | 0.60 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0060 | 950 (830 – 1000) |
| S1 | E | 0.30 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.025 | 0.032 | 0.038 | 0.050 | 0.065 | 0.080 | 30 (25 – 34) |
| | | 0.30 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 0,0026 | 0,0032 | 100 (83 – 110) |
| S2 | E | 0.30 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.025 | 0.032 | 0.038 | 0.050 | 0.065 | 0.080 | 27 (17 – 38) |
| | | 0.30 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 0,0026 | 0,0032 | 90 (56 – 120) |
| S3 | E | 0.30 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.025 | 0.032 | 0.038 | 0.050 | 0.065 | 0.080 | 23 (15 – 32) |
| | | 0.30 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 0,0026 | 0,0032 | 75 (50 – 100) |
| S11 | E | 0.50 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.040 | 0.050 | 0.065 | 0.080 | 0.10 | 85 (63 – 110) |
| | | 0.50 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 280 (210 – 360) |
| S12 | E | 0.50 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.040 | 0.050 | 0.065 | 0.080 | 0.10 | 65 (48 – 86) |
| | | 0.50 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 215 (160 – 280) |
| S13 | E | 0.50 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.040 | 0.050 | 0.065 | 0.080 | 0.10 | 50 (38 – 66) |
| | | 0.50 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 165 (130 – 210) |
| H5 | M/A/D | 0.40 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.040 | 0.050 | 65 (52 – 76) |
| | | 0.40 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 215 (180 – 240) |
| H8 | M/A/D | 0.40 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.040 | 0.050 | 65 (52 – 76) |
| | | 0.40 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 215 (180 – 240) |
| H11 | M/A/D | 0.40 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.040 | 0.050 | 80 (66 – 97) |
| | | 0.40 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 260 (220 – 310) |
| H12 | M/A/D | 0.40 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.040 | 0.050 | 75 (60 – 89) |
| | | 0.40 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 245 (200 – 290) |
| H21 | M/A/D | 0.40 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.040 | 0.050 | 125 (90 – 160) |
| | | 0.40 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 410 (300 – 520) |
| TS1 | A | 0.70 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 240 (150 – 330) |
| | | 0.70 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 790 (500 – 1000) |
| TP1 | A | 0.70 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 250 (150 – 340) |
| | | 0.70 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 820 (500 – 1100) |
| GR1 | A | 0.80 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 485 (390 – 580) |
| | | 0.80 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 1600 (1300 – 1900) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_s = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – JS554 Eckfräsen/Schruppen – Zoll

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | | 1/4 | 5/16 | 3/8 | 1/2 | 5/8 | 3/4 | 1 | |
| P1 | M/A/D/E | 0.400 | 1.0 | 0.065 | 0.080 | 0.095 | 0.12 | 0.14 | 0.16 | 0.19 | 215 (190 – 240) |
| | | 0,400 | 1,0 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0065 | 0,0075 | 710 (630 – 780) |
| P2 | M/A/D/E | 0.400 | 1.0 | 0.065 | 0.080 | 0.095 | 0.13 | 0.15 | 0.17 | 0.20 | 210 (190 – 240) |
| | | 0,400 | 1,0 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0060 | 0,0065 | 0,0080 | 690 (630 – 780) |
| P3 | M/A/D/E | 0.400 | 1.0 | 0.060 | 0.075 | 0.090 | 0.12 | 0.14 | 0.16 | 0.18 | 185 (160 – 200) |
| | | 0,400 | 1,0 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0055 | 0,0065 | 0,0070 | 610 (530 – 650) |
| P4 | M/A/D/E | 0.400 | 1.0 | 0.060 | 0.075 | 0.090 | 0.12 | 0.14 | 0.15 | 0.18 | 160 (140 – 180) |
| | | 0,400 | 1,0 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0055 | 0,0060 | 0,0070 | 520 (460 – 590) |
| P5 | M/A/D/E | 0.400 | 1.0 | 0.060 | 0.075 | 0.085 | 0.11 | 0.13 | 0.15 | 0.18 | 155 (140 – 170) |
| | | 0,400 | 1,0 | 0,0024 | 0,0030 | 0,0034 | 0,0044 | 0,0050 | 0,0060 | 0,0070 | 510 (460 – 550) |
| P6 | M/A/D/E | 0.400 | 1.0 | 0.060 | 0.070 | 0.085 | 0.11 | 0.13 | 0.15 | 0.18 | 175 (160 – 200) |
| | | 0,400 | 1,0 | 0,0024 | 0,0028 | 0,0034 | 0,0044 | 0,0050 | 0,0060 | 0,0070 | 570 (530 – 650) |
| P7 | M/A/D/E | 0.400 | 1.0 | 0.060 | 0.070 | 0.085 | 0.11 | 0.13 | 0.15 | 0.18 | 165 (150 – 180) |
| | | 0,400 | 1,0 | 0,0024 | 0,0028 | 0,0034 | 0,0044 | 0,0050 | 0,0060 | 0,0070 | 540 (500 – 590) |
| P8 | M/A/D/E | 0.400 | 1.0 | 0.060 | 0.075 | 0.090 | 0.12 | 0.14 | 0.16 | 0.18 | 155 (140 – 170) |
| | | 0,400 | 1,0 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0055 | 0,0065 | 0,0070 | 510 (460 – 550) |
| P11 | M/A/D/E | 0.400 | 1.0 | 0.055 | 0.070 | 0.085 | 0.11 | 0.13 | 0.15 | 0.17 | 140 (130 – 150) |
| | | 0,400 | 1,0 | 0,0022 | 0,0028 | 0,0034 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 460 (430 – 490) |
| P12 | M/A/D/E | 0.400 | 1.0 | 0.038 | 0.048 | 0.060 | 0.075 | 0.090 | 0.10 | 0.12 | 90 (79 – 100) |
| | | 0,400 | 1,0 | 0,0015 | 0,0019 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 0,0048 | 295 (260 – 320) |
| M1 | E | 0.400 | 1.0 | 0.042 | 0.055 | 0.065 | 0.085 | 0.10 | 0.11 | 0.13 | 110 (96 – 120) |
| | | 0,400 | 1,0 | 0,0017 | 0,0022 | 0,0026 | 0,0034 | 0,0040 | 0,0044 | 0,0050 | 360 (320 – 390) |
| M2 | E | 0.400 | 1.0 | 0.038 | 0.048 | 0.060 | 0.075 | 0.090 | 0.10 | 0.12 | 90 (79 – 100) |
| | | 0,400 | 1,0 | 0,0015 | 0,0019 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 0,0048 | 295 (260 – 320) |
| M3 | E | 0.400 | 0.90 | 0.032 | 0.040 | 0.048 | 0.065 | 0.075 | 0.085 | 0.10 | 55 (45 – 66) |
| | | 0,400 | 0,90 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0030 | 0,0034 | 0,0040 | 180 (150 – 210) |
| M4 | E | 0.400 | 0.90 | 0.028 | 0.036 | 0.042 | 0.055 | 0.065 | 0.075 | 0.085 | 43 (35 – 51) |
| | | 0,400 | 0,90 | 0,0011 | 0,0014 | 0,0017 | 0,0022 | 0,0026 | 0,0030 | 0,0034 | 140 (120 – 160) |
| M5 | E | 0.400 | 0.90 | 0.028 | 0.036 | 0.042 | 0.055 | 0.075 | 0.085 | 0.10 | 36 (29 – 42) |
| | | 0,400 | 0,90 | 0,0011 | 0,0014 | 0,0017 | 0,0022 | 0,0026 | 0,0030 | 0,0034 | 120 (96 – 130) |
| K1 | E | 0.400 | 1.2 | 0.050 | 0.065 | 0.080 | 0.10 | 0.12 | 0.13 | 0.16 | 175 (160 – 190) |
| | | 0,400 | 1,2 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0048 | 0,0050 | 0,0065 | 570 (530 – 620) |
| K2 | E | 0.400 | 1.2 | 0.048 | 0.060 | 0.070 | 0.090 | 0.11 | 0.12 | 0.14 | 155 (140 – 170) |
| | | 0,400 | 1,2 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0044 | 0,0048 | 0,0055 | 510 (460 – 550) |
| K3 | E | 0.400 | 1.2 | 0.048 | 0.060 | 0.070 | 0.090 | 0.11 | 0.12 | 0.14 | 130 (120 – 140) |
| | | 0,400 | 1,2 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0044 | 0,0048 | 0,0055 | 425 (400 – 450) |
| K4 | E | 0.400 | 1.2 | 0.048 | 0.060 | 0.070 | 0.090 | 0.11 | 0.12 | 0.14 | 125 (110 – 140) |
| | | 0,400 | 1,2 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0044 | 0,0048 | 0,0055 | 410 (370 – 450) |
| K5 | E | 0.400 | 1.0 | 0.050 | 0.065 | 0.080 | 0.10 | 0.12 | 0.13 | 0.16 | 155 (140 – 170) |
| | | 0,400 | 1,0 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0048 | 0,0050 | 0,0065 | 510 (460 – 550) |
| K6 | E | 0.400 | 1.0 | 0.055 | 0.070 | 0.085 | 0.11 | 0.13 | 0.15 | 0.17 | 220 (190 – 250) |
| | | 0,400 | 1,0 | 0,0022 | 0,0028 | 0,0034 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 720 (630 – 820) |
| K7 | E | 0.400 | 1.0 | 0.050 | 0.065 | 0.080 | 0.10 | 0.12 | 0.13 | 0.16 | 195 (170 – 220) |
| | | 0,400 | 1,0 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0048 | 0,0050 | 0,0065 | 640 (560 – 720) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Universell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster


Schnittdaten – JS554 Eckfräsen/Schruppen – Zoll

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|-------|-------|-------|-------|-------|-------|--------------------|
| | | | | 1/4 | 5/16 | 3/8 | 1/2 | 5/8 | 3/4 | 1 | |
| N1 | E | 0.500 | 0.90 | 0.050 | 0.065 | 0.075 | 0.10 | 0.12 | 0.13 | 0.15 | 610 (510 – 710) |
| | | 0,500 | 0,90 | 0,020 | 0,026 | 0,030 | 0,040 | 0,048 | 0,050 | 0,060 | 2000 (1700 – 2300) |
| N2 | E | 0.500 | 0.90 | 0.050 | 0.065 | 0.075 | 0.10 | 0.12 | 0.13 | 0.15 | 390 (330 – 450) |
| | | 0,500 | 0,90 | 0,020 | 0,026 | 0,030 | 0,040 | 0,048 | 0,050 | 0,060 | 1275 (1100 – 1400) |
| N3 | E | 0.500 | 0.90 | 0.050 | 0.065 | 0.075 | 0.10 | 0.12 | 0.13 | 0.15 | 260 (220 – 300) |
| | | 0,500 | 0,90 | 0,020 | 0,026 | 0,030 | 0,040 | 0,048 | 0,050 | 0,060 | 850 (730 – 980) |
| N11 | E | 0.500 | 1.1 | 0.050 | 0.065 | 0.075 | 0.10 | 0.12 | 0.13 | 0.15 | 320 (270 – 370) |
| | | 0,500 | 1,1 | 0,020 | 0,026 | 0,030 | 0,040 | 0,048 | 0,050 | 0,060 | 1050 (890 – 1200) |
| S1 | E | 0.150 | 0.50 | 0.055 | 0.070 | 0.085 | 0.11 | 0.13 | 0.14 | 0.17 | 38 (32 – 44) |
| | | 0,150 | 0,50 | 0,022 | 0,028 | 0,034 | 0,044 | 0,050 | 0,055 | 0,065 | 125 (110 – 140) |
| S2 | E | 0.150 | 0.50 | 0.055 | 0.070 | 0.085 | 0.11 | 0.13 | 0.14 | 0.17 | 35 (21 – 48) |
| | | 0,150 | 0,50 | 0,022 | 0,028 | 0,034 | 0,044 | 0,050 | 0,055 | 0,065 | 115 (69 – 150) |
| S3 | E | 0.150 | 0.50 | 0.050 | 0.065 | 0.075 | 0.10 | 0.12 | 0.13 | 0.16 | 30 (19 – 42) |
| | | 0,150 | 0,50 | 0,020 | 0,026 | 0,030 | 0,040 | 0,048 | 0,050 | 0,065 | 100 (63 – 130) |
| S11 | E | 0.400 | 0.70 | 0.038 | 0.048 | 0.060 | 0.075 | 0.090 | 0.10 | 0.12 | 100 (72 – 120) |
| | | 0,400 | 0,70 | 0,015 | 0,019 | 0,024 | 0,030 | 0,036 | 0,040 | 0,048 | 330 (240 – 390) |
| S12 | E | 0.400 | 0.70 | 0.038 | 0.048 | 0.060 | 0.075 | 0.090 | 0.10 | 0.12 | 75 (56 – 99) |
| | | 0,400 | 0,70 | 0,015 | 0,019 | 0,024 | 0,030 | 0,036 | 0,040 | 0,048 | 245 (190 – 320) |
| S13 | E | 0.400 | 0.70 | 0.034 | 0.042 | 0.050 | 0.065 | 0.080 | 0.090 | 0.10 | 60 (44 – 78) |
| | | 0,400 | 0,70 | 0,013 | 0,017 | 0,020 | 0,026 | 0,032 | 0,036 | 0,040 | 195 (150 – 250) |
| H5 | M/A/D | 0.200 | 0.90 | 0.048 | 0.060 | 0.070 | 0.095 | 0.11 | 0.12 | 0.15 | 75 (59 – 88) |
| | | 0,200 | 0,90 | 0,019 | 0,024 | 0,028 | 0,038 | 0,044 | 0,048 | 0,060 | 245 (200 – 280) |
| H8 | M/A/D | 0.200 | 0.90 | 0.036 | 0.046 | 0.055 | 0.070 | 0.085 | 0.095 | 0.11 | 80 (63 – 93) |
| | | 0,200 | 0,90 | 0,014 | 0,018 | 0,022 | 0,028 | 0,034 | 0,038 | 0,044 | 260 (210 – 300) |
| H21 | M/A/D | 0.200 | 0.90 | 0.036 | 0.046 | 0.055 | 0.070 | 0.085 | 0.095 | 0.11 | 155 (110 – 190) |
| | | 0,200 | 0,90 | 0,014 | 0,018 | 0,022 | 0,028 | 0,034 | 0,038 | 0,044 | 510 (370 – 620) |
| H31 | M/A/D | 0.200 | 0.90 | 0.032 | 0.040 | 0.048 | 0.060 | 0.075 | 0.080 | 0.095 | 60 (48 – 71) |
| | | 0,200 | 0,90 | 0,013 | 0,016 | 0,019 | 0,024 | 0,030 | 0,032 | 0,038 | 195 (160 – 230) |
| TS1 | A | 0.500 | 1.0 | 0.065 | 0.080 | 0.095 | 0.12 | 0.15 | 0.16 | 0.19 | 285 (180 – 400) |
| | | 0,500 | 1,0 | 0,026 | 0,032 | 0,038 | 0,048 | 0,060 | 0,065 | 0,075 | 940 (600 – 1300) |
| TP1 | A | 0.500 | 1.0 | 0.065 | 0.080 | 0.095 | 0.12 | 0.15 | 0.16 | 0.19 | 295 (180 – 410) |
| | | 0,500 | 1,0 | 0,026 | 0,032 | 0,038 | 0,048 | 0,060 | 0,065 | 0,075 | 970 (600 – 1300) |
| GR1 | A | 0.500 | 1.1 | 0.065 | 0.080 | 0.095 | 0.12 | 0.15 | 0.16 | 0.19 | 580 (470 – 690) |
| | | 0,500 | 1,1 | 0,026 | 0,032 | 0,038 | 0,048 | 0,060 | 0,065 | 0,075 | 1900 (1600 – 2200) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – JS554 Nutfräsen – Zoll

| SMG |  | a _p /DC | f _z | | | | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | 1/4 | 5/16 | 3/8 | 1/2 | 5/8 | 3/4 | 1 | |
| P1 | M/A/D/E | 1.0 | 0.038 | 0.048 | 0.055 | 0.075 | 0.095 | 0.11 | 0.15 | 195 (170 – 220) |
| | | 1,0 | 0,0015 | 0,0019 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0060 | 640 (560 – 720) |
| P2 | M/A/D/E | 1.0 | 0.038 | 0.048 | 0.055 | 0.075 | 0.095 | 0.11 | 0.15 | 190 (170 – 210) |
| | | 1,0 | 0,0015 | 0,0019 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0060 | 620 (560 – 680) |
| P3 | M/A/D/E | 1.0 | 0.038 | 0.048 | 0.055 | 0.075 | 0.095 | 0.11 | 0.15 | 165 (140 – 180) |
| | | 1,0 | 0,0015 | 0,0019 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0060 | 540 (460 – 590) |
| P4 | M/A/D/E | 1.0 | 0.038 | 0.048 | 0.055 | 0.075 | 0.095 | 0.11 | 0.15 | 145 (130 – 160) |
| | | 1,0 | 0,0015 | 0,0019 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0060 | 475 (430 – 520) |
| P5 | M/A/D/E | 1.0 | 0.038 | 0.048 | 0.055 | 0.075 | 0.095 | 0.11 | 0.15 | 135 (120 – 150) |
| | | 1,0 | 0,0015 | 0,0019 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0060 | 445 (400 – 490) |
| P6 | M/A/D/E | 1.0 | 0.038 | 0.048 | 0.055 | 0.075 | 0.095 | 0.11 | 0.15 | 155 (140 – 170) |
| | | 1,0 | 0,0015 | 0,0019 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0060 | 510 (460 – 550) |
| P7 | M/A/D/E | 1.0 | 0.038 | 0.048 | 0.055 | 0.075 | 0.095 | 0.11 | 0.15 | 145 (130 – 160) |
| | | 1,0 | 0,0015 | 0,0019 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0060 | 475 (430 – 520) |
| P8 | M/A/D/E | 1.0 | 0.038 | 0.048 | 0.055 | 0.075 | 0.095 | 0.11 | 0.15 | 135 (120 – 150) |
| | | 1,0 | 0,0015 | 0,0019 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0060 | 445 (400 – 490) |
| P11 | M/A/D/E | 0.80 | 0.025 | 0.032 | 0.038 | 0.050 | 0.065 | 0.075 | 0.10 | 130 (120 – 140) |
| | | 0,80 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 0,0040 | 425 (400 – 450) |
| P12 | M/A/D/E | 0.80 | 0.025 | 0.032 | 0.038 | 0.050 | 0.065 | 0.075 | 0.10 | 80 (69 – 87) |
| | | 0,80 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 0,0040 | 260 (230 – 280) |
| M1 | E | 0.80 | 0.025 | 0.032 | 0.038 | 0.050 | 0.065 | 0.075 | 0.10 | 95 (85 – 100) |
| | | 0,80 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 0,0040 | 310 (280 – 320) |
| M2 | E | 0.80 | 0.025 | 0.032 | 0.038 | 0.050 | 0.065 | 0.075 | 0.10 | 80 (69 – 87) |
| | | 0,80 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 0,0040 | 260 (230 – 280) |
| M3 | E | 0.60 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 48 (39 – 57) |
| | | 0,60 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 155 (130 – 180) |
| M4 | E | 0.60 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 36 (29 – 43) |
| | | 0,60 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 120 (96 – 140) |
| M5 | E | 0.60 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 30 (25 – 36) |
| | | 0,60 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 100 (83 – 110) |
| K1 | E | 1.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.13 | 155 (140 – 170) |
| | | 1,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 510 (460 – 550) |
| K2 | E | 1.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.13 | 135 (120 – 150) |
| | | 1,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 445 (400 – 490) |
| K3 | E | 1.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.13 | 115 (110 – 120) |
| | | 1,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 375 (370 – 390) |
| K4 | E | 1.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.13 | 110 (96 – 120) |
| | | 1,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 360 (320 – 390) |
| K5 | E | 0.70 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.13 | 135 (120 – 150) |
| | | 0,70 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 445 (400 – 490) |
| K6 | E | 0.70 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.13 | 200 (180 – 220) |
| | | 0,70 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 660 (600 – 720) |
| K7 | E | 0.70 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.13 | 175 (150 – 190) |
| | | 0,70 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 570 (500 – 620) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Universell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

Schnittdaten – JS554 Nutfräsen – Zoll

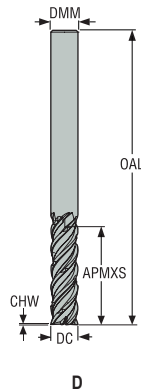
| SMG | | a _p /DC | f _z | | | | | | | v _c |
|-----|-------|--------------------|----------------|---------|---------|--------|--------|--------|--------|--------------------|
| | | | 1/4 | 5/16 | 3/8 | 1/2 | 5/8 | 3/4 | 1 | |
| N1 | E | 0.50 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.13 | 570 (480 – 670) |
| | | 0.50 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 1875 (1600 – 2100) |
| N2 | E | 0.50 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.13 | 370 (310 – 430) |
| | | 0.50 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 1225 (1100 – 1400) |
| N3 | E | 0.50 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.13 | 245 (210 – 280) |
| | | 0.50 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 800 (690 – 910) |
| N11 | E | 0.60 | 0.038 | 0.048 | 0.055 | 0.075 | 0.095 | 0.11 | 0.15 | 290 (250 – 330) |
| | | 0.60 | 0,0015 | 0,0019 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0060 | 950 (830 – 1000) |
| S1 | E | 0.30 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 30 (25 – 34) |
| | | 0.30 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 100 (83 – 110) |
| S2 | E | 0.30 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 27 (17 – 38) |
| | | 0.30 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 90 (56 – 120) |
| S3 | E | 0.30 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 23 (15 – 32) |
| | | 0.30 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 75 (50 – 100) |
| S11 | E | 0.50 | 0.026 | 0.032 | 0.038 | 0.050 | 0.065 | 0.080 | 0.10 | 85 (63 – 110) |
| | | 0.50 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 280 (210 – 360) |
| S12 | E | 0.50 | 0.026 | 0.032 | 0.038 | 0.050 | 0.065 | 0.080 | 0.10 | 65 (48 – 86) |
| | | 0.50 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 215 (160 – 280) |
| S13 | E | 0.50 | 0.026 | 0.032 | 0.038 | 0.050 | 0.065 | 0.080 | 0.10 | 50 (38 – 66) |
| | | 0.50 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 165 (130 – 210) |
| H5 | M/A/D | 0.40 | 0.013 | 0.016 | 0.019 | 0.026 | 0.032 | 0.038 | 0.050 | 65 (52 – 76) |
| | | 0.40 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 215 (180 – 240) |
| H8 | M/A/D | 0.40 | 0.013 | 0.016 | 0.019 | 0.026 | 0.032 | 0.038 | 0.050 | 65 (52 – 76) |
| | | 0.40 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 215 (180 – 240) |
| H21 | M/A/D | 0.40 | 0.013 | 0.016 | 0.019 | 0.026 | 0.032 | 0.038 | 0.050 | 125 (90 – 160) |
| | | 0.40 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 410 (300 – 520) |
| H31 | M/A/D | 0.40 | 0.013 | 0.016 | 0.019 | 0.026 | 0.032 | 0.038 | 0.050 | 48 (39 – 57) |
| | | 0.40 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 155 (130 – 180) |
| TS1 | A | 0.70 | 0.065 | 0.080 | 0.095 | 0.12 | 0.15 | 0.16 | 0.19 | 240 (150 – 330) |
| | | 0.70 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 790 (500 – 1000) |
| TP1 | A | 0.70 | 0.065 | 0.080 | 0.095 | 0.12 | 0.15 | 0.16 | 0.19 | 250 (150 – 340) |
| | | 0.70 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 820 (500 – 1100) |
| GR1 | A | 0.80 | 0.065 | 0.080 | 0.095 | 0.12 | 0.15 | 0.16 | 0.19 | 485 (390 – 580) |
| | | 0.80 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 1600 (1300 – 1900) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_s = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

JS554-3C

Dynamisches Fräsen – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Fase



- Toleranzen:
- DMM= h5
- DC= e7
- Spanteiler
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | Spanteiler | DC | DMM | APMXS | OAL | CHW | PCEDC | Zylindrisch |
|-----------------------|--------------------|------------------|-------------------|------------|------|------|-------|-------|-------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | | |
| JS554060D3C.0Z4C-SIRA | 02810475 | 3 | D | ■ | 6,0 | 6,0 | 23,0 | 65,0 | 0,075 | 4 | ■ |
| JS554080D3C.0Z4C-SIRA | 02810477 | 3 | D | ■ | 8,0 | 8,0 | 32,0 | 75,0 | 0,1 | 4 | ■ |
| JS554100D3C.0Z4C-SIRA | 02810479 | 3 | D | ■ | 10,0 | 10,0 | 40,0 | 85,0 | 0,125 | 4 | ■ |
| JS554120D3C.0Z4C-SIRA | 02810481 | 3 | D | ■ | 12,0 | 12,0 | 45,0 | 100,0 | 0,15 | 4 | ■ |
| JS554160D3C.0Z4C-SIRA | 02810483 | 3 | D | ■ | 16,0 | 16,0 | 55,0 | 115,0 | 0,2 | 4 | ■ |
| JS554200D3C.0Z4C-SIRA | 02810485 | 3 | D | ■ | 20,0 | 20,0 | 65,0 | 125,0 | 0,25 | 4 | ■ |
| JS554250D3C.0Z4C-SIRA | 02810486 | 3 | D | ■ | 25,0 | 25,0 | 85,0 | 150,0 | 0,3 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

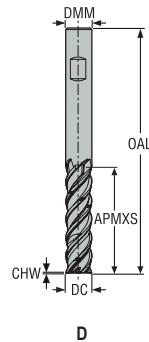
X-Heads

Minimaster Plus

Minimaster

JS554-3C

Dynamisches Fräsen – Universell – Eckfräser – 4 Schneiden – Weldon – Fase



- Toleranzen:
- DMM= h5
- DC= e7
- Spanteiler
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | Spanteiler | DC | DMM | APMXS | OAL | CHW | PCEDC | Weldon |
|-----------------------|--------------------|------------------|-------------------|------------|------|------|-------|-------|-------|-------|--------|
| | | | | | mm | mm | mm | mm | mm | | |
| JS554060D3C.3Z4C-SIRA | 02810474 | 3 | D | ■ | 6,0 | 6,0 | 23,0 | 65,0 | 0,075 | 4 | ■ |
| JS554080D3C.3Z4C-SIRA | 02810476 | 3 | D | ■ | 8,0 | 8,0 | 32,0 | 75,0 | 0,1 | 4 | ■ |
| JS554100D3C.3Z4C-SIRA | 02810478 | 3 | D | ■ | 10,0 | 10,0 | 40,0 | 85,0 | 0,125 | 4 | ■ |
| JS554120D3C.3Z4C-SIRA | 02810480 | 3 | D | ■ | 12,0 | 12,0 | 45,0 | 100,0 | 0,15 | 4 | ■ |
| JS554160D3C.3Z4C-SIRA | 02810482 | 3 | D | ■ | 16,0 | 16,0 | 55,0 | 115,0 | 0,2 | 4 | ■ |
| JS554200D3C.3Z4C-SIRA | 02810484 | 3 | D | ■ | 20,0 | 20,0 | 65,0 | 125,0 | 0,25 | 4 | ■ |
| JS554250D3C.3Z4C-SIRA | 02810487 | 3 | D | ■ | 25,0 | 25,0 | 85,0 | 150,0 | 0,3 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite


Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JS554-3C Dynamisches Fräsen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 6 | 8 | 10 | 12 | 16 | 20 | 25 | |
| P1 | M/A/D/E | 0.100 | 3.6 | 0.065 | 0.085 | 0.11 | 0.13 | 0.16 | 0.18 | 0.20 | 350 (320 – 380) |
| | | 0,100 | 3,6 | 0,0026 | 0,0034 | 0,0044 | 0,0050 | 0,0065 | 0,0070 | 0,0080 | 1150 (1100 – 1200) |
| P2 | M/A/D/E | 0.100 | 3.6 | 0.065 | 0.090 | 0.11 | 0.13 | 0.16 | 0.19 | 0.22 | 340 (310 – 370) |
| | | 0,100 | 3,6 | 0,0026 | 0,0036 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 0,0085 | 1125 (1100 – 1200) |
| P3 | M/A/D/E | 0.100 | 3.6 | 0.060 | 0.085 | 0.10 | 0.12 | 0.15 | 0.18 | 0.20 | 295 (270 – 320) |
| | | 0,100 | 3,6 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 0,0060 | 0,0070 | 0,0080 | 970 (890 – 1000) |
| P4 | M/A/D/E | 0.100 | 3.6 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 260 (240 – 280) |
| | | 0,100 | 3,6 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 850 (790 – 910) |
| P5 | M/A/D/E | 0.100 | 3.6 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 250 (230 – 270) |
| | | 0,100 | 3,6 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 820 (760 – 880) |
| P6 | M/A/D/E | 0.100 | 3.6 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 280 (260 – 300) |
| | | 0,100 | 3,6 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 920 (860 – 980) |
| P7 | M/A/D/E | 0.100 | 3.6 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 265 (240 – 290) |
| | | 0,100 | 3,6 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 870 (790 – 950) |
| P8 | M/A/D/E | 0.100 | 3.6 | 0.060 | 0.085 | 0.10 | 0.12 | 0.15 | 0.18 | 0.20 | 250 (230 – 270) |
| | | 0,100 | 3,6 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 0,0060 | 0,0070 | 0,0080 | 820 (760 – 880) |
| P11 | M/A/D/E | 0.100 | 3.6 | 0.070 | 0.095 | 0.12 | 0.14 | 0.19 | 0.24 | 0.28 | 245 (230 – 270) |
| | | 0,100 | 3,6 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0075 | 0,0095 | 0,011 | 800 (760 – 880) |
| P12 | M/A/D/E | 0.100 | 3.6 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 150 (140 – 160) |
| | | 0,100 | 3,6 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 490 (460 – 520) |
| M1 | E | 0.100 | 3.6 | 0.065 | 0.090 | 0.11 | 0.13 | 0.16 | 0.19 | 0.22 | 180 (160 – 210) |
| | | 0,100 | 3,6 | 0,0026 | 0,0036 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 0,0085 | 590 (530 – 680) |
| M2 | E | 0.100 | 3.6 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 150 (130 – 170) |
| | | 0,100 | 3,6 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 490 (430 – 550) |
| M3 | E | 0.100 | 3.6 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 100 (90 – 100) |
| | | 0,100 | 3,6 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 330 (300 – 320) |
| M4 | E | 0.100 | 3.6 | 0.050 | 0.070 | 0.085 | 0.10 | 0.13 | 0.15 | 0.17 | 75 (70 – 85) |
| | | 0,100 | 3,6 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0050 | 0,0060 | 0,0065 | 245 (230 – 270) |
| M5 | E | 0.100 | 3.6 | 0.050 | 0.070 | 0.085 | 0.10 | 0.13 | 0.15 | 0.17 | 65 (59 – 71) |
| | | 0,100 | 3,6 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0050 | 0,0060 | 0,0065 | 215 (200 – 230) |
| K1 | E | 0.100 | 3.6 | 0.065 | 0.090 | 0.11 | 0.13 | 0.16 | 0.19 | 0.22 | 340 (310 – 370) |
| | | 0,100 | 3,6 | 0,0026 | 0,0036 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 0,0085 | 1125 (1100 – 1200) |
| K2 | E | 0.100 | 3.6 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 185 (160 – 210) |
| | | 0,100 | 3,6 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 610 (530 – 680) |
| K3 | E | 0.100 | 3.6 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 255 (240 – 280) |
| | | 0,100 | 3,6 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 840 (790 – 910) |
| K4 | E | 0.100 | 3.6 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 245 (220 – 260) |
| | | 0,100 | 3,6 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 800 (730 – 850) |
| K5 | E | 0.100 | 3.6 | 0.055 | 0.070 | 0.090 | 0.11 | 0.13 | 0.15 | 0.17 | 150 (140 – 160) |
| | | 0,100 | 3,6 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 490 (460 – 520) |
| K6 | E | 0.100 | 3.6 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 215 (200 – 230) |
| | | 0,100 | 3,6 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 710 (660 – 750) |
| K7 | E | 0.100 | 3.6 | 0.055 | 0.070 | 0.090 | 0.11 | 0.13 | 0.15 | 0.17 | 190 (180 – 200) |
| | | 0,100 | 3,6 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 620 (600 – 650) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Universell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

Schnittdaten – JS554-3C Dynamisches Fräsen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 6 | 8 | 10 | 12 | 16 | 20 | 25 | |
| N1 | E | 0.100 | 3.6 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 750 (650 – 840) |
| | | 0,100 | 3,6 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 2450 (2200 – 2700) |
| N2 | E | 0.100 | 3.6 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 480 (420 – 540) |
| | | 0,100 | 3,6 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 1575 (1400 – 1700) |
| N3 | E | 0.100 | 3.6 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 320 (280 – 360) |
| | | 0,100 | 3,6 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 1050 (920 – 1100) |
| N11 | E | 0.100 | 3.6 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.19 | 375 (330 – 420) |
| | | 0,100 | 3,6 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 1225 (1100 – 1300) |
| S1 | E | 0.0500 | 3.6 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 0.14 | 0.15 | 50 (40 – 60) |
| | | 0,0500 | 3,6 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0060 | 165 (140 – 190) |
| S2 | E | 0.0500 | 3.6 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 0.14 | 0.15 | 40 (33 – 48) |
| | | 0,0500 | 3,6 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0060 | 130 (110 – 150) |
| S3 | E | 0.0500 | 3.6 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 0.14 | 0.15 | 25 (20 – 29) |
| | | 0,0500 | 3,6 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0060 | 80 (66 – 95) |
| S11 | E | 0.100 | 3.6 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 0.14 | 0.15 | 195 (130 – 220) |
| | | 0,100 | 3,6 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0060 | 640 (430 – 720) |
| S12 | E | 0.100 | 3.6 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 0.14 | 0.15 | 150 (100 – 160) |
| | | 0,100 | 3,6 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0060 | 490 (330 – 520) |
| S13 | E | 0.100 | 3.6 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 120 (80 – 130) |
| | | 0,100 | 3,6 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 395 (270 – 420) |
| H5 | M/A/D | 0.0500 | 3.6 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 0.095 | 200 (190 – 220) |
| | | 0,0500 | 3,6 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 0,0038 | 660 (630 – 720) |
| H8 | M/A/D | 0.0500 | 3.6 | 0.022 | 0.030 | 0.038 | 0.046 | 0.055 | 0.065 | 0.075 | 210 (190 – 220) |
| | | 0,0500 | 3,6 | 0,00085 | 0,0012 | 0,0015 | 0,0018 | 0,0022 | 0,0026 | 0,0030 | 690 (630 – 720) |
| H11 | M/A/D | 0.0500 | 3.6 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 0.095 | 255 (240 – 280) |
| | | 0,0500 | 3,6 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 0,0038 | 840 (790 – 910) |
| H12 | M/A/D | 0.100 | 3.6 | 0.032 | 0.042 | 0.050 | 0.060 | 0.075 | 0.090 | 0.10 | 205 (190 – 220) |
| | | 0,100 | 3,6 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 670 (630 – 720) |
| H21 | M/A/D | 0.0500 | 3.6 | 0.022 | 0.030 | 0.038 | 0.046 | 0.055 | 0.065 | 0.075 | 210 (190 – 220) |
| | | 0,0500 | 3,6 | 0,00085 | 0,0012 | 0,0015 | 0,0018 | 0,0022 | 0,0026 | 0,0030 | 690 (630 – 720) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

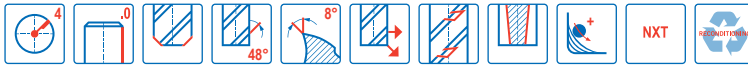
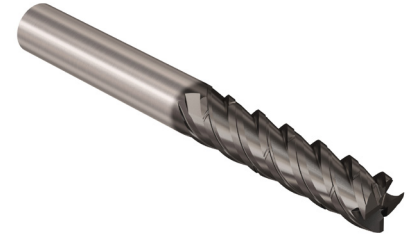
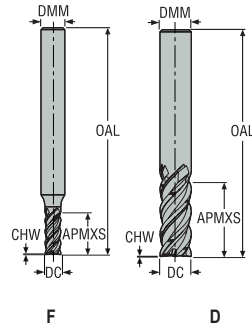
a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

JS564

Dynamisches Fräsen – Universell – Eckfräser – 4 Schneiden – Zylindrisch – Fase



- Toleranzen:
- DMM = h5
- DC= e7
- Spanteiler
- Nachschleifen möglich, wenn DC ≥ Ø8 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | Spanteiler | DC | DMM | APMXS | OAL | CHW | PCEDC | Zylindrisch |
|----------------------|--------------------|------------------|-------------------|------------|------|------|-------|-------|-------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | | |
| JS564030F2C.0Z4C-NXT | 03067338 | 2 | F | ■ | 3,0 | 6,0 | 7,0 | 57,0 | 0,04 | 4 | ■ |
| JS564040F2C.0Z4C-NXT | 03067339 | 2 | F | ■ | 4,0 | 6,0 | 10,0 | 57,0 | 0,05 | 4 | ■ |
| JS564050F2C.0Z4C-NXT | 03067340 | 2 | F | ■ | 5,0 | 6,0 | 12,5 | 57,0 | 0,06 | 4 | ■ |
| JS564060D2C.0Z4C-NXT | 03067341 | 2 | D | ■ | 6,0 | 6,0 | 15,0 | 57,0 | 0,075 | 4 | ■ |
| JS564080D2C.0Z4C-NXT | 03067342 | 2 | D | ■ | 8,0 | 8,0 | 20,0 | 63,0 | 0,1 | 4 | ■ |
| JS564100D2C.0Z4C-NXT | 03067343 | 2 | D | ■ | 10,0 | 10,0 | 25,0 | 72,0 | 0,125 | 4 | ■ |
| JS564120D2C.0Z4C-NXT | 03067344 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 0,15 | 4 | ■ |
| JS564160D2C.0Z4C-NXT | 03067345 | 2 | D | ■ | 16,0 | 16,0 | 40,0 | 99,0 | 0,2 | 4 | ■ |
| JS564200D2C.0Z4C-NXT | 03067346 | 2 | D | ■ | 20,0 | 20,0 | 50,0 | 114,0 | 0,25 | 4 | ■ |
| JS564060D3C.0Z4C-NXT | 03067347 | 3 | D | ■ | 6,0 | 6,0 | 23,0 | 64,0 | 0,075 | 4 | ■ |
| JS564080D3C.0Z4C-NXT | 03067348 | 3 | D | ■ | 8,0 | 8,0 | 32,0 | 74,0 | 0,1 | 4 | ■ |
| JS564100D3C.0Z4C-NXT | 03067349 | 3 | D | ■ | 10,0 | 10,0 | 40,0 | 88,0 | 0,125 | 4 | ■ |
| JS564120D3C.0Z4C-NXT | 03067350 | 3 | D | ■ | 12,0 | 12,0 | 45,0 | 99,0 | 0,15 | 4 | ■ |
| JS564160D3C.0Z4C-NXT | 03067351 | 3 | D | ■ | 16,0 | 16,0 | 55,0 | 114,0 | 0,2 | 4 | ■ |
| JS564200D3C.0Z4C-NXT | 03067352 | 3 | D | ■ | 20,0 | 20,0 | 65,0 | 126,0 | 0,25 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und
Composite


Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JS564 Eckfräsen dynamisches Fräsen

| SMG |  | a _p /DC | a _e /DC | f _z | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|-------------------|
| | | | | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| P1 | E/M/A/D | 0.150 | 2.4 | 0.042 | 0.055 | 0.065 | 0.085 | 0.11 | 0.13 | 0.16 | 0.18 | 305 (270 – 340) |
| | | 0,150 | 2,4 | 0,0017 | 0,0022 | 0,0026 | 0,0034 | 0,0044 | 0,0050 | 0,0065 | 0,0070 | 1000 (890 – 1100) |
| P2 | E/M/A/D | 0.150 | 2.4 | 0.044 | 0.055 | 0.065 | 0.085 | 0.11 | 0.13 | 0.16 | 0.18 | 295 (260 – 330) |
| | | 0,150 | 2,4 | 0,0017 | 0,0022 | 0,0026 | 0,0034 | 0,0044 | 0,0050 | 0,0065 | 0,0070 | 970 (860 – 1000) |
| P3 | E/M/A/D | 0.150 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 260 (230 – 290) |
| | | 0,150 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 850 (760 – 950) |
| P4 | E/M/A/D | 0.150 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 230 (200 – 250) |
| | | 0,150 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 750 (660 – 820) |
| P5 | E/M/A/D | 0.150 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 215 (190 – 240) |
| | | 0,150 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 710 (630 – 780) |
| P6 | E/M/A/D | 0.150 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 240 (210 – 270) |
| | | 0,150 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 790 (690 – 880) |
| P7 | E/M/A/D | 0.150 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 230 (200 – 250) |
| | | 0,150 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 750 (660 – 820) |
| P8 | E/M/A/D | 0.150 | 2.4 | 0.042 | 0.050 | 0.060 | 0.085 | 0.10 | 0.12 | 0.15 | 0.18 | 215 (190 – 240) |
| | | 0,150 | 2,4 | 0,0017 | 0,0020 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 0,0060 | 0,0070 | 710 (630 – 780) |
| P11 | E/M/A/D | 0.150 | 2.4 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.17 | 0.22 | 0.25 | 200 (180 – 220) |
| | | 0,150 | 2,4 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0065 | 0,0085 | 0,010 | 660 (600 – 720) |
| P12 | E/M/A/D | 0.150 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 130 (120 – 140) |
| | | 0,150 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 425 (400 – 450) |
| M1 | E | 0.150 | 2.4 | 0.044 | 0.055 | 0.065 | 0.090 | 0.11 | 0.13 | 0.16 | 0.19 | 195 (170 – 210) |
| | | 0,150 | 2,4 | 0,0017 | 0,0022 | 0,0026 | 0,0036 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 640 (560 – 680) |
| M2 | E | 0.150 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 160 (140 – 170) |
| | | 0,150 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 520 (460 – 550) |
| M3 | E | 0.100 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 130 (110 – 140) |
| | | 0,100 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 425 (370 – 450) |
| M4 | E | 0.100 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 130 (110 – 140) |
| | | 0,100 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 425 (370 – 450) |
| M5 | E | 0.100 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 110 (92 – 120) |
| | | 0,100 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 360 (310 – 390) |
| K1 | E | 0.150 | 2.4 | 0.044 | 0.055 | 0.065 | 0.090 | 0.11 | 0.13 | 0.16 | 0.19 | 260 (230 – 290) |
| | | 0,150 | 2,4 | 0,0017 | 0,0022 | 0,0026 | 0,0036 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 850 (760 – 950) |
| K2 | E | 0.150 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 230 (200 – 250) |
| | | 0,150 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 750 (660 – 820) |
| K3 | E | 0.150 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 195 (170 – 210) |
| | | 0,150 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 640 (560 – 680) |
| K4 | E | 0.150 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 185 (170 – 200) |
| | | 0,150 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 610 (560 – 650) |
| K5 | E | 0.150 | 2.4 | 0.036 | 0.044 | 0.055 | 0.070 | 0.090 | 0.11 | 0.13 | 0.15 | 115 (99 – 120) |
| | | 0,150 | 2,4 | 0,0014 | 0,0017 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 375 (330 – 390) |
| K6 | E | 0.150 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 165 (150 – 180) |
| | | 0,150 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 540 (500 – 590) |
| K7 | E | 0.150 | 2.4 | 0.036 | 0.044 | 0.055 | 0.070 | 0.090 | 0.11 | 0.13 | 0.15 | 145 (130 – 160) |
| | | 0,150 | 2,4 | 0,0014 | 0,0017 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 475 (430 – 520) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Universell

Stahl und Guss

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JS564 Eckfräsen dynamisches Fräsen

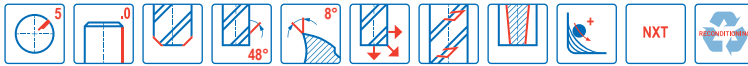
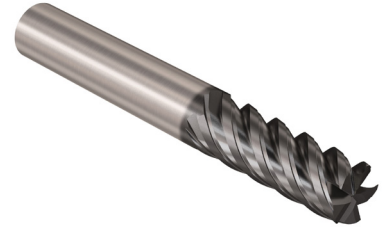
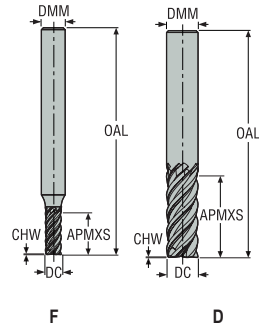
| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|---------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| N1 | E | 0.150 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 700 (600 – 790) |
| | | 0,150 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 2300 (2000 – 2500) |
| N2 | E | 0.150 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 450 (390 – 510) |
| | | 0,150 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 1475 (1300 – 1600) |
| N3 | E | 0.100 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 500 (400 – 590) |
| | | 0,100 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 1650 (1400 – 1900) |
| N11 | E | 0.150 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 350 (300 – 390) |
| | | 0,150 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 1150 (990 – 1200) |
| S1 | E | 0.0300 | 2.4 | 0.030 | 0.038 | 0.046 | 0.060 | 0.075 | 0.090 | 0.11 | 0.13 | 60 (37 – 86) |
| | | 0,0300 | 2,4 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 195 (130 – 280) |
| S2 | E | 0.0300 | 2.4 | 0.030 | 0.038 | 0.046 | 0.060 | 0.075 | 0.090 | 0.11 | 0.13 | 50 (30 – 69) |
| | | 0,0300 | 2,4 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 165 (99 – 220) |
| S3 | E | 0.0300 | 2.4 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 43 (26 – 60) |
| | | 0,0300 | 2,4 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 140 (86 – 190) |
| S11 | E | 0.0800 | 2.4 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 160 (140 – 180) |
| | | 0,0800 | 2,4 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 520 (460 – 590) |
| S12 | E | 0.0800 | 2.4 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 125 (110 – 140) |
| | | 0,0800 | 2,4 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 410 (370 – 450) |
| S13 | E | 0.0800 | 2.4 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 125 (110 – 140) |
| | | 0,0800 | 2,4 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 410 (370 – 450) |
| H8 | M/A/D | 0.0500 | 2.4 | 0.022 | 0.026 | 0.032 | 0.042 | 0.055 | 0.065 | 0.080 | 0.090 | 160 (140 – 180) |
| | | 0,0500 | 2,4 | 0,00085 | 0,0010 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 520 (460 – 590) |
| H21 | M/A/D | 0.0500 | 2.4 | 0.022 | 0.026 | 0.032 | 0.042 | 0.055 | 0.065 | 0.080 | 0.090 | 160 (140 – 180) |
| | | 0,0500 | 2,4 | 0,00085 | 0,0010 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 520 (460 – 590) |
| H31 | M/A/D | 0.0500 | 2.4 | 0.018 | 0.024 | 0.028 | 0.036 | 0.046 | 0.055 | 0.070 | 0.080 | 125 (110 – 140) |
| | | 0,0500 | 2,4 | 0,00070 | 0,00095 | 0,0011 | 0,0014 | 0,0018 | 0,0022 | 0,0028 | 0,0032 | 410 (370 – 450) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

JS565

Dynamisches Fräsen – Universell – Eckfräser – 5 Schneiden – Zylindrisch – Fase



- Toleranzen:
- DMM = h5
- DC= e7
- PCEDC5= ohne Spanteiler
- PCEDC5C= mit Spanteiler
- Nachschleifen möglich, wenn DC ≥ Ø8 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | Spanteiler | DC | DMM | APMXS | OAL | CHW | PCEDC | Zylindrisch |
|----------------------|--------------------|------------------|-------------------|------------|------|------|-------|-------|-------|-------|-------------|
| | | | | | | | | | | | |
| JS565040F2C.0Z5-NXT | 03067369 | 2 | F | - | 4,0 | 6,0 | 10,0 | 57,0 | 0,05 | 5 | ■ |
| JS565040F2C.0Z5C-NXT | 03067378 | 2 | F | ■ | 4,0 | 6,0 | 10,0 | 57,0 | 0,05 | 5 | ■ |
| JS565050F2C.0Z5-NXT | 03067370 | 2 | F | - | 5,0 | 6,0 | 12,5 | 57,0 | 0,06 | 5 | ■ |
| JS565050F2C.0Z5C-NXT | 03067379 | 2 | F | ■ | 5,0 | 6,0 | 12,5 | 57,0 | 0,06 | 5 | ■ |
| JS565060D2C.0Z5-NXT | 03067371 | 2 | D | - | 6,0 | 6,0 | 15,0 | 57,0 | 0,075 | 5 | ■ |
| JS565060D2C.0Z5C-NXT | 03067380 | 2 | D | ■ | 6,0 | 6,0 | 15,0 | 57,0 | 0,075 | 5 | ■ |
| JS565080D2C.0Z5-NXT | 03067372 | 2 | D | - | 8,0 | 8,0 | 20,0 | 63,0 | 0,1 | 5 | ■ |
| JS565080D2C.0Z5C-NXT | 03067381 | 2 | D | ■ | 8,0 | 8,0 | 20,0 | 63,0 | 0,1 | 5 | ■ |
| JS565100D2C.0Z5-NXT | 03067373 | 2 | D | - | 10,0 | 10,0 | 25,0 | 72,0 | 0,125 | 5 | ■ |
| JS565100D2C.0Z5C-NXT | 03067382 | 2 | D | ■ | 10,0 | 10,0 | 25,0 | 72,0 | 0,125 | 5 | ■ |
| JS565120D2C.0Z5-NXT | 03067374 | 2 | D | - | 12,0 | 12,0 | 30,0 | 83,0 | 0,15 | 5 | ■ |
| JS565120D2C.0Z5C-NXT | 03067383 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 0,15 | 5 | ■ |
| JS565160D2C.0Z5-NXT | 03067375 | 2 | D | - | 16,0 | 16,0 | 40,0 | 99,0 | 0,2 | 5 | ■ |
| JS565160D2C.0Z5C-NXT | 03067384 | 2 | D | ■ | 16,0 | 16,0 | 40,0 | 99,0 | 0,2 | 5 | ■ |
| JS565200D2C.0Z5-NXT | 03067376 | 2 | D | - | 20,0 | 20,0 | 50,0 | 114,0 | 0,25 | 5 | ■ |
| JS565200D2C.0Z5C-NXT | 03067385 | 2 | D | ■ | 20,0 | 20,0 | 50,0 | 114,0 | 0,25 | 5 | ■ |
| JS565060D3C.0Z5C-NXT | 03067386 | 3 | D | ■ | 6,0 | 6,0 | 23,0 | 64,0 | 0,075 | 5 | ■ |
| JS565080D3C.0Z5C-NXT | 03067387 | 3 | D | ■ | 8,0 | 8,0 | 32,0 | 74,0 | 0,1 | 5 | ■ |
| JS565100D3C.0Z5C-NXT | 03067388 | 3 | D | ■ | 10,0 | 10,0 | 40,0 | 88,0 | 0,125 | 5 | ■ |
| JS565120D3C.0Z5C-NXT | 03067389 | 3 | D | ■ | 12,0 | 12,0 | 45,0 | 99,0 | 0,15 | 5 | ■ |
| JS565160D3C.0Z5C-NXT | 03067390 | 3 | D | ■ | 16,0 | 16,0 | 55,0 | 114,0 | 0,2 | 5 | ■ |
| JS565200D3C.0Z5C-NXT | 03067391 | 3 | D | ■ | 20,0 | 20,0 | 65,0 | 126,0 | 0,25 | 5 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

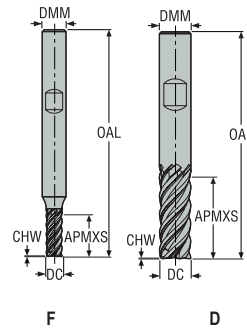
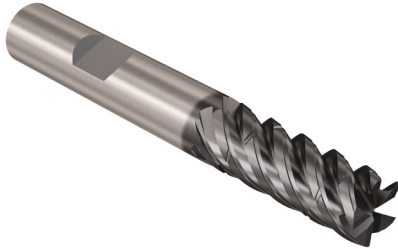
X-Heads

Minimaster Plus

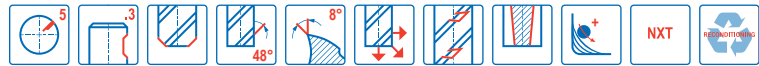
Minimaster

JS565

Dynamisches Fräsen – Universell – Eckfräser – 5 Schneiden – Weldon – Fase



- Toleranzen:
- DMM = h5
- DC= e7
- PCEDC5= ohne Spanteiler
- PCEDC5C= mit Spanteiler
- Nachschleifen möglich, wenn DC ≥ Ø8 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | Spanteiler | DC | DMM | APMXS | OAL | CHW | PCEDC | Weldon |
|----------------------|--------------------|------------------|-------------------|------------|------|------|-------|-------|-------|-------|--------|
| | | | | | mm | mm | mm | mm | mm | | |
| JS565040F2C.3Z5-NXT | 03067393 | 2 | F | – | 4,0 | 6,0 | 10,0 | 57,0 | 0,05 | 5 | ■ |
| JS565040F2C.3Z5C-NXT | 03067402 | 2 | F | ■ | 4,0 | 6,0 | 10,0 | 57,0 | 0,05 | 5 | ■ |
| JS565050F2C.3Z5-NXT | 03067394 | 2 | F | – | 5,0 | 6,0 | 12,5 | 57,0 | 0,06 | 5 | ■ |
| JS565050F2C.3Z5C-NXT | 03067403 | 2 | F | ■ | 5,0 | 6,0 | 12,5 | 57,0 | 0,06 | 5 | ■ |
| JS565060D2C.3Z5-NXT | 03067395 | 2 | D | – | 6,0 | 6,0 | 15,0 | 57,0 | 0,075 | 5 | ■ |
| JS565060D2C.3Z5C-NXT | 03067404 | 2 | D | ■ | 6,0 | 6,0 | 15,0 | 57,0 | 0,075 | 5 | ■ |
| JS565080D2C.3Z5-NXT | 03067396 | 2 | D | – | 8,0 | 8,0 | 20,0 | 63,0 | 0,1 | 5 | ■ |
| JS565080D2C.3Z5C-NXT | 03067405 | 2 | D | ■ | 8,0 | 8,0 | 20,0 | 63,0 | 0,1 | 5 | ■ |
| JS565100D2C.3Z5-NXT | 03067397 | 2 | D | – | 10,0 | 10,0 | 25,0 | 72,0 | 0,125 | 5 | ■ |
| JS565100D2C.3Z5C-NXT | 03067406 | 2 | D | ■ | 10,0 | 10,0 | 25,0 | 72,0 | 0,125 | 5 | ■ |
| JS565120D2C.3Z5-NXT | 03067398 | 2 | D | – | 12,0 | 12,0 | 30,0 | 83,0 | 0,15 | 5 | ■ |
| JS565120D2C.3Z5C-NXT | 03067407 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 0,15 | 5 | ■ |
| JS565160D2C.3Z5-NXT | 03067399 | 2 | D | – | 16,0 | 16,0 | 40,0 | 99,0 | 0,2 | 5 | ■ |
| JS565160D2C.3Z5C-NXT | 03067408 | 2 | D | ■ | 16,0 | 16,0 | 40,0 | 99,0 | 0,2 | 5 | ■ |
| JS565200D2C.3Z5-NXT | 03067400 | 2 | D | – | 20,0 | 20,0 | 50,0 | 114,0 | 0,25 | 5 | ■ |
| JS565200D2C.3Z5C-NXT | 03067409 | 2 | D | ■ | 20,0 | 20,0 | 50,0 | 114,0 | 0,25 | 5 | ■ |
| JS565060D3C.3Z5C-NXT | 03067410 | 3 | D | ■ | 6,0 | 6,0 | 23,0 | 64,0 | 0,075 | 5 | ■ |
| JS565080D3C.3Z5C-NXT | 03067411 | 3 | D | ■ | 8,0 | 8,0 | 32,0 | 74,0 | 0,1 | 5 | ■ |
| JS565100D3C.3Z5C-NXT | 03067412 | 3 | D | ■ | 10,0 | 10,0 | 40,0 | 88,0 | 0,125 | 5 | ■ |
| JS565120D3C.3Z5C-NXT | 03067413 | 3 | D | ■ | 12,0 | 12,0 | 45,0 | 99,0 | 0,15 | 5 | ■ |
| JS565160D3C.3Z5C-NXT | 03067414 | 3 | D | ■ | 16,0 | 16,0 | 55,0 | 114,0 | 0,2 | 5 | ■ |
| JS565200D3C.3Z5C-NXT | 03067415 | 3 | D | ■ | 20,0 | 20,0 | 65,0 | 126,0 | 0,25 | 5 | ■ |

■ Lagerstandard.

Universell

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Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und Composite


Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JS565 Eckfräsen dynamisches Fräsen

| SMG |  | a _p /DC | a _e /DC | f _z | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|-------------------|
| | | | | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| P1 | E/M/A/D | 0.100 | 2.4 | 0.050 | 0.065 | 0.075 | 0.10 | 0.13 | 0.15 | 0.19 | 0.22 | 325 (270 – 340) |
| | | 0,100 | 2,4 | 0,0020 | 0,0026 | 0,0030 | 0,0040 | 0,0050 | 0,0060 | 0,0075 | 0,0085 | 1075 (890 – 1100) |
| P2 | E/M/A/D | 0.100 | 2.4 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.15 | 0.19 | 0.22 | 315 (260 – 330) |
| | | 0,100 | 2,4 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0060 | 0,0075 | 0,0085 | 1025 (860 – 1000) |
| P3 | E/M/A/D | 0.100 | 2.4 | 0.048 | 0.060 | 0.075 | 0.10 | 0.12 | 0.14 | 0.18 | 0.20 | 280 (230 – 290) |
| | | 0,100 | 2,4 | 0,0019 | 0,0024 | 0,0030 | 0,0040 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 920 (760 – 950) |
| P4 | E/M/A/D | 0.100 | 2.4 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.18 | 0.20 | 245 (200 – 250) |
| | | 0,100 | 2,4 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 800 (660 – 820) |
| P5 | E/M/A/D | 0.100 | 2.4 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.18 | 0.20 | 230 (190 – 240) |
| | | 0,100 | 2,4 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 750 (630 – 780) |
| P6 | E/M/A/D | 0.100 | 2.4 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.17 | 0.20 | 260 (210 – 270) |
| | | 0,100 | 2,4 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0065 | 0,0080 | 850 (690 – 880) |
| P7 | E/M/A/D | 0.100 | 2.4 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.17 | 0.20 | 245 (200 – 250) |
| | | 0,100 | 2,4 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0065 | 0,0080 | 800 (660 – 820) |
| P8 | E/M/A/D | 0.100 | 2.4 | 0.050 | 0.060 | 0.075 | 0.10 | 0.12 | 0.15 | 0.18 | 0.22 | 230 (190 – 240) |
| | | 0,100 | 2,4 | 0,0020 | 0,0024 | 0,0030 | 0,0040 | 0,0048 | 0,0060 | 0,0070 | 0,0085 | 750 (630 – 780) |
| P11 | E/M/A/D | 0.100 | 2.4 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 0.24 | 0.30 | 225 (190 – 230) |
| | | 0,100 | 2,4 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0095 | 0,012 | 740 (630 – 750) |
| P12 | E/M/A/D | 0.100 | 2.4 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.18 | 0.20 | 140 (120 – 140) |
| | | 0,100 | 2,4 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 460 (400 – 450) |
| M1 | E | 0.100 | 2.4 | 0.055 | 0.065 | 0.080 | 0.11 | 0.13 | 0.16 | 0.19 | 0.22 | 205 (180 – 210) |
| | | 0,100 | 2,4 | 0,0022 | 0,0026 | 0,0032 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 0,0085 | 670 (600 – 680) |
| M2 | E | 0.100 | 2.4 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.18 | 0.20 | 170 (140 – 170) |
| | | 0,100 | 2,4 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 560 (460 – 550) |
| M3 | E | 0.100 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 130 (110 – 140) |
| | | 0,100 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 425 (370 – 450) |
| M4 | E | 0.100 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 130 (110 – 140) |
| | | 0,100 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 425 (370 – 450) |
| M5 | E | 0.100 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 110 (92 – 120) |
| | | 0,100 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 360 (310 – 390) |
| K1 | E | 0.100 | 2.4 | 0.055 | 0.065 | 0.080 | 0.11 | 0.13 | 0.16 | 0.19 | 0.22 | 275 (230 – 290) |
| | | 0,100 | 2,4 | 0,0022 | 0,0026 | 0,0032 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 0,0085 | 900 (760 – 950) |
| K2 | E | 0.100 | 2.4 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.18 | 0.20 | 245 (200 – 250) |
| | | 0,100 | 2,4 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 800 (660 – 820) |
| K3 | E | 0.100 | 2.4 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.18 | 0.20 | 205 (170 – 210) |
| | | 0,100 | 2,4 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 670 (560 – 680) |
| K4 | E | 0.100 | 2.4 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.18 | 0.20 | 200 (170 – 200) |
| | | 0,100 | 2,4 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 660 (560 – 650) |
| K5 | E | 0.100 | 2.4 | 0.044 | 0.055 | 0.065 | 0.085 | 0.11 | 0.13 | 0.16 | 0.18 | 120 (98 – 120) |
| | | 0,100 | 2,4 | 0,0017 | 0,0022 | 0,0026 | 0,0034 | 0,0044 | 0,0050 | 0,0065 | 0,0070 | 395 (330 – 390) |
| K6 | E | 0.100 | 2.4 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.18 | 0.20 | 175 (150 – 180) |
| | | 0,100 | 2,4 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 570 (500 – 590) |
| K7 | E | 0.100 | 2.4 | 0.044 | 0.055 | 0.065 | 0.085 | 0.11 | 0.13 | 0.16 | 0.18 | 155 (130 – 160) |
| | | 0,100 | 2,4 | 0,0017 | 0,0022 | 0,0026 | 0,0034 | 0,0044 | 0,0050 | 0,0065 | 0,0070 | 510 (430 – 520) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JS565 Eckfräsen dynamisches Fräsen

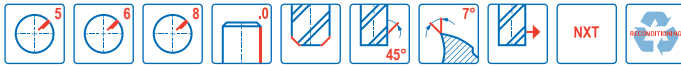
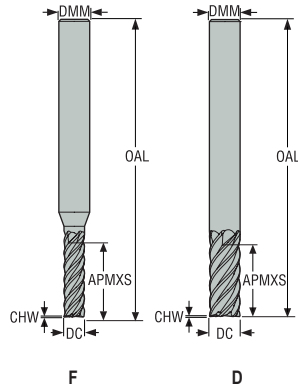
| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| N1 | E | 0.100 | 2.4 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.18 | 0.20 | 740 (600 – 790) |
| | | 0,100 | 2,4 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 2425 (2000 – 2500) |
| N2 | E | 0.100 | 2.4 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.18 | 0.20 | 475 (390 – 510) |
| | | 0,100 | 2,4 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 1550 (1300 – 1600) |
| N3 | E | 0.100 | 2.4 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 500 (400 – 590) |
| | | 0,100 | 2,4 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 1650 (1400 – 1900) |
| N11 | E | 0.100 | 2.4 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.18 | 0.20 | 370 (300 – 390) |
| | | 0,100 | 2,4 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 1225 (990 – 1200) |
| S1 | E | 0.0300 | 2.4 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 60 (38 – 86) |
| | | 0,0300 | 2,4 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 195 (130 – 280) |
| S2 | E | 0.0300 | 2.4 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 50 (30 – 70) |
| | | 0,0300 | 2,4 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 165 (99 – 220) |
| S3 | E | 0.0300 | 2.4 | 0.026 | 0.032 | 0.038 | 0.050 | 0.065 | 0.075 | 0.095 | 0.11 | 43 (27 – 60) |
| | | 0,0300 | 2,4 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 140 (89 – 190) |
| S11 | E | 0.0800 | 2.4 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 160 (140 – 180) |
| | | 0,0800 | 2,4 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 520 (460 – 590) |
| S12 | E | 0.0800 | 2.4 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 125 (110 – 140) |
| | | 0,0800 | 2,4 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 410 (370 – 450) |
| S13 | E | 0.0800 | 2.4 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 125 (110 – 140) |
| | | 0,0800 | 2,4 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 410 (370 – 450) |
| H8 | M/A/D | 0.0500 | 2.4 | 0.022 | 0.026 | 0.032 | 0.042 | 0.055 | 0.065 | 0.080 | 0.090 | 160 (140 – 180) |
| | | 0,0500 | 2,4 | 0,00085 | 0,0010 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 520 (460 – 590) |
| H21 | M/A/D | 0.0500 | 2.4 | 0.024 | 0.028 | 0.034 | 0.046 | 0.060 | 0.070 | 0.085 | 0.10 | 155 (140 – 180) |
| | | 0,0500 | 2,4 | 0,00095 | 0,0011 | 0,0013 | 0,0018 | 0,0024 | 0,0028 | 0,0034 | 0,0040 | 510 (460 – 590) |
| H31 | M/A/D | 0.0500 | 2.4 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 120 (110 – 140) |
| | | 0,0500 | 2,4 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 395 (370 – 450) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

JS520

Hochleistungsfräser – Universell – Eckfräser – 5-8 Schneiden – Zylindrisch – Fase



- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | CHW | PCEDC | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | | |
| JS520040F2C.0Z5-NXT | 02927474 | 2 | F | 4,0 | 6,0 | 10,0 | 57,0 | 0,04 | 5 | ■ |
| JS520050F2C.0Z5-NXT | 02927476 | 2 | F | 5,0 | 6,0 | 12,0 | 57,0 | 0,05 | 5 | ■ |
| JS520060D2C.0Z5-NXT | 02927478 | 2 | D | 6,0 | 6,0 | 15,0 | 57,0 | 0,06 | 5 | ■ |
| JS520060D2C.0Z6-NXT | 02927479 | 2 | D | 6,0 | 6,0 | 15,0 | 57,0 | 0,06 | 6 | ■ |
| JS520080D2C.0Z5-NXT | 02927482 | 2 | D | 8,0 | 8,0 | 20,0 | 63,0 | 0,08 | 5 | ■ |
| JS520080D2C.0Z6-NXT | 02927483 | 2 | D | 8,0 | 8,0 | 20,0 | 63,0 | 0,08 | 6 | ■ |
| JS520100D2C.0Z6-NXT | 02927486 | 2 | D | 10,0 | 10,0 | 25,0 | 72,0 | 0,1 | 6 | ■ |
| JS520120D2C.0Z6-NXT | 02927488 | 2 | D | 12,0 | 12,0 | 25,0 | 83,0 | 0,12 | 6 | ■ |
| JS520140D2C.0Z6-NXT | 02927490 | 2 | D | 14,0 | 14,0 | 30,0 | 83,0 | 0,14 | 6 | ■ |
| JS520160D2C.0Z6-NXT | 02927491 | 2 | D | 16,0 | 16,0 | 30,0 | 92,0 | 0,16 | 6 | ■ |
| JS520160D2C.0Z8-NXT | 02927492 | 2 | D | 16,0 | 16,0 | 30,0 | 92,0 | 0,16 | 8 | ■ |
| JS520200D2C.0Z8-NXT | 02927495 | 2 | D | 20,0 | 20,0 | 35,0 | 104,0 | 0,2 | 8 | ■ |
| JS520250D2C.0Z8-NXT | 02927497 | 2 | D | 25,0 | 25,0 | 50,0 | 125,0 | 0,25 | 8 | ■ |
| JS520040F3C.0Z5-NXT | 02927475 | 3 | F | 4,0 | 6,0 | 15,0 | 57,0 | 0,04 | 5 | ■ |
| JS520050F3C.0Z5-NXT | 02927477 | 3 | F | 5,0 | 6,0 | 19,0 | 57,0 | 0,05 | 5 | ■ |
| JS520060D3C.0Z5-NXT | 02927480 | 3 | D | 6,0 | 6,0 | 20,0 | 63,0 | 0,06 | 5 | ■ |
| JS520060D3C.0Z6-NXT | 02927481 | 3 | D | 6,0 | 6,0 | 20,0 | 63,0 | 0,06 | 6 | ■ |
| JS520080D3C.0Z5-NXT | 02927484 | 3 | D | 8,0 | 8,0 | 30,0 | 80,0 | 0,08 | 5 | ■ |
| JS520080D3C.0Z6-NXT | 02927485 | 3 | D | 8,0 | 8,0 | 30,0 | 80,0 | 0,08 | 6 | ■ |
| JS520100D3C.0Z6-NXT | 02927487 | 3 | D | 10,0 | 10,0 | 40,0 | 89,0 | 0,1 | 6 | ■ |
| JS520120D3C.0Z6-NXT | 02927489 | 3 | D | 12,0 | 12,0 | 45,0 | 100,0 | 0,12 | 6 | ■ |
| JS520160D3C.0Z6-NXT | 02927493 | 3 | D | 16,0 | 16,0 | 65,0 | 125,0 | 0,16 | 6 | ■ |
| JS520160D3C.0Z8-NXT | 02927494 | 3 | D | 16,0 | 16,0 | 65,0 | 125,0 | 0,16 | 8 | ■ |
| JS520200D3C.0Z8-NXT | 02927496 | 3 | D | 20,0 | 20,0 | 65,0 | 125,0 | 0,2 | 8 | ■ |
| JS520250D3C.0Z8-NXT | 02927498 | 3 | D | 25,0 | 25,0 | 75,0 | 150,0 | 0,25 | 8 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

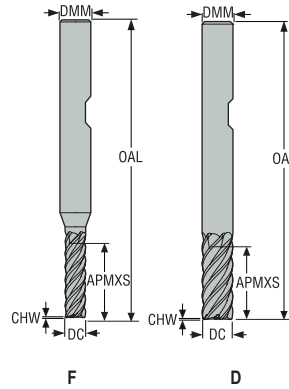
X-Heads

Minimaster Plus

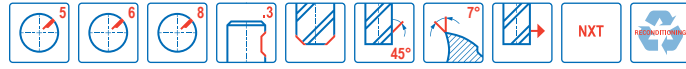
Minimaster

JS520

Hochleistungsfräser – Universell – Eckfräser – 5-8 Schneiden – Weldon – Fase



- Toleranzen:
- DMM=h5
- DC=e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | CHW | PCEDC | Weldon |
|---------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|-------|-------------------------------------|
| | | | | mm | mm | mm | mm | mm | | |
| JS520040F2C.3Z5-NXT | 02927499 | 2 | F | 4,0 | 6,0 | 10,0 | 57,0 | 0,04 | 5 | <input type="checkbox"/> |
| JS520050F2C.3Z5-NXT | 02927501 | 2 | F | 5,0 | 6,0 | 12,0 | 57,0 | 0,05 | 5 | <input type="checkbox"/> |
| JS520060D2C.3Z5-NXT | 02927503 | 2 | D | 6,0 | 6,0 | 15,0 | 57,0 | 0,06 | 5 | <input type="checkbox"/> |
| JS520060D2C.3Z6-NXT | 02927504 | 2 | D | 6,0 | 6,0 | 15,0 | 57,0 | 0,06 | 6 | <input type="checkbox"/> |
| JS520080D2C.3Z5-NXT | 02927507 | 2 | D | 8,0 | 8,0 | 20,0 | 63,0 | 0,08 | 5 | <input type="checkbox"/> |
| JS520080D2C.3Z6-NXT | 02927508 | 2 | D | 8,0 | 8,0 | 20,0 | 63,0 | 0,08 | 6 | <input type="checkbox"/> |
| JS520100D2C.3Z6-NXT | 02927511 | 2 | D | 10,0 | 10,0 | 25,0 | 72,0 | 0,1 | 6 | <input type="checkbox"/> |
| JS520120D2C.3Z6-NXT | 02927513 | 2 | D | 12,0 | 12,0 | 25,0 | 83,0 | 0,12 | 6 | <input type="checkbox"/> |
| JS520140D2C.3Z6-NXT | 02927515 | 2 | D | 14,0 | 14,0 | 30,0 | 83,0 | 0,14 | 6 | <input type="checkbox"/> |
| JS520160D2C.3Z6-NXT | 02927516 | 2 | D | 16,0 | 16,0 | 30,0 | 92,0 | 0,16 | 6 | <input type="checkbox"/> |
| JS520160D2C.3Z8-NXT | 02927517 | 2 | D | 16,0 | 16,0 | 30,0 | 92,0 | 0,16 | 8 | <input checked="" type="checkbox"/> |
| JS520200D2C.3Z8-NXT | 02927520 | 2 | D | 20,0 | 20,0 | 35,0 | 104,0 | 0,2 | 8 | <input checked="" type="checkbox"/> |
| JS520250D2C.3Z8-NXT | 02927522 | 2 | D | 25,0 | 25,0 | 50,0 | 125,0 | 0,25 | 8 | <input type="checkbox"/> |
| JS520040F3C.3Z5-NXT | 02927500 | 3 | F | 4,0 | 6,0 | 15,0 | 57,0 | 0,04 | 5 | <input type="checkbox"/> |
| JS520050F3C.3Z5-NXT | 02927502 | 3 | F | 5,0 | 6,0 | 19,0 | 57,0 | 0,05 | 5 | <input type="checkbox"/> |
| JS520060D3C.3Z5-NXT | 02927505 | 3 | D | 6,0 | 6,0 | 20,0 | 63,0 | 0,06 | 5 | <input type="checkbox"/> |
| JS520060D3C.3Z6-NXT | 02927506 | 3 | D | 6,0 | 6,0 | 20,0 | 63,0 | 0,06 | 6 | <input type="checkbox"/> |
| JS520080D3C.3Z5-NXT | 02927509 | 3 | D | 8,0 | 8,0 | 30,0 | 80,0 | 0,08 | 5 | <input type="checkbox"/> |
| JS520080D3C.3Z6-NXT | 02927510 | 3 | D | 8,0 | 8,0 | 30,0 | 80,0 | 0,08 | 6 | <input type="checkbox"/> |
| JS520100D3C.3Z6-NXT | 02927512 | 3 | D | 10,0 | 10,0 | 40,0 | 89,0 | 0,1 | 6 | <input type="checkbox"/> |
| JS520120D3C.3Z6-NXT | 02927514 | 3 | D | 12,0 | 12,0 | 45,0 | 100,0 | 0,12 | 6 | <input type="checkbox"/> |
| JS520160D3C.3Z6-NXT | 02927518 | 3 | D | 16,0 | 16,0 | 65,0 | 125,0 | 0,16 | 6 | <input type="checkbox"/> |
| JS520160D3C.3Z8-NXT | 02927519 | 3 | D | 16,0 | 16,0 | 65,0 | 125,0 | 0,16 | 8 | <input type="checkbox"/> |
| JS520200D3C.3Z8-NXT | 02927521 | 3 | D | 20,0 | 20,0 | 65,0 | 125,0 | 0,2 | 8 | <input type="checkbox"/> |
| JS520250D3C.3Z8-NXT | 02927523 | 3 | D | 25,0 | 25,0 | 75,0 | 150,0 | 0,25 | 8 | <input type="checkbox"/> |

■ Lagerstandard. □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Universell

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Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite


Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JS520 Eckfräsen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | | 4 | 5 | 6 | 8 | 10 | 12 | 14 | 16 | 20 | 25 | |
| P1 | E/M/A | 0.100 | 2.0 | 0.034 | 0.044 | 0.050 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 0.15 | 0.17 | 180 (120 – 250) |
| | | 0,100 | 2,0 | 0,0013 | 0,0017 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 0,0065 | 590 (400 – 820) |
| P2 | E/M/A | 0.100 | 2.0 | 0.036 | 0.044 | 0.055 | 0.070 | 0.090 | 0.10 | 0.12 | 0.13 | 0.15 | 0.17 | 175 (110 – 240) |
| | | 0,100 | 2,0 | 0,0014 | 0,0017 | 0,0022 | 0,0028 | 0,0036 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 0,0065 | 570 (370 – 780) |
| P3 | E/M/A | 0.100 | 2.0 | 0.034 | 0.042 | 0.050 | 0.065 | 0.085 | 0.10 | 0.11 | 0.12 | 0.14 | 0.16 | 155 (95 – 210) |
| | | 0,100 | 2,0 | 0,0013 | 0,0017 | 0,0020 | 0,0026 | 0,0034 | 0,0040 | 0,0044 | 0,0048 | 0,0055 | 0,0065 | 510 (320 – 680) |
| P4 | E/M/A | 0.100 | 2.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.16 | 135 (84 – 180) |
| | | 0,100 | 2,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0065 | 445 (280 – 590) |
| P5 | E/M/A | 0.100 | 2.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 130 (81 – 180) |
| | | 0,100 | 2,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 425 (270 – 590) |
| P6 | E/M/A | 0.100 | 2.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.13 | 0.15 | 145 (90 – 200) |
| | | 0,100 | 2,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0050 | 0,0060 | 475 (300 – 650) |
| P7 | E/M/A | 0.100 | 2.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.13 | 0.15 | 140 (85 – 190) |
| | | 0,100 | 2,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0050 | 0,0060 | 460 (280 – 620) |
| P8 | E/M/A | 0.100 | 2.0 | 0.034 | 0.042 | 0.050 | 0.065 | 0.085 | 0.10 | 0.11 | 0.12 | 0.14 | 0.16 | 130 (80 – 170) |
| | | 0,100 | 2,0 | 0,0013 | 0,0017 | 0,0020 | 0,0026 | 0,0034 | 0,0040 | 0,0044 | 0,0048 | 0,0055 | 0,0065 | 425 (270 – 550) |
| P11 | E/M/A | 0.100 | 2.0 | 0.046 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.16 | 0.17 | 0.20 | 0.22 | 195 (160 – 230) |
| | | 0,100 | 2,0 | 0,0018 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0065 | 0,0065 | 0,0080 | 0,0085 | 640 (530 – 750) |
| P12 | E/M/A | 0.100 | 2.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 125 (100 – 140) |
| | | 0,100 | 2,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 410 (330 – 450) |
| M1 | E/M/A | 0.100 | 2.0 | 0.036 | 0.044 | 0.055 | 0.070 | 0.090 | 0.10 | 0.12 | 0.13 | 0.15 | 0.17 | 150 (130 – 180) |
| | | 0,100 | 2,0 | 0,0014 | 0,0017 | 0,0022 | 0,0028 | 0,0036 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 0,0065 | 490 (430 – 590) |
| M2 | E/M/A | 0.100 | 2.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 125 (100 – 150) |
| | | 0,100 | 2,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 410 (330 – 490) |
| M3 | E/M/A | 0.100 | 2.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 100 (75 – 120) |
| | | 0,100 | 2,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 330 (250 – 390) |
| M4 | E/M/A | 0.100 | 2.0 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.095 | 0.10 | 0.12 | 0.13 | 75 (58 – 96) |
| | | 0,100 | 2,0 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0038 | 0,0040 | 0,0048 | 0,0050 | 245 (200 – 310) |
| M5 | E/M/A | 0.100 | 2.0 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.095 | 0.10 | 0.12 | 0.13 | 65 (49 – 80) |
| | | 0,100 | 2,0 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0038 | 0,0040 | 0,0048 | 0,0050 | 215 (170 – 260) |
| K1 | E/M/A | 0.100 | 2.0 | 0.036 | 0.044 | 0.055 | 0.070 | 0.090 | 0.10 | 0.12 | 0.13 | 0.15 | 0.17 | 175 (110 – 240) |
| | | 0,100 | 2,0 | 0,0014 | 0,0017 | 0,0022 | 0,0028 | 0,0036 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 0,0065 | 570 (370 – 780) |
| K2 | E/M/A | 0.100 | 2.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 155 (97 – 210) |
| | | 0,100 | 2,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 510 (320 – 680) |
| K3 | E/M/A | 0.100 | 2.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 135 (82 – 180) |
| | | 0,100 | 2,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 445 (270 – 590) |
| K4 | E/M/A | 0.100 | 2.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 125 (79 – 170) |
| | | 0,100 | 2,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 410 (260 – 550) |
| K5 | E/M/A | 0.100 | 2.0 | 0.028 | 0.036 | 0.044 | 0.060 | 0.070 | 0.085 | 0.095 | 0.11 | 0.12 | 0.14 | 75 (48 – 100) |
| | | 0,100 | 2,0 | 0,0011 | 0,0014 | 0,0017 | 0,0024 | 0,0028 | 0,0034 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 245 (160 – 320) |
| K6 | E/M/A | 0.100 | 2.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 110 (69 – 150) |
| | | 0,100 | 2,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 360 (230 – 490) |
| K7 | E/M/A | 0.100 | 2.0 | 0.028 | 0.036 | 0.044 | 0.060 | 0.070 | 0.085 | 0.095 | 0.11 | 0.12 | 0.14 | 100 (62 – 130) |
| | | 0,100 | 2,0 | 0,0011 | 0,0014 | 0,0017 | 0,0024 | 0,0028 | 0,0034 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 330 (210 – 420) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Universell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

Schnittdaten – JS520 Eckfräsen

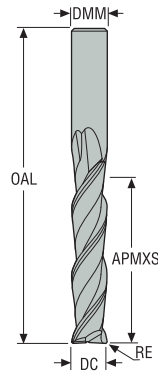
| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 4 | 5 | 6 | 8 | 10 | 12 | 14 | 16 | 20 | 25 | |
| N1 | E/M/A | 0.100 | 2.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 500 (450 – 550) |
| | | 0,100 | 2,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 1650 (1500 – 1800) |
| N2 | E/M/A | 0.100 | 2.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 320 (290 – 350) |
| | | 0,100 | 2,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 1050 (960 – 1100) |
| N3 | E/M/A | 0.100 | 2.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 215 (200 – 230) |
| | | 0,100 | 2,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 710 (660 – 750) |
| N11 | E/M/A | 0.100 | 2.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 400 (350 – 450) |
| | | 0,100 | 2,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 1300 (1200 – 1400) |
| S1 | E/M/A | 0.0600 | 2.0 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.065 | 0.075 | 0.085 | 0.095 | 75 (63 – 86) |
| | | 0,0600 | 2,0 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0026 | 0,0030 | 0,0034 | 0,0038 | 245 (210 – 280) |
| S2 | E/M/A | 0.0600 | 2.0 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.065 | 0.075 | 0.085 | 0.095 | 60 (50 – 70) |
| | | 0,0600 | 2,0 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0026 | 0,0030 | 0,0034 | 0,0038 | 195 (170 – 220) |
| S3 | E/M/A | 0.0600 | 2.0 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.065 | 0.075 | 0.085 | 0.095 | 40 (30 – 49) |
| | | 0,0600 | 2,0 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0026 | 0,0030 | 0,0034 | 0,0038 | 130 (99 – 160) |
| S11 | E/M/A | 0.100 | 2.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 105 (92 – 110) |
| | | 0,100 | 2,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 345 (310 – 360) |
| S12 | E/M/A | 0.100 | 2.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 80 (71 – 90) |
| | | 0,100 | 2,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 260 (240 – 290) |
| S13 | E/M/A | 0.100 | 2.0 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.095 | 0.10 | 0.12 | 0.13 | 65 (56 – 71) |
| | | 0,100 | 2,0 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0038 | 0,0040 | 0,0048 | 0,0050 | 215 (190 – 230) |
| H5 | M/A | 0.0600 | 2.0 | 0.030 | 0.038 | 0.046 | 0.060 | 0.075 | 0.090 | 0.10 | 0.11 | 0.13 | 0.14 | 125 (64 – 180) |
| | | 0,0600 | 2,0 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 0,0044 | 0,0050 | 0,0055 | 410 (210 – 590) |
| H8 | M/A | 0.0600 | 2.0 | 0.024 | 0.028 | 0.034 | 0.046 | 0.060 | 0.070 | 0.075 | 0.085 | 0.10 | 0.11 | 130 (66 – 190) |
| | | 0,0600 | 2,0 | 0,00095 | 0,0011 | 0,0013 | 0,0018 | 0,0024 | 0,0028 | 0,0030 | 0,0034 | 0,0040 | 0,0044 | 425 (220 – 620) |
| H11 | M/A | 0.0600 | 2.0 | 0.030 | 0.038 | 0.046 | 0.060 | 0.075 | 0.090 | 0.10 | 0.11 | 0.13 | 0.14 | 160 (81 – 240) |
| | | 0,0600 | 2,0 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 0,0044 | 0,0050 | 0,0055 | 520 (270 – 780) |
| H12 | M/A | 0.0600 | 2.0 | 0.024 | 0.028 | 0.034 | 0.046 | 0.060 | 0.070 | 0.075 | 0.085 | 0.10 | 0.11 | 150 (76 – 220) |
| | | 0,0600 | 2,0 | 0,00095 | 0,0011 | 0,0013 | 0,0018 | 0,0024 | 0,0028 | 0,0030 | 0,0034 | 0,0040 | 0,0044 | 490 (250 – 720) |
| H21 | M/A | 0.0600 | 2.0 | 0.024 | 0.028 | 0.034 | 0.046 | 0.060 | 0.070 | 0.075 | 0.085 | 0.10 | 0.11 | 130 (66 – 190) |
| | | 0,0600 | 2,0 | 0,00095 | 0,0011 | 0,0013 | 0,0018 | 0,0024 | 0,0028 | 0,0030 | 0,0034 | 0,0040 | 0,0044 | 425 (220 – 620) |
| H31 | M/A | 0.0600 | 2.0 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.065 | 0.075 | 0.085 | 0.095 | 100 (51 – 150) |
| | | 0,0600 | 2,0 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0026 | 0,0030 | 0,0034 | 0,0038 | 330 (170 – 490) |
| TS1 | A/D | 0.100 | 2.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 500 (450 – 550) |
| | | 0,100 | 2,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 1650 (1500 – 1800) |
| TP1 | A/D | 0.100 | 2.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 395 (350 – 440) |
| | | 0,100 | 2,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 1300 (1200 – 1400) |
| GR1 | A/D | 0.100 | 2.0 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.15 | 500 (450 – 550) |
| | | 0,100 | 2,0 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0060 | 1650 (1500 – 1800) |

Schnittdaten, siehe Seite 561 - 568

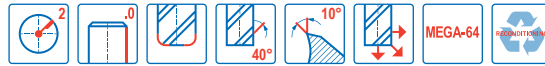
SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

JS522

Hochleistungsfräser – Universell – Eckfräser – 2 Schneiden – Hohe Schulter – Zylindrisch – Eckenradius



D



- Toleranzen:
- Rundlaufabweichung = Ø6-Ø8 <0,01, Ø10-Ø12 <0,015, Ø16-Ø32 <0,02
- DMM = h5
- DC= -0,02/-0,04 mm
- RE= 0,1±0,1 mm, RE= 0,5 ±0,03 mm
- RE= 3,1 ±0,05 mm, RE= 4 ±0,05 mm

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | RE | PCEDC | Zylindrisch |
|------------------------|----------------|--------------|---------------|------|------|-------|-------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | | |
| 522060R010Z2.0-MEGA-64 | 02747756 | 4 | D | 6,0 | 6,0 | 30,0 | 80,0 | 0,1 | 2 | ■ |
| 522080R010Z2.0-MEGA-64 | 02747763 | 4 | D | 8,0 | 8,0 | 40,0 | 85,0 | 0,1 | 2 | ■ |
| 522100R010Z2.0-MEGA-64 | 02747765 | 4 | D | 10,0 | 10,0 | 50,0 | 100,0 | 0,1 | 2 | ■ |
| 522120R010Z2.0-MEGA-64 | 02747766 | 4 | D | 12,0 | 12,0 | 60,0 | 115,0 | 0,1 | 2 | ■ |
| 522160R050Z2.0-MEGA-64 | 02747767 | 4 | D | 16,0 | 16,0 | 80,0 | 150,0 | 0,5 | 2 | ■ |
| 522160R310Z2.0-MEGA-64 | 02747768 | 4 | D | 16,0 | 16,0 | 80,0 | 150,0 | 3,1 | 2 | ■ |
| JS522160D4R600.0Z2-M64 | 03093681 | 4 | D | 16,0 | 16,0 | 80,0 | 150,0 | 6,0 | 2 | ■ |
| 522200R050Z2.0-MEGA-64 | 02747769 | 4 | D | 20,0 | 20,0 | 100,0 | 175,0 | 0,5 | 2 | ■ |
| 522200R310Z2.0-MEGA-64 | 02747770 | 4 | D | 20,0 | 20,0 | 100,0 | 175,0 | 3,1 | 2 | ■ |
| JS522200D4R600.0Z2-M64 | 03093682 | 4 | D | 20,0 | 20,0 | 100,0 | 175,0 | 6,0 | 2 | ■ |
| 522250R050Z2.0-MEGA-64 | 02747771 | 4 | D | 25,0 | 25,0 | 125,0 | 205,0 | 0,5 | 2 | ■ |
| 522250R310Z2.0-MEGA-64 | 02747772 | 4 | D | 25,0 | 25,0 | 125,0 | 205,0 | 3,1 | 2 | ■ |
| 522250R400Z2.0-MEGA-64 | 02747773 | 4 | D | 25,0 | 25,0 | 125,0 | 205,0 | 4,0 | 2 | ■ |
| JS522250D4R600.0Z2-M64 | 03093683 | 4 | D | 25,0 | 25,0 | 125,0 | 205,0 | 6,0 | 2 | ■ |
| 522320R050Z2.0-MEGA-64 | 02747774 | 4 | D | 32,0 | 32,0 | 160,0 | 245,0 | 0,5 | 2 | ■ |
| 522320R400Z2.0-MEGA-64 | 02747775 | 4 | D | 32,0 | 32,0 | 160,0 | 245,0 | 4,0 | 2 | ■ |
| JS522320D4R600.0Z2-M64 | 03093684 | 4 | D | 32,0 | 32,0 | 160,0 | 245,0 | 6,0 | 2 | ■ |

■ Lagerstandard.

*JS522 Schlichtfräser mit langer Schneide sorgt für exzellente Oberflächengüten und Rechtwinkligkeit bei hohen Schultern.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster


Schnittdaten – JS522 Eckfräsen/Vorschlichten

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | | 6 | 8 | 10 | 12 | 16 | 20 | 25 | 32 | |
| P1 | E/M/A | 0.0500 | 4.0 | 0.046 | 0.060 | 0.075 | 0.090 | 0.11 | 0.13 | 0.14 | 0.16 | 160 (140 – 170) |
| | | 0,0500 | 4,0 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0055 | 0,0065 | 520 (460 – 550) |
| P2 | E/M/A | 0.0500 | 4.0 | 0.046 | 0.060 | 0.075 | 0.090 | 0.11 | 0.13 | 0.15 | 0.17 | 155 (140 – 170) |
| | | 0,0500 | 4,0 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 510 (460 – 550) |
| P3 | E/M/A | 0.0500 | 4.0 | 0.044 | 0.060 | 0.075 | 0.085 | 0.11 | 0.12 | 0.14 | 0.16 | 165 (150 – 180) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0024 | 0,0030 | 0,0034 | 0,0044 | 0,0048 | 0,0055 | 0,0065 | 540 (500 – 590) |
| P4 | E/M/A | 0.0500 | 4.0 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.14 | 0.15 | 145 (130 – 160) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0055 | 0,0060 | 475 (430 – 520) |
| P5 | E/M/A | 0.0500 | 4.0 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 0.15 | 140 (130 – 160) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 460 (430 – 520) |
| P6 | E/M/A | 0.0500 | 4.0 | 0.042 | 0.055 | 0.070 | 0.080 | 0.10 | 0.12 | 0.13 | 0.15 | 120 (110 – 140) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0032 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 395 (370 – 450) |
| P7 | E/M/A | 0.0500 | 4.0 | 0.042 | 0.055 | 0.070 | 0.080 | 0.10 | 0.12 | 0.13 | 0.15 | 115 (95 – 130) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0032 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 375 (320 – 420) |
| P8 | E/M/A | 0.0500 | 4.0 | 0.044 | 0.060 | 0.075 | 0.085 | 0.11 | 0.12 | 0.14 | 0.16 | 105 (89 – 120) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0024 | 0,0030 | 0,0034 | 0,0044 | 0,0048 | 0,0055 | 0,0065 | 345 (300 – 390) |
| P11 | E/M/A | 0.0500 | 4.0 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 0.20 | 0.22 | 105 (87 – 120) |
| | | 0,0500 | 4,0 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0080 | 0,0085 | 345 (290 – 390) |
| P12 | E/M/A | 0.0500 | 4.0 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 0.15 | 65 (55 – 75) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 215 (190 – 240) |
| M1 | E/M/A | 0.0500 | 4.0 | 0.046 | 0.060 | 0.075 | 0.090 | 0.11 | 0.13 | 0.15 | 0.17 | 110 (86 – 130) |
| | | 0,0500 | 4,0 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 360 (290 – 420) |
| M2 | E/M/A | 0.0500 | 4.0 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 0.15 | 90 (71 – 110) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 295 (240 – 360) |
| M3 | E/M/A | 0.0500 | 4.0 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 0.15 | 80 (61 – 100) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 260 (210 – 320) |
| M4 | E/M/A | 0.0500 | 4.0 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 0.12 | 0.13 | 60 (47 – 76) |
| | | 0,0500 | 4,0 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0048 | 0,0050 | 195 (160 – 240) |
| M5 | E/M/A | 0.0500 | 4.0 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 0.12 | 0.13 | 50 (39 – 63) |
| | | 0,0500 | 4,0 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0048 | 0,0050 | 165 (130 – 200) |
| K1 | E/M/A | 0.0500 | 4.0 | 0.046 | 0.060 | 0.075 | 0.090 | 0.11 | 0.13 | 0.15 | 0.17 | 120 (100 – 130) |
| | | 0,0500 | 4,0 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 395 (330 – 420) |
| K2 | E/M/A | 0.0500 | 4.0 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 0.15 | 105 (87 – 120) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 345 (290 – 390) |
| K3 | E/M/A | 0.0500 | 4.0 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 0.15 | 90 (74 – 100) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 295 (250 – 320) |
| K4 | E/M/A | 0.0500 | 4.0 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 0.15 | 85 (71 – 98) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 280 (240 – 320) |
| K5 | E/M/A | 0.0500 | 4.0 | 0.038 | 0.050 | 0.065 | 0.075 | 0.090 | 0.11 | 0.12 | 0.14 | 100 (81 – 120) |
| | | 0,0500 | 4,0 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 0,0036 | 0,0044 | 0,0048 | 0,0055 | 330 (270 – 390) |
| K6 | E/M/A | 0.0500 | 4.0 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 0.15 | 150 (120 – 170) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 490 (400 – 550) |
| K7 | E/M/A | 0.0500 | 4.0 | 0.038 | 0.050 | 0.065 | 0.075 | 0.090 | 0.11 | 0.12 | 0.14 | 130 (110 – 150) |
| | | 0,0500 | 4,0 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 0,0036 | 0,0044 | 0,0048 | 0,0055 | 425 (370 – 490) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – JS522 Eckfräsen/Vorschlichten

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 6 | 8 | 10 | 12 | 16 | 20 | 25 | 32 | |
| N1 | E/M/A | 0.0500 | 4.0 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 0.15 | 400 (310 – 500) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 1300 (1100 – 1600) |
| N2 | E/M/A | 0.0500 | 4.0 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 0.15 | 300 (210 – 400) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 980 (690 – 1300) |
| N3 | E/M/A | 0.0500 | 4.0 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 0.15 | 200 (140 – 260) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 660 (460 – 850) |
| N11 | E/M/A | 0.0500 | 4.0 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 0.15 | 300 (260 – 350) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 980 (860 – 1100) |
| S1 | E/M/A | 0.0500 | 4.0 | 0.018 | 0.024 | 0.030 | 0.036 | 0.044 | 0.050 | 0.055 | 0.065 | 48 (39 – 57) |
| | | 0,0500 | 4,0 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0017 | 0,0020 | 0,0022 | 0,0026 | 155 (130 – 180) |
| S2 | E/M/A | 0.0500 | 4.0 | 0.018 | 0.024 | 0.030 | 0.036 | 0.044 | 0.050 | 0.055 | 0.065 | 39 (31 – 46) |
| | | 0,0500 | 4,0 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0017 | 0,0020 | 0,0022 | 0,0026 | 130 (110 – 150) |
| S3 | E/M/A | 0.0300 | 4.0 | 0.018 | 0.024 | 0.030 | 0.036 | 0.044 | 0.050 | 0.055 | 0.065 | 42 (32 – 51) |
| | | 0,0300 | 4,0 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0017 | 0,0020 | 0,0022 | 0,0026 | 140 (110 – 160) |
| S11 | E/M/A | 0.0500 | 4.0 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 0.15 | 125 (100 – 140) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 410 (330 – 450) |
| S12 | E/M/A | 0.0500 | 4.0 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 0.15 | 95 (77 – 110) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 310 (260 – 360) |
| S13 | E/M/A | 0.0500 | 4.0 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 0.12 | 0.13 | 75 (61 – 90) |
| | | 0,0500 | 4,0 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0048 | 0,0050 | 245 (210 – 290) |
| TS1 | A/D | 0.0500 | 4.0 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 0.15 | 500 (410 – 600) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 1650 (1400 – 1900) |
| TP1 | A/D | 0.0500 | 4.0 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 0.15 | 400 (310 – 500) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 1300 (1100 – 1600) |
| GR1 | A/D | 0.0500 | 4.0 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 0.15 | 500 (410 – 600) |
| | | 0,0500 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 1650 (1400 – 1900) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

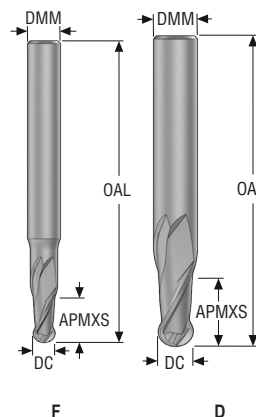
X-Heads

Minimaster Plus

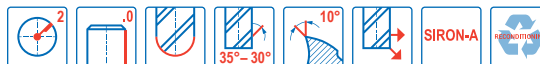
Minimaster

JSB512

Allgemeine Anwendung – Universell – Kugelkopf – 2 Schneiden – Zylindrisch



- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø10 ist



| Bezeichnung | Beschichtung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | PCEDC | Zylindrisch |
|------------------|--------------|--------------------|------------------|-------------------|------|------|-------|------|-------|-------------|
| | | | | | mm | mm | mm | mm | | |
| JSB512020F2B.0Z2 | SIRA | 10053561 | 2 | F | 2,0 | 3,0 | 3,0 | 40,0 | 2 | ■ |
| JSB512030D2B.0Z2 | SIRA | 10053562 | 2 | D | 3,0 | 3,0 | 5,0 | 40,0 | 2 | ■ |
| JSB512040D2B.0Z2 | SIRA | 10053563 | 2 | D | 4,0 | 4,0 | 6,0 | 50,0 | 2 | ■ |
| JSB512050F2B.0Z2 | SIRA | 10053564 | 2 | F | 5,0 | 6,0 | 8,0 | 57,0 | 2 | ■ |
| JSB512060D2B.0Z2 | SIRA | 10053565 | 2 | D | 6,0 | 6,0 | 9,0 | 57,0 | 2 | ■ |
| JSB512080D2B.0Z2 | SIRA | 10053566 | 2 | D | 8,0 | 8,0 | 12,0 | 63,0 | 2 | ■ |
| JSB512100D2B.0Z2 | SIRA | 10053567 | 2 | D | 10,0 | 10,0 | 15,0 | 72,0 | 2 | ■ |
| JSB512120D2B.0Z2 | SIRA | 10053568 | 2 | D | 12,0 | 12,0 | 18,0 | 83,0 | 2 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite


Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JSB512 Kopierfräsen/Schruppen

| SMG |  | a _p /DC | a _p /DC | f _z | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|--------|--------|--------|--------|--------|--------------------|
| | | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | |
| P1 | M/A/D/E | 0.150 | 1.2 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.042 | 0.050 | 0.060 | 150 (63 – 180) |
| | | 0,150 | 1,2 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0017 | 0,0020 | 0,0024 | 490 (210 – 590) |
| P2 | M/A/D/E | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 150 (63 – 180) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 490 (210 – 590) |
| P3 | M/A/D/E | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 150 (63 – 180) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 490 (210 – 590) |
| P4 | M/A/D/E | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 150 (63 – 180) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 490 (210 – 590) |
| P5 | M/A/D/E | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 150 (63 – 180) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 490 (210 – 590) |
| P6 | M/A/D/E | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 150 (63 – 180) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 490 (210 – 590) |
| P7 | M/A/D/E | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 150 (63 – 180) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 490 (210 – 590) |
| P8 | M/A/D/E | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 150 (63 – 180) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 490 (210 – 590) |
| P11 | M/A/D/E | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 90 (63 – 120) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 295 (210 – 390) |
| P12 | M/A/D/E | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 90 (63 – 120) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 295 (210 – 390) |
| M1 | E/M/A | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 90 (63 – 120) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 295 (210 – 390) |
| M2 | E/M/A | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 90 (63 – 120) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 295 (210 – 390) |
| M3 | E/M/A | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 90 (63 – 120) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 295 (210 – 390) |
| M4 | E/M/A | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 90 (63 – 120) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 295 (210 – 390) |
| M5 | E/M/A | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 90 (63 – 120) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 295 (210 – 390) |
| K1 | A/D/M/E | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 150 (63 – 180) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 490 (210 – 590) |
| K2 | A/D/M/E | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 150 (63 – 180) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 490 (210 – 590) |
| K3 | A/D/M/E | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 150 (63 – 180) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 490 (210 – 590) |
| K4 | A/D/M/E | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 150 (63 – 180) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 490 (210 – 590) |
| K5 | A/D/M/E | 0.150 | 1.2 | 0.012 | 0.018 | 0.025 | 0.030 | 0.036 | 0.050 | 0.060 | 0.070 | 145 (61 – 180) |
| | | 0,150 | 1,2 | 0,00048 | 0,00070 | 0,0010 | 0,0012 | 0,0014 | 0,0020 | 0,0024 | 0,0028 | 475 (210 – 590) |
| K6 | A/D/M/E | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 150 (63 – 180) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 490 (210 – 590) |
| K7 | A/D/M/E | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 150 (63 – 180) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 490 (210 – 590) |
| N1 | E/M/A | 0.150 | 1.2 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.042 | 0.050 | 0.060 | 500 (380 – 620) |
| | | 0,150 | 1,2 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0017 | 0,0020 | 0,0024 | 1650 (1300 – 2000) |
| N11 | E/M/A | 0.150 | 1.2 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.042 | 0.050 | 0.060 | 375 (260 – 500) |
| | | 0,150 | 1,2 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0017 | 0,0020 | 0,0024 | 1225 (860 – 1600) |
| S11 | E | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 90 (66 – 130) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 295 (220 – 420) |
| S12 | E | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 90 (63 – 120) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 295 (210 – 390) |
| S13 | E | 0.150 | 1.2 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 90 (63 – 120) |
| | | 0,150 | 1,2 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 295 (210 – 390) |

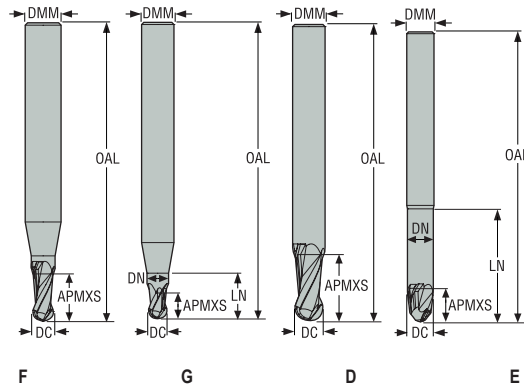
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

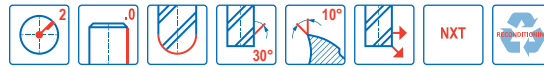
Universell
Stahl und Guss
Stahlfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

JS532

Hochleistungsfräser – Universell – Kugelkopf – 2 Schneiden – Zylindrisch



- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|------|------|-------|-------|-------|------|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS532010F1B.0Z2-NXT | 02928193 | 1 | F | 1,0 | 3,0 | 2,0 | 38,0 | 3,1 | 1,0 | 0,5 | 2 | ■ |
| JS532015F1B.0Z2-NXT | 02928194 | 1 | F | 1,5 | 3,0 | 3,0 | 38,0 | 4,6 | 1,5 | 0,75 | 2 | ■ |
| JS532020F1B.0Z2-NXT | 02928195 | 1 | F | 2,0 | 3,0 | 4,0 | 38,0 | 6,1 | 2,0 | 1,0 | 2 | ■ |
| JS532025F1B.0Z2-NXT | 02928197 | 1 | F | 2,5 | 3,0 | 5,0 | 38,0 | 7,1 | 2,5 | 1,25 | 2 | ■ |
| JS532030D1B.0Z2-NXT | 02928199 | 1 | D | 3,0 | 3,0 | 6,0 | 38,0 | – | – | 1,5 | 2 | ■ |
| JS532035F1B.0Z2-NXT | 02928202 | 1 | F | 3,5 | 6,0 | 7,0 | 57,0 | 9,6 | 3,5 | 1,75 | 2 | ■ |
| JS532040F1B.0Z2-NXT | 02928203 | 1 | F | 4,0 | 6,0 | 8,0 | 57,0 | 10,75 | 4,0 | 2,0 | 2 | ■ |
| JS532045F1B.0Z2-NXT | 02928206 | 1 | F | 4,5 | 6,0 | 9,0 | 57,0 | 11,75 | 4,5 | 2,25 | 2 | ■ |
| JS532050F1B.0Z2-NXT | 02928207 | 1 | F | 5,0 | 6,0 | 10,0 | 57,0 | 12,75 | 5,0 | 2,5 | 2 | ■ |
| JS532060D1B.0Z2-NXT | 02928210 | 1 | D | 6,0 | 6,0 | 12,0 | 57,0 | – | – | 3,0 | 2 | ■ |
| JS532080D1B.0Z2-NXT | 02928213 | 1 | D | 8,0 | 8,0 | 16,0 | 63,0 | – | – | 4,0 | 2 | ■ |
| JS532100D1B.0Z2-NXT | 02928216 | 1 | D | 10,0 | 10,0 | 20,0 | 72,0 | – | – | 5,0 | 2 | ■ |
| JS532120D1B.0Z2-NXT | 02928219 | 1 | D | 12,0 | 12,0 | 24,0 | 83,0 | – | – | 6,0 | 2 | ■ |
| JS532160D1B.0Z2-NXT | 02928222 | 1 | D | 16,0 | 16,0 | 32,0 | 92,0 | – | – | 8,0 | 2 | ■ |
| JS532200D1B.0Z2-NXT | 02928225 | 1 | D | 20,0 | 20,0 | 40,0 | 104,0 | – | – | 10,0 | 2 | ■ |
| JS532020G2B.0Z2-NXT | 02928196 | 2 | G | 2,0 | 3,0 | 2,0 | 38,0 | 8,0 | 1,9 | 1,0 | 2 | ■ |
| JS532030E2B.0Z2-NXT | 02928200 | 2 | E | 3,0 | 3,0 | 3,0 | 38,0 | 10,0 | 2,85 | 1,5 | 2 | ■ |
| JS532040G2B.0Z2-NXT | 02928204 | 2 | G | 4,0 | 6,0 | 4,0 | 57,0 | 15,0 | 3,8 | 2,0 | 2 | ■ |
| JS532050G2B.0Z2-NXT | 02928208 | 2 | G | 5,0 | 6,0 | 5,0 | 57,0 | 20,0 | 4,8 | 2,5 | 2 | ■ |
| JS532060E2B.0Z2-NXT | 02928211 | 2 | E | 6,0 | 6,0 | 6,0 | 63,0 | 25,0 | 5,7 | 3,0 | 2 | ■ |
| JS532080E2B.0Z2-NXT | 02928214 | 2 | E | 8,0 | 8,0 | 8,0 | 80,0 | 35,0 | 7,6 | 4,0 | 2 | ■ |
| JS532100E2B.0Z2-NXT | 02928217 | 2 | E | 10,0 | 10,0 | 10,0 | 82,0 | 40,0 | 9,5 | 5,0 | 2 | ■ |
| JS532120E2B.0Z2-NXT | 02928220 | 2 | E | 12,0 | 12,0 | 12,0 | 100,0 | 50,0 | 11,4 | 6,0 | 2 | ■ |
| JS532160E2B.0Z2-NXT | 02928223 | 2 | E | 16,0 | 16,0 | 16,0 | 125,0 | 72,0 | 15,2 | 8,0 | 2 | ■ |
| JS532030E3B.0Z2-NXT | 02928201 | 3 | E | 3,0 | 3,0 | 3,0 | 52,0 | 20,0 | 2,85 | 1,5 | 2 | ■ |
| JS532040G3B.0Z2-NXT | 02928205 | 3 | G | 4,0 | 6,0 | 4,0 | 63,0 | 24,0 | 3,8 | 2,0 | 2 | ■ |
| JS532050G3B.0Z2-NXT | 02928209 | 3 | G | 5,0 | 6,0 | 5,0 | 75,0 | 35,0 | 4,8 | 2,5 | 2 | ■ |
| JS532060E3B.0Z2-NXT | 02928212 | 3 | E | 6,0 | 6,0 | 6,0 | 80,0 | 42,0 | 5,7 | 3,0 | 2 | ■ |
| JS532080E3B.0Z2-NXT | 02928215 | 3 | E | 8,0 | 8,0 | 8,0 | 100,0 | 60,0 | 7,6 | 4,0 | 2 | ■ |
| JS532100E3B.0Z2-NXT | 02928218 | 3 | E | 10,0 | 10,0 | 10,0 | 125,0 | 80,0 | 9,5 | 5,0 | 2 | ■ |
| JS532120E3B.0Z2-NXT | 02928221 | 3 | E | 12,0 | 12,0 | 12,0 | 125,0 | 75,0 | 11,4 | 6,0 | 2 | ■ |
| JS532160E3B.0Z2-NXT | 02928224 | 3 | E | 16,0 | 16,0 | 16,0 | 150,0 | 100,0 | 15,2 | 8,0 | 2 | ■ |

■ Lagerstandard.

Universell

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ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und
Composite

Graphit

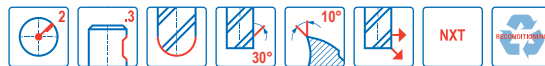
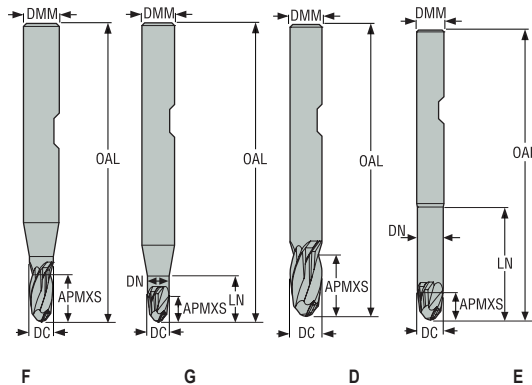
X-Heads

Minimaster Plus

Minimaster

JS532

Hochleistungsfräser – Universell – Kugelkopf – 2 Schneiden – Weldon



- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Weldon |
|---------------------|----------------|--------------|---------------|------|------|-------|-------|-------|------|------|-------|--------------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | |
| JS532035F1B.3Z2-NXT | 02928254 | 1 | F | 3,5 | 6,0 | 7,0 | 57,0 | 9,6 | 3,5 | 1,75 | 2 | <input type="checkbox"/> |
| JS532040F1B.3Z2-NXT | 02928255 | 1 | F | 4,0 | 6,0 | 8,0 | 57,0 | 10,75 | 4,0 | 2,0 | 2 | <input type="checkbox"/> |
| JS532045F1B.3Z2-NXT | 02928258 | 1 | F | 4,5 | 6,0 | 9,0 | 57,0 | 11,75 | 4,5 | 2,25 | 2 | <input type="checkbox"/> |
| JS532050F1B.3Z2-NXT | 02928259 | 1 | F | 5,0 | 6,0 | 10,0 | 57,0 | 12,75 | 5,0 | 2,5 | 2 | <input type="checkbox"/> |
| JS532060D1B.3Z2-NXT | 02928263 | 1 | D | 6,0 | 6,0 | 12,0 | 57,0 | – | – | 3,0 | 2 | <input type="checkbox"/> |
| JS532080D1B.3Z2-NXT | 02928266 | 1 | D | 8,0 | 8,0 | 16,0 | 63,0 | – | – | 4,0 | 2 | <input type="checkbox"/> |
| JS532100D1B.3Z2-NXT | 02928269 | 1 | D | 10,0 | 10,0 | 20,0 | 72,0 | – | – | 5,0 | 2 | <input type="checkbox"/> |
| JS532120D1B.3Z2-NXT | 02928272 | 1 | D | 12,0 | 12,0 | 24,0 | 83,0 | – | – | 6,0 | 2 | <input type="checkbox"/> |
| JS532160D1B.3Z2-NXT | 02928275 | 1 | D | 16,0 | 16,0 | 32,0 | 92,0 | – | – | 8,0 | 2 | <input type="checkbox"/> |
| JS532200D1B.3Z2-NXT | 02928278 | 1 | D | 20,0 | 20,0 | 40,0 | 104,0 | – | – | 10,0 | 2 | <input type="checkbox"/> |
| JS532040G2B.3Z2-NXT | 02928256 | 2 | G | 4,0 | 6,0 | 4,0 | 57,0 | 18,0 | 3,8 | 2,0 | 2 | <input type="checkbox"/> |
| JS532050G2B.3Z2-NXT | 02928260 | 2 | G | 5,0 | 6,0 | 5,0 | 57,0 | 18,0 | 4,8 | 2,5 | 2 | <input type="checkbox"/> |
| JS532060E2B.3Z2-NXT | 02928264 | 2 | E | 6,0 | 6,0 | 6,0 | 63,0 | 25,0 | 5,7 | 3,0 | 2 | <input type="checkbox"/> |
| JS532080E2B.3Z2-NXT | 02928267 | 2 | E | 8,0 | 8,0 | 8,0 | 80,0 | 35,0 | 7,6 | 4,0 | 2 | <input type="checkbox"/> |
| JS532100E2B.3Z2-NXT | 02928270 | 2 | E | 10,0 | 10,0 | 10,0 | 82,0 | 40,0 | 9,5 | 5,0 | 2 | <input type="checkbox"/> |
| JS532120E2B.3Z2-NXT | 02928273 | 2 | E | 12,0 | 12,0 | 12,0 | 100,0 | 50,0 | 11,4 | 6,0 | 2 | <input type="checkbox"/> |
| JS532160E2B.3Z2-NXT | 02928276 | 2 | E | 16,0 | 16,0 | 16,0 | 125,0 | 70,0 | 15,2 | 8,0 | 2 | <input type="checkbox"/> |
| JS532040G3B.3Z2-NXT | 02928257 | 3 | G | 4,0 | 6,0 | 4,0 | 63,0 | 24,0 | 3,8 | 2,0 | 2 | <input type="checkbox"/> |
| JS532050G3B.3Z2-NXT | 02928261 | 3 | G | 5,0 | 6,0 | 5,0 | 75,0 | 35,0 | 4,8 | 2,5 | 2 | <input type="checkbox"/> |
| JS532060E3B.3Z2-NXT | 02928265 | 3 | E | 6,0 | 6,0 | 6,0 | 80,0 | 42,0 | 5,7 | 3,0 | 2 | <input type="checkbox"/> |
| JS532080E3B.3Z2-NXT | 02928268 | 3 | E | 8,0 | 8,0 | 8,0 | 100,0 | 60,0 | 7,6 | 4,0 | 2 | <input type="checkbox"/> |
| JS532100E3B.3Z2-NXT | 02928271 | 3 | E | 10,0 | 10,0 | 10,0 | 125,0 | 80,0 | 9,5 | 5,0 | 2 | <input type="checkbox"/> |
| JS532120E3B.3Z2-NXT | 02928274 | 3 | E | 12,0 | 12,0 | 12,0 | 125,0 | 75,0 | 11,4 | 6,0 | 2 | <input type="checkbox"/> |
| JS532160E3B.3Z2-NXT | 02928277 | 3 | E | 16,0 | 16,0 | 16,0 | 150,0 | 100,0 | 15,2 | 8,0 | 2 | <input type="checkbox"/> |

Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JS532 Kopierfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|---------|---------|---------|---------|--------|--------|--------|--------|--------|--------|-----------------|----------------|
| | | | | 1 | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | | |
| P1 | M/A/D/E | 0.200 | 0.20 | 0.0060 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.11 | 205 (140 – 180) | |
| | | 0,200 | 0,20 | 0,00024 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0044 | 670 (460 – 590) | |
| P2 | M/A/D/E | 0.200 | 0.20 | 0.0060 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.11 | 200 (130 – 180) | |
| | | 0,200 | 0,20 | 0,00024 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0044 | 660 (430 – 590) | |
| P3 | M/A/D/E | 0.200 | 0.20 | 0.0060 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.11 | 170 (110 – 150) | |
| | | 0,200 | 0,20 | 0,00024 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0044 | 560 (370 – 490) | |
| P4 | M/A/D/E | 0.200 | 0.20 | 0.0060 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.10 | 150 (97 – 130) | |
| | | 0,200 | 0,20 | 0,00024 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0040 | 490 (320 – 420) | |
| P5 | M/A/D/E | 0.200 | 0.20 | 0.0060 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 145 (93 – 130) | |
| | | 0,200 | 0,20 | 0,00024 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 475 (310 – 420) | |
| P6 | M/A/D/E | 0.200 | 0.20 | 0.0060 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 160 (110 – 140) | |
| | | 0,200 | 0,20 | 0,00024 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 520 (370 – 450) | |
| P7 | M/A/D/E | 0.200 | 0.20 | 0.0060 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 150 (98 – 140) | |
| | | 0,200 | 0,20 | 0,00024 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 490 (330 – 450) | |
| P8 | M/A/D/E | 0.200 | 0.20 | 0.0060 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.11 | 145 (93 – 130) | |
| | | 0,200 | 0,20 | 0,00024 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0044 | 475 (310 – 420) | |
| P11 | M/A/D/E | 0.100 | 0.10 | 0.0060 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 170 (110 – 150) | |
| | | 0,100 | 0,10 | 0,00024 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 560 (370 – 490) | |
| P12 | M/A/D/E | 0.100 | 0.10 | 0.0060 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 100 (64 – 92) | |
| | | 0,100 | 0,10 | 0,00024 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 330 (210 – 300) | |
| M1 | E | 0.100 | 0.10 | 0.0060 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 195 (170 – 220) | |
| | | 0,100 | 0,10 | 0,00024 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 640 (560 – 720) | |
| M2 | E | 0.100 | 0.10 | 0.0060 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 115 (93 – 130) | |
| | | 0,100 | 0,10 | 0,00024 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 375 (310 – 420) | |
| M3 | E | 0.100 | 0.10 | 0.0050 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.095 | 95 (73 – 110) | |
| | | 0,100 | 0,10 | 0,00020 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0038 | 310 (240 – 360) | |
| M4 | E | 0.100 | 0.10 | 0.0048 | 0.0095 | 0.014 | 0.019 | 0.024 | 0.028 | 0.038 | 0.048 | 0.055 | 0.070 | 0.080 | 70 (55 – 85) | |
| | | 0,100 | 0,10 | 0,00019 | 0,00038 | 0,00055 | 0,00075 | 0,00095 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 230 (190 – 270) | |
| M5 | E | 0.100 | 0.10 | 0.0048 | 0.0095 | 0.014 | 0.019 | 0.024 | 0.028 | 0.038 | 0.048 | 0.055 | 0.070 | 0.080 | 60 (46 – 71) | |
| | | 0,100 | 0,10 | 0,00019 | 0,00038 | 0,00055 | 0,00075 | 0,00095 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 195 (160 – 230) | |
| K1 | E | 0.200 | 0.20 | 0.0060 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 195 (180 – 210) | |
| | | 0,200 | 0,20 | 0,00024 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 640 (600 – 680) | |
| K2 | E | 0.200 | 0.20 | 0.0055 | 0.011 | 0.016 | 0.022 | 0.028 | 0.032 | 0.044 | 0.055 | 0.065 | 0.085 | 0.095 | 170 (160 – 180) | |
| | | 0,200 | 0,20 | 0,00022 | 0,00044 | 0,00065 | 0,00085 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0034 | 0,0038 | 560 (530 – 590) | |
| K3 | E | 0.200 | 0.20 | 0.0055 | 0.011 | 0.016 | 0.022 | 0.028 | 0.032 | 0.044 | 0.055 | 0.065 | 0.085 | 0.095 | 145 (130 – 150) | |
| | | 0,200 | 0,20 | 0,00022 | 0,00044 | 0,00065 | 0,00085 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0034 | 0,0038 | 475 (430 – 490) | |
| K4 | E | 0.200 | 0.20 | 0.0055 | 0.011 | 0.016 | 0.022 | 0.028 | 0.032 | 0.044 | 0.055 | 0.065 | 0.085 | 0.095 | 140 (130 – 150) | |
| | | 0,200 | 0,20 | 0,00022 | 0,00044 | 0,00065 | 0,00085 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0034 | 0,0038 | 460 (430 – 490) | |
| K5 | E | 0.100 | 0.10 | 0.0050 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.095 | 165 (150 – 180) | |
| | | 0,100 | 0,10 | 0,00020 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0038 | 540 (500 – 590) | |
| K6 | E | 0.100 | 0.10 | 0.0050 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 245 (220 – 270) | |
| | | 0,100 | 0,10 | 0,00020 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 800 (730 – 880) | |
| K7 | E | 0.100 | 0.10 | 0.0050 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.095 | 210 (190 – 230) | |
| | | 0,100 | 0,10 | 0,00020 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0038 | 690 (630 – 750) | |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)


f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Schnittdaten – JS532 Kopierfräsen/Schruppen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|---------|---------|---------|--------|--------|--------|--------|--------|--------------------|
| | | | | 1 | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| N1 | E | 0.200 | 0.30 | 0.0080 | 0.016 | 0.024 | 0.032 | 0.038 | 0.046 | 0.060 | 0.080 | 0.095 | 0.11 | 0.13 | 610 (520 – 710) |
| | | 0,200 | 0,30 | 0,00032 | 0,00065 | 0,00095 | 0,0013 | 0,0015 | 0,0018 | 0,0024 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 2000 (1800 – 2300) |
| N2 | E | 0.200 | 0.30 | 0.0080 | 0.016 | 0.024 | 0.032 | 0.038 | 0.046 | 0.060 | 0.080 | 0.095 | 0.11 | 0.13 | 395 (330 – 450) |
| | | 0,200 | 0,30 | 0,00032 | 0,00065 | 0,00095 | 0,0013 | 0,0015 | 0,0018 | 0,0024 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 1300 (1100 – 1400) |
| N3 | E | 0.200 | 0.30 | 0.0080 | 0.016 | 0.024 | 0.032 | 0.038 | 0.046 | 0.060 | 0.080 | 0.095 | 0.11 | 0.13 | 260 (220 – 300) |
| | | 0,200 | 0,30 | 0,00032 | 0,00065 | 0,00095 | 0,0013 | 0,0015 | 0,0018 | 0,0024 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 850 (730 – 980) |
| N11 | E | 0.200 | 0.30 | 0.0050 | 0.010 | 0.016 | 0.020 | 0.026 | 0.032 | 0.040 | 0.050 | 0.060 | 0.075 | 0.090 | 415 (370 – 460) |
| | | 0,200 | 0,30 | 0,00020 | 0,00040 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 1350 (1300 – 1500) |
| S1 | E | 0.150 | 0.10 | 0.0040 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 60 (52 – 72) |
| | | 0,150 | 0,10 | 0,00016 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 195 (180 – 230) |
| S2 | E | 0.150 | 0.10 | 0.0040 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 50 (42 – 58) |
| | | 0,150 | 0,10 | 0,00016 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 165 (140 – 190) |
| S3 | E | 0.100 | 0.10 | 0.0036 | 0.0070 | 0.010 | 0.014 | 0.018 | 0.020 | 0.028 | 0.036 | 0.042 | 0.055 | 0.060 | 32 (22 – 42) |
| | | 0,100 | 0,10 | 0,00014 | 0,00028 | 0,00040 | 0,00055 | 0,00070 | 0,00080 | 0,0011 | 0,0014 | 0,0017 | 0,0022 | 0,0024 | 105 (73 – 130) |
| S11 | E | 0.200 | 0.20 | 0.0060 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 105 (94 – 110) |
| | | 0,200 | 0,20 | 0,00024 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 345 (310 – 360) |
| S12 | E | 0.200 | 0.20 | 0.0060 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 80 (72 – 92) |
| | | 0,200 | 0,20 | 0,00024 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 260 (240 – 300) |
| S13 | E | 0.200 | 0.20 | 0.0055 | 0.011 | 0.016 | 0.022 | 0.026 | 0.032 | 0.042 | 0.055 | 0.060 | 0.080 | 0.090 | 65 (57 – 72) |
| | | 0,200 | 0,20 | 0,00022 | 0,00044 | 0,00065 | 0,00085 | 0,0010 | 0,0013 | 0,0017 | 0,0022 | 0,0024 | 0,0032 | 0,0036 | 215 (190 – 230) |
| TS1 | A | 0.200 | 0.40 | 0.0075 | 0.015 | 0.024 | 0.030 | 0.038 | 0.046 | 0.065 | 0.075 | 0.090 | 0.12 | 0.13 | 610 (570 – 660) |
| | | 0,200 | 0,40 | 0,00030 | 0,00060 | 0,00095 | 0,0012 | 0,0015 | 0,0018 | 0,0026 | 0,0030 | 0,0036 | 0,0048 | 0,0050 | 2000 (1900 – 2100) |
| TP1 | A | 0.200 | 0.40 | 0.0075 | 0.015 | 0.024 | 0.030 | 0.038 | 0.046 | 0.065 | 0.075 | 0.090 | 0.12 | 0.13 | 610 (570 – 660) |
| | | 0,200 | 0,40 | 0,00030 | 0,00060 | 0,00095 | 0,0012 | 0,0015 | 0,0018 | 0,0026 | 0,0030 | 0,0036 | 0,0048 | 0,0050 | 2000 (1900 – 2100) |
| GR1 | A | 0.200 | 0.40 | 0.0075 | 0.015 | 0.024 | 0.030 | 0.038 | 0.046 | 0.065 | 0.075 | 0.090 | 0.12 | 0.13 | 610 (570 – 660) |
| | | 0,200 | 0,40 | 0,00030 | 0,00060 | 0,00095 | 0,0012 | 0,0015 | 0,0018 | 0,0026 | 0,0030 | 0,0036 | 0,0048 | 0,0050 | 2000 (1900 – 2100) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

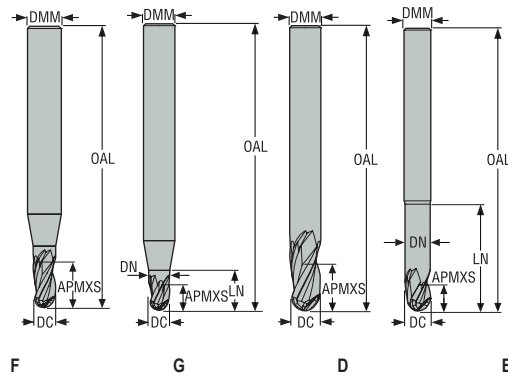
X-Heads

Minimaster Plus

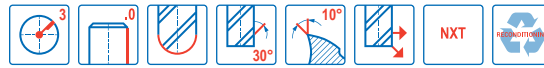
Minimaster

JS533

Hochleistungsfräser – Universell – Kugelkopf – 3 Schneiden – Zylindrisch



- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|------|------|-------|-------|-------|------|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS533010F1B.0Z3-NXT | 02928284 | 1 | F | 1,0 | 3,0 | 2,0 | 38,0 | 3,0 | 1,05 | 0,5 | 3 | ■ |
| JS533015F1B.0Z3-NXT | 02928286 | 1 | F | 1,5 | 3,0 | 3,0 | 38,0 | 4,6 | 1,55 | 0,75 | 3 | ■ |
| JS533020F1B.0Z3-NXT | 02928287 | 1 | F | 2,0 | 3,0 | 4,0 | 38,0 | 5,6 | 2,05 | 1,0 | 3 | ■ |
| JS533030D1B.0Z3-NXT | 02928289 | 1 | D | 3,0 | 3,0 | 6,0 | 38,0 | – | – | 1,5 | 3 | ■ |
| JS533040F1B.0Z3-NXT | 02928291 | 1 | F | 4,0 | 6,0 | 8,0 | 57,0 | 10,75 | 4,05 | 2,0 | 3 | ■ |
| JS533050F1B.0Z3-NXT | 02928293 | 1 | F | 5,0 | 6,0 | 10,0 | 57,0 | 13,75 | 5,05 | 2,5 | 3 | ■ |
| JS533060D1B.0Z3-NXT | 02928295 | 1 | D | 6,0 | 6,0 | 12,0 | 57,0 | – | – | 3,0 | 3 | ■ |
| JS533080D1B.0Z3-NXT | 02928297 | 1 | D | 8,0 | 8,0 | 16,0 | 63,0 | – | – | 4,0 | 3 | ■ |
| JS533100D1B.0Z3-NXT | 02928299 | 1 | D | 10,0 | 10,0 | 20,0 | 72,0 | – | – | 5,0 | 3 | ■ |
| JS533120D1B.0Z3-NXT | 02928301 | 1 | D | 12,0 | 12,0 | 24,0 | 83,0 | – | – | 6,0 | 3 | ■ |
| JS533160D1B.0Z3-NXT | 02928303 | 1 | D | 16,0 | 16,0 | 32,0 | 110,0 | – | – | 8,0 | 3 | ■ |
| JS533200D1B.0Z3-NXT | 02928305 | 1 | D | 20,0 | 20,0 | 40,0 | 125,0 | – | – | 10,0 | 3 | ■ |
| JS533020G2B.0Z3-NXT | 02928288 | 2 | G | 2,0 | 3,0 | 2,0 | 38,0 | 7,0 | 1,9 | 1,0 | 3 | ■ |
| JS533030E2B.0Z3-NXT | 02928290 | 2 | E | 3,0 | 3,0 | 3,0 | 38,0 | 9,0 | 2,85 | 1,5 | 3 | ■ |
| JS533040G2B.0Z3-NXT | 02928292 | 2 | G | 4,0 | 6,0 | 4,0 | 57,0 | 15,0 | 3,8 | 2,0 | 3 | ■ |
| JS533050G2B.0Z3-NXT | 02928294 | 2 | G | 5,0 | 6,0 | 5,0 | 57,0 | 15,0 | 4,8 | 2,5 | 3 | ■ |
| JS533060E2B.0Z3-NXT | 02928296 | 2 | E | 6,0 | 6,0 | 6,0 | 63,0 | 25,0 | 5,7 | 3,0 | 3 | ■ |
| JS533080E2B.0Z3-NXT | 02928298 | 2 | E | 8,0 | 8,0 | 8,0 | 80,0 | 35,0 | 7,6 | 4,0 | 3 | ■ |
| JS533100E2B.0Z3-NXT | 02928300 | 2 | E | 10,0 | 10,0 | 10,0 | 89,0 | 40,0 | 9,5 | 5,0 | 3 | ■ |
| JS533120E2B.0Z3-NXT | 02928302 | 2 | E | 12,0 | 12,0 | 12,0 | 100,0 | 50,0 | 11,4 | 6,0 | 3 | ■ |
| JS533160E2B.0Z3-NXT | 02928304 | 2 | E | 16,0 | 16,0 | 16,0 | 125,0 | 70,0 | 15,2 | 8,0 | 3 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und Composite

Graphit

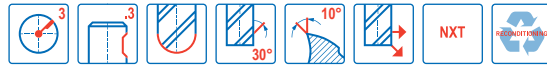
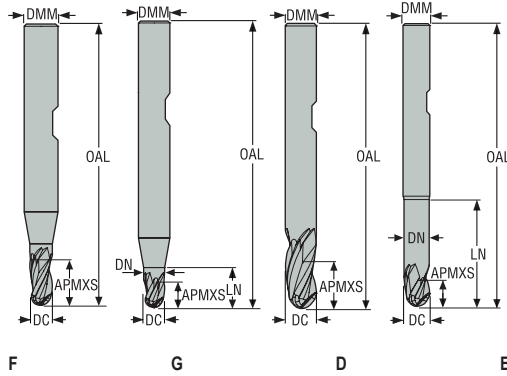
X-Heads

Minimaster Plus

Minimaster

JS533

Hochleistungsfräser – Universell – Kugelkopf – 3 Schneiden – Weldon



- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Weldon |
|---------------------|----------------|--------------|---------------|------|------|-------|-------|-------|------|------|-------|--------------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS533040F1B.3Z3-NXT | 02928323 | 1 | F | 4,0 | 6,0 | 8,0 | 57,0 | 10,75 | 4,05 | 2,0 | 3 | <input type="checkbox"/> |
| JS533050F1B.3Z3-NXT | 02928325 | 1 | F | 5,0 | 6,0 | 10,0 | 57,0 | 13,75 | 5,05 | 2,5 | 3 | <input type="checkbox"/> |
| JS533060D1B.3Z3-NXT | 02928326 | 1 | D | 6,0 | 6,0 | 12,0 | 57,0 | - | - | 3,0 | 3 | <input type="checkbox"/> |
| JS533080D1B.3Z3-NXT | 02928328 | 1 | D | 8,0 | 8,0 | 16,0 | 63,0 | - | - | 4,0 | 3 | <input type="checkbox"/> |
| JS533100D1B.3Z3-NXT | 02928330 | 1 | D | 10,0 | 10,0 | 20,0 | 72,0 | - | - | 5,0 | 3 | <input type="checkbox"/> |
| JS533120D1B.3Z3-NXT | 02928332 | 1 | D | 12,0 | 12,0 | 24,0 | 83,0 | - | - | 6,0 | 3 | <input type="checkbox"/> |
| JS533160D1B.3Z3-NXT | 02928334 | 1 | D | 16,0 | 16,0 | 32,0 | 109,0 | - | - | 8,0 | 3 | <input type="checkbox"/> |
| JS533200D1B.3Z3-NXT | 02928336 | 1 | D | 20,0 | 20,0 | 40,0 | 125,0 | - | - | 10,0 | 3 | <input type="checkbox"/> |
| JS533040G2B.3Z3-NXT | 02928324 | 2 | G | 4,0 | 6,0 | 4,0 | 57,0 | 15,0 | 3,8 | 2,0 | 3 | <input type="checkbox"/> |
| JS533050G2B.3Z3-NXT | 02928341 | 2 | G | 5,0 | 6,0 | 5,0 | 57,0 | 15,0 | 4,8 | 2,5 | 3 | <input type="checkbox"/> |
| JS533060E2B.3Z3-NXT | 02928327 | 2 | E | 6,0 | 6,0 | 6,0 | 63,0 | 25,0 | 5,7 | 3,0 | 3 | <input type="checkbox"/> |
| JS533080E2B.3Z3-NXT | 02928329 | 2 | E | 8,0 | 8,0 | 8,0 | 80,0 | 35,0 | 7,6 | 4,0 | 3 | <input type="checkbox"/> |
| JS533100E2B.3Z3-NXT | 02928331 | 2 | E | 10,0 | 10,0 | 10,0 | 89,0 | 40,0 | 9,5 | 5,0 | 3 | <input type="checkbox"/> |
| JS533120E2B.3Z3-NXT | 02928333 | 2 | E | 12,0 | 12,0 | 12,0 | 100,0 | 50,0 | 11,4 | 6,0 | 3 | <input type="checkbox"/> |
| JS533160E2B.3Z3-NXT | 02928335 | 2 | E | 16,0 | 16,0 | 16,0 | 122,0 | 70,0 | 15,2 | 8,0 | 3 | <input type="checkbox"/> |

Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster


Schnittdaten – JS533 Kopierfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|---------|---------|---------|---------|---------|---------|--------|--------|--------|--------|-----------------|
| | | | | 1 | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| P1 | M/A/D/E | 0.0300 | 0.80 | 0.0032 | 0.0065 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.026 | 0.032 | 0.038 | 0.048 | 0.055 | 200 (180 – 220) |
| | | 0,0300 | 0,80 | 0,00013 | 0,00026 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0019 | 0,0022 | 660 (600 – 720) |
| P2 | M/A/D/E | 0.0300 | 0.80 | 0.0034 | 0.0065 | 0.010 | 0.013 | 0.017 | 0.020 | 0.026 | 0.034 | 0.038 | 0.048 | 0.055 | 195 (170 – 220) |
| | | 0,0300 | 0,80 | 0,00013 | 0,00026 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0015 | 0,0019 | 0,0022 | 640 (560 – 720) |
| P3 | M/A/D/E | 0.0300 | 0.80 | 0.0032 | 0.0060 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.025 | 0.032 | 0.036 | 0.046 | 0.055 | 165 (150 – 180) |
| | | 0,0300 | 0,80 | 0,00013 | 0,00024 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0014 | 0,0018 | 0,0022 | 540 (500 – 590) |
| P4 | M/A/D/E | 0.0300 | 0.80 | 0.0030 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.025 | 0.030 | 0.036 | 0.044 | 0.050 | 145 (130 – 160) |
| | | 0,0300 | 0,80 | 0,00012 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,0010 | 0,0012 | 0,0014 | 0,0017 | 0,0020 | 475 (430 – 520) |
| P5 | M/A/D/E | 0.0300 | 0.80 | 0.0030 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.044 | 0.050 | 140 (130 – 160) |
| | | 0,0300 | 0,80 | 0,00012 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0017 | 0,0020 | 460 (430 – 520) |
| P6 | M/A/D/E | 0.0300 | 0.80 | 0.0030 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.034 | 0.044 | 0.050 | 155 (140 – 170) |
| | | 0,0300 | 0,80 | 0,00012 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0013 | 0,0017 | 0,0020 | 510 (460 – 550) |
| P7 | M/A/D/E | 0.0300 | 0.80 | 0.0030 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.034 | 0.044 | 0.050 | 150 (130 – 160) |
| | | 0,0300 | 0,80 | 0,00012 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0013 | 0,0017 | 0,0020 | 490 (430 – 520) |
| P8 | M/A/D/E | 0.0300 | 0.80 | 0.0032 | 0.0060 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.025 | 0.032 | 0.036 | 0.046 | 0.055 | 140 (120 – 150) |
| | | 0,0300 | 0,80 | 0,00013 | 0,00024 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0014 | 0,0018 | 0,0022 | 460 (400 – 490) |
| P11 | M/A/D/E | 0.0300 | 0.80 | 0.0044 | 0.0090 | 0.013 | 0.018 | 0.022 | 0.026 | 0.036 | 0.044 | 0.050 | 0.065 | 0.075 | 140 (130 – 160) |
| | | 0,0300 | 0,80 | 0,00017 | 0,00036 | 0,00050 | 0,00070 | 0,00085 | 0,0010 | 0,0014 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 460 (430 – 520) |
| P12 | M/A/D/E | 0.0300 | 0.80 | 0.0030 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.044 | 0.050 | 85 (73 – 97) |
| | | 0,0300 | 0,80 | 0,00012 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0017 | 0,0020 | 280 (240 – 310) |
| M1 | E | 0.0300 | 0.80 | 0.0034 | 0.0065 | 0.010 | 0.013 | 0.017 | 0.020 | 0.026 | 0.034 | 0.038 | 0.048 | 0.055 | 125 (99 – 140) |
| | | 0,0300 | 0,80 | 0,00013 | 0,00026 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0015 | 0,0019 | 0,0022 | 410 (330 – 450) |
| M2 | E | 0.0300 | 0.80 | 0.0030 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.044 | 0.050 | 100 (80 – 120) |
| | | 0,0300 | 0,80 | 0,00012 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0017 | 0,0020 | 330 (270 – 390) |
| M3 | E | 0.0300 | 0.80 | 0.0030 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.044 | 0.050 | 70 (50 – 90) |
| | | 0,0300 | 0,80 | 0,00012 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0017 | 0,0020 | 230 (170 – 290) |
| M4 | E | 0.0300 | 0.80 | 0.0026 | 0.0050 | 0.0080 | 0.011 | 0.013 | 0.016 | 0.022 | 0.026 | 0.030 | 0.038 | 0.044 | 55 (38 – 67) |
| | | 0,0300 | 0,80 | 0,00010 | 0,00020 | 0,00032 | 0,00044 | 0,00050 | 0,00065 | 0,00085 | 0,0010 | 0,0012 | 0,0015 | 0,0017 | 180 (130 – 210) |
| M5 | E | 0.0300 | 0.80 | 0.0026 | 0.0050 | 0.0080 | 0.011 | 0.013 | 0.016 | 0.022 | 0.026 | 0.030 | 0.038 | 0.044 | 44 (32 – 56) |
| | | 0,0300 | 0,80 | 0,00010 | 0,00020 | 0,00032 | 0,00044 | 0,00050 | 0,00065 | 0,00085 | 0,0010 | 0,0012 | 0,0015 | 0,0017 | 145 (110 – 180) |
| K1 | E | 0.0300 | 0.80 | 0.0040 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.046 | 0.060 | 0.070 | 145 (130 – 160) |
| | | 0,0300 | 0,80 | 0,00016 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0018 | 0,0024 | 0,0028 | 475 (430 – 520) |
| K2 | E | 0.0300 | 0.80 | 0.0036 | 0.0075 | 0.011 | 0.015 | 0.018 | 0.022 | 0.030 | 0.036 | 0.042 | 0.055 | 0.060 | 125 (110 – 140) |
| | | 0,0300 | 0,80 | 0,00014 | 0,00030 | 0,00044 | 0,00060 | 0,00070 | 0,00085 | 0,0012 | 0,0014 | 0,0017 | 0,0022 | 0,0024 | 410 (370 – 450) |
| K3 | E | 0.0300 | 0.80 | 0.0050 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 105 (91 – 110) |
| | | 0,0300 | 0,80 | 0,00020 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 345 (300 – 360) |
| K4 | E | 0.0300 | 0.80 | 0.0050 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 120 (100 – 140) |
| | | 0,0300 | 0,80 | 0,00020 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 395 (330 – 450) |
| K5 | E | 0.0300 | 0.80 | 0.0044 | 0.0090 | 0.013 | 0.018 | 0.022 | 0.026 | 0.036 | 0.044 | 0.055 | 0.065 | 0.075 | 70 (61 – 84) |
| | | 0,0300 | 0,80 | 0,00017 | 0,00036 | 0,00050 | 0,00070 | 0,00085 | 0,0010 | 0,0014 | 0,0017 | 0,0022 | 0,0026 | 0,0030 | 230 (210 – 270) |
| K6 | E | 0.0300 | 0.80 | 0.0050 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 105 (89 – 120) |
| | | 0,0300 | 0,80 | 0,00020 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 345 (300 – 390) |
| K7 | E | 0.0300 | 0.80 | 0.0044 | 0.0090 | 0.013 | 0.018 | 0.022 | 0.026 | 0.036 | 0.044 | 0.055 | 0.065 | 0.075 | 155 (130 – 180) |
| | | 0,0300 | 0,80 | 0,00017 | 0,00036 | 0,00050 | 0,00070 | 0,00085 | 0,0010 | 0,0014 | 0,0017 | 0,0022 | 0,0026 | 0,0030 | 510 (430 – 590) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – JS533 Kopierfräsen/Schruppen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|---------|---------|---------|---------|--------|--------|--------|--------|--------------------|----------------|
| | | | | 1 | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | | |
| N1 | E | 0.0300 | 0.80 | 0.0050 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 800 (700 – 900) | |
| | | 0,0300 | 0,80 | 0,00020 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 2625 (2300 – 2900) | |
| N2 | E | 0.0300 | 0.80 | 0.0050 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 510 (450 – 570) | |
| | | 0,0300 | 0,80 | 0,00020 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 1675 (1500 – 1800) | |
| N3 | E | 0.0300 | 0.80 | 0.0050 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 345 (300 – 380) | |
| | | 0,0300 | 0,80 | 0,00020 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 1125 (990 – 1200) | |
| N11 | E | 0.0300 | 0.80 | 0.0040 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.046 | 0.060 | 0.070 | 400 (350 – 450) | |
| | | 0,0300 | 0,80 | 0,00016 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0018 | 0,0024 | 0,0028 | 1300 (1200 – 1400) | |
| S1 | E | 0.0300 | 0.80 | 0.0030 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.044 | 0.050 | 100 (90 – 110) | |
| | | 0,0300 | 0,80 | 0,00012 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0017 | 0,0020 | 330 (300 – 360) | |
| S2 | E | 0.0300 | 0.80 | 0.0030 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.044 | 0.050 | 80 (73 – 88) | |
| | | 0,0300 | 0,80 | 0,00012 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0017 | 0,0020 | 260 (240 – 280) | |
| S11 | E | 0.0300 | 0.80 | 0.0030 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.044 | 0.050 | 130 (120 – 140) | |
| | | 0,0300 | 0,80 | 0,00012 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0017 | 0,0020 | 425 (400 – 450) | |
| S12 | E | 0.0300 | 0.80 | 0.0030 | 0.0060 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.044 | 0.050 | 100 (91 – 110) | |
| | | 0,0300 | 0,80 | 0,00012 | 0,00024 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0017 | 0,0020 | 330 (300 – 360) | |
| S13 | E | 0.0300 | 0.80 | 0.0026 | 0.0050 | 0.0080 | 0.011 | 0.013 | 0.016 | 0.022 | 0.026 | 0.030 | 0.038 | 0.044 | 80 (70 – 85) | |
| | | 0,0300 | 0,80 | 0,00010 | 0,00020 | 0,00032 | 0,00044 | 0,00050 | 0,00065 | 0,00085 | 0,0010 | 0,0012 | 0,0015 | 0,0017 | 260 (230 – 270) | |
| TS1 | A | 0.0300 | 0.80 | 0.0040 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.046 | 0.060 | 0.070 | 800 (760 – 850) | |
| | | 0,0300 | 0,80 | 0,00016 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0018 | 0,0024 | 0,0028 | 2625 (2500 – 2700) | |
| TP1 | A | 0.0300 | 0.80 | 0.0040 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.046 | 0.060 | 0.070 | 800 (760 – 850) | |
| | | 0,0300 | 0,80 | 0,00016 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0018 | 0,0024 | 0,0028 | 2625 (2500 – 2700) | |
| GR1 | A | 0.0300 | 0.80 | 0.0040 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.046 | 0.060 | 0.070 | 800 (760 – 850) | |
| | | 0,0300 | 0,80 | 0,00016 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0018 | 0,0024 | 0,0028 | 2625 (2500 – 2700) | |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

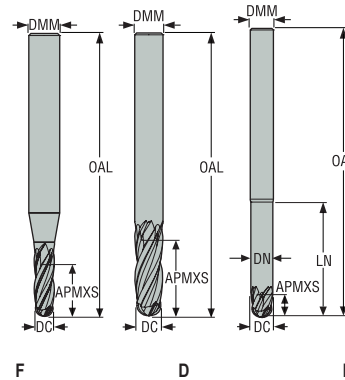
X-Heads

Minimaster Plus

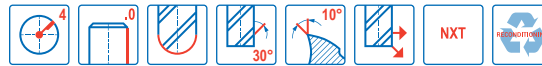
Minimaster

JS534

Hochleistungsfräser – Universell – Kugelkopf – 4 Schneiden – Zylindrisch



- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|------|------|-------|-------|-------|------|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS534020F1B.0Z4-NXT | 02928366 | 1 | F | 2,0 | 3,0 | 6,0 | 38,0 | 6,7 | 2,05 | 1,0 | 4 | ■ |
| JS534030D1B.0Z4-NXT | 02928367 | 1 | D | 3,0 | 3,0 | 9,0 | 38,0 | – | – | 1,5 | 4 | ■ |
| JS534040F1B.0Z4-NXT | 02928368 | 1 | F | 4,0 | 6,0 | 12,0 | 57,0 | 14,0 | 4,05 | 2,0 | 4 | ■ |
| JS534050F1B.0Z4-NXT | 02928370 | 1 | F | 5,0 | 6,0 | 15,0 | 57,0 | 17,0 | 5,05 | 2,5 | 4 | ■ |
| JS534060D1B.0Z4-NXT | 02928372 | 1 | D | 6,0 | 6,0 | 18,0 | 57,0 | – | – | 3,0 | 4 | ■ |
| JS534080D1B.0Z4-NXT | 02928375 | 1 | D | 8,0 | 8,0 | 24,0 | 69,0 | – | – | 4,0 | 4 | ■ |
| JS534100D1B.0Z4-NXT | 02928378 | 1 | D | 10,0 | 10,0 | 30,0 | 82,0 | – | – | 5,0 | 4 | ■ |
| JS534120D1B.0Z4-NXT | 02928381 | 1 | D | 12,0 | 12,0 | 36,0 | 100,0 | – | – | 6,0 | 4 | ■ |
| JS534160D1B.0Z4-NXT | 02928384 | 1 | D | 16,0 | 16,0 | 48,0 | 110,0 | – | – | 8,0 | 4 | ■ |
| JS534200D1B.0Z4-NXT | 02928387 | 1 | D | 20,0 | 20,0 | 60,0 | 125,0 | – | – | 10,0 | 4 | ■ |
| JS534040F2B.0Z4-NXT | 02928369 | 2 | F | 4,0 | 6,0 | 20,0 | 63,0 | 22,0 | 4,05 | 2,0 | 4 | ■ |
| JS534050F2B.0Z4-NXT | 02928371 | 2 | F | 5,0 | 6,0 | 25,0 | 75,0 | 27,0 | 5,05 | 2,5 | 4 | ■ |
| JS534060D2B.0Z4-NXT | 02928373 | 2 | D | 6,0 | 6,0 | 30,0 | 75,0 | – | – | 3,0 | 4 | ■ |
| JS534080D2B.0Z4-NXT | 02928376 | 2 | D | 8,0 | 8,0 | 40,0 | 80,0 | – | – | 4,0 | 4 | ■ |
| JS534100D2B.0Z4-NXT | 02928379 | 2 | D | 10,0 | 10,0 | 50,0 | 100,0 | – | – | 5,0 | 4 | ■ |
| JS534120D2B.0Z4-NXT | 02928382 | 2 | D | 12,0 | 12,0 | 60,0 | 125,0 | – | – | 6,0 | 4 | ■ |
| JS534160D2B.0Z4-NXT | 02928385 | 2 | D | 16,0 | 16,0 | 80,0 | 130,0 | – | – | 8,0 | 4 | ■ |
| JS534060E3B.0Z4-NXT | 02928374 | 3 | E | 6,0 | 6,0 | 6,0 | 75,0 | 30,0 | 5,7 | 3,0 | 4 | ■ |
| JS534080E3B.0Z4-NXT | 02928377 | 3 | E | 8,0 | 8,0 | 8,0 | 80,0 | 40,0 | 7,6 | 4,0 | 4 | ■ |
| JS534100E3B.0Z4-NXT | 02928380 | 3 | E | 10,0 | 10,0 | 10,0 | 100,0 | 50,0 | 9,7 | 5,0 | 4 | ■ |
| JS534120E3B.0Z4-NXT | 02928383 | 3 | E | 12,0 | 12,0 | 12,0 | 125,0 | 60,0 | 11,4 | 6,0 | 4 | ■ |
| JS534160E3B.0Z4-NXT | 02928386 | 3 | E | 16,0 | 16,0 | 16,0 | 130,0 | 80,0 | 15,2 | 8,0 | 4 | ■ |
| JS534200E3B.0Z4-NXT | 02928388 | 3 | E | 20,0 | 20,0 | 20,0 | 150,0 | 100,0 | 19,0 | 10,0 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und
Composite

Graphit

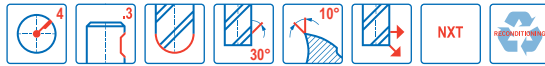
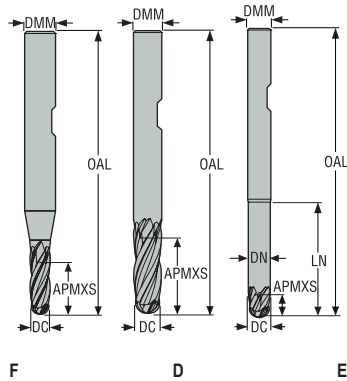
X-Heads

Minimaster Plus

Minimaster

JS534

Hochleistungsfräser – Universell – Kugelkopf – 4 Schneiden – Weldon



- Toleranzen:
- DMM=h5
- DC=e8
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Weldon |
|---------------------|----------------|--------------|---------------|------|------|-------|-------|-------|------|------|-------|--------------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | |
| JS534040F1B.3Z4-NXT | 02928390 | 1 | F | 4,0 | 6,0 | 12,0 | 57,0 | 14,0 | 4,05 | 2,0 | 4 | <input type="checkbox"/> |
| JS534050F1B.3Z4-NXT | 02928392 | 1 | F | 5,0 | 6,0 | 15,0 | 57,0 | 17,0 | 5,05 | 2,5 | 4 | <input type="checkbox"/> |
| JS534060D1B.3Z4-NXT | 02928394 | 1 | D | 6,0 | 6,0 | 18,0 | 57,0 | - | - | 3,0 | 4 | <input type="checkbox"/> |
| JS534080D1B.3Z4-NXT | 02928397 | 1 | D | 8,0 | 8,0 | 24,0 | 69,0 | - | - | 4,0 | 4 | <input type="checkbox"/> |
| JS534100D1B.3Z4-NXT | 02928400 | 1 | D | 10,0 | 10,0 | 30,0 | 82,0 | - | - | 5,0 | 4 | <input type="checkbox"/> |
| JS534120D1B.3Z4-NXT | 02928403 | 1 | D | 12,0 | 12,0 | 36,0 | 100,0 | - | - | 6,0 | 4 | <input type="checkbox"/> |
| JS534160D1B.3Z4-NXT | 02928406 | 1 | D | 16,0 | 16,0 | 48,0 | 110,0 | - | - | 8,0 | 4 | <input type="checkbox"/> |
| JS534200D1B.3Z4-NXT | 02928409 | 1 | D | 20,0 | 20,0 | 60,0 | 125,0 | - | - | 10,0 | 4 | <input type="checkbox"/> |
| JS534040F2B.3Z4-NXT | 02928391 | 2 | F | 4,0 | 6,0 | 20,0 | 63,0 | 22,0 | 4,05 | 2,0 | 4 | <input type="checkbox"/> |
| JS534050F2B.3Z4-NXT | 02928393 | 2 | F | 5,0 | 6,0 | 25,0 | 75,0 | 27,0 | 5,05 | 2,5 | 4 | <input type="checkbox"/> |
| JS534060D2B.3Z4-NXT | 02928395 | 2 | D | 6,0 | 6,0 | 30,0 | 75,0 | - | - | 3,0 | 4 | <input type="checkbox"/> |
| JS534080D2B.3Z4-NXT | 02928398 | 2 | D | 8,0 | 8,0 | 40,0 | 80,0 | - | - | 4,0 | 4 | <input type="checkbox"/> |
| JS534100D2B.3Z4-NXT | 02928401 | 2 | D | 10,0 | 10,0 | 50,0 | 100,0 | - | - | 5,0 | 4 | <input type="checkbox"/> |
| JS534120D2B.3Z4-NXT | 02928404 | 2 | D | 12,0 | 12,0 | 60,0 | 125,0 | - | - | 6,0 | 4 | <input type="checkbox"/> |
| JS534160D2B.3Z4-NXT | 02928407 | 2 | D | 16,0 | 16,0 | 80,0 | 130,0 | - | - | 8,0 | 4 | <input type="checkbox"/> |
| JS534060E3B.3Z4-NXT | 02928396 | 3 | E | 6,0 | 6,0 | 6,0 | 75,0 | 30,0 | 5,7 | 3,0 | 4 | <input type="checkbox"/> |
| JS534080E3B.3Z4-NXT | 02928399 | 3 | E | 8,0 | 8,0 | 8,0 | 80,0 | 40,0 | 7,6 | 4,0 | 4 | <input type="checkbox"/> |
| JS534100E3B.3Z4-NXT | 02928402 | 3 | E | 10,0 | 10,0 | 10,0 | 100,0 | 50,0 | 9,7 | 5,0 | 4 | <input type="checkbox"/> |
| JS534120E3B.3Z4-NXT | 02928405 | 3 | E | 12,0 | 12,0 | 12,0 | 125,0 | 60,0 | 11,4 | 6,0 | 4 | <input type="checkbox"/> |
| JS534160E3B.3Z4-NXT | 02928408 | 3 | E | 16,0 | 16,0 | 16,0 | 130,0 | 80,0 | 15,2 | 8,0 | 4 | <input type="checkbox"/> |
| JS534200E3B.3Z4-NXT | 02928410 | 3 | E | 20,0 | 20,0 | 20,0 | 150,0 | 100,0 | 19,0 | 10,0 | 4 | <input type="checkbox"/> |

Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster


Schnittdaten – JS534 Kopierfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|---------|---------|---------|---------|--------|--------|--------|--------|--------|--------------------|
| | | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| P1 | M/A/D/E | 0.0300 | 4.0 | 0.0085 | 0.013 | 0.017 | 0.022 | 0.026 | 0.034 | 0.044 | 0.050 | 0.065 | 0.075 | 345 (310 – 370) |
| | | 0,0300 | 4,0 | 0,00034 | 0,00050 | 0,00065 | 0,00085 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 1125 (1100 – 1200) |
| P2 | M/A/D/E | 0.0300 | 4.0 | 0.0090 | 0.013 | 0.018 | 0.022 | 0.026 | 0.036 | 0.044 | 0.050 | 0.065 | 0.075 | 335 (300 – 360) |
| | | 0,0300 | 4,0 | 0,00036 | 0,00050 | 0,00070 | 0,00085 | 0,0010 | 0,0014 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 1100 (990 – 1100) |
| P3 | M/A/D/E | 0.0300 | 4.0 | 0.0085 | 0.012 | 0.017 | 0.020 | 0.025 | 0.034 | 0.042 | 0.050 | 0.060 | 0.070 | 290 (260 – 310) |
| | | 0,0300 | 4,0 | 0,00034 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 0,0028 | 950 (860 – 1000) |
| P4 | M/A/D/E | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 255 (230 – 280) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 840 (760 – 910) |
| P5 | M/A/D/E | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 245 (220 – 260) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 800 (730 – 850) |
| P6 | M/A/D/E | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.046 | 0.060 | 0.065 | 230 (210 – 250) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0018 | 0,0024 | 0,0026 | 750 (690 – 820) |
| P7 | M/A/D/E | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.046 | 0.060 | 0.065 | 220 (200 – 240) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0018 | 0,0024 | 0,0026 | 720 (660 – 780) |
| P8 | M/A/D/E | 0.0300 | 4.0 | 0.0085 | 0.012 | 0.017 | 0.020 | 0.025 | 0.034 | 0.042 | 0.050 | 0.060 | 0.070 | 205 (190 – 220) |
| | | 0,0300 | 4,0 | 0,00034 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 0,0028 | 670 (630 – 720) |
| P11 | M/A/D/E | 0.0300 | 4.0 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 210 (190 – 230) |
| | | 0,0300 | 4,0 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 690 (630 – 750) |
| P12 | M/A/D/E | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 125 (120 – 130) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 410 (400 – 420) |
| M1 | E | 0.0300 | 4.0 | 0.0090 | 0.013 | 0.018 | 0.022 | 0.026 | 0.036 | 0.044 | 0.050 | 0.065 | 0.075 | 180 (160 – 200) |
| | | 0,0300 | 4,0 | 0,00036 | 0,00050 | 0,00070 | 0,00085 | 0,0010 | 0,0014 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 590 (530 – 650) |
| M2 | E | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 145 (130 – 160) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 475 (430 – 520) |
| M3 | E | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 155 (140 – 180) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 510 (460 – 590) |
| M4 | E | 0.0300 | 4.0 | 0.0070 | 0.010 | 0.014 | 0.017 | 0.020 | 0.028 | 0.034 | 0.042 | 0.050 | 0.060 | 120 (100 – 130) |
| | | 0,0300 | 4,0 | 0,00028 | 0,00040 | 0,00055 | 0,00065 | 0,00080 | 0,0011 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 395 (330 – 420) |
| M5 | E | 0.0300 | 4.0 | 0.0070 | 0.010 | 0.014 | 0.017 | 0.020 | 0.028 | 0.034 | 0.042 | 0.050 | 0.060 | 100 (83 – 110) |
| | | 0,0300 | 4,0 | 0,00028 | 0,00040 | 0,00055 | 0,00065 | 0,00080 | 0,0011 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 330 (280 – 360) |
| K1 | E | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 245 (220 – 260) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 800 (730 – 850) |
| K2 | E | 0.0300 | 4.0 | 0.0075 | 0.011 | 0.015 | 0.018 | 0.022 | 0.030 | 0.036 | 0.042 | 0.055 | 0.060 | 215 (200 – 230) |
| | | 0,0300 | 4,0 | 0,00030 | 0,00044 | 0,00060 | 0,00070 | 0,00085 | 0,0012 | 0,0014 | 0,0017 | 0,0022 | 0,0024 | 710 (660 – 750) |
| K3 | E | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 180 (160 – 190) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 590 (530 – 620) |
| K4 | E | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 170 (160 – 180) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 560 (530 – 590) |
| K5 | E | 0.0300 | 4.0 | 0.0070 | 0.011 | 0.014 | 0.018 | 0.022 | 0.028 | 0.036 | 0.042 | 0.055 | 0.060 | 200 (180 – 220) |
| | | 0,0300 | 4,0 | 0,00028 | 0,00044 | 0,00055 | 0,00070 | 0,00085 | 0,0011 | 0,0014 | 0,0017 | 0,0022 | 0,0024 | 660 (600 – 720) |
| K6 | E | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 295 (260 – 330) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 970 (860 – 1000) |
| K7 | E | 0.0300 | 4.0 | 0.0070 | 0.011 | 0.014 | 0.018 | 0.022 | 0.028 | 0.036 | 0.042 | 0.055 | 0.060 | 260 (230 – 280) |
| | | 0,0300 | 4,0 | 0,00028 | 0,00044 | 0,00055 | 0,00070 | 0,00085 | 0,0011 | 0,0014 | 0,0017 | 0,0022 | 0,0024 | 850 (760 – 910) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – JS534 Kopierfräsen/Schruppen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|---------|---------|--------|--------|--------|--------|--------|--------------------|
| | | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| N1 | E | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 1025 (910 — 1100) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 3375 (3000 — 3600) |
| N2 | E | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 910 (780 — 1000) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 2975 (2600 — 3200) |
| N3 | E | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 600 (520 — 690) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 1975 (1800 — 2200) |
| N11 | E | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 500 (440 — 560) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 1650 (1500 — 1800) |
| S1 | E | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 110 (88 — 110) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 360 (290 — 360) |
| S2 | E | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 90 (71 — 90) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 295 (240 — 290) |
| S3 | E | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 85 (63 — 87) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 280 (210 — 280) |
| S11 | E | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 185 (150 — 180) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 610 (500 — 590) |
| S12 | E | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 140 (120 — 140) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 460 (400 — 450) |
| S13 | E | 0.0300 | 4.0 | 0.0070 | 0.010 | 0.014 | 0.017 | 0.020 | 0.028 | 0.034 | 0.042 | 0.050 | 0.060 | 110 (91 — 110) |
| | | 0,0300 | 4,0 | 0,00028 | 0,00040 | 0,00055 | 0,00065 | 0,00080 | 0,0011 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 360 (300 — 360) |
| TS1 | A | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 900 (840 — 960) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 2950 (2800 — 3100) |
| TP1 | A | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 900 (840 — 960) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 2950 (2800 — 3100) |
| GR1 | A | 0.0300 | 4.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 900 (840 — 960) |
| | | 0,0300 | 4,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 2950 (2800 — 3100) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

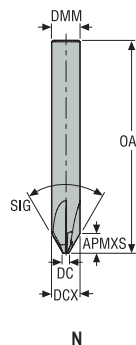
X-Heads

Minimaster Plus

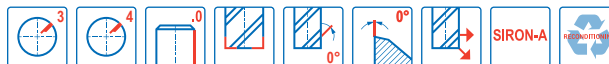
Minimaster

JS506

Allgemeine Anwendung – Universell – Fase – 3-4 Schneiden – Zylindrisch



- Toleranzen:
- DMM=h5
- SIG= ±0,5°
- Nachschleifen möglich, wenn DMM ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DCX | DMM | APMXS | OAL | SIG° | PCEDC | Zylindrisch |
|----------------------|--------------------|------------------|-------------------|-----|------|------|-------|------|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | | | |
| JS506030N2CZ3.0-SIRA | 02881622 | 2 | N | 0,6 | 3,0 | 3,0 | 2,0 | 50,0 | 60,0 | 3 | ■ |
| JS506040N2CZ3.0-SIRA | 02881623 | 2 | N | 0,8 | 4,0 | 4,0 | 2,7 | 50,0 | 60,0 | 3 | ■ |
| JS506060N2CZ4.0-SIRA | 02881624 | 2 | N | 1,2 | 6,0 | 6,0 | 4,1 | 57,0 | 60,0 | 4 | ■ |
| JS506080N2CZ4.0-SIRA | 02881626 | 2 | N | 1,6 | 8,0 | 8,0 | 5,5 | 63,0 | 60,0 | 4 | ■ |
| JS506100N2CZ4.0-SIRA | 02881628 | 2 | N | 2,0 | 10,0 | 10,0 | 6,9 | 72,0 | 60,0 | 4 | ■ |
| JS506120N2CZ4.0-SIRA | 02881630 | 2 | N | 2,4 | 12,0 | 12,0 | 8,3 | 83,0 | 60,0 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

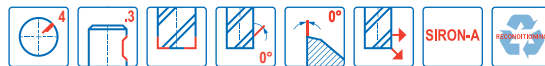
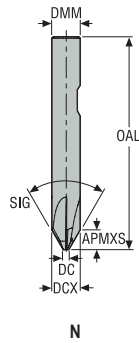
X-Heads

Minimaster Plus

Minimaster

JS506

Allgemeine Anwendung – Universell – Fase – 3-4 Schneiden – Weldon



- Toleranzen:
- DMM=h5
- SIG= ±0,5°
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DCX | DMM | APMXS | OAL | SIG° | PCEDC | Weldon |
|----------------------|--------------------|------------------|-------------------|-----|------|------|-------|------|------|-------|--------|
| | | | | mm | mm | mm | mm | mm | | | |
| JS506060N2CZ4.3-SIRA | 02881625 | 2 | N | 1,2 | 6,0 | 6,0 | 4,1 | 57,0 | 60,0 | 4 | ■ |
| JS506080N2CZ4.3-SIRA | 02881627 | 2 | N | 1,6 | 8,0 | 8,0 | 5,5 | 63,0 | 60,0 | 4 | ■ |
| JS506100N2CZ4.3-SIRA | 02881629 | 2 | N | 2,0 | 10,0 | 10,0 | 6,9 | 72,0 | 60,0 | 4 | ■ |
| JS506120N2CZ4.3-SIRA | 02881631 | 2 | N | 2,4 | 12,0 | 12,0 | 8,3 | 83,0 | 60,0 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und
Composite

Graphit

X-Heads

Minimaster Plus

Minimaster


Schnittdaten – JS506 Anfasen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|---------|--------|--------|--------|--------|-----------------|
| | | | | 3 | 4 | 6 | 8 | 10 | 12 | |
| P1 | M/A/D/E | 0.100 | 0.55 | 0.022 | 0.028 | 0.042 | 0.055 | 0.070 | 0.080 | 200 (180 – 220) |
| | | 0,100 | 0,55 | 0,00085 | 0,0011 | 0,0017 | 0,0022 | 0,0028 | 0,0032 | 660 (600 – 720) |
| P2 | M/A/D/E | 0.100 | 0.55 | 0.022 | 0.028 | 0.042 | 0.055 | 0.070 | 0.085 | 195 (180 – 220) |
| | | 0,100 | 0,55 | 0,00085 | 0,0011 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 640 (600 – 720) |
| P3 | M/A/D/E | 0.100 | 0.55 | 0.020 | 0.026 | 0.040 | 0.055 | 0.065 | 0.080 | 170 (150 – 190) |
| | | 0,100 | 0,55 | 0,00080 | 0,0010 | 0,0016 | 0,0022 | 0,0026 | 0,0032 | 560 (500 – 620) |
| P4 | M/A/D/E | 0.100 | 0.55 | 0.020 | 0.026 | 0.040 | 0.055 | 0.065 | 0.080 | 150 (130 – 160) |
| | | 0,100 | 0,55 | 0,00080 | 0,0010 | 0,0016 | 0,0022 | 0,0026 | 0,0032 | 490 (430 – 520) |
| P5 | M/A/D/E | 0.100 | 0.55 | 0.019 | 0.026 | 0.038 | 0.050 | 0.065 | 0.075 | 140 (130 – 160) |
| | | 0,100 | 0,55 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 460 (430 – 520) |
| P6 | M/A/D/E | 0.100 | 0.55 | 0.019 | 0.025 | 0.038 | 0.050 | 0.065 | 0.075 | 160 (140 – 180) |
| | | 0,100 | 0,55 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 520 (460 – 590) |
| P7 | M/A/D/E | 0.100 | 0.55 | 0.019 | 0.025 | 0.038 | 0.050 | 0.065 | 0.075 | 150 (140 – 170) |
| | | 0,100 | 0,55 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 490 (460 – 550) |
| P8 | M/A/D/E | 0.100 | 0.55 | 0.020 | 0.026 | 0.040 | 0.055 | 0.065 | 0.080 | 140 (130 – 160) |
| | | 0,100 | 0,55 | 0,00080 | 0,0010 | 0,0016 | 0,0022 | 0,0026 | 0,0032 | 460 (430 – 520) |
| P11 | M/A/D/E | 0.100 | 0.55 | 0.019 | 0.025 | 0.038 | 0.050 | 0.065 | 0.075 | 145 (130 – 160) |
| | | 0,100 | 0,55 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 475 (430 – 520) |
| P12 | M/A/D/E | 0.100 | 0.55 | 0.013 | 0.017 | 0.026 | 0.034 | 0.044 | 0.050 | 85 (75 – 97) |
| | | 0,100 | 0,55 | 0,00050 | 0,00065 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 280 (250 – 310) |
| M1 | E/M/A | 0.100 | 0.55 | 0.022 | 0.028 | 0.042 | 0.055 | 0.070 | 0.085 | 120 (95 – 140) |
| | | 0,100 | 0,55 | 0,00085 | 0,0011 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 395 (320 – 450) |
| M2 | E/M/A | 0.100 | 0.55 | 0.019 | 0.026 | 0.038 | 0.050 | 0.065 | 0.075 | 95 (76 – 110) |
| | | 0,100 | 0,55 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 310 (250 – 360) |
| M3 | E/M/A | 0.100 | 0.55 | 0.019 | 0.026 | 0.038 | 0.050 | 0.065 | 0.075 | 60 (43 – 80) |
| | | 0,100 | 0,55 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 195 (150 – 260) |
| M4 | E/M/A | 0.100 | 0.55 | 0.017 | 0.022 | 0.034 | 0.046 | 0.055 | 0.065 | 46 (33 – 60) |
| | | 0,100 | 0,55 | 0,00065 | 0,00085 | 0,0013 | 0,0018 | 0,0022 | 0,0026 | 150 (110 – 190) |
| M5 | E/M/A | 0.100 | 0.55 | 0.017 | 0.022 | 0.034 | 0.046 | 0.055 | 0.065 | 39 (27 – 50) |
| | | 0,100 | 0,55 | 0,00065 | 0,00085 | 0,0013 | 0,0018 | 0,0022 | 0,0026 | 130 (89 – 160) |
| K1 | A/D/M/E | 0.100 | 0.55 | 0.022 | 0.028 | 0.042 | 0.055 | 0.070 | 0.085 | 200 (180 – 220) |
| | | 0,100 | 0,55 | 0,00085 | 0,0011 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 660 (600 – 720) |
| K2 | A/D/M/E | 0.100 | 0.55 | 0.019 | 0.026 | 0.038 | 0.050 | 0.065 | 0.075 | 170 (150 – 190) |
| | | 0,100 | 0,55 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 560 (500 – 620) |
| K3 | A/D/M/E | 0.100 | 0.55 | 0.019 | 0.026 | 0.038 | 0.050 | 0.065 | 0.075 | 145 (130 – 160) |
| | | 0,100 | 0,55 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 475 (430 – 520) |
| K4 | A/D/M/E | 0.100 | 0.55 | 0.019 | 0.026 | 0.038 | 0.050 | 0.065 | 0.075 | 140 (130 – 150) |
| | | 0,100 | 0,55 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 460 (430 – 490) |
| K5 | A/D/M/E | 0.100 | 0.55 | 0.018 | 0.024 | 0.034 | 0.046 | 0.060 | 0.070 | 85 (72 – 93) |
| | | 0,100 | 0,55 | 0,00070 | 0,00095 | 0,0013 | 0,0018 | 0,0024 | 0,0028 | 280 (240 – 300) |
| K6 | A/D/M/E | 0.100 | 0.55 | 0.019 | 0.026 | 0.038 | 0.050 | 0.065 | 0.075 | 125 (110 – 130) |
| | | 0,100 | 0,55 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 410 (370 – 420) |
| K7 | A/D/M/E | 0.100 | 0.55 | 0.018 | 0.024 | 0.034 | 0.046 | 0.060 | 0.070 | 105 (92 – 120) |
| | | 0,100 | 0,55 | 0,00070 | 0,00095 | 0,0013 | 0,0018 | 0,0024 | 0,0028 | 345 (310 – 390) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – JS506 Anfasen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|--------|--------|--------|--------------------|
| | | | | 3 | 4 | 6 | 8 | 10 | 12 | |
| N1 | E/M/A | 0.100 | 0.55 | 0.019 | 0.026 | 0.038 | 0.050 | 0.065 | 0.075 | 475 (430 – 520) |
| | | 0,100 | 0,55 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 1550 (1500 – 1700) |
| N2 | E/M/A | 0.100 | 0.55 | 0.019 | 0.026 | 0.038 | 0.050 | 0.065 | 0.075 | 305 (280 – 330) |
| | | 0,100 | 0,55 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 1000 (920 – 1000) |
| N3 | E/M/A | 0.100 | 0.55 | 0.019 | 0.026 | 0.038 | 0.050 | 0.065 | 0.075 | 205 (190 – 220) |
| | | 0,100 | 0,55 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 670 (630 – 720) |
| N11 | E/M/A | 0.100 | 0.55 | 0.019 | 0.026 | 0.038 | 0.050 | 0.065 | 0.075 | 270 (250 – 290) |
| | | 0,100 | 0,55 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 890 (830 – 950) |
| S1 | E | 0.100 | 0.55 | 0.020 | 0.028 | 0.042 | 0.055 | 0.070 | 0.080 | 41 (14 – 68) |
| | | 0,100 | 0,55 | 0,00080 | 0,0011 | 0,0017 | 0,0022 | 0,0028 | 0,0032 | 135 (46 – 220) |
| S2 | E | 0.100 | 0.55 | 0.020 | 0.028 | 0.042 | 0.055 | 0.070 | 0.080 | 33 (12 – 55) |
| | | 0,100 | 0,55 | 0,00080 | 0,0011 | 0,0017 | 0,0022 | 0,0028 | 0,0032 | 110 (40 – 180) |
| S3 | E | 0.100 | 0.55 | 0.019 | 0.026 | 0.038 | 0.050 | 0.065 | 0.075 | 28 (9.5 – 47) |
| | | 0,100 | 0,55 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 90 (32 – 150) |
| S11 | E | 0.100 | 0.55 | 0.019 | 0.026 | 0.038 | 0.050 | 0.065 | 0.075 | 95 (68 – 110) |
| | | 0,100 | 0,55 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 310 (230 – 360) |
| S12 | E | 0.100 | 0.55 | 0.019 | 0.026 | 0.038 | 0.050 | 0.065 | 0.075 | 70 (53 – 90) |
| | | 0,100 | 0,55 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 230 (180 – 290) |
| S13 | E | 0.100 | 0.55 | 0.017 | 0.022 | 0.034 | 0.046 | 0.055 | 0.065 | 55 (41 – 69) |
| | | 0,100 | 0,55 | 0,00065 | 0,00085 | 0,0013 | 0,0018 | 0,0022 | 0,0026 | 180 (140 – 220) |
| H5 | M/A/D | 0.0500 | 1.5 | 0.015 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 65 (45 – 83) |
| | | 0,0500 | 1,5 | 0,00060 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 215 (150 – 270) |
| H8 | M/A/D | 0.0500 | 1.5 | 0.011 | 0.015 | 0.022 | 0.030 | 0.038 | 0.044 | 60 (44 – 81) |
| | | 0,0500 | 1,5 | 0,00044 | 0,00060 | 0,00085 | 0,0012 | 0,0015 | 0,0017 | 195 (150 – 260) |
| H11 | M/A/D | 0.0500 | 1.5 | 0.015 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 80 (57 – 100) |
| | | 0,0500 | 1,5 | 0,00060 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 260 (190 – 320) |
| H12 | M/A/D | 0.0500 | 1.5 | 0.011 | 0.015 | 0.022 | 0.030 | 0.038 | 0.044 | 70 (51 – 94) |
| | | 0,0500 | 1,5 | 0,00044 | 0,00060 | 0,00085 | 0,0012 | 0,0015 | 0,0017 | 230 (170 – 300) |
| H21 | M/A/D | 0.0500 | 1.5 | 0.011 | 0.015 | 0.022 | 0.030 | 0.038 | 0.044 | 60 (44 – 81) |
| | | 0,0500 | 1,5 | 0,00044 | 0,00060 | 0,00085 | 0,0012 | 0,0015 | 0,0017 | 195 (150 – 260) |
| TS1 | A/D | 0.100 | 0.55 | 0.019 | 0.026 | 0.038 | 0.050 | 0.065 | 0.075 | 475 (430 – 520) |
| | | 0,100 | 0,55 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 1550 (1500 – 1700) |
| TP1 | A/D | 0.100 | 0.55 | 0.019 | 0.026 | 0.038 | 0.050 | 0.065 | 0.075 | 475 (430 – 520) |
| | | 0,100 | 0,55 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 1550 (1500 – 1700) |
| GR1 | A/D | 0.100 | 0.55 | 0.019 | 0.026 | 0.038 | 0.050 | 0.065 | 0.075 | 475 (430 – 520) |
| | | 0,100 | 0,55 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 1550 (1500 – 1700) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

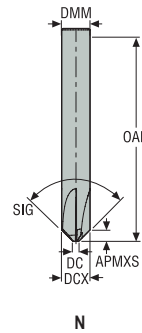
X-Heads

Minimaster Plus

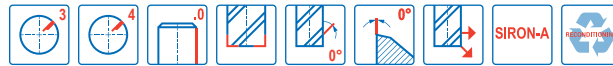
Minimaster

JS509

Allgemeine Anwendung – Universell – Fase – 3-4 Schneiden – Zylindrisch



- Toleranzen:
- DMM=h5
- SIG= ±0,5°
- Nachschleifen möglich, wenn DMM ≥ Ø6 ist



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DCX | DMM | APMXS | OAL | SIG° | PCEDC | Zylindrisch |
|----------------------|----------------|--------------|---------------|-----|------|------|-------|------|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | | | |
| JS509030N2CZ3.0-SIRA | 02881634 | 2 | N | 0,6 | 3,0 | 3,0 | 1,2 | 50,0 | 90,0 | 3 | ■ |
| JS509040N2CZ3.0-SIRA | 02881635 | 2 | N | 0,8 | 4,0 | 4,0 | 1,6 | 50,0 | 90,0 | 3 | ■ |
| JS509060N2CZ4.0-SIRA | 02881636 | 2 | N | 1,2 | 6,0 | 6,0 | 2,4 | 57,0 | 90,0 | 4 | ■ |
| JS509080N2CZ4.0-SIRA | 02881638 | 2 | N | 1,6 | 8,0 | 8,0 | 3,2 | 63,0 | 90,0 | 4 | ■ |
| JS509100N2CZ4.0-SIRA | 02881640 | 2 | N | 2,0 | 10,0 | 10,0 | 4,0 | 72,0 | 90,0 | 4 | ■ |
| JS509120N2CZ4.0-SIRA | 02881642 | 2 | N | 2,4 | 12,0 | 12,0 | 4,8 | 83,0 | 90,0 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

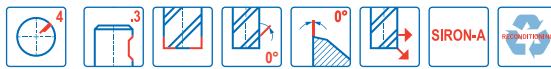
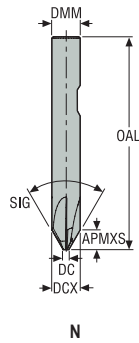
X-Heads

Minimaster Plus

Minimaster

JS509

Allgemeine Anwendung – Universell – Fase – 3-4 Schneiden – Weldon



- Toleranzen:
- DMM=h5
- SIG= ±0,5°
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DCX | DMM | APMXS | OAL | SIG° | PCEDC | Weldon |
|----------------------|--------------------|------------------|-------------------|-----|------|------|-------|------|------|-------|--------|
| | | | | mm | mm | mm | mm | mm | | | |
| JS509060N2CZ4.3-SIRA | 02881637 | 2 | N | 1,2 | 6,0 | 6,0 | 2,4 | 57,0 | 90,0 | 4 | ■ |
| JS509080N2CZ4.3-SIRA | 02881639 | 2 | N | 1,6 | 8,0 | 8,0 | 3,2 | 63,0 | 90,0 | 4 | ■ |
| JS509100N2CZ4.3-SIRA | 02881641 | 2 | N | 2,0 | 10,0 | 10,0 | 4,0 | 72,0 | 90,0 | 4 | ■ |
| JS509120N2CZ4.3-SIRA | 02881643 | 2 | N | 2,4 | 12,0 | 12,0 | 4,8 | 83,0 | 90,0 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

X-Heads

Minimaster Plus

Minimaster


Schnittdaten – JS509 Anfasen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------------------|
| | | | | 3 | 4 | 6 | 8 | 10 | 12 | |
| P1 | M/A/D/E | 0.100 | 0.55 | 0.034 | 0.044 | 0.065 | 0.090 | 0.11 | 0.13 | 380 (340 – 430) |
| | | 0,100 | 0,55 | 0,0013 | 0,0017 | 0,0026 | 0,0036 | 0,0044 | 0,0050 | 1250 (1200 – 1400) |
| P2 | M/A/D/E | 0.100 | 0.55 | 0.034 | 0.044 | 0.065 | 0.090 | 0.11 | 0.13 | 370 (330 – 420) |
| | | 0,100 | 0,55 | 0,0013 | 0,0017 | 0,0026 | 0,0036 | 0,0044 | 0,0050 | 1225 (1100 – 1300) |
| P3 | M/A/D/E | 0.100 | 0.55 | 0.032 | 0.042 | 0.065 | 0.085 | 0.11 | 0.12 | 320 (280 – 360) |
| | | 0,100 | 0,55 | 0,0013 | 0,0017 | 0,0026 | 0,0034 | 0,0044 | 0,0048 | 1050 (920 – 1100) |
| P4 | M/A/D/E | 0.100 | 0.55 | 0.032 | 0.042 | 0.060 | 0.085 | 0.10 | 0.12 | 280 (250 – 310) |
| | | 0,100 | 0,55 | 0,0013 | 0,0017 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 920 (830 – 1000) |
| P5 | M/A/D/E | 0.100 | 0.55 | 0.030 | 0.040 | 0.060 | 0.085 | 0.10 | 0.12 | 270 (240 – 300) |
| | | 0,100 | 0,55 | 0,0012 | 0,0016 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 890 (790 – 980) |
| P6 | M/A/D/E | 0.100 | 0.55 | 0.030 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 305 (270 – 340) |
| | | 0,100 | 0,55 | 0,0012 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 1000 (890 – 1100) |
| P7 | M/A/D/E | 0.100 | 0.55 | 0.030 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 285 (250 – 320) |
| | | 0,100 | 0,55 | 0,0012 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 940 (830 – 1000) |
| P8 | M/A/D/E | 0.100 | 0.55 | 0.032 | 0.042 | 0.065 | 0.085 | 0.11 | 0.12 | 270 (240 – 300) |
| | | 0,100 | 0,55 | 0,0013 | 0,0017 | 0,0026 | 0,0034 | 0,0044 | 0,0048 | 890 (790 – 980) |
| P11 | M/A/D/E | 0.100 | 0.55 | 0.030 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 280 (250 – 310) |
| | | 0,100 | 0,55 | 0,0012 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 920 (830 – 1000) |
| P12 | M/A/D/E | 0.100 | 0.55 | 0.020 | 0.028 | 0.042 | 0.055 | 0.070 | 0.080 | 165 (150 – 180) |
| | | 0,100 | 0,55 | 0,00080 | 0,0011 | 0,0017 | 0,0022 | 0,0028 | 0,0032 | 540 (500 – 590) |
| M1 | E/M/A | 0.100 | 0.55 | 0.034 | 0.044 | 0.065 | 0.090 | 0.11 | 0.13 | 220 (180 – 260) |
| | | 0,100 | 0,55 | 0,0013 | 0,0017 | 0,0026 | 0,0036 | 0,0044 | 0,0050 | 720 (600 – 850) |
| M2 | E/M/A | 0.100 | 0.55 | 0.030 | 0.040 | 0.060 | 0.085 | 0.10 | 0.12 | 180 (150 – 210) |
| | | 0,100 | 0,55 | 0,0012 | 0,0016 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 590 (500 – 680) |
| M3 | E/M/A | 0.100 | 0.55 | 0.030 | 0.040 | 0.060 | 0.085 | 0.10 | 0.12 | 115 (81 – 150) |
| | | 0,100 | 0,55 | 0,0012 | 0,0016 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 375 (270 – 490) |
| M4 | E/M/A | 0.100 | 0.55 | 0.026 | 0.036 | 0.055 | 0.070 | 0.090 | 0.10 | 90 (61 – 110) |
| | | 0,100 | 0,55 | 0,0010 | 0,0014 | 0,0022 | 0,0028 | 0,0036 | 0,0040 | 295 (210 – 360) |
| M5 | E/M/A | 0.100 | 0.55 | 0.026 | 0.036 | 0.055 | 0.070 | 0.090 | 0.10 | 75 (51 – 95) |
| | | 0,100 | 0,55 | 0,0010 | 0,0014 | 0,0022 | 0,0028 | 0,0036 | 0,0040 | 245 (170 – 310) |
| K1 | A/D/M/E | 0.100 | 0.55 | 0.034 | 0.044 | 0.065 | 0.090 | 0.11 | 0.13 | 375 (330 – 420) |
| | | 0,100 | 0,55 | 0,0013 | 0,0017 | 0,0026 | 0,0036 | 0,0044 | 0,0050 | 1225 (1100 – 1300) |
| K2 | A/D/M/E | 0.100 | 0.55 | 0.030 | 0.040 | 0.060 | 0.085 | 0.10 | 0.12 | 325 (290 – 360) |
| | | 0,100 | 0,55 | 0,0012 | 0,0016 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 1075 (960 – 1100) |
| K3 | A/D/M/E | 0.100 | 0.55 | 0.030 | 0.040 | 0.060 | 0.085 | 0.10 | 0.12 | 275 (240 – 310) |
| | | 0,100 | 0,55 | 0,0012 | 0,0016 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 900 (790 – 1000) |
| K4 | A/D/M/E | 0.100 | 0.55 | 0.030 | 0.040 | 0.060 | 0.085 | 0.10 | 0.12 | 265 (230 – 290) |
| | | 0,100 | 0,55 | 0,0012 | 0,0016 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 870 (760 – 950) |
| K5 | A/D/M/E | 0.100 | 0.55 | 0.028 | 0.036 | 0.055 | 0.075 | 0.090 | 0.11 | 155 (140 – 170) |
| | | 0,100 | 0,55 | 0,0011 | 0,0014 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 510 (460 – 550) |
| K6 | A/D/M/E | 0.100 | 0.55 | 0.030 | 0.040 | 0.060 | 0.085 | 0.10 | 0.12 | 230 (210 – 260) |
| | | 0,100 | 0,55 | 0,0012 | 0,0016 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 750 (690 – 850) |
| K7 | A/D/M/E | 0.100 | 0.55 | 0.028 | 0.036 | 0.055 | 0.075 | 0.090 | 0.11 | 200 (180 – 220) |
| | | 0,100 | 0,55 | 0,0011 | 0,0014 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 660 (600 – 720) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – JS509 Anfasen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|--------|--------|--------|--------|--------------------|
| | | | | 3 | 4 | 6 | 8 | 10 | 12 | |
| N1 | E/M/A | 0.100 | 0.55 | 0.030 | 0.040 | 0.060 | 0.085 | 0.10 | 0.12 | 900 (810 – 980) |
| | | 0,100 | 0,55 | 0,0012 | 0,0016 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 2950 (2700 – 3200) |
| N2 | E/M/A | 0.100 | 0.55 | 0.030 | 0.040 | 0.060 | 0.085 | 0.10 | 0.12 | 580 (530 – 630) |
| | | 0,100 | 0,55 | 0,0012 | 0,0016 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 1900 (1800 – 2000) |
| N3 | E/M/A | 0.100 | 0.55 | 0.030 | 0.040 | 0.060 | 0.085 | 0.10 | 0.12 | 385 (350 – 420) |
| | | 0,100 | 0,55 | 0,0012 | 0,0016 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 1275 (1200 – 1300) |
| N11 | E/M/A | 0.100 | 0.55 | 0.030 | 0.040 | 0.060 | 0.085 | 0.10 | 0.12 | 510 (470 – 560) |
| | | 0,100 | 0,55 | 0,0012 | 0,0016 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 1675 (1600 – 1800) |
| S1 | E | 0.100 | 0.55 | 0.017 | 0.022 | 0.032 | 0.044 | 0.055 | 0.065 | 70 (24 – 110) |
| | | 0,100 | 0,55 | 0,00065 | 0,00085 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 230 (79 – 360) |
| S2 | E | 0.100 | 0.55 | 0.017 | 0.022 | 0.032 | 0.044 | 0.055 | 0.065 | 55 (19 – 94) |
| | | 0,100 | 0,55 | 0,00065 | 0,00085 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 180 (63 – 300) |
| S3 | E | 0.100 | 0.55 | 0.015 | 0.020 | 0.030 | 0.042 | 0.050 | 0.060 | 49 (17 – 80) |
| | | 0,100 | 0,55 | 0,00060 | 0,00080 | 0,0012 | 0,0017 | 0,0020 | 0,0024 | 160 (56 – 260) |
| S11 | E | 0.100 | 0.55 | 0.030 | 0.040 | 0.060 | 0.085 | 0.10 | 0.12 | 175 (130 – 220) |
| | | 0,100 | 0,55 | 0,0012 | 0,0016 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 570 (430 – 720) |
| S12 | E | 0.100 | 0.55 | 0.030 | 0.040 | 0.060 | 0.085 | 0.10 | 0.12 | 135 (99 – 170) |
| | | 0,100 | 0,55 | 0,0012 | 0,0016 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 445 (330 – 550) |
| S13 | E | 0.100 | 0.55 | 0.026 | 0.036 | 0.055 | 0.070 | 0.090 | 0.10 | 105 (77 – 130) |
| | | 0,100 | 0,55 | 0,0010 | 0,0014 | 0,0022 | 0,0028 | 0,0036 | 0,0040 | 345 (260 – 420) |
| H5 | M/A/D | 0.0500 | 1.2 | 0.020 | 0.026 | 0.040 | 0.050 | 0.065 | 0.075 | 115 (80 – 140) |
| | | 0,0500 | 1,2 | 0,00080 | 0,0010 | 0,0016 | 0,0020 | 0,0026 | 0,0030 | 375 (270 – 450) |
| H8 | M/A/D | 0.0500 | 1.2 | 0.015 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 110 (78 – 140) |
| | | 0,0500 | 1,2 | 0,00060 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 360 (260 – 450) |
| H11 | M/A/D | 0.0500 | 1.2 | 0.020 | 0.026 | 0.040 | 0.050 | 0.065 | 0.075 | 145 (110 – 190) |
| | | 0,0500 | 1,2 | 0,00080 | 0,0010 | 0,0016 | 0,0020 | 0,0026 | 0,0030 | 475 (370 – 620) |
| H12 | M/A/D | 0.0500 | 1.2 | 0.015 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 130 (91 – 170) |
| | | 0,0500 | 1,2 | 0,00060 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 425 (300 – 550) |
| H21 | M/A/D | 0.0500 | 1.2 | 0.015 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 110 (78 – 140) |
| | | 0,0500 | 1,2 | 0,00060 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 360 (260 – 450) |
| TS1 | A/D | 0.100 | 0.55 | 0.030 | 0.040 | 0.060 | 0.085 | 0.10 | 0.12 | 900 (810 – 980) |
| | | 0,100 | 0,55 | 0,0012 | 0,0016 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 2950 (2700 – 3200) |
| TP1 | A/D | 0.100 | 0.55 | 0.030 | 0.040 | 0.060 | 0.085 | 0.10 | 0.12 | 900 (810 – 980) |
| | | 0,100 | 0,55 | 0,0012 | 0,0016 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 2950 (2700 – 3200) |
| GR1 | A/D | 0.100 | 0.55 | 0.030 | 0.040 | 0.060 | 0.085 | 0.10 | 0.12 | 900 (810 – 980) |
| | | 0,100 | 0,55 | 0,0012 | 0,0016 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 2950 (2700 – 3200) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

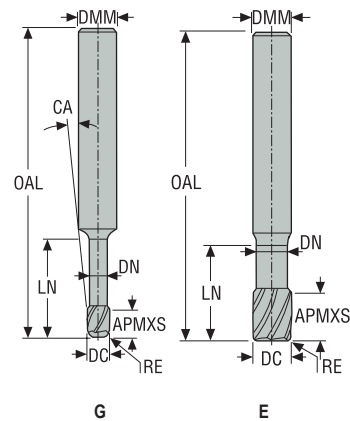
X-Heads

Minimaster Plus

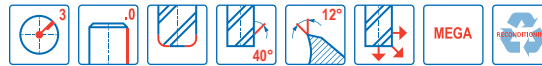
Minimaster

JH910

Hochgeschwindigkeitsfräsen – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM= h5
- DC= -0,02/-0,03 mm
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | CA | PCEDC | Zylindrisch |
|-----------------|--------------------|------------------|-------------------|------|------|-------|------|------|------|-----|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | | |
| 910020R020-MEGA | 00020058 | 2 | G | 2,0 | 3,0 | 3,0 | 40,0 | 6,0 | 1,9 | 0,2 | 3,5 | 3 | ■ |
| 910025R020-MEGA | 00020065 | 2 | G | 2,5 | 3,0 | 4,0 | 40,0 | 6,0 | 2,4 | 0,2 | 2,0 | 3 | ■ |
| 910030R010-MEGA | 00020073 | 2 | E | 3,0 | 3,0 | 4,0 | 40,0 | 7,0 | 2,8 | 0,1 | - | 3 | ■ |
| 910030R020-MEGA | 00020142 | 2 | E | 3,0 | 3,0 | 4,0 | 40,0 | 7,0 | 2,8 | 0,2 | - | 3 | ■ |
| 910035R020-MEGA | 00020144 | 2 | G | 3,5 | 6,0 | 5,0 | 50,0 | 9,0 | 3,2 | 0,2 | 6,0 | 3 | ■ |
| 910040R020-MEGA | 00020151 | 2 | G | 4,0 | 6,0 | 5,0 | 50,0 | 9,0 | 3,7 | 0,2 | 5,0 | 3 | ■ |
| 910040R030-MEGA | 00020152 | 2 | G | 4,0 | 6,0 | 5,0 | 50,0 | 9,0 | 3,7 | 0,3 | 5,0 | 3 | ■ |
| 910040R050-MEGA | 00020155 | 2 | G | 4,0 | 6,0 | 5,0 | 50,0 | 9,0 | 3,7 | 0,5 | 5,0 | 3 | ■ |
| 910050R020-MEGA | 00020159 | 2 | G | 5,0 | 6,0 | 6,0 | 50,0 | 11,0 | 4,6 | 0,2 | 2,5 | 3 | ■ |
| 910060R020-MEGA | 00020160 | 2 | E | 6,0 | 6,0 | 7,0 | 60,0 | 14,0 | 5,6 | 0,2 | - | 3 | ■ |
| 910060R030-MEGA | 00020161 | 2 | E | 6,0 | 6,0 | 7,0 | 60,0 | 14,0 | 5,6 | 0,3 | - | 3 | ■ |
| 910060R050-MEGA | 00020162 | 2 | E | 6,0 | 6,0 | 7,0 | 60,0 | 14,0 | 5,6 | 0,5 | - | 3 | ■ |
| 910080R020-MEGA | 00020163 | 2 | E | 8,0 | 8,0 | 9,0 | 60,0 | 18,0 | 7,4 | 0,2 | - | 3 | ■ |
| 910080R050-MEGA | 00020164 | 2 | E | 8,0 | 8,0 | 9,0 | 60,0 | 18,0 | 7,4 | 0,5 | - | 3 | ■ |
| 910100R020-MEGA | 00020165 | 2 | E | 10,0 | 10,0 | 12,0 | 70,0 | 25,0 | 9,4 | 0,2 | - | 3 | ■ |
| 910100R050-MEGA | 00020166 | 2 | E | 10,0 | 10,0 | 12,0 | 70,0 | 25,0 | 9,4 | 0,5 | - | 3 | ■ |
| 910100R100-MEGA | 00020167 | 2 | E | 10,0 | 10,0 | 12,0 | 70,0 | 25,0 | 9,4 | 1,0 | - | 3 | ■ |
| 910120R050-MEGA | 00020168 | 2 | E | 12,0 | 12,0 | 15,0 | 80,0 | 30,0 | 11,4 | 0,5 | - | 3 | ■ |
| 910120R100-MEGA | 00020169 | 2 | E | 12,0 | 12,0 | 15,0 | 80,0 | 30,0 | 11,4 | 1,0 | - | 3 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

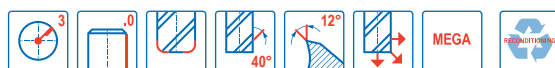
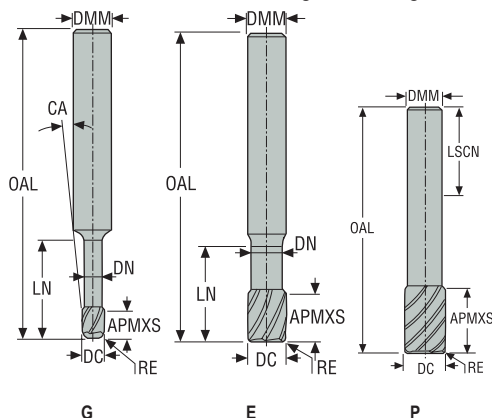
X-Heads

Minimaster Plus

Minimaster

JH910

Hochgeschwindigkeitsfräsen – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM= h5
- DC= -0,02/-0,03 mm
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | CA | LSCN | PCEDC | Zylindrisch |
|---------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-----|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | mm | | |
| 910L020-MEGA | 00022002 | 3 | G | 2,0 | 3,0 | 3,0 | 60,0 | 10,0 | 1,9 | 0,2 | 2,5 | 28,0 | 3 | ■ |
| 910L030-MEGA | 00022003 | 3 | E | 3,0 | 3,0 | 4,0 | 60,0 | 14,0 | 2,8 | 0,2 | – | 28,0 | 3 | ■ |
| 910L040-MEGA | 00022004 | 3 | G | 4,0 | 6,0 | 5,0 | 65,0 | 18,0 | 3,7 | 0,2 | 3,0 | 36,0 | 3 | ■ |
| 910L050-MEGA | 00022005 | 3 | G | 5,0 | 6,0 | 6,0 | 65,0 | 22,0 | 4,6 | 0,2 | 1,5 | 36,0 | 3 | ■ |
| 910L060-MEGA | 00022006 | 3 | E | 6,0 | 6,0 | 7,0 | 80,0 | 26,0 | 5,6 | 0,3 | – | 36,0 | 3 | ■ |
| 910L080-MEGA | 00022007 | 3 | E | 8,0 | 8,0 | 9,0 | 85,0 | 36,0 | 7,4 | 0,5 | – | 36,0 | 3 | ■ |
| 910L100-MEGA | 00022009 | 3 | E | 10,0 | 10,0 | 12,0 | 100,0 | 45,0 | 9,4 | 0,5 | – | 40,0 | 3 | ■ |
| 910L120-MEGA | 00022011 | 3 | E | 12,0 | 12,0 | 15,0 | 125,0 | 54,0 | 11,4 | 0,5 | – | 45,0 | 3 | ■ |
| 910L160-MEGA | 00022013 | 3 | E | 16,0 | 16,0 | 18,0 | 125,0 | 65,0 | 15,4 | 1,0 | – | 48,0 | 3 | ■ |
| 910RS070-MEGA | 00021772 | 4 | P | 7,0 | 6,0 | 8,0 | 100,0 | – | – | 0,3 | – | 36,0 | 3 | ■ |
| 910RS090-MEGA | 00021781 | 4 | P | 9,0 | 8,0 | 11,0 | 100,0 | – | – | 0,5 | – | 36,0 | 3 | ■ |
| 910RS110-MEGA | 00021782 | 4 | P | 11,0 | 10,0 | 13,0 | 125,0 | – | – | 0,5 | – | 40,0 | 3 | ■ |
| 910RS130-MEGA | 00021784 | 4 | P | 13,0 | 12,0 | 16,0 | 150,0 | – | – | 0,6 | – | 45,0 | 3 | ■ |
| 910RS170-MEGA | 00021800 | 4 | P | 17,0 | 16,0 | 20,0 | 150,0 | – | – | 0,6 | – | 48,0 | 3 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JH910 Eckfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|---------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 16 | 17 | |
| P1 | M/E/A | 0.0400 | 1.1 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 455 (410 – 500) |
| | | 0,0400 | 1,1 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 1500 (1400 – 1600) |
| P2 | M/E/A | 0.0400 | 1.1 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 445 (400 – 490) |
| | | 0,0400 | 1,1 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 1450 (1400 – 1600) |
| P3 | M/E/A | 0.0400 | 1.1 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 385 (350 – 420) |
| | | 0,0400 | 1,1 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 1275 (1200 – 1300) |
| P4 | M/E/A | 0.0400 | 1.1 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 335 (300 – 370) |
| | | 0,0400 | 1,1 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 1100 (990 – 1200) |
| P5 | M/E/A | 0.0400 | 1.1 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 320 (290 – 350) |
| | | 0,0400 | 1,1 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 1050 (960 – 1100) |
| P6 | M/E/A | 0.0400 | 1.1 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 360 (330 – 400) |
| | | 0,0400 | 1,1 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 1175 (1100 – 1300) |
| P7 | M/E/A | 0.0400 | 1.1 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 340 (310 – 370) |
| | | 0,0400 | 1,1 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 1125 (1100 – 1200) |
| P8 | M/E/A | 0.0400 | 1.1 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 320 (290 – 350) |
| | | 0,0400 | 1,1 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 1050 (960 – 1100) |
| P11 | M/E/A | 0.0400 | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 330 (300 – 360) |
| | | 0,0400 | 1,0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 1125 (990 – 1100) |
| P12 | M/E/A | 0.0400 | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 195 (180 – 210) |
| | | 0,0400 | 1,0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 640 (600 – 680) |
| M1 | M/E/A | 0.0400 | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 200 (180 – 220) |
| | | 0,0400 | 1,0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 660 (600 – 720) |
| M2 | M/E/A | 0.0400 | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 160 (150 – 170) |
| | | 0,0400 | 1,0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 520 (500 – 550) |
| M3 | M/E/A | 0.0300 | 0.80 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 110 (91 – 120) |
| | | 0,0300 | 0,80 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 360 (300 – 390) |
| M4 | M/E/A | 0.0300 | 0.80 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 80 (68 – 94) |
| | | 0,0300 | 0,80 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 260 (230 – 300) |
| M5 | M/E/A | 0.0300 | 0.80 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 70 (57 – 78) |
| | | 0,0300 | 0,80 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 230 (190 – 250) |
| K1 | A/E | 0.0400 | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 315 (270 – 350) |
| | | 0,0400 | 1,0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 1025 (890 – 1100) |
| K2 | A/E | 0.0400 | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 270 (240 – 310) |
| | | 0,0400 | 1,0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 890 (790 – 1000) |
| K3 | A/E | 0.0400 | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 230 (200 – 260) |
| | | 0,0400 | 1,0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 750 (660 – 850) |
| K4 | A/E | 0.0400 | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 220 (190 – 250) |
| | | 0,0400 | 1,0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 720 (630 – 820) |
| K5 | A/E | 0.0300 | 0.80 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 280 (240 – 320) |
| | | 0,0300 | 0,80 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 920 (790 – 1000) |
| K6 | A/E | 0.0300 | 0.80 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 415 (350 – 480) |
| | | 0,0300 | 0,80 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 1350 (1200 – 1500) |
| K7 | A/E | 0.0300 | 0.80 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 355 (300 – 410) |
| | | 0,0300 | 0,80 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 1175 (990 – 1300) |
| S1 | E/M/A | 0.0300 | 0.70 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 115 (93 – 130) |
| | | 0,0300 | 0,70 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 375 (310 – 420) |
| S2 | E/M/A | 0.0300 | 0.70 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 95 (75 – 110) |
| | | 0,0300 | 0,70 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 310 (250 – 360) |
| S3 | E/M/A | 0.0200 | 0.50 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.055 | 0.065 | 0.070 | 0.080 | 0.090 | 0.095 | 0.10 | 0.13 | 0.14 | 50 (40 – 59) |
| | | 0,0200 | 0,50 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0022 | 0,0026 | 0,0028 | 0,0032 | 0,0036 | 0,0038 | 0,0040 | 0,0050 | 0,0055 | 165 (140 – 190) |
| S11 | E/M/A | 0.0400 | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 175 (160 – 190) |
| | | 0,0400 | 1,0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 570 (530 – 620) |
| S12 | E/M/A | 0.0400 | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 135 (120 – 150) |
| | | 0,0400 | 1,0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 0,0048 | 0,0050 | 0,0065 | 0,0065 | 445 (400 – 490) |
| S13 | E/M/A | 0.0400 | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 0.12 | 0.13 | 0.16 | 0.17 | 105 (90 – 110) |
| | | 0,0400 | 1,0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | | | | | | | | | | | |

Schnittdaten – JH910 Nutfräsen

Table with columns: SMG, a_p/DC, f_z (values 2-17), v_c. Rows include P1-P12, M1-M5, K1-K7, S1-S13, TP1, GR1.

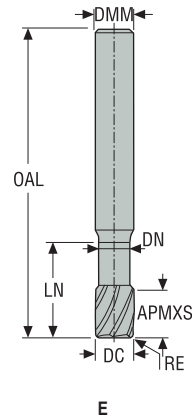
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
v_c= m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

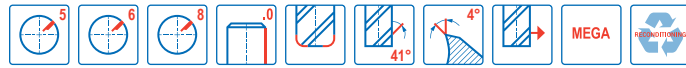
- Universell
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

JH930

Hochgeschwindigkeitsfräsen – Universell – Eckfräser – 5-8 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,05 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|-----------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| 930060R020-MEGA | 00022026 | 2 | E | 6,0 | 6,0 | 9,0 | 55,0 | 15,0 | 5,6 | 0,2 | 5 | ■ |
| 930060R050-MEGA | 00022027 | 2 | E | 6,0 | 6,0 | 9,0 | 55,0 | 15,0 | 5,6 | 0,5 | 5 | ■ |
| 930080R020-MEGA | 00022028 | 2 | E | 8,0 | 8,0 | 12,0 | 60,0 | 18,0 | 7,4 | 0,2 | 5 | ■ |
| 930080R050-MEGA | 00022029 | 2 | E | 8,0 | 8,0 | 12,0 | 60,0 | 18,0 | 7,4 | 0,5 | 5 | ■ |
| 930100R030-MEGA | 00022030 | 2 | E | 10,0 | 10,0 | 15,0 | 70,0 | 25,0 | 9,4 | 0,3 | 6 | ■ |
| 930100R100-MEGA | 00022031 | 2 | E | 10,0 | 10,0 | 15,0 | 70,0 | 25,0 | 9,4 | 1,0 | 6 | ■ |
| 930120R050-MEGA | 00022033 | 2 | E | 12,0 | 12,0 | 18,0 | 80,0 | 30,0 | 11,4 | 0,5 | 6 | ■ |
| 930120R100-MEGA | 00022034 | 2 | E | 12,0 | 12,0 | 18,0 | 80,0 | 30,0 | 11,4 | 1,0 | 6 | ■ |
| 930160R050-MEGA | 00022035 | 2 | E | 16,0 | 16,0 | 24,0 | 90,0 | 35,0 | 15,4 | 0,5 | 8 | ■ |
| 930160R100-MEGA | 00022040 | 2 | E | 16,0 | 16,0 | 24,0 | 90,0 | 35,0 | 15,4 | 1,0 | 8 | ■ |
| 930200R050-MEGA | 00022044 | 2 | E | 20,0 | 20,0 | 30,0 | 100,0 | 38,0 | 19,2 | 0,5 | 8 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und
Composite


Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JH930 Eckfräsen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | v _c |
|-----|---|--------------------|--------------------|------------------|------------------|-----------------|-----------------|-----------------|-----------------|---------------------------------------|
| | | | | 6 | 8 | 10 | 12 | 16 | 20 | |
| P1 | M/E/A | 0,0400 0,0400 | 0,70 0,70 | 0,065 0,0026 | 0,085 0,0034 | 0,11 0,0044 | 0,13 0,0050 | 0,16 0,0065 | 0,18 0,0070 | 440 (370 – 490) 1450 (1300 – 1600) |
| P2 | M/E/A | 0,0400 0,0400 | 0,70 0,70 | 0,065 0,0026 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,16 0,0065 | 0,19 0,0075 | 430 (360 – 480) 1400 (1200 – 1500) |
| P3 | M/E/A | 0,0400 0,0400 | 0,70 0,70 | 0,060 0,0024 | 0,085 0,0034 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,18 0,0070 | 375 (320 – 420) 1225 (1100 – 1300) |
| P4 | M/E/A | 0,0400 0,0400 | 0,70 0,70 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 330 (280 – 370) 1075 (920 – 1200) |
| P5 | M/E/A | 0,0400 0,0400 | 0,70 0,70 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 315 (270 – 350) 1025 (890 – 1100) |
| P6 | M/E/A | 0,0400 0,0400 | 0,70 0,70 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 355 (300 – 390) 1175 (990 – 1200) |
| P7 | M/E/A | 0,0400 0,0400 | 0,70 0,70 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 335 (280 – 370) 1100 (920 – 1200) |
| P8 | M/E/A | 0,0400 0,0400 | 0,70 0,70 | 0,060 0,0024 | 0,085 0,0034 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,18 0,0070 | 315 (270 – 350) 1025 (890 – 1100) |
| P11 | M/E/A | 0,0400 0,0400 | 0,70 0,70 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 325 (280 – 360) 1075 (920 – 1100) |
| P12 | M/E/A | 0,0400 0,0400 | 0,70 0,70 | 0,040 0,0016 | 0,055 0,0022 | 0,070 0,0028 | 0,080 0,0032 | 0,10 0,0040 | 0,11 0,0044 | 200 (170 – 220) 660 (560 – 720) |
| K1 | E/M/A | 0,0400 0,0400 | 0,70 0,70 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 255 (210 – 300) 840 (690 – 980) |
| K2 | E/M/A | 0,0400 0,0400 | 0,70 0,70 | 0,055 0,0022 | 0,075 0,0030 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,15 0,0060 | 225 (180 – 260) 740 (600 – 850) |
| K3 | E/M/A | 0,0400 0,0400 | 0,70 0,70 | 0,055 0,0022 | 0,075 0,0030 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,15 0,0060 | 190 (160 – 220) 620 (530 – 720) |
| K4 | E/M/A | 0,0400 0,0400 | 0,70 0,70 | 0,055 0,0022 | 0,075 0,0030 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,15 0,0060 | 180 (150 – 210) 590 (500 – 680) |
| K5 | E/M/A | 0,0300 0,0300 | 0,50 0,50 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 205 (160 – 250) 670 (530 – 820) |
| K6 | E/M/A | 0,0300 0,0300 | 0,50 0,50 | 0,065 0,0026 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,16 0,0065 | 0,19 0,0075 | 300 (230 – 370) 980 (760 – 1200) |
| K7 | E/M/A | 0,0300 0,0300 | 0,50 0,50 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 260 (200 – 320) 850 (660 – 1000) |
| S1 | E/M/A | 0,0300 0,0300 | 0,44 0,44 | 0,055 0,0022 | 0,070 0,0028 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,15 0,0060 | 80 (62 – 100) 260 (210 – 320) |
| S2 | E/M/A | 0,0300 0,0300 | 0,44 0,44 | 0,055 0,0022 | 0,070 0,0028 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,15 0,0060 | 65 (50 – 82) 215 (170 – 260) |
| S3 | E/M/A | 0,0200 0,0200 | 0,70 0,70 | 0,055 0,0022 | 0,070 0,0028 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,15 0,0060 | 41 (31 – 50) 135 (110 – 160) |
| S11 | E/M/A | 0,0400 0,0400 | 0,70 0,70 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 160 (140 – 180) 520 (460 – 590) |
| S12 | E/M/A | 0,0400 0,0400 | 0,70 0,70 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 120 (110 – 140) 395 (370 – 450) |
| S13 | E/M/A | 0,0400 0,0400 | 0,70 0,70 | 0,050 0,0020 | 0,070 0,0028 | 0,085 0,0034 | 0,10 0,0040 | 0,13 0,0050 | 0,15 0,0060 | 95 (81 – 110) 310 (270 – 360) |
| H3 | M/A | 0,0200 0,0200 | 0,50 0,50 | 0,018 0,00070 | 0,024 0,00095 | 0,030 0,0012 | 0,036 0,0014 | 0,044 0,0017 | 0,050 0,0020 | 55 (41 – 71) 180 (140 – 230) |
| H5 | M/A | 0,0300 0,0300 | 0,50 0,50 | 0,024 0,00095 | 0,032 0,0013 | 0,040 0,0016 | 0,048 0,0019 | 0,060 0,0024 | 0,070 0,0028 | 250 (210 – 300) 820 (690 – 980) |
| H7 | M/A | 0,0200 0,0200 | 0,50 0,50 | 0,018 0,00070 | 0,024 0,00095 | 0,030 0,0012 | 0,036 0,0014 | 0,044 0,0017 | 0,050 0,0020 | 55 (41 – 71) 180 (140 – 230) |
| H8 | M/A | 0,0300 0,0300 | 0,50 0,50 | 0,018 0,00070 | 0,024 0,00095 | 0,030 0,0012 | 0,036 0,0014 | 0,044 0,0017 | 0,050 0,0020 | 255 (210 – 300) 840 (690 – 980) |
| H11 | M/A | 0,0300 0,0300 | 0,50 0,50 | 0,024 0,00095 | 0,032 0,0013 | 0,040 0,0016 | 0,048 0,0019 | 0,060 0,0024 | 0,070 0,0028 | 320 (260 – 380) 1050 (860 – 1200) |
| H12 | M/A | 0,0400 0,0400 | 0,70 0,70 | 0,030 0,0012 | 0,042 0,0017 | 0,050 0,0020 | 0,060 0,0024 | 0,075 0,0030 | 0,085 0,0034 | 270 (220 – 320) 890 (730 – 1000) |
| H21 | M/A | 0,0300 0,0300 | 0,50 0,50 | 0,018 0,00070 | 0,024 0,00095 | 0,030 0,0012 | 0,036 0,0014 | 0,044 0,0017 | 0,050 0,0020 | 255 (210 – 300) 840 (690 – 980) |
| H31 | M/A | 0,0300 0,0300 | 0,50 0,50 | 0,024 0,00095 | 0,032 0,0013 | 0,040 0,0016 | 0,048 0,0019 | 0,060 0,0024 | 0,070 0,0028 | 155 (130 – 180) 510 (430 – 590) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

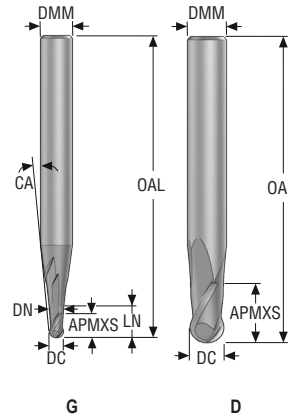
a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

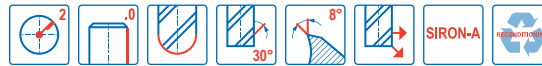
Universell
Stahl und Guss
Stahl und Guss
Rohtrenn- und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

JHB970

Hochgeschwindigkeitsfräsen – Universell – Kugelkopf – 2 Schneiden – Zylindrisch



- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | CA° | PCEDC | Zylindrisch |
|------------------|--------------|----------------|--------------|---------------|------|------|-------|-------|------|-----|-----|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | | | |
| JHB970020G1B.0Z2 | SIRA | 10072058 | 1 | G | 2,0 | 3,0 | 3,0 | 50,0 | 10,0 | 1,9 | 2,5 | 2 | ■ |
| JHB970030D1B.0Z2 | SIRA | 10072059 | 1 | D | 3,0 | 3,0 | 4,5 | 50,0 | - | - | - | 2 | ■ |
| JHB970040D1B.0Z2 | SIRA | 10072060 | 1 | D | 4,0 | 4,0 | 6,0 | 60,0 | - | - | - | 2 | ■ |
| JHB970050D1B.0Z2 | SIRA | 10072061 | 1 | D | 5,0 | 5,0 | 7,5 | 60,0 | - | - | - | 2 | ■ |
| JHB970060D1B.0Z2 | SIRA | 10072062 | 1 | D | 6,0 | 6,0 | 9,0 | 75,0 | - | - | - | 2 | ■ |
| JHB970020G2B.0Z2 | SIRA | 10072063 | 2 | G | 2,0 | 6,0 | 3,0 | 60,0 | 4,0 | 1,9 | 8,0 | 2 | ■ |
| JHB970025G2B.0Z2 | SIRA | 10072064 | 2 | G | 2,5 | 6,0 | 4,0 | 60,0 | 5,0 | 2,4 | 7,5 | 2 | ■ |
| JHB970030G2B.0Z2 | SIRA | 10072065 | 2 | G | 3,0 | 6,0 | 4,5 | 60,0 | 6,0 | 2,8 | 5,5 | 2 | ■ |
| JHB970035G2B.0Z2 | SIRA | 10072066 | 2 | G | 3,5 | 6,0 | 5,0 | 60,0 | 7,0 | 3,2 | 4,5 | 2 | ■ |
| JHB970040G2B.0Z2 | SIRA | 10072067 | 2 | G | 4,0 | 6,0 | 6,0 | 60,0 | 8,0 | 3,7 | 3,0 | 2 | ■ |
| JHB970050G2B.0Z2 | SIRA | 10072068 | 2 | G | 5,0 | 6,0 | 7,5 | 60,0 | 10,0 | 4,6 | 2,0 | 2 | ■ |
| JHB970060G2B.0Z2 | SIRA | 10072069 | 2 | G | 6,0 | 8,0 | 9,0 | 75,0 | 12,0 | 5,6 | 2,5 | 2 | ■ |
| JHB970080D2B.0Z2 | SIRA | 10072070 | 2 | D | 8,0 | 8,0 | 12,0 | 75,0 | - | - | - | 2 | ■ |
| JHB970100D2B.0Z2 | SIRA | 10072071 | 2 | D | 10,0 | 10,0 | 15,0 | 80,0 | - | - | - | 2 | ■ |
| JHB970120D2B.0Z2 | SIRA | 10072072 | 2 | D | 12,0 | 12,0 | 18,0 | 90,0 | - | - | - | 2 | ■ |
| JHB970160D2B.0Z2 | SIRA | 10072073 | 2 | D | 16,0 | 16,0 | 24,0 | 100,0 | - | - | - | 2 | ■ |
| JHB970020G3B.0Z2 | SIRA | 10072074 | 3 | G | 2,0 | 6,0 | 3,0 | 80,0 | 4,0 | 1,9 | 8,0 | 2 | ■ |
| JHB970030G3B.0Z2 | SIRA | 10072075 | 3 | G | 3,0 | 6,0 | 4,5 | 80,0 | 6,0 | 2,8 | 5,5 | 2 | ■ |
| JHB970040G3B.0Z2 | SIRA | 10072076 | 3 | G | 4,0 | 6,0 | 6,0 | 80,0 | 8,0 | 3,7 | 3,0 | 2 | ■ |
| JHB970060G3B.0Z2 | SIRA | 10072077 | 3 | G | 6,0 | 8,0 | 9,0 | 100,0 | 12,0 | 5,6 | 2,5 | 2 | ■ |
| JHB970080D3B.0Z2 | SIRA | 10072078 | 3 | D | 8,0 | 8,0 | 12,0 | 108,0 | - | - | - | 2 | ■ |
| JHB970100D3B.0Z2 | SIRA | 10072079 | 3 | D | 10,0 | 10,0 | 15,0 | 125,0 | - | - | - | 2 | ■ |
| JHB970120D3B.0Z2 | SIRA | 10072080 | 3 | D | 12,0 | 12,0 | 18,0 | 125,0 | - | - | - | 2 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JHB970 Kopierfräsen/Schruppen

| SMG | Kühlung | a _e /DC | a _p /DC | f _z | | | | | | | | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|--------|-----------------|
| | | | | 2 | 2.5 | 3 | 3.5 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | |
| P1 | M | 0.200 | 1.0 | 0.011 | 0.014 | 0.016 | 0.019 | 0.022 | 0.028 | 0.032 | 0.044 | 0.055 | 0.065 | 0.080 | 210 (190 – 230) |
| | | 0,200 | 1,0 | 0,00044 | 0,00055 | 0,00065 | 0,00075 | 0,00085 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 690 (630 – 750) |
| P2 | M | 0.200 | 1.0 | 0.011 | 0.014 | 0.017 | 0.019 | 0.022 | 0.028 | 0.034 | 0.044 | 0.055 | 0.065 | 0.080 | 205 (180 – 230) |
| | | 0,200 | 1,0 | 0,00044 | 0,00055 | 0,00065 | 0,00075 | 0,00085 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 670 (600 – 750) |
| P3 | M | 0.200 | 1.0 | 0.010 | 0.013 | 0.016 | 0.018 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 0.075 | 180 (160 – 200) |
| | | 0,200 | 1,0 | 0,00040 | 0,00050 | 0,00065 | 0,00070 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 590 (530 – 650) |
| P4 | M | 0.200 | 1.0 | 0.010 | 0.013 | 0.015 | 0.018 | 0.020 | 0.026 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 155 (140 – 170) |
| | | 0,200 | 1,0 | 0,00040 | 0,00050 | 0,00060 | 0,00070 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 510 (460 – 550) |
| P5 | M | 0.200 | 1.0 | 0.010 | 0.012 | 0.015 | 0.018 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 150 (140 – 170) |
| | | 0,200 | 1,0 | 0,00040 | 0,00048 | 0,00060 | 0,00065 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 490 (460 – 550) |
| P6 | M | 0.200 | 1.0 | 0.010 | 0.012 | 0.015 | 0.017 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 170 (150 – 190) |
| | | 0,200 | 1,0 | 0,00040 | 0,00048 | 0,00060 | 0,00065 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 560 (500 – 620) |
| P7 | M | 0.200 | 1.0 | 0.010 | 0.012 | 0.015 | 0.017 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 160 (140 – 180) |
| | | 0,200 | 1,0 | 0,00040 | 0,00048 | 0,00060 | 0,00065 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 520 (460 – 590) |
| P8 | M | 0.200 | 1.0 | 0.010 | 0.013 | 0.016 | 0.018 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 0.075 | 150 (140 – 170) |
| | | 0,200 | 1,0 | 0,00040 | 0,00050 | 0,00065 | 0,00070 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 490 (460 – 550) |
| P11 | M | 0.200 | 1.0 | 0.010 | 0.012 | 0.015 | 0.017 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 75 (67 – 86) |
| | | 0,200 | 1,0 | 0,00040 | 0,00048 | 0,00060 | 0,00065 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 245 (220 – 280) |
| P12 | M | 0.200 | 1.0 | 0.0070 | 0.0085 | 0.010 | 0.012 | 0.014 | 0.017 | 0.020 | 0.028 | 0.034 | 0.040 | 0.050 | 48 (42 – 53) |
| | | 0,200 | 1,0 | 0,00028 | 0,00034 | 0,00040 | 0,00048 | 0,00055 | 0,00065 | 0,00080 | 0,0011 | 0,0013 | 0,0016 | 0,0020 | 155 (140 – 170) |
| M1 | E | 0.200 | 1.0 | 0.0090 | 0.011 | 0.013 | 0.015 | 0.018 | 0.022 | 0.026 | 0.036 | 0.044 | 0.050 | 0.065 | 90 (80 – 100) |
| | | 0,200 | 1,0 | 0,00036 | 0,00044 | 0,00050 | 0,00060 | 0,00070 | 0,00085 | 0,0010 | 0,0014 | 0,0017 | 0,0020 | 0,0026 | 295 (270 – 320) |
| M2 | E | 0.200 | 1.0 | 0.0080 | 0.010 | 0.012 | 0.014 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 75 (65 – 85) |
| | | 0,200 | 1,0 | 0,00032 | 0,00040 | 0,00048 | 0,00055 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 245 (220 – 270) |
| M3 | E | 0.150 | 1.0 | 0.0060 | 0.0075 | 0.0090 | 0.010 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.044 | 65 (55 – 75) |
| | | 0,150 | 1,0 | 0,00024 | 0,00030 | 0,00036 | 0,00040 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0017 | 215 (190 – 240) |
| M4 | E | 0.150 | 1.0 | 0.0050 | 0.0065 | 0.0080 | 0.0090 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.038 | 49 (42 – 56) |
| | | 0,150 | 1,0 | 0,00020 | 0,00026 | 0,00032 | 0,00036 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0015 | 160 (140 – 180) |
| M5 | E | 0.150 | 1.0 | 0.0050 | 0.0065 | 0.0080 | 0.0090 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.038 | 41 (35 – 47) |
| | | 0,150 | 1,0 | 0,00020 | 0,00026 | 0,00032 | 0,00036 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0015 | 135 (120 – 150) |
| S1 | E | 0.100 | 0.80 | 0.0060 | 0.0075 | 0.0090 | 0.010 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.044 | 50 (40 – 59) |
| | | 0,100 | 0,80 | 0,00024 | 0,00030 | 0,00036 | 0,00040 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0017 | 165 (140 – 190) |
| S2 | E | 0.100 | 0.80 | 0.0060 | 0.0075 | 0.0090 | 0.010 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.044 | 40 (33 – 48) |
| | | 0,100 | 0,80 | 0,00024 | 0,00030 | 0,00036 | 0,00040 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0017 | 130 (110 – 150) |
| S3 | E | 0.100 | 0.60 | 0.0040 | 0.0050 | 0.0060 | 0.0070 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.028 | 30 (20 – 39) |
| | | 0,100 | 0,60 | 0,00016 | 0,00020 | 0,00024 | 0,00028 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0011 | 100 (66 – 120) |
| S11 | E | 0.200 | 1.0 | 0.010 | 0.012 | 0.015 | 0.018 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 90 (79 – 100) |
| | | 0,200 | 1,0 | 0,00040 | 0,00048 | 0,00060 | 0,00065 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 295 (260 – 320) |
| S12 | E | 0.200 | 1.0 | 0.010 | 0.012 | 0.015 | 0.018 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 70 (61 – 80) |
| | | 0,200 | 1,0 | 0,00040 | 0,00048 | 0,00060 | 0,00065 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 230 (210 – 260) |
| S13 | E | 0.200 | 1.0 | 0.0085 | 0.011 | 0.013 | 0.015 | 0.017 | 0.022 | 0.026 | 0.034 | 0.044 | 0.050 | 0.065 | 55 (48 – 63) |
| | | 0,200 | 1,0 | 0,00034 | 0,00044 | 0,00050 | 0,00060 | 0,00065 | 0,00085 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0026 | 180 (160 – 200) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

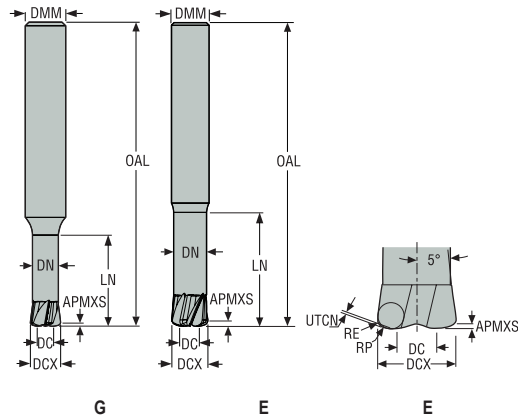
a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

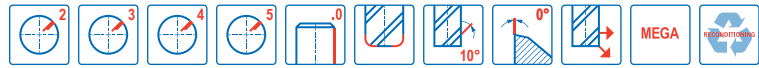
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X-Heads
Minimaster Plus
Minimaster

JHF980

Hochvorschubfräser – Universell – 2-5 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,05 mm
- CA= Kollisionswinkel
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



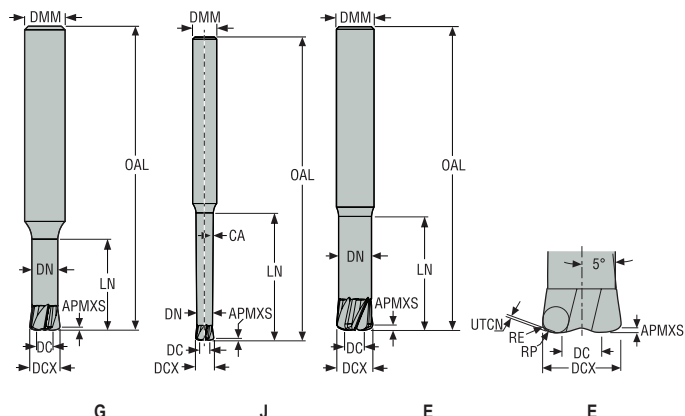
| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DCX | DC | DMM | APMXS | OAL | LN | DN | RE | RP | UTCN | CA° | PCEDC | Zylindrisch |
|-----------------------|--------------------|------------------|-------------------|------|------|------|-------|------|------|------|------|-------|-------|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | mm | mm | | | |
| 980K080Z3-MEGA | 02587115 | 1 | E | 8,0 | 4,0 | 8,0 | 0,4 | 70,0 | 12,0 | 3,0 | 0,6 | 0,935 | 0,198 | - | 3 | ■ |
| JHF980080E1H.0Z5-MEGA | 03003384 | 1 | E | 8,0 | 4,0 | 8,0 | 0,4 | 70,0 | 12,0 | 7,0 | 0,6 | 0,935 | 0,198 | - | 5 | ■ |
| 980K100Z3-MEGA | 02587117 | 1 | E | 10,0 | 5,0 | 10,0 | 0,45 | 80,0 | 15,0 | 3,8 | 0,8 | 1,176 | 0,232 | - | 3 | ■ |
| JHF980100E1H.0Z5-MEGA | 03003385 | 1 | E | 10,0 | 5,0 | 10,0 | 0,45 | 80,0 | 15,0 | 8,8 | 0,8 | 1,176 | 0,232 | - | 5 | ■ |
| 980K120Z3-MEGA | 02587118 | 1 | E | 12,0 | 6,0 | 12,0 | 0,5 | 80,0 | 18,0 | 4,6 | 1,0 | 1,417 | 0,265 | - | 3 | ■ |
| JHF980120E1H.0Z5-MEGA | 03003386 | 1 | E | 12,0 | 6,0 | 12,0 | 0,5 | 80,0 | 18,0 | 10,6 | 1,0 | 1,417 | 0,265 | - | 5 | ■ |
| 980010-MEGA | 02587111 | 2 | G | 1,0 | 0,5 | 6,0 | 0,07 | 40,0 | 3,0 | 0,7 | 0,07 | 0,127 | 0,028 | 19,5 | 2 | ■ |
| 980015-MEGA | 02511199 | 2 | G | 1,5 | 0,75 | 6,0 | 0,1 | 40,0 | 4,5 | 1,2 | 0,1 | 0,183 | 0,043 | 14,0 | 2 | ■ |
| 980020-MEGA | 02511221 | 2 | G | 2,0 | 1,0 | 6,0 | 0,15 | 40,0 | 6,0 | 1,7 | 0,15 | 0,269 | 0,055 | 11,0 | 2 | ■ |
| 980030-MEGA | 02511224 | 2 | G | 3,0 | 1,5 | 6,0 | 0,2 | 50,0 | 9,0 | 2,6 | 0,2 | 0,366 | 0,085 | 7,0 | 2 | ■ |
| JHF980030G2H.0Z4-MEGA | 03003387 | 2 | G | 3,0 | 1,5 | 6,0 | 0,2 | 50,0 | 9,0 | 2,6 | 0,2 | 0,366 | 0,085 | 7,12 | 4 | ■ |
| 980040-MEGA | 02511229 | 2 | G | 4,0 | 2,0 | 6,0 | 0,25 | 60,0 | 12,0 | 3,5 | 0,3 | 0,503 | 0,107 | 4,0 | 2 | ■ |
| JHF980040G2H.0Z4-MEGA | 03003388 | 2 | G | 4,0 | 2,0 | 6,0 | 0,25 | 60,0 | 12,0 | 3,5 | 0,3 | 0,503 | 0,107 | 4,0 | 4 | ■ |
| 980050-MEGA | 02511233 | 2 | G | 5,0 | 2,5 | 6,0 | 0,3 | 60,0 | 15,0 | 4,4 | 0,4 | 0,641 | 0,128 | 2,0 | 2 | ■ |
| JHF980050G2H.0Z4-MEGA | 03003389 | 2 | G | 5,0 | 2,5 | 6,0 | 0,3 | 60,0 | 15,0 | 4,4 | 0,4 | 0,641 | 0,128 | 1,77 | 4 | ■ |
| 980060-MEGA | 02511314 | 2 | G | 6,0 | 3,0 | 8,0 | 0,35 | 60,0 | 18,0 | 5,2 | 0,5 | 0,778 | 0,15 | 3,0 | 2 | ■ |
| JHF980060G2H.0Z4-MEGA | 03003390 | 2 | G | 6,0 | 3,0 | 8,0 | 0,35 | 60,0 | 18,0 | 5,2 | 0,5 | 0,778 | 0,15 | 2,86 | 4 | ■ |
| 980080-MEGA | 02511322 | 2 | E | 8,0 | 4,0 | 8,0 | 0,4 | 70,0 | 24,0 | 7,0 | 0,6 | 0,935 | 0,198 | - | 2 | ■ |
| JHF980080E2H.0Z5-MEGA | 03003391 | 2 | E | 8,0 | 4,0 | 8,0 | 0,4 | 70,0 | 24,0 | 7,0 | 0,6 | 0,935 | 0,198 | - | 5 | ■ |
| 980100-MEGA | 02511341 | 2 | E | 10,0 | 5,0 | 10,0 | 0,45 | 80,0 | 30,0 | 8,8 | 0,8 | 1,176 | 0,232 | - | 2 | ■ |
| 980100Z3-MEGA | 02511342 | 2 | E | 10,0 | 5,0 | 10,0 | 0,45 | 80,0 | 30,0 | 8,8 | 0,8 | 1,176 | 0,232 | - | 3 | ■ |
| JHF980100E2H.0Z5-MEGA | 03003392 | 2 | E | 10,0 | 5,0 | 10,0 | 0,45 | 80,0 | 30,0 | 8,8 | 0,8 | 1,176 | 0,232 | - | 5 | ■ |
| 980120-MEGA | 02511346 | 2 | E | 12,0 | 6,0 | 12,0 | 0,5 | 80,0 | 36,0 | 10,6 | 1,0 | 1,417 | 0,265 | - | 2 | ■ |
| 980120Z3-MEGA | 02511347 | 2 | E | 12,0 | 6,0 | 12,0 | 0,5 | 80,0 | 36,0 | 10,6 | 1,0 | 1,417 | 0,265 | - | 3 | ■ |
| JHF980120E2H.0Z5-MEGA | 03003393 | 2 | E | 12,0 | 6,0 | 12,0 | 0,5 | 80,0 | 36,0 | 10,6 | 1,0 | 1,417 | 0,265 | - | 5 | ■ |

■ Lagerstandard.
*UTCN = Theoretische Abweichung

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Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

JHF980

Hochvorschubfräser – Universell – 2-5 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM= h5
- DC= -0,02/-0,05 mm
- RE= ±0,05 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DCX | DC | DMM | APMXS | OAL | LN | DN | RE | RP | UTCN | CA° | NA | PCEDC | Zylindrisch |
|-----------------------|--------------------|------------------|-------------------|------|------|------|-------|-------|------|------|------|-------|-------|------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| 980ML010-MEGA | 02587113 | 3 | G | 1,0 | 0,5 | 6,0 | 0,07 | 40,0 | 5,0 | 0,7 | 0,07 | 0,127 | 0,028 | 15,5 | 0,0 | 2 | ■ |
| 980ML015-MEGA | 02511219 | 3 | G | 1,5 | 0,75 | 6,0 | 0,1 | 40,0 | 7,5 | 1,2 | 0,1 | 0,183 | 0,043 | 10,5 | 0,0 | 2 | ■ |
| 980ML020-MEGA | 02511222 | 3 | G | 2,0 | 1,0 | 6,0 | 0,15 | 40,0 | 10,0 | 1,7 | 0,15 | 0,269 | 0,055 | 8,0 | 0,0 | 2 | ■ |
| JHF980020G3H.0Z4-MEGA | 03003394 | 3 | G | 2,0 | 1,0 | 6,0 | 0,15 | 40,0 | 10,0 | 1,7 | 0,15 | 0,269 | 0,055 | 8,46 | 0,0 | 4 | ■ |
| 980ML030-MEGA | 02511225 | 3 | G | 3,0 | 1,5 | 6,0 | 0,2 | 50,0 | 15,0 | 2,6 | 0,2 | 0,366 | 0,085 | 5,0 | 0,0 | 2 | ■ |
| JHF980030G3H.0Z4-MEGA | 03003395 | 3 | G | 3,0 | 1,5 | 6,0 | 0,2 | 50,0 | 15,0 | 2,6 | 0,2 | 0,366 | 0,085 | 4,79 | 0,0 | 4 | ■ |
| 980ML040-MEGA | 02511231 | 3 | G | 4,0 | 2,0 | 6,0 | 0,25 | 70,0 | 20,0 | 3,5 | 0,3 | 0,503 | 0,107 | 2,5 | 0,0 | 2 | ■ |
| JHF980040G3H.0Z4-MEGA | 03003396 | 3 | G | 4,0 | 2,0 | 6,0 | 0,25 | 70,0 | 20,0 | 3,5 | 0,3 | 0,503 | 0,107 | 2,59 | 0,0 | 4 | ■ |
| 980ML050-MEGA | 02511234 | 3 | G | 5,0 | 2,5 | 6,0 | 0,3 | 80,0 | 25,0 | 4,4 | 0,4 | 0,641 | 0,128 | 1,5 | 0,0 | 2 | ■ |
| JHF980050G3H.0Z4-MEGA | 03003397 | 3 | G | 5,0 | 2,5 | 6,0 | 0,3 | 80,0 | 25,0 | 4,4 | 0,4 | 0,641 | 0,128 | 1,12 | 0,0 | 4 | ■ |
| 980ML060-MEGA | 02511315 | 3 | G | 6,0 | 3,0 | 8,0 | 0,35 | 80,0 | 30,0 | 5,2 | 0,5 | 0,778 | 0,15 | 2,0 | 0,0 | 2 | ■ |
| JHF980060G3H.0Z4-MEGA | 03003398 | 3 | G | 6,0 | 3,0 | 8,0 | 0,35 | 80,0 | 30,0 | 5,2 | 0,5 | 0,778 | 0,15 | 1,8 | 0,0 | 4 | ■ |
| 980ML080-MEGA | 02511338 | 3 | E | 8,0 | 4,0 | 8,0 | 0,4 | 80,0 | 40,0 | 7,0 | 0,6 | 0,935 | 0,198 | – | 0,0 | 2 | ■ |
| JHF980080E3H.0Z5-MEGA | 03003399 | 3 | E | 8,0 | 4,0 | 8,0 | 0,4 | 80,0 | 40,0 | 7,0 | 0,6 | 0,935 | 0,198 | – | 0,0 | 5 | ■ |
| 980ML100-MEGA | 02511344 | 3 | E | 10,0 | 5,0 | 10,0 | 0,45 | 90,0 | 50,0 | 8,8 | 0,8 | 1,176 | 0,232 | – | 0,0 | 2 | ■ |
| JHF980100E3H.0Z5-MEGA | 03003400 | 3 | E | 10,0 | 5,0 | 10,0 | 0,45 | 90,0 | 50,0 | 8,8 | 0,8 | 1,176 | 0,232 | – | 0,0 | 5 | ■ |
| 980ML120-MEGA | 02511348 | 3 | E | 12,0 | 6,0 | 12,0 | 0,5 | 110,0 | 60,0 | 10,6 | 1,0 | 1,417 | 0,265 | – | 0,0 | 2 | ■ |
| JHF980120E3H.0Z5-MEGA | 03003401 | 3 | E | 12,0 | 6,0 | 12,0 | 0,5 | 110,0 | 60,0 | 10,6 | 1,0 | 1,417 | 0,265 | – | 0,0 | 5 | ■ |
| 980TL010-MEGA | 02587114 | 4 | J | 1,0 | 0,5 | 6,0 | 0,07 | 40,0 | 7,0 | 0,7 | 0,07 | 0,127 | 0,028 | 13,0 | 0,5 | 2 | ■ |
| 980TL015-MEGA | 02511220 | 4 | J | 1,5 | 0,75 | 6,0 | 0,1 | 40,0 | 10,5 | 1,2 | 0,1 | 0,183 | 0,043 | 8,5 | 0,5 | 2 | ■ |
| 980TL020-MEGA | 02511223 | 4 | J | 2,0 | 1,0 | 6,0 | 0,15 | 50,0 | 14,0 | 1,7 | 0,15 | 0,269 | 0,055 | 6,5 | 0,5 | 2 | ■ |
| 980TL030-MEGA | 02511226 | 4 | J | 3,0 | 1,5 | 6,0 | 0,2 | 60,0 | 21,0 | 2,6 | 0,2 | 0,366 | 0,085 | 3,5 | 0,5 | 2 | ■ |
| JHF980030J4H.0Z4-MEGA | 03003402 | 4 | J | 3,0 | 1,5 | 6,0 | 0,2 | 60,0 | 21,0 | 2,6 | 0,2 | 0,366 | 0,085 | 3,63 | 0,5 | 4 | ■ |
| 980TL040-MEGA | 02511232 | 4 | J | 4,0 | 2,0 | 6,0 | 0,25 | 80,0 | 28,0 | 3,5 | 0,3 | 0,503 | 0,107 | 2,0 | 0,5 | 2 | ■ |
| JHF980040J4H.0Z4-MEGA | 03003403 | 4 | J | 4,0 | 2,0 | 6,0 | 0,25 | 80,0 | 28,0 | 3,5 | 0,3 | 0,503 | 0,107 | 1,93 | 0,5 | 4 | ■ |
| 980TL050-MEGA | 02511240 | 4 | J | 5,0 | 2,5 | 6,0 | 0,3 | 90,0 | 35,0 | 4,4 | 0,4 | 0,641 | 0,128 | 1,0 | 0,5 | 2 | ■ |
| JHF980050J4H.0Z4-MEGA | 03003404 | 4 | J | 5,0 | 2,5 | 6,0 | 0,3 | 90,0 | 35,0 | 4,4 | 0,4 | 0,641 | 0,128 | 0,82 | 0,5 | 4 | ■ |
| 980TL060-MEGA | 02511321 | 4 | J | 6,0 | 3,0 | 8,0 | 0,35 | 100,0 | 42,0 | 5,2 | 0,5 | 0,778 | 0,15 | 1,5 | 0,5 | 2 | ■ |
| JHF980060J4H.0Z4-MEGA | 03003405 | 4 | J | 6,0 | 3,0 | 8,0 | 0,35 | 100,0 | 42,0 | 5,2 | 0,5 | 0,778 | 0,15 | 1,33 | 0,5 | 4 | ■ |
| 980TL080-MEGA | 02511340 | 4 | E | 8,0 | 4,0 | 8,0 | 0,4 | 100,0 | 56,0 | 7,0 | 0,6 | 0,935 | 0,198 | – | 0,5 | 2 | ■ |
| JHF980080E4H.0Z5-MEGA | 03003406 | 4 | E | 8,0 | 4,0 | 8,0 | 0,4 | 100,0 | 56,0 | 7,0 | 0,6 | 0,935 | 0,198 | – | 0,0 | 5 | ■ |
| 980TL100-MEGA | 02511345 | 4 | E | 10,0 | 5,0 | 10,0 | 0,45 | 110,0 | 70,0 | 8,8 | 0,8 | 1,176 | 0,232 | – | 0,5 | 2 | ■ |
| JHF980100E4H.0Z5-MEGA | 03003407 | 4 | E | 10,0 | 5,0 | 10,0 | 0,45 | 110,0 | 70,0 | 8,8 | 0,8 | 1,176 | 0,232 | – | 0,0 | 5 | ■ |
| 980TL120-MEGA | 02511349 | 4 | E | 12,0 | 6,0 | 12,0 | 0,5 | 130,0 | 84,0 | 10,6 | 1,0 | 1,417 | 0,265 | – | 0,5 | 2 | ■ |
| JHF980120E4H.0Z5-MEGA | 03003408 | 4 | E | 12,0 | 6,0 | 12,0 | 0,5 | 130,0 | 84,0 | 10,6 | 1,0 | 1,417 | 0,265 | – | 0,0 | 5 | ■ |

■ Lagerstandard. *UTCN = Theoretische Abweichung


Schnittdaten – JHF980 Eckfräsen

| SMG | | a _e /DCX | a _p /DCX | f _z | | | | | | | | | | v _c |
|-----|-------|---------------------|---------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|-------|--------------------|
| | | | | 1 | 1.5 | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | |
| P1 | E/M/A | 0.30 | 0.040 | 0.050 | 0.075 | 0.10 | 0.15 | 0.20 | 0.25 | 0.30 | 0.40 | 0.50 | 0.60 | 385 (350 – 430) |
| | | 0.30 | 0.040 | 0.0020 | 0.0030 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 1275 (1200 – 1400) |
| P2 | E/M/A | 0.30 | 0.040 | 0.050 | 0.075 | 0.10 | 0.15 | 0.20 | 0.25 | 0.30 | 0.40 | 0.50 | 0.60 | 375 (340 – 410) |
| | | 0.30 | 0.040 | 0.0020 | 0.0030 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 1225 (1200 – 1300) |
| P3 | E/M/A | 0.30 | 0.040 | 0.050 | 0.075 | 0.10 | 0.15 | 0.20 | 0.25 | 0.30 | 0.40 | 0.50 | 0.60 | 325 (290 – 360) |
| | | 0.30 | 0.040 | 0.0020 | 0.0030 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 1075 (960 – 1100) |
| P4 | E/M/A | 0.30 | 0.040 | 0.050 | 0.075 | 0.10 | 0.15 | 0.20 | 0.25 | 0.30 | 0.40 | 0.50 | 0.60 | 285 (260 – 310) |
| | | 0.30 | 0.040 | 0.0020 | 0.0030 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 940 (860 – 1000) |
| P5 | E/M/A | 0.30 | 0.040 | 0.050 | 0.075 | 0.10 | 0.15 | 0.20 | 0.25 | 0.30 | 0.40 | 0.50 | 0.60 | 275 (250 – 300) |
| | | 0.30 | 0.040 | 0.0020 | 0.0030 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 900 (830 – 980) |
| P6 | E/M/A | 0.30 | 0.040 | 0.044 | 0.070 | 0.090 | 0.14 | 0.18 | 0.22 | 0.28 | 0.36 | 0.44 | 0.55 | 215 (190 – 240) |
| | | 0.30 | 0.040 | 0.0017 | 0.0028 | 0.0036 | 0.0055 | 0.0070 | 0.0085 | 0.011 | 0.014 | 0.017 | 0.022 | 710 (630 – 780) |
| P7 | E/M/A | 0.30 | 0.040 | 0.044 | 0.070 | 0.090 | 0.14 | 0.18 | 0.22 | 0.28 | 0.36 | 0.44 | 0.55 | 205 (180 – 230) |
| | | 0.30 | 0.040 | 0.0017 | 0.0028 | 0.0036 | 0.0055 | 0.0070 | 0.0085 | 0.011 | 0.014 | 0.017 | 0.022 | 670 (600 – 750) |
| P8 | E/M/A | 0.30 | 0.040 | 0.044 | 0.070 | 0.090 | 0.14 | 0.18 | 0.22 | 0.28 | 0.36 | 0.44 | 0.55 | 190 (170 – 210) |
| | | 0.30 | 0.040 | 0.0017 | 0.0028 | 0.0036 | 0.0055 | 0.0070 | 0.0085 | 0.011 | 0.014 | 0.017 | 0.022 | 620 (560 – 680) |
| P11 | E/M/A | 0.30 | 0.040 | 0.044 | 0.070 | 0.090 | 0.14 | 0.18 | 0.22 | 0.28 | 0.36 | 0.44 | 0.55 | 195 (170 – 220) |
| | | 0.30 | 0.040 | 0.0017 | 0.0028 | 0.0036 | 0.0055 | 0.0070 | 0.0085 | 0.011 | 0.014 | 0.017 | 0.022 | 640 (560 – 720) |
| P12 | E/M/A | 0.30 | 0.036 | 0.040 | 0.060 | 0.080 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.48 | 120 (110 – 130) |
| | | 0.30 | 0.036 | 0.0016 | 0.0024 | 0.0032 | 0.0048 | 0.0065 | 0.0080 | 0.0095 | 0.013 | 0.016 | 0.019 | 395 (370 – 420) |
| M1 | E/M/A | 0.30 | 0.036 | 0.040 | 0.060 | 0.080 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.48 | 190 (170 – 210) |
| | | 0.30 | 0.036 | 0.0016 | 0.0024 | 0.0032 | 0.0048 | 0.0065 | 0.0080 | 0.0095 | 0.013 | 0.016 | 0.019 | 620 (560 – 680) |
| M2 | E/M/A | 0.30 | 0.036 | 0.040 | 0.060 | 0.080 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.48 | 150 (140 – 160) |
| | | 0.30 | 0.036 | 0.0016 | 0.0024 | 0.0032 | 0.0048 | 0.0065 | 0.0080 | 0.0095 | 0.013 | 0.016 | 0.019 | 490 (460 – 520) |
| M3 | E/M/A | 0.30 | 0.036 | 0.040 | 0.060 | 0.080 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.48 | 115 (98 – 130) |
| | | 0.30 | 0.036 | 0.0016 | 0.0024 | 0.0032 | 0.0048 | 0.0065 | 0.0080 | 0.0095 | 0.013 | 0.016 | 0.019 | 375 (330 – 420) |
| M4 | E/M/A | 0.30 | 0.036 | 0.040 | 0.060 | 0.080 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.48 | 85 (73 – 100) |
| | | 0.30 | 0.036 | 0.0016 | 0.0024 | 0.0032 | 0.0048 | 0.0065 | 0.0080 | 0.0095 | 0.013 | 0.016 | 0.019 | 280 (240 – 320) |
| M5 | E/M/A | 0.30 | 0.036 | 0.040 | 0.060 | 0.080 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.48 | 70 (61 – 83) |
| | | 0.30 | 0.036 | 0.0016 | 0.0024 | 0.0032 | 0.0048 | 0.0065 | 0.0080 | 0.0095 | 0.013 | 0.016 | 0.019 | 230 (210 – 270) |
| K1 | E/M/A | 0.30 | 0.040 | 0.040 | 0.060 | 0.080 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.48 | 225 (200 – 250) |
| | | 0.30 | 0.040 | 0.0016 | 0.0024 | 0.0032 | 0.0048 | 0.0065 | 0.0080 | 0.0095 | 0.013 | 0.016 | 0.019 | 740 (660 – 820) |
| K2 | E/M/A | 0.30 | 0.040 | 0.040 | 0.060 | 0.080 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.48 | 195 (170 – 220) |
| | | 0.30 | 0.040 | 0.0016 | 0.0024 | 0.0032 | 0.0048 | 0.0065 | 0.0080 | 0.0095 | 0.013 | 0.016 | 0.019 | 640 (560 – 720) |
| K3 | E/M/A | 0.30 | 0.040 | 0.040 | 0.060 | 0.080 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.48 | 165 (150 – 180) |
| | | 0.30 | 0.040 | 0.0016 | 0.0024 | 0.0032 | 0.0048 | 0.0065 | 0.0080 | 0.0095 | 0.013 | 0.016 | 0.019 | 540 (500 – 590) |
| K4 | E/M/A | 0.30 | 0.040 | 0.040 | 0.060 | 0.080 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.48 | 155 (140 – 170) |
| | | 0.30 | 0.040 | 0.0016 | 0.0024 | 0.0032 | 0.0048 | 0.0065 | 0.0080 | 0.0095 | 0.013 | 0.016 | 0.019 | 510 (460 – 550) |
| K5 | E/M/A | 0.30 | 0.040 | 0.032 | 0.050 | 0.065 | 0.10 | 0.13 | 0.16 | 0.20 | 0.26 | 0.32 | 0.40 | 165 (140 – 190) |
| | | 0.30 | 0.040 | 0.0013 | 0.0020 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 540 (460 – 620) |
| K6 | E/M/A | 0.30 | 0.040 | 0.032 | 0.050 | 0.065 | 0.10 | 0.13 | 0.16 | 0.20 | 0.26 | 0.32 | 0.40 | 245 (200 – 290) |
| | | 0.30 | 0.040 | 0.0013 | 0.0020 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 800 (660 – 950) |
| K7 | E/M/A | 0.30 | 0.040 | 0.032 | 0.050 | 0.065 | 0.10 | 0.13 | 0.16 | 0.20 | 0.26 | 0.32 | 0.40 | 210 (170 – 250) |
| | | 0.30 | 0.040 | 0.0013 | 0.0020 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 690 (560 – 820) |
| S1 | E | 0.30 | 0.022 | 0.024 | 0.036 | 0.048 | 0.070 | 0.095 | 0.12 | 0.14 | 0.19 | 0.24 | 0.28 | 60 (50 – 74) |
| | | 0.30 | 0.022 | 0.00095 | 0.0014 | 0.0019 | 0.0028 | 0.0038 | 0.0048 | 0.0055 | 0.0075 | 0.0095 | 0.011 | 195 (170 – 240) |
| S2 | E | 0.30 | 0.022 | 0.024 | 0.036 | 0.048 | 0.070 | 0.095 | 0.12 | 0.14 | 0.19 | 0.24 | 0.28 | 50 (41 – 60) |
| | | 0.30 | 0.022 | 0.00095 | 0.0014 | 0.0019 | 0.0028 | 0.0038 | 0.0048 | 0.0055 | 0.0075 | 0.0095 | 0.011 | 165 (140 – 190) |
| S3 | E | 0.30 | 0.022 | 0.024 | 0.036 | 0.048 | 0.070 | 0.095 | 0.12 | 0.14 | 0.19 | 0.24 | 0.28 | 37 (25 – 49) |
| | | 0.30 | 0.022 | 0.00095 | 0.0014 | 0.0019 | 0.0028 | 0.0038 | 0.0048 | 0.0055 | 0.0075 | 0.0095 | 0.011 | 120 (83 – 160) |
| S11 | E | 0.30 | 0.022 | 0.036 | 0.050 | 0.070 | 0.10 | 0.14 | 0.18 | 0.20 | 0.28 | 0.36 | 0.42 | 175 (160 – 190) |
| | | 0.30 | 0.022 | 0.0014 | 0.0020 | 0.0028 | 0.0040 | 0.0055 | 0.0070 | 0.0080 | 0.011 | 0.014 | 0.017 | 570 (530 – 620) |
| S12 | E | 0.30 | 0.022 | 0.036 | 0.050 | 0.070 | 0.10 | 0.14 | 0.18 | 0.20 | 0.28 | 0.36 | 0.42 | 135 (120 – 150) |
| | | 0.30 | 0.022 | 0.0014 | 0.0020 | 0.0028 | 0.0040 | 0.0055 | 0.0070 | 0.0080 | 0.011 | 0.014 | 0.017 | 445 (400 – 490) |
| S13 | E | 0.30 | 0.022 | 0.036 | 0.050 | 0.070 | 0.10 | 0.14 | 0.18 | 0.20 | 0.28 | 0.36 | 0.42 | 105 (90 – 110) |
| | | 0.30 | 0.022 | 0.0014 | 0.0020 | 0.0028 | 0.0040 | 0.0055 | 0.0070 | 0.0080 | 0.011 | 0.014 | 0.017 | 345 (300 – 360) |
| H5 | M/A/D | 0.30 | 0.036 | 0.040 | 0.060 | 0.080 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.48 | 115 (98 – 130) |
| | | 0.30 | 0.036 | 0.0016 | 0.0024 | 0.0032 | 0.0048 | 0.0065 | 0.0080 | 0.0095 | 0.013 | 0.016 | 0.019 | 375 (330 – 420) |
| H8 | M/A/D | 0.30 | 0.036 | 0.040 | 0.060 | 0.080 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.48 | 115 (98 – 130) |
| | | 0.30 | 0.036 | 0.0016 | 0.0024 | 0.0032 | 0.0048 | 0.0065 | 0.0080 | 0.0095 | 0.013 | 0.016 | 0.019 | 375 (330 – 420) |
| H21 | M/A/D | 0.30 | 0.036 | 0.040 | 0.060 | 0.080 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.48 | 115 (98 – 130) |
| | | 0.30 | 0.036 | 0.0016 | 0.0024 | 0.0032 | 0.0048 | 0.0065 | 0.0080 | 0.0095 | 0.013 | 0.016 | 0.019 | 375 (330 – 420) |
| H31 | M/A/D | 0.30 | 0.036 | 0.040 | 0.060 | 0.080 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 0.48 | 90 (74 – 100) |
| | | 0.30 | 0.036 | 0.0016 | 0.0024 | 0.0032 | 0.0048 | 0.0065 | 0.0080 | 0.0095 | 0.013 | 0.016 | 0.019 | 295 (250 – 320) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – JHF980 Nutfräsen

| SMG |  | a _p /DCX | f _z | | | | | | | | | | v _c |
|-----|---|---------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | 1 | 1.5 | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | |
| P1 | E/M/A | 0.040 | 0.030 | 0.046 | 0.060 | 0.090 | 0.12 | 0.15 | 0.18 | 0.24 | 0.30 | 0.36 | 340 (310 – 370) |
| | | 0,040 | 0,0012 | 0,0018 | 0,0024 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0095 | 0,012 | 0,014 | 1125 (1100 – 1200) |
| P2 | E/M/A | 0.040 | 0.030 | 0.046 | 0.060 | 0.090 | 0.12 | 0.15 | 0.18 | 0.24 | 0.30 | 0.36 | 330 (300 – 360) |
| | | 0,040 | 0,0012 | 0,0018 | 0,0024 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0095 | 0,012 | 0,014 | 1075 (990 – 1100) |
| P3 | E/M/A | 0.040 | 0.030 | 0.046 | 0.060 | 0.090 | 0.12 | 0.15 | 0.18 | 0.24 | 0.30 | 0.36 | 285 (260 – 310) |
| | | 0,040 | 0,0012 | 0,0018 | 0,0024 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0095 | 0,012 | 0,014 | 940 (860 – 1000) |
| P4 | E/M/A | 0.040 | 0.030 | 0.046 | 0.060 | 0.090 | 0.12 | 0.15 | 0.18 | 0.24 | 0.30 | 0.36 | 250 (230 – 270) |
| | | 0,040 | 0,0012 | 0,0018 | 0,0024 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0095 | 0,012 | 0,014 | 820 (760 – 880) |
| P5 | E/M/A | 0.040 | 0.030 | 0.046 | 0.060 | 0.090 | 0.12 | 0.15 | 0.18 | 0.24 | 0.30 | 0.36 | 240 (220 – 260) |
| | | 0,040 | 0,0012 | 0,0018 | 0,0024 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0095 | 0,012 | 0,014 | 790 (730 – 850) |
| P6 | E/M/A | 0.040 | 0.028 | 0.040 | 0.055 | 0.080 | 0.11 | 0.14 | 0.16 | 0.22 | 0.28 | 0.32 | 185 (160 – 210) |
| | | 0,040 | 0,0011 | 0,0016 | 0,0022 | 0,0032 | 0,0044 | 0,0055 | 0,0065 | 0,0085 | 0,011 | 0,013 | 610 (530 – 680) |
| P7 | E/M/A | 0.040 | 0.028 | 0.040 | 0.055 | 0.080 | 0.11 | 0.14 | 0.16 | 0.22 | 0.28 | 0.32 | 175 (160 – 200) |
| | | 0,040 | 0,0011 | 0,0016 | 0,0022 | 0,0032 | 0,0044 | 0,0055 | 0,0065 | 0,0085 | 0,011 | 0,013 | 570 (530 – 650) |
| P8 | E/M/A | 0.040 | 0.028 | 0.040 | 0.055 | 0.080 | 0.11 | 0.14 | 0.16 | 0.22 | 0.28 | 0.32 | 165 (150 – 180) |
| | | 0,040 | 0,0011 | 0,0016 | 0,0022 | 0,0032 | 0,0044 | 0,0055 | 0,0065 | 0,0085 | 0,011 | 0,013 | 540 (500 – 590) |
| P11 | E/M/A | 0.040 | 0.028 | 0.040 | 0.055 | 0.080 | 0.11 | 0.14 | 0.16 | 0.22 | 0.28 | 0.32 | 170 (150 – 190) |
| | | 0,040 | 0,0011 | 0,0016 | 0,0022 | 0,0032 | 0,0044 | 0,0055 | 0,0065 | 0,0085 | 0,011 | 0,013 | 560 (500 – 620) |
| P12 | E/M/A | 0.036 | 0.024 | 0.036 | 0.048 | 0.070 | 0.095 | 0.12 | 0.14 | 0.19 | 0.24 | 0.28 | 105 (90 – 110) |
| | | 0,036 | 0,00095 | 0,0014 | 0,0019 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0075 | 0,0095 | 0,011 | 345 (300 – 360) |
| M1 | E/M/A | 0.036 | 0.024 | 0.036 | 0.048 | 0.070 | 0.095 | 0.12 | 0.14 | 0.19 | 0.24 | 0.28 | 165 (150 – 180) |
| | | 0,036 | 0,00095 | 0,0014 | 0,0019 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0075 | 0,0095 | 0,011 | 540 (500 – 590) |
| M2 | E/M/A | 0.036 | 0.024 | 0.036 | 0.048 | 0.070 | 0.095 | 0.12 | 0.14 | 0.19 | 0.24 | 0.28 | 130 (120 – 140) |
| | | 0,036 | 0,00095 | 0,0014 | 0,0019 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0075 | 0,0095 | 0,011 | 425 (400 – 450) |
| M3 | E/M/A | 0.036 | 0.024 | 0.036 | 0.048 | 0.070 | 0.095 | 0.12 | 0.14 | 0.19 | 0.24 | 0.28 | 100 (85 – 110) |
| | | 0,036 | 0,00095 | 0,0014 | 0,0019 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0075 | 0,0095 | 0,011 | 330 (280 – 360) |
| M4 | E/M/A | 0.036 | 0.024 | 0.036 | 0.048 | 0.070 | 0.095 | 0.12 | 0.14 | 0.19 | 0.24 | 0.28 | 75 (64 – 87) |
| | | 0,036 | 0,00095 | 0,0014 | 0,0019 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0075 | 0,0095 | 0,011 | 245 (210 – 280) |
| M5 | E/M/A | 0.036 | 0.024 | 0.036 | 0.048 | 0.070 | 0.095 | 0.12 | 0.14 | 0.19 | 0.24 | 0.28 | 65 (53 – 72) |
| | | 0,036 | 0,00095 | 0,0014 | 0,0019 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0075 | 0,0095 | 0,011 | 215 (180 – 230) |
| K1 | E/M/A | 0.040 | 0.030 | 0.046 | 0.060 | 0.090 | 0.12 | 0.15 | 0.18 | 0.24 | 0.30 | 0.36 | 185 (160 – 210) |
| | | 0,040 | 0,0012 | 0,0018 | 0,0024 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0095 | 0,012 | 0,014 | 610 (530 – 680) |
| K2 | E/M/A | 0.040 | 0.030 | 0.046 | 0.060 | 0.090 | 0.12 | 0.15 | 0.18 | 0.24 | 0.30 | 0.36 | 160 (140 – 180) |
| | | 0,040 | 0,0012 | 0,0018 | 0,0024 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0095 | 0,012 | 0,014 | 520 (460 – 590) |
| K3 | E/M/A | 0.040 | 0.030 | 0.046 | 0.060 | 0.090 | 0.12 | 0.15 | 0.18 | 0.24 | 0.30 | 0.36 | 135 (120 – 150) |
| | | 0,040 | 0,0012 | 0,0018 | 0,0024 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0095 | 0,012 | 0,014 | 445 (400 – 490) |
| K4 | E/M/A | 0.040 | 0.030 | 0.046 | 0.060 | 0.090 | 0.12 | 0.15 | 0.18 | 0.24 | 0.30 | 0.36 | 130 (120 – 140) |
| | | 0,040 | 0,0012 | 0,0018 | 0,0024 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0095 | 0,012 | 0,014 | 425 (400 – 450) |
| K5 | E/M/A | 0.040 | 0.028 | 0.040 | 0.055 | 0.080 | 0.11 | 0.14 | 0.16 | 0.22 | 0.28 | 0.32 | 135 (110 – 150) |
| | | 0,040 | 0,0011 | 0,0016 | 0,0022 | 0,0032 | 0,0044 | 0,0055 | 0,0065 | 0,0085 | 0,011 | 0,013 | 445 (370 – 490) |
| K6 | E/M/A | 0.040 | 0.028 | 0.040 | 0.055 | 0.080 | 0.11 | 0.14 | 0.16 | 0.22 | 0.28 | 0.32 | 195 (160 – 230) |
| | | 0,040 | 0,0011 | 0,0016 | 0,0022 | 0,0032 | 0,0044 | 0,0055 | 0,0065 | 0,0085 | 0,011 | 0,013 | 640 (530 – 750) |
| K7 | E/M/A | 0.040 | 0.028 | 0.040 | 0.055 | 0.080 | 0.11 | 0.14 | 0.16 | 0.22 | 0.28 | 0.32 | 170 (140 – 200) |
| | | 0,040 | 0,0011 | 0,0016 | 0,0022 | 0,0032 | 0,0044 | 0,0055 | 0,0065 | 0,0085 | 0,011 | 0,013 | 560 (460 – 650) |
| S1 | E | 0.022 | 0.018 | 0.028 | 0.036 | 0.055 | 0.070 | 0.090 | 0.11 | 0.14 | 0.18 | 0.22 | 50 (42 – 62) |
| | | 0,022 | 0,00070 | 0,0011 | 0,0014 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0055 | 0,0070 | 0,0085 | 165 (140 – 200) |
| S2 | E | 0.022 | 0.018 | 0.028 | 0.036 | 0.055 | 0.070 | 0.090 | 0.11 | 0.14 | 0.18 | 0.22 | 42 (34 – 50) |
| | | 0,022 | 0,00070 | 0,0011 | 0,0014 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0055 | 0,0070 | 0,0085 | 140 (120 – 160) |
| S3 | E | 0.022 | 0.018 | 0.028 | 0.036 | 0.055 | 0.070 | 0.090 | 0.11 | 0.14 | 0.18 | 0.22 | 31 (21 – 41) |
| | | 0,022 | 0,00070 | 0,0011 | 0,0014 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0055 | 0,0070 | 0,0085 | 100 (69 – 130) |
| S11 | E | 0.022 | 0.018 | 0.028 | 0.036 | 0.055 | 0.070 | 0.090 | 0.11 | 0.14 | 0.18 | 0.22 | 155 (140 – 170) |
| | | 0,022 | 0,00070 | 0,0011 | 0,0014 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0055 | 0,0070 | 0,0085 | 510 (460 – 550) |
| S12 | E | 0.022 | 0.018 | 0.028 | 0.036 | 0.055 | 0.070 | 0.090 | 0.11 | 0.14 | 0.18 | 0.22 | 120 (110 – 130) |
| | | 0,022 | 0,00070 | 0,0011 | 0,0014 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0055 | 0,0070 | 0,0085 | 395 (370 – 420) |
| S13 | E | 0.022 | 0.018 | 0.028 | 0.036 | 0.055 | 0.070 | 0.090 | 0.11 | 0.14 | 0.18 | 0.22 | 95 (82 – 100) |
| | | 0,022 | 0,00070 | 0,0011 | 0,0014 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0055 | 0,0070 | 0,0085 | 310 (270 – 320) |
| H5 | M/A/D | 0.036 | 0.024 | 0.036 | 0.048 | 0.070 | 0.095 | 0.12 | 0.14 | 0.19 | 0.24 | 0.28 | 100 (86 – 110) |
| | | 0,036 | 0,00095 | 0,0014 | 0,0019 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0075 | 0,0095 | 0,011 | 330 (290 – 360) |
| H8 | M/A/D | 0.036 | 0.024 | 0.036 | 0.048 | 0.070 | 0.095 | 0.12 | 0.14 | 0.19 | 0.24 | 0.28 | 100 (86 – 110) |
| | | 0,036 | 0,00095 | 0,0014 | 0,0019 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0075 | 0,0095 | 0,011 | 330 (290 – 360) |
| H21 | M/A/D | 0.036 | 0.024 | 0.036 | 0.048 | 0.070 | 0.095 | 0.12 | 0.14 | 0.19 | 0.24 | 0.28 | 100 (86 – 110) |
| | | 0,036 | 0,00095 | 0,0014 | 0,0019 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0075 | 0,0095 | 0,011 | 330 (290 – 360) |
| H31 | M/A/D | 0.036 | 0.024 | 0.036 | 0.048 | 0.070 | 0.095 | 0.12 | 0.14 | 0.19 | 0.24 | 0.28 | 75 (65 – 88) |
| | | 0,036 | 0,00095 | 0,0014 | 0,0019 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0075 | 0,0095 | 0,011 | 245 (220 – 280) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Universell

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Stahlfreie und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

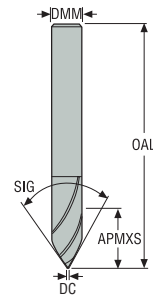
X-Heads

Minimaster Plus

Minimaster

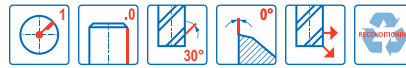
J29

Allgemeine Anwendung – Universell – Gravieren – 1 Schneide – Zylindrisch



D

- Toleranzen:
- DMM=h5
- Nachschleifen möglich, wenn DMM ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | SIG° | PCEDC | Zylindrisch |
|-------------|--------------------|------------------|-------------------|-----|-----|-------|------|------|-------|-------------|
| | | | | mm | mm | mm | mm | | | |
| 29030 | 00029373 | 2 | D | 0,2 | 3,0 | 2,6 | 40,0 | 60,0 | 1 | ■ |
| 29040 | 00029381 | 2 | D | 0,2 | 4,0 | 3,5 | 50,0 | 60,0 | 1 | ■ |
| 29060 | 00029396 | 2 | D | 0,2 | 6,0 | 5,2 | 50,0 | 60,0 | 1 | ■ |

■ Lagerstandard.

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ISO-S-Werkstoffe

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Kunststoffe und
Composite


Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – J29 Nutfräsen

| SMG |  | a _p /DC | f _z | | | v _c |
|-----|---|--------------------|----------------|--------|--------|-----------------|
| | | | 3 | 4 | 6 | |
| P1 | E | 0.50 | 0.24 | 0.26 | 0.28 | 42 (32 – 63) |
| | | 0,50 | 0,0095 | 0,010 | 0,011 | 140 (110 – 200) |
| P2 | E | 0.50 | 0.24 | 0.26 | 0.30 | 41 (32 – 61) |
| | | 0,50 | 0,0095 | 0,010 | 0,012 | 135 (110 – 200) |
| P3 | E | 0.50 | 0.24 | 0.25 | 0.28 | 36 (28 – 54) |
| | | 0,50 | 0,0095 | 0,010 | 0,011 | 120 (92 – 170) |
| P4 | E | 0.50 | 0.22 | 0.24 | 0.26 | 31 (24 – 47) |
| | | 0,50 | 0,0085 | 0,0095 | 0,010 | 100 (79 – 150) |
| P5 | E | 0.50 | 0.22 | 0.24 | 0.26 | 30 (23 – 45) |
| | | 0,50 | 0,0085 | 0,0095 | 0,010 | 100 (76 – 140) |
| P6 | E | 0.50 | 0.22 | 0.24 | 0.26 | 34 (26 – 51) |
| | | 0,50 | 0,0085 | 0,0095 | 0,010 | 110 (86 – 160) |
| P7 | E | 0.50 | 0.22 | 0.24 | 0.26 | 32 (25 – 48) |
| | | 0,50 | 0,0085 | 0,0095 | 0,010 | 105 (83 – 150) |
| P8 | E | 0.50 | 0.24 | 0.25 | 0.28 | 30 (23 – 45) |
| | | 0,50 | 0,0095 | 0,010 | 0,011 | 100 (76 – 140) |
| P11 | E | 0.50 | 0.22 | 0.24 | 0.26 | 31 (24 – 46) |
| | | 0,50 | 0,0085 | 0,0095 | 0,010 | 100 (79 – 150) |
| P12 | E | 0.50 | 0.15 | 0.16 | 0.18 | 19 (15 – 29) |
| | | 0,50 | 0,0060 | 0,0065 | 0,0070 | 60 (50 – 95) |
| M1 | E | 0.50 | 0.22 | 0.24 | 0.26 | 30 (23 – 45) |
| | | 0,50 | 0,0085 | 0,0095 | 0,010 | 100 (76 – 140) |
| M2 | E | 0.50 | 0.22 | 0.24 | 0.26 | 30 (23 – 45) |
| | | 0,50 | 0,0085 | 0,0095 | 0,010 | 100 (76 – 140) |
| M3 | E | 0.50 | 0.18 | 0.19 | 0.22 | 24 (18 – 35) |
| | | 0,50 | 0,0070 | 0,0075 | 0,0085 | 80 (60 – 110) |
| M4 | E | 0.50 | 0.16 | 0.17 | 0.18 | 18 (14 – 27) |
| | | 0,50 | 0,0065 | 0,0065 | 0,0070 | 60 (46 – 88) |
| M5 | E | 0.50 | 0.16 | 0.17 | 0.18 | 15 (12 – 22) |
| | | 0,50 | 0,0065 | 0,0065 | 0,0070 | 49 (40 – 72) |
| K1 | E | 0.50 | 0.22 | 0.24 | 0.26 | 30 (23 – 45) |
| | | 0,50 | 0,0085 | 0,0095 | 0,010 | 100 (76 – 140) |
| K2 | E | 0.50 | 0.20 | 0.22 | 0.24 | 26 (21 – 40) |
| | | 0,50 | 0,0080 | 0,0085 | 0,0095 | 85 (69 – 130) |
| K3 | E | 0.50 | 0.20 | 0.22 | 0.24 | 22 (17 – 33) |
| | | 0,50 | 0,0080 | 0,0085 | 0,0095 | 70 (56 – 100) |
| K4 | E | 0.50 | 0.20 | 0.22 | 0.24 | 21 (17 – 32) |
| | | 0,50 | 0,0080 | 0,0085 | 0,0095 | 70 (56 – 100) |
| K5 | E | 0.50 | 0.18 | 0.20 | 0.22 | 13 (9.8 – 19) |
| | | 0,50 | 0,0070 | 0,0080 | 0,0085 | 43 (33 – 62) |
| K6 | E | 0.50 | 0.20 | 0.22 | 0.24 | 19 (15 – 28) |
| | | 0,50 | 0,0080 | 0,0085 | 0,0095 | 60 (50 – 91) |
| K7 | E | 0.50 | 0.18 | 0.20 | 0.22 | 16 (13 – 25) |
| | | 0,50 | 0,0070 | 0,0080 | 0,0085 | 50 (43 – 82) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

Schnittdaten – J29 Nutfräsen

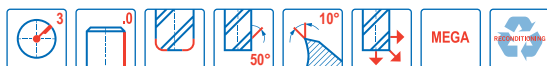
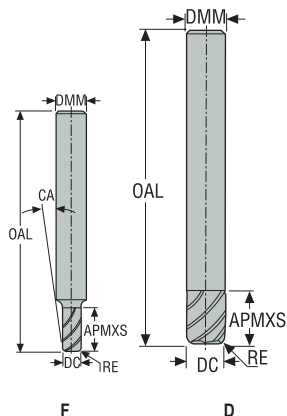
| SMG | | a _p /DC | f _z | | | v _c |
|-----|-------|--------------------|----------------|--------|--------|-----------------|
| | | | 3 | 4 | 6 | |
| N1 | E | 0.50 | 0.22 | 0.24 | 0.26 | 30 (23 – 45) |
| | | 0.50 | 0,0085 | 0,0095 | 0,010 | 100 (76 – 140) |
| N2 | E | 0.50 | 0.22 | 0.24 | 0.26 | 19 (15 – 29) |
| | | 0.50 | 0,0085 | 0,0095 | 0,010 | 60 (50 – 95) |
| N3 | E | 0.50 | 0.22 | 0.24 | 0.26 | 13 (9.8 – 19) |
| | | 0.50 | 0,0085 | 0,0095 | 0,010 | 43 (33 – 62) |
| N11 | E | 0.50 | 0.22 | 0.24 | 0.26 | 17 (14 – 26) |
| | | 0.50 | 0,0085 | 0,0095 | 0,010 | 55 (46 – 85) |
| S1 | E | 0.50 | 0.24 | 0.26 | 0.28 | 43 (33 – 64) |
| | | 0.50 | 0,0095 | 0,010 | 0,011 | 140 (110 – 200) |
| S2 | E | 0.50 | 0.24 | 0.26 | 0.28 | 34 (27 – 51) |
| | | 0.50 | 0,0095 | 0,010 | 0,011 | 110 (89 – 160) |
| S3 | E | 0.50 | 0.22 | 0.24 | 0.26 | 30 (23 – 45) |
| | | 0.50 | 0,0085 | 0,0095 | 0,010 | 100 (76 – 140) |
| S11 | E | 0.50 | 0.22 | 0.24 | 0.26 | 39 (30 – 59) |
| | | 0.50 | 0,0085 | 0,0095 | 0,010 | 130 (99 – 190) |
| S12 | E | 0.50 | 0.22 | 0.24 | 0.26 | 30 (23 – 45) |
| | | 0.50 | 0,0085 | 0,0095 | 0,010 | 100 (76 – 140) |
| S13 | E | 0.50 | 0.19 | 0.20 | 0.24 | 24 (18 – 35) |
| | | 0.50 | 0,0075 | 0,0080 | 0,0095 | 80 (60 – 110) |
| H5 | M/A/D | 0.50 | 0.22 | 0.24 | 0.26 | 30 (23 – 45) |
| | | 0.50 | 0,0085 | 0,0095 | 0,010 | 100 (76 – 140) |
| H8 | M/A/D | 0.50 | 0.17 | 0.18 | 0.20 | 32 (24 – 47) |
| | | 0.50 | 0,0065 | 0,0070 | 0,0080 | 105 (79 – 150) |
| H11 | M/A/D | 0.50 | 0.22 | 0.24 | 0.26 | 39 (30 – 58) |
| | | 0.50 | 0,0085 | 0,0095 | 0,010 | 130 (99 – 190) |
| H12 | M/A/D | 0.50 | 0.12 | 0.12 | 0.14 | 12 (9.1 – 18) |
| | | 0.50 | 0,0048 | 0,0048 | 0,0055 | 39 (30 – 59) |
| H21 | M/A/D | 0.50 | 0.17 | 0.18 | 0.20 | 32 (24 – 47) |
| | | 0.50 | 0,0065 | 0,0070 | 0,0080 | 105 (79 – 150) |
| H31 | M/A/D | 0.50 | 0.15 | 0.16 | 0.17 | 24 (19 – 36) |
| | | 0.50 | 0,0060 | 0,0065 | 0,0065 | 80 (63 – 110) |
| TS1 | E | 0.50 | 0.22 | 0.24 | 0.26 | 30 (23 – 45) |
| | | 0.50 | 0,0085 | 0,0095 | 0,010 | 100 (76 – 140) |
| TP1 | E | 0.50 | 0.22 | 0.24 | 0.26 | 30 (23 – 45) |
| | | 0.50 | 0,0085 | 0,0095 | 0,010 | 100 (76 – 140) |
| GR1 | D | 0.50 | 0.22 | 0.24 | 0.26 | 30 (23 – 45) |
| | | 0.50 | 0,0085 | 0,0095 | 0,010 | 100 (76 – 140) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

J36

Allgemeine Anwendung – Universell – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM= h5
- DC= Ø2-Ø6= -0,02/-0,034 mm
- DC= Ø8-Ø20= -0,02/-0,044 mm
- RE= Ø2-Ø12= +0,05 mm
- RE= Ø14-Ø20= +0,1 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | RE | CA | PCEDC | Zylindrisch |
|-------------|--------------------|------------------|-------------------|------|------|-------|-------|-----|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | | |
| 36020-MEGA | 00025621 | 2 | F | 2,0 | 3,0 | 9,0 | 40,0 | 0,1 | 2,5 | 3 | ■ |
| 36030-MEGA | 00025626 | 2 | D | 3,0 | 3,0 | 12,0 | 40,0 | 0,1 | – | 3 | ■ |
| 36040-MEGA | 00025628 | 2 | D | 4,0 | 4,0 | 14,0 | 50,0 | 0,1 | – | 3 | ■ |
| 36050-MEGA | 00025651 | 2 | D | 5,0 | 5,0 | 20,0 | 50,0 | 0,1 | – | 3 | ■ |
| 36060-MEGA | 00025663 | 2 | D | 6,0 | 6,0 | 20,0 | 65,0 | 0,1 | – | 3 | ■ |
| 36080-MEGA | 00025674 | 2 | D | 8,0 | 8,0 | 20,0 | 65,0 | 0,2 | – | 3 | ■ |
| 36100-MEGA | 00025680 | 2 | D | 10,0 | 10,0 | 25,0 | 75,0 | 0,2 | – | 3 | ■ |
| 36120-MEGA | 00025681 | 2 | D | 12,0 | 12,0 | 25,0 | 75,0 | 0,2 | – | 3 | ■ |
| 36160-MEGA | 00025689 | 2 | D | 16,0 | 16,0 | 30,0 | 90,0 | 0,5 | – | 3 | ■ |
| 36200-MEGA | 00025692 | 2 | D | 20,0 | 20,0 | 40,0 | 100,0 | 0,5 | – | 3 | ■ |

■ Lagerstandard.

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Composite

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Minimaster


Schnittdaten – J36 Eckfräsen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|---------|---------|--------|--------|--------|--------|--------|-----------------|
| | | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| P1 | E | 0.200 | 1.0 | 0.013 | 0.019 | 0.026 | 0.032 | 0.038 | 0.050 | 0.065 | 0.075 | 0.095 | 0.11 | 200 (170 – 220) |
| | | 0,200 | 1,0 | 0,00050 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 660 (560 – 720) |
| P2 | E | 0.200 | 1.0 | 0.013 | 0.020 | 0.026 | 0.034 | 0.040 | 0.055 | 0.065 | 0.080 | 0.095 | 0.11 | 190 (170 – 210) |
| | | 0,200 | 1,0 | 0,00050 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0022 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 620 (560 – 680) |
| P3 | E | 0.200 | 1.0 | 0.012 | 0.019 | 0.025 | 0.032 | 0.038 | 0.050 | 0.060 | 0.075 | 0.090 | 0.11 | 170 (150 – 190) |
| | | 0,200 | 1,0 | 0,00048 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 560 (500 – 620) |
| P4 | E | 0.200 | 1.0 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 150 (130 – 160) |
| | | 0,200 | 1,0 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 490 (430 – 520) |
| P5 | E | 0.200 | 1.0 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 140 (130 – 160) |
| | | 0,200 | 1,0 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 460 (430 – 520) |
| P6 | E | 0.200 | 1.0 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.085 | 0.10 | 160 (140 – 180) |
| | | 0,200 | 1,0 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0034 | 0,0040 | 520 (460 – 590) |
| P7 | E | 0.200 | 1.0 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.085 | 0.10 | 150 (130 – 170) |
| | | 0,200 | 1,0 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0034 | 0,0040 | 490 (430 – 550) |
| P8 | E | 0.200 | 1.0 | 0.012 | 0.019 | 0.025 | 0.032 | 0.038 | 0.050 | 0.060 | 0.075 | 0.090 | 0.11 | 140 (130 – 160) |
| | | 0,200 | 1,0 | 0,00048 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 460 (430 – 520) |
| P11 | E | 0.200 | 1.0 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.085 | 0.10 | 145 (130 – 160) |
| | | 0,200 | 1,0 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0034 | 0,0040 | 475 (430 – 520) |
| P12 | E | 0.200 | 1.0 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 0.070 | 90 (79 – 100) |
| | | 0,200 | 1,0 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 295 (260 – 320) |
| M1 | E | 0.200 | 1.0 | 0.015 | 0.024 | 0.030 | 0.038 | 0.046 | 0.060 | 0.075 | 0.090 | 0.11 | 0.13 | 115 (92 – 140) |
| | | 0,200 | 1,0 | 0,00060 | 0,00095 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 375 (310 – 450) |
| M2 | E | 0.200 | 1.0 | 0.014 | 0.020 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 95 (76 – 110) |
| | | 0,200 | 1,0 | 0,00055 | 0,00080 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 310 (250 – 360) |
| M3 | E | 0.100 | 1.0 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 75 (56 – 95) |
| | | 0,100 | 1,0 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 245 (190 – 310) |
| M4 | E | 0.100 | 1.0 | 0.0085 | 0.013 | 0.017 | 0.022 | 0.026 | 0.034 | 0.044 | 0.050 | 0.065 | 0.075 | 60 (43 – 73) |
| | | 0,100 | 1,0 | 0,00034 | 0,00050 | 0,00065 | 0,00085 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 195 (150 – 230) |
| M5 | E | 0.100 | 1.0 | 0.0085 | 0.013 | 0.017 | 0.022 | 0.026 | 0.034 | 0.044 | 0.050 | 0.065 | 0.075 | 48 (36 – 60) |
| | | 0,100 | 1,0 | 0,00034 | 0,00050 | 0,00065 | 0,00085 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 155 (120 – 190) |
| K1 | E | 0.200 | 1.0 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 140 (130 – 160) |
| | | 0,200 | 1,0 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 460 (430 – 520) |
| K2 | E | 0.200 | 1.0 | 0.011 | 0.016 | 0.022 | 0.028 | 0.032 | 0.044 | 0.055 | 0.065 | 0.080 | 0.090 | 125 (110 – 140) |
| | | 0,200 | 1,0 | 0,00044 | 0,00065 | 0,00085 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 410 (370 – 450) |
| K3 | E | 0.200 | 1.0 | 0.011 | 0.016 | 0.022 | 0.028 | 0.032 | 0.044 | 0.055 | 0.065 | 0.080 | 0.090 | 105 (91 – 120) |
| | | 0,200 | 1,0 | 0,00044 | 0,00065 | 0,00085 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 345 (300 – 390) |
| K4 | E | 0.200 | 1.0 | 0.011 | 0.016 | 0.022 | 0.028 | 0.032 | 0.044 | 0.055 | 0.065 | 0.080 | 0.090 | 100 (87 – 110) |
| | | 0,200 | 1,0 | 0,00044 | 0,00065 | 0,00085 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 330 (290 – 360) |
| K5 | E | 0.200 | 1.0 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.085 | 60 (53 – 69) |
| | | 0,200 | 1,0 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0034 | 195 (180 – 220) |
| K6 | E | 0.200 | 1.0 | 0.011 | 0.016 | 0.022 | 0.028 | 0.032 | 0.044 | 0.055 | 0.065 | 0.080 | 0.090 | 90 (76 – 100) |
| | | 0,200 | 1,0 | 0,00044 | 0,00065 | 0,00085 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 295 (250 – 320) |
| K7 | E | 0.200 | 1.0 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.085 | 80 (67 – 89) |
| | | 0,200 | 1,0 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0034 | 260 (220 – 290) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – J36 Eckfräsen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|---------|---------|---------|---------|---------|--------|--------|--------------------|
| | | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| N1 | E | 0.300 | 1.2 | 0.022 | 0.032 | 0.042 | 0.055 | 0.065 | 0.085 | 0.11 | 0.13 | 0.16 | 0.18 | 650 (540 – 750) |
| | | 0,300 | 1,2 | 0,00085 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0034 | 0,0044 | 0,0050 | 0,0065 | 0,0070 | 2125 (1800 – 2400) |
| N2 | E | 0.300 | 1.2 | 0.022 | 0.032 | 0.042 | 0.055 | 0.065 | 0.085 | 0.11 | 0.13 | 0.16 | 0.18 | 415 (350 – 480) |
| | | 0,300 | 1,2 | 0,00085 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0034 | 0,0044 | 0,0050 | 0,0065 | 0,0070 | 1350 (1200 – 1500) |
| N3 | E | 0.300 | 1.2 | 0.022 | 0.032 | 0.042 | 0.055 | 0.065 | 0.085 | 0.11 | 0.13 | 0.16 | 0.18 | 275 (240 – 320) |
| | | 0,300 | 1,2 | 0,00085 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0034 | 0,0044 | 0,0050 | 0,0065 | 0,0070 | 900 (790 – 1000) |
| N11 | E | 0.300 | 1.0 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 305 (260 – 350) |
| | | 0,300 | 1,0 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 1000 (860 – 1100) |
| S1 | E | 0.120 | 0.90 | 0.0055 | 0.0080 | 0.011 | 0.014 | 0.016 | 0.022 | 0.028 | 0.032 | 0.040 | 0.046 | 70 (60 – 83) |
| | | 0,120 | 0,90 | 0,00022 | 0,00032 | 0,00044 | 0,00055 | 0,00065 | 0,00085 | 0,0011 | 0,0013 | 0,0016 | 0,0018 | 230 (200 – 270) |
| S2 | E | 0.120 | 0.90 | 0.0055 | 0.0080 | 0.011 | 0.014 | 0.016 | 0.022 | 0.028 | 0.032 | 0.040 | 0.046 | 60 (48 – 67) |
| | | 0,120 | 0,90 | 0,00022 | 0,00032 | 0,00044 | 0,00055 | 0,00065 | 0,00085 | 0,0011 | 0,0013 | 0,0016 | 0,0018 | 195 (160 – 210) |
| S3 | E | 0.120 | 0.90 | 0.0036 | 0.0055 | 0.0075 | 0.0090 | 0.011 | 0.015 | 0.018 | 0.022 | 0.028 | 0.032 | 39 (30 – 48) |
| | | 0,120 | 0,90 | 0,00014 | 0,00022 | 0,00030 | 0,00036 | 0,00044 | 0,00060 | 0,00070 | 0,00085 | 0,0011 | 0,0013 | 130 (99 – 150) |
| S11 | E | 0.300 | 1.0 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 100 (89 – 110) |
| | | 0,300 | 0,90 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 330 (300 – 360) |
| S12 | E | 0.300 | 1.0 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 80 (68 – 87) |
| | | 0,300 | 0,90 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 260 (230 – 280) |
| S13 | E | 0.300 | 1.0 | 0.0085 | 0.013 | 0.017 | 0.022 | 0.026 | 0.034 | 0.044 | 0.050 | 0.065 | 0.075 | 60 (54 – 69) |
| | | 0,300 | 0,90 | 0,00036 | 0,00050 | 0,00070 | 0,00085 | 0,0010 | 0,0014 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 195 (180 – 220) |
| TS1 | A | 0.400 | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 500 (460 – 550) |
| | | 0,400 | 1,0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 1650 (1600 – 1800) |
| TP1 | A | 0.400 | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 500 (460 – 550) |
| | | 0,400 | 1,0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 1650 (1600 – 1800) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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Graphit

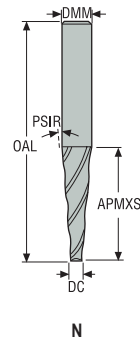
X-Heads

Minimaster Plus

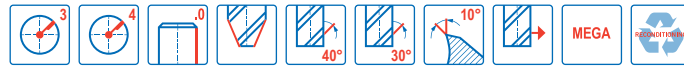
Minimaster

HK

Allgemeine Anwendung – Universell – Konisch – 3-4 Schneiden – Zylindrisch – Scharfe Schneide konisch



- Toleranzen:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | PSIR° | PCEDC | Zylindrisch |
|----------------|----------------|--------------|---------------|------|------|-------|------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | | | |
| HK020-040-MEGA | 00028666 | 2 | N | 4,0 | 6,0 | 20,0 | 65,0 | 2,0 | 3 | ■ |
| HK020-050-MEGA | 00028669 | 2 | N | 5,0 | 8,0 | 30,0 | 75,0 | 2,0 | 3 | ■ |
| HK020-100-MEGA | 00028694 | 2 | N | 10,0 | 12,0 | 28,0 | 80,0 | 2,0 | 4 | ■ |

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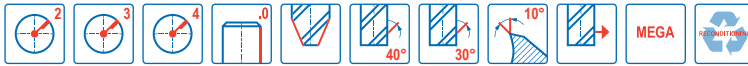
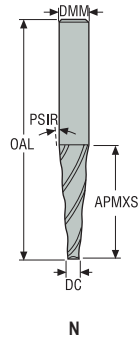
X-Heads

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Minimaster

HKM-HK

Allgemeine Anwendung – Universell – Konisch – 2-4 Schneiden – Zylindrisch – Scharfe Schneide konisch



- Toleranzen:
- DMM= h5
- DC= HKM= +0,07/+0,03 mm
- DC= HK= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | PSIR° | PCEDC | Zylindrisch |
|-----------------|--------------------|------------------|-------------------|-----|------|-------|-------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | | | |
| HKM030-015-MEGA | 00028738 | 2 | N | 1,5 | 3,0 | 6,0 | 40,0 | 3,0 | 2 | ■ |
| HK030-025-MEGA | 00028741 | 2 | N | 2,5 | 6,0 | 20,0 | 65,0 | 3,0 | 3 | ■ |
| HK030-033-MEGA | 00028744 | 2 | N | 3,0 | 8,0 | 30,0 | 75,0 | 3,0 | 3 | ■ |
| HK030-065-MEGA | 00028759 | 2 | N | 6,0 | 12,0 | 55,0 | 110,0 | 3,0 | 3 | ■ |
| HK030-083-MEGA | 00028771 | 2 | N | 8,0 | 12,0 | 30,0 | 80,0 | 3,0 | 4 | ■ |

■ Lagerstandard.

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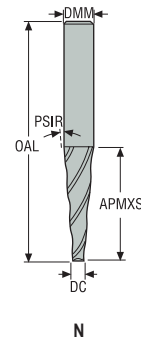
X-Heads

Minimaster Plus

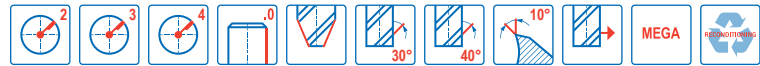
Minimaster

HKM-HK

Allgemeine Anwendung – Universell – Konisch – 2-4 Schneiden – Zylindrisch – Scharfe Schneide konisch



- Toleranzen:
- DMM= h5
- DC= HKM= +0,07/+0,03 mm
- DC= HK= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | PSIR° | PCEDC | Zylindrisch |
|-----------------|----------------|--------------|---------------|------|------|-------|-------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | | | |
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| HKM050-015-MEGA | 00028952 | 2 | N | 1,5 | 3,0 | 6,0 | 40,0 | 5,0 | 2 | ■ |
| HKM050-020-MEGA | 00028954 | 2 | N | 2,0 | 4,0 | 10,0 | 50,0 | 5,0 | 2 | ■ |
| HKM050-025-MEGA | 00028958 | 2 | N | 2,5 | 5,0 | 10,0 | 50,0 | 5,0 | 2 | ■ |
| HK050-025-MEGA | 00028960 | 2 | N | 2,5 | 6,0 | 20,0 | 65,0 | 5,0 | 3 | ■ |
| HK050-032-MEGA | 00028972 | 2 | N | 3,0 | 8,0 | 28,0 | 70,0 | 5,0 | 3 | ■ |
| HK050-0420-MEGA | 00028998 | 2 | N | 4,0 | 8,0 | 22,0 | 65,0 | 5,0 | 3 | ■ |
| HK050-050-MEGA | 00029012 | 2 | N | 5,0 | 12,0 | 40,0 | 100,0 | 5,0 | 3 | ■ |
| HK050-063-MEGA | 00029014 | 2 | N | 6,0 | 12,0 | 32,0 | 90,0 | 5,0 | 3 | ■ |
| HK050-065-MEGA | 00029017 | 2 | N | 6,0 | 16,0 | 55,0 | 110,0 | 5,0 | 3 | ■ |
| HK050-103-MEGA | 00029020 | 2 | N | 10,0 | 16,0 | 32,0 | 90,0 | 5,0 | 4 | ■ |
| HK050-105-MEGA | 00029025 | 2 | N | 10,0 | 20,0 | 55,0 | 115,0 | 5,0 | 4 | ■ |

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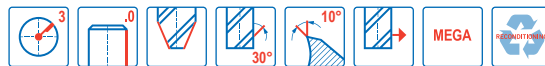
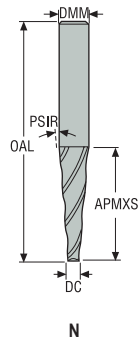
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Allgemeine Anwendung – Universell – Konisch – 3 Schneiden – Zylindrisch – Scharfe Schneide konisch



- Toleranzen:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | PSIR° | PCEDC | Zylindrisch |
|----------------|--------------------|------------------|-------------------|-----|------|-------|------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | | | |
| HK070-025-MEGA | 00029030 | 2 | N | 2,5 | 8,0 | 22,0 | 65,0 | 7,0 | 3 | ■ |
| HK070-050-MEGA | 00029034 | 2 | N | 5,0 | 12,0 | 28,0 | 80,0 | 7,0 | 3 | ■ |

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Graphit

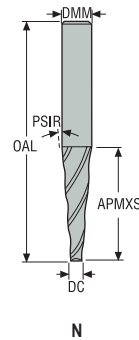
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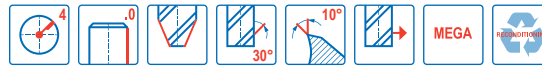
Minimaster

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Allgemeine Anwendung – Universell – Konisch – 4 Schneiden – Zylindrisch – Scharfe Schneide konisch



- Toleranzen:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | PSIR° | PCEDC | Zylindrisch |
|----------------|--------------------|------------------|-------------------|-----------|------------|------------|------------|-------|-------|-------------|
| HK080-083-MEGA | 00029041 | 2 | N | 8,0 mm | 18,0 mm | 35,0 mm | 90,0 mm | 8,0 | 4 | ■ |

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Graphit

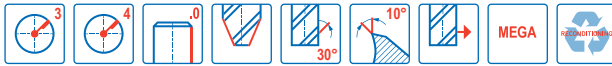
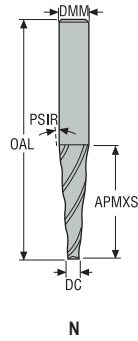
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- Toleranzen:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | PSIR° | PCEDC | Zylindrisch |
|----------------|----------------|--------------|---------------|-----|------|-------|------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | | | |
| HK100-025-MEGA | 00029052 | 2 | N | 2,5 | 10,0 | 20,0 | 75,0 | 10,0 | 3 | ■ |
| HK100-030-MEGA | 00029066 | 2 | N | 3,0 | 14,0 | 30,0 | 90,0 | 10,0 | 3 | ■ |
| HK100-050-MEGA | 00029069 | 2 | N | 5,0 | 16,0 | 30,0 | 90,0 | 10,0 | 3 | ■ |
| HK100-080-MEGA | 00029083 | 2 | N | 8,0 | 20,0 | 32,0 | 90,0 | 10,0 | 4 | ■ |

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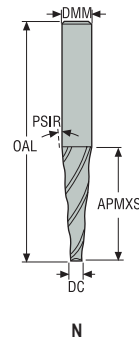
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Minimaster Plus

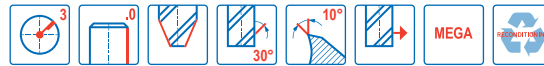
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Allgemeine Anwendung – Universell – Konisch – 3 Schneiden – Zylindrisch – Scharfe Schneide konisch



- Toleranzen:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | PSIR° | PCEDC | Zylindrisch |
|----------------|--------------------|------------------|-------------------|-----|------|-------|------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | | | |
| HK110-020-MEGA | 00029110 | 2 | N | 2,0 | 10,0 | 20,0 | 75,0 | 11,0 | 3 | ■ |
| HK110-050-MEGA | 00029117 | 2 | N | 5,0 | 14,0 | 20,0 | 80,0 | 11,0 | 3 | ■ |

■ Lagerstandard.

Schnittdaten unter My Pages – Vorschlag auf www.secotools.com

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

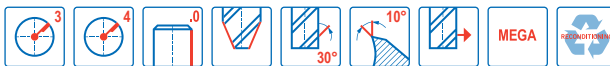
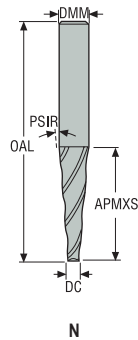
X-Heads

Minimaster Plus

Minimaster

HK

Allgemeine Anwendung – Universell – Konisch – 3-4 Schneiden – Zylindrisch – Scharfe Schneide konisch



- Toleranzen:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | PSIR° | PCEDC | Zylindrisch |
|-----------------|--------------------|------------------|-------------------|-----|------|-------|------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | | | |
| HK150-025 | 00029119 | 2 | N | 2,5 | 14,0 | 20,0 | 80,0 | 15,0 | 3 | ■ |
| HK150-025-MEGA | 00029151 | 2 | N | 2,5 | 14,0 | 20,0 | 80,0 | 15,0 | 3 | ■ |
| HK150-040 | 00029124 | 2 | N | 4,0 | 12,0 | 15,0 | 65,0 | 15,0 | 3 | ■ |
| HK150-040-MEGA | 00029154 | 2 | N | 4,0 | 12,0 | 15,0 | 65,0 | 15,0 | 3 | ■ |
| HK150-0651 | 00029133 | 2 | N | 6,5 | 12,0 | 10,0 | 65,0 | 15,0 | 3 | ■ |
| HK150-0651-MEGA | 00029160 | 2 | N | 6,5 | 12,0 | 10,0 | 65,0 | 15,0 | 3 | ■ |
| HK150-0652 | 00029138 | 2 | N | 6,5 | 20,0 | 25,0 | 90,0 | 15,0 | 3 | ■ |
| HK150-0652-MEGA | 00029161 | 2 | N | 6,5 | 20,0 | 25,0 | 90,0 | 15,0 | 3 | ■ |
| HK150-080 | 00029149 | 2 | N | 8,0 | 20,0 | 20,0 | 80,0 | 15,0 | 4 | ■ |
| HK150-080-MEGA | 00029162 | 2 | N | 8,0 | 20,0 | 20,0 | 80,0 | 15,0 | 4 | ■ |

■ Lagerstandard.
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Rostfrei und
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NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

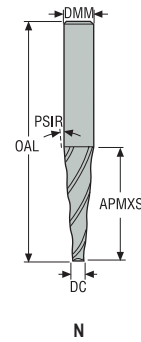
X-Heads

Minimaster Plus

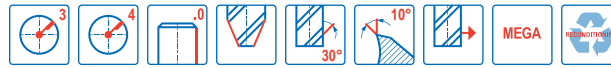
Minimaster

HK

Allgemeine Anwendung – Universell – Konisch – 3-4 Schneiden – Zylindrisch – Scharfe Schneide konisch



- Toleranzen:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | PSIR° | PCEDC | Zylindrisch |
|----------------|----------------|--------------|---------------|-----|------|-------|------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | | | |
| HK200-025 | 00029165 | 2 | N | 2,5 | 10,0 | 10,0 | 75,0 | 20,0 | 3 | ■ |
| HK200-025-MEGA | 00029168 | 2 | N | 2,5 | 10,0 | 10,0 | 75,0 | 20,0 | 3 | ■ |
| HK200-045 | 00029166 | 2 | N | 4,5 | 16,0 | 15,0 | 90,0 | 20,0 | 4 | ■ |
| HK200-045-MEGA | 00029203 | 2 | N | 4,5 | 16,0 | 15,0 | 90,0 | 20,0 | 4 | ■ |

■ Lagerstandard.

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Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

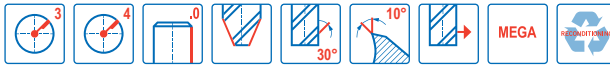
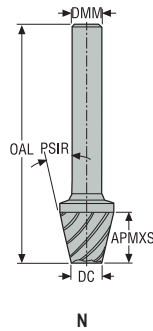
X-Heads

Minimaster Plus

Minimaster

HK

Allgemeine Anwendung – Universell – Konisch – 3-4 Schneiden – Zylindrisch – Scharfe Schneide konisch



- Toleranzen:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | PSIR° | PCEDC | Zylindrisch |
|----------------|----------------|--------------|---------------|-----|------|-------|------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | | | |
| HK300-025 | 00029208 | 2 | N | 2,5 | 10,0 | 10,0 | 75,0 | 30,0 | 3 | ■ |
| HK300-025-MEGA | 00029211 | 2 | N | 2,5 | 10,0 | 10,0 | 75,0 | 30,0 | 3 | ■ |
| HK300-045 | 00029210 | 2 | N | 4,5 | 16,0 | 16,0 | 90,0 | 30,0 | 4 | ■ |
| HK300-045-MEGA | 00029212 | 2 | N | 4,5 | 16,0 | 16,0 | 90,0 | 30,0 | 4 | ■ |

■ Lagerstandard.

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Rostfrei und ISO-S-Werkstoffe

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Kunststoffe und Composite

Graphit

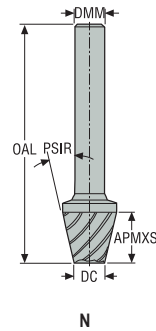
X-Heads

Minimaster Plus

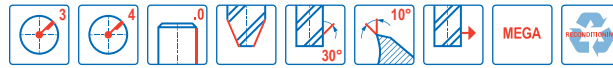
Minimaster

HK

Allgemeine Anwendung – Universell – Konisch – 3-4 Schneiden – Zylindrisch – Scharfe Schneide konisch



- Toleranzen:
- DMM= h5
- DC= +0,1/0 mm
- PSIR= ±0,1°
- Nachschleifen möglich



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | PSIR° | PCEDC | Zylindrisch |
|----------------|----------------|--------------|---------------|-----|------|-------|------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | | | |
| HK450-025 | 00029215 | 2 | N | 2,5 | 12,0 | 10,0 | 75,0 | 45,0 | 3 | ■ |
| HK450-025-MEGA | 00029229 | 2 | N | 2,5 | 12,0 | 10,0 | 75,0 | 45,0 | 3 | ■ |
| HK450-045 | 00029217 | 2 | N | 4,5 | 16,0 | 16,0 | 90,0 | 45,0 | 4 | ■ |
| HK450-045-MEGA | 00029232 | 2 | N | 4,5 | 16,0 | 16,0 | 90,0 | 45,0 | 4 | ■ |

■ Lagerstandard.

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Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

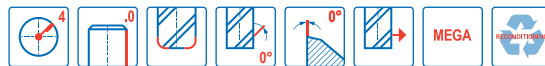
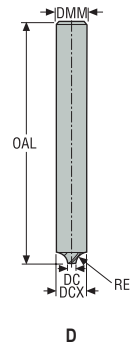
X-Heads

Minimaster Plus

Minimaster

V31

Allgemeine Anwendung – Universell – Konkav – 4 Schneiden – Zylindrisch



- Toleranzen:
- DMM= h5
- DC= ±0,04 mm
- RE= ±0,02 mm
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DCX | DMM | APMXS | OAL | RE | PCEDC | Zylindrisch |
|-------------|--------------------|------------------|-------------------|-----|------|------|-------|------|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | | |
| 31100-MEGA | 00029307 | 2 | D | 4,0 | 6,0 | 6,0 | 1,0 | 64,0 | 1,0 | 4 | ■ |
| 31200-MEGA | 00029315 | 2 | D | 4,0 | 8,0 | 8,0 | 2,0 | 75,0 | 2,0 | 4 | ■ |
| 31300-MEGA | 00029326 | 2 | D | 4,0 | 10,0 | 10,0 | 3,0 | 75,0 | 3,0 | 4 | ■ |
| 31400-MEGA | 00029328 | 2 | D | 4,0 | 12,0 | 12,0 | 4,0 | 75,0 | 4,0 | 4 | ■ |
| 31050-MEGA | 00029285 | 2 | D | 5,0 | 6,0 | 6,0 | 0,5 | 64,0 | 0,5 | 4 | ■ |
| 31150-MEGA | 00029313 | 2 | D | 5,0 | 8,0 | 8,0 | 1,5 | 75,0 | 1,5 | 4 | ■ |
| 31250-MEGA | 00029324 | 2 | D | 5,0 | 10,0 | 10,0 | 2,5 | 75,0 | 2,5 | 4 | ■ |
| 31350-MEGA | 00029327 | 2 | D | 5,0 | 12,0 | 12,0 | 3,5 | 75,0 | 3,5 | 4 | ■ |
| 31500-MEGA | 00029330 | 2 | D | 6,0 | 16,0 | 16,0 | 5,0 | 75,0 | 5,0 | 4 | ■ |
| 31600-MEGA | 00029331 | 2 | D | 8,0 | 20,0 | 20,0 | 6,0 | 80,0 | 6,0 | 4 | ■ |
| 31999-MEGA | 00029335 | 2 | D | 8,0 | 28,0 | 25,0 | 10,0 | 80,0 | 10,0 | 4 | ■ |
| 31800-MEGA | 00029333 | 2 | D | 9,0 | 25,0 | 25,0 | 8,0 | 75,0 | 8,0 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composits

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – V31 Eckfräsen/Schruppen

| SMG | a _p /DC | f _z | | | | | | | | | v _c |
|-----|--------------------|----------------|---------|---------|--------|--------|--------|--------|--------|--------|------------------|
| | | 6 | 8 | 10 | 12 | 16 | 20 | 25 | 28 | | |
| P1 | E/M/A | 0,24 | 0,024 | 0,032 | 0,040 | 0,048 | 0,065 | 0,080 | 0,095 | 0,10 | 290 (195 – 310) |
| | | 0,24 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,004 | 950 (640 – 1100) |
| P2 | E/M/A | 0,24 | 0,024 | 0,034 | 0,042 | 0,050 | 0,065 | 0,080 | 0,095 | 0,10 | 280 (190 – 305) |
| | | 0,24 | 0,00095 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 0,0038 | 0,004 | 910 (620 – 1000) |
| P3 | E/M/A | 0,24 | 0,024 | 0,032 | 0,040 | 0,046 | 0,060 | 0,075 | 0,090 | 0,095 | 240 (165 – 260) |
| | | 0,24 | 0,00095 | 0,0013 | 0,0016 | 0,0018 | 0,0024 | 0,003 | 0,0036 | 0,0038 | 790 (540 – 850) |
| P4 | E/M/A | 0,24 | 0,022 | 0,030 | 0,038 | 0,046 | 0,060 | 0,075 | 0,090 | 0,095 | 210 (145 – 230) |
| | | 0,24 | 0,00085 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,003 | 0,0036 | 0,0038 | 680 (475 – 760) |
| P5 | E/M/A | 0,24 | 0,022 | 0,030 | 0,038 | 0,046 | 0,060 | 0,075 | 0,085 | 0,095 | 205 (135 – 220) |
| | | 0,24 | 0,00085 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,003 | 0,0034 | 0,0038 | 670 (445 – 730) |
| P6 | E/M/A | 0,24 | 0,022 | 0,030 | 0,038 | 0,044 | 0,060 | 0,075 | 0,085 | 0,095 | 230 (155 – 245) |
| | | 0,24 | 0,00085 | 0,0012 | 0,0015 | 0,0017 | 0,0024 | 0,003 | 0,0050 | 0,0038 | 760 (510 – 800) |
| P7 | E/M/A | 0,24 | 0,022 | 0,030 | 0,038 | 0,044 | 0,060 | 0,075 | 0,085 | 0,095 | 215 (145 – 230) |
| | | 0,24 | 0,00085 | 0,0012 | 0,0015 | 0,0017 | 0,0024 | 0,003 | 0,0050 | 0,0038 | 710 (475 – 760) |
| P8 | E/M/A | 0,24 | 0,024 | 0,032 | 0,040 | 0,046 | 0,060 | 0,075 | 0,090 | 0,095 | 205 (140 – 220) |
| | | 0,24 | 0,00095 | 0,0013 | 0,0016 | 0,0018 | 0,0024 | 0,003 | 0,0036 | 0,0038 | 670 (460 – 730) |
| P11 | E/M/A | 0,24 | 0,022 | 0,030 | 0,038 | 0,044 | 0,060 | 0,075 | 0,085 | 0,095 | 210 (140 – 225) |
| | | 0,24 | 0,00085 | 0,0012 | 0,0015 | 0,0017 | 0,0024 | 0,003 | 0,0050 | 0,0038 | 680 (460 – 740) |
| M1 | E/M/A | 0,24 | 0,024 | 0,034 | 0,042 | 0,050 | 0,065 | 0,080 | 0,095 | 0,10 | 255 (170 – 270) |
| | | 0,24 | 0,00095 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 0,0038 | 0,004 | 840 (560 – 890) |
| M2 | E/M/A | 0,24 | 0,022 | 0,030 | 0,038 | 0,046 | 0,060 | 0,075 | 0,085 | 0,095 | 205 (135 – 220) |
| | | 0,24 | 0,00085 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,003 | 0,0050 | 0,0038 | 670 (445 – 730) |
| M3 | E/M/A | 0,24 | 0,018 | 0,024 | 0,030 | 0,036 | 0,048 | 0,060 | 0,070 | 0,075 | 150 (105 – 165) |
| | | 0,24 | 0,0007 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,003 | 490 (345 – 540) |
| M4 | E/M/A | 0,24 | 0,016 | 0,020 | 0,026 | 0,032 | 0,042 | 0,050 | 0,060 | 0,065 | 110 (75 – 120) |
| | | 0,24 | 0,00065 | 0,0008 | 0,0010 | 0,0013 | 0,0017 | 0,0022 | 0,0024 | 0,0026 | 360 (250 – 400) |
| M5 | E/M/A | 0,24 | 0,016 | 0,020 | 0,026 | 0,032 | 0,042 | 0,050 | 0,060 | 0,065 | 95 (65 – 100) |
| | | 0,24 | 0,00065 | 0,0008 | 0,0010 | 0,0013 | 0,0017 | 0,0022 | 0,0024 | 0,0026 | 310 (220 – 320) |
| K1 | E/M/A | 0,24 | 0,022 | 0,030 | 0,038 | 0,046 | 0,060 | 0,075 | 0,085 | 0,095 | 205 (135 – 220) |
| | | 0,24 | 0,00085 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,003 | 0,0050 | 0,0038 | 670 (445 – 730) |
| K2 | E/M/A | 0,24 | 0,020 | 0,028 | 0,034 | 0,040 | 0,055 | 0,065 | 0,080 | 0,085 | 175 (120 – 190) |
| | | 0,24 | 0,0008 | 0,0011 | 0,0013 | 0,0016 | 0,0022 | 0,0026 | 0,0032 | 0,0050 | 570 (400 – 620) |
| K3 | E/M/A | 0,24 | 0,020 | 0,028 | 0,034 | 0,040 | 0,055 | 0,065 | 0,080 | 0,085 | 150 (100 – 160) |
| | | 0,24 | 0,0008 | 0,0011 | 0,0013 | 0,0016 | 0,0022 | 0,0026 | 0,0032 | 0,0050 | 490 (320 – 530) |
| K4 | E/M/A | 0,24 | 0,020 | 0,028 | 0,034 | 0,040 | 0,055 | 0,065 | 0,080 | 0,085 | 140 (95 – 150) |
| | | 0,24 | 0,0008 | 0,0011 | 0,0013 | 0,0016 | 0,0022 | 0,0026 | 0,0032 | 0,0050 | 460 (310 – 490) |
| K5 | E/M/A | 0,24 | 0,018 | 0,024 | 0,030 | 0,036 | 0,050 | 0,060 | 0,070 | 0,075 | 85 (55 – 90) |
| | | 0,24 | 0,0007 | 0,00095 | 0,0012 | 0,0014 | 0,0022 | 0,0024 | 0,0028 | 0,003 | 280 (180 – 300) |
| K6 | E/M/A | 0,24 | 0,020 | 0,028 | 0,034 | 0,040 | 0,055 | 0,065 | 0,080 | 0,085 | 125 (85 – 135) |
| | | 0,24 | 0,0008 | 0,0011 | 0,0013 | 0,0016 | 0,0022 | 0,0026 | 0,0032 | 0,0050 | 410 (280 – 445) |
| K7 | E/M/A | 0,24 | 0,018 | 0,024 | 0,030 | 0,036 | 0,050 | 0,060 | 0,070 | 0,075 | 105 (70 – 115) |
| | | 0,24 | 0,0007 | 0,00095 | 0,0012 | 0,0014 | 0,0022 | 0,0024 | 0,0028 | 0,003 | 345 (220 – 375) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – V31 Eckfräsen/Schruppen

| SMG | | a _p /DC | f _z | | | | | | | | v _c |
|-----|-------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|-------------------|
| | | | 6 | 8 | 10 | 12 | 16 | 20 | 25 | 28 | |
| N1 | E/M/A | 0,24 | 0,022 | 0,030 | 0,038 | 0,046 | 0,060 | 0,075 | 0,085 | 0,095 | 315 (215 – 340) |
| | | 0,24 | 0,00085 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,003 | 0,0050 | 0,0038 | 1025 (710 – 1125) |
| N2 | E/M/A | 0,24 | 0,022 | 0,030 | 0,038 | 0,046 | 0,060 | 0,075 | 0,085 | 0,095 | 205 (135 – 220) |
| | | 0,24 | 0,00085 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,003 | 0,0050 | 0,0038 | 670 (445 – 730) |
| N3 | E/M/A | 0,24 | 0,022 | 0,030 | 0,038 | 0,046 | 0,060 | 0,075 | 0,085 | 0,095 | 135 (90 – 145) |
| | | 0,24 | 0,00085 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,003 | 0,0050 | 0,0038 | 445 (300 – 475) |
| N11 | E/M/A | 0,24 | 0,022 | 0,030 | 0,038 | 0,046 | 0,060 | 0,075 | 0,085 | 0,095 | 205 (135 – 220) |
| | | 0,24 | 0,00085 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,003 | 0,0050 | 0,0038 | 670 (445 – 730) |
| S1 | E/M/A | 0,24 | 0,024 | 0,032 | 0,040 | 0,048 | 0,065 | 0,080 | 0,095 | 0,10 | 205 (140 – 220) |
| | | 0,24 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,004 | 670 (460 – 730) |
| S2 | E/M/A | 0,24 | 0,024 | 0,032 | 0,040 | 0,048 | 0,065 | 0,080 | 0,095 | 0,10 | 205 (140 – 220) |
| | | 0,24 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,004 | 670 (460 – 730) |
| S3 | E/M/A | 0,24 | 0,022 | 0,030 | 0,038 | 0,046 | 0,060 | 0,075 | 0,085 | 0,095 | 205 (135 – 220) |
| | | 0,24 | 0,00085 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,003 | 0,0050 | 0,0038 | 670 (445 – 730) |
| S11 | E/M/A | 0,24 | 0,022 | 0,030 | 0,038 | 0,046 | 0,060 | 0,075 | 0,085 | 0,095 | 265 (180 – 285) |
| | | 0,24 | 0,00085 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,003 | 0,0050 | 0,0038 | 870 (590 – 940) |
| S12 | E/M/A | 0,24 | 0,022 | 0,030 | 0,038 | 0,046 | 0,060 | 0,075 | 0,085 | 0,095 | 205 (135 – 220) |
| | | 0,24 | 0,00085 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,003 | 0,0050 | 0,0038 | 670 (445 – 730) |
| S13 | E/M/A | 0,24 | 0,020 | 0,026 | 0,032 | 0,040 | 0,050 | 0,065 | 0,075 | 0,080 | 155 (105 – 165) |
| | | 0,24 | 0,0008 | 0,0010 | 0,0013 | 0,0016 | 0,0022 | 0,0026 | 0,003 | 0,0032 | 510 (345 – 540) |
| H5 | M/A | 0,24 | 0,034 | 0,046 | 0,055 | 0,070 | 0,090 | 0,11 | 0,13 | 0,14 | 275 (185 – 295) |
| | | 0,24 | 0,0013 | 0,0018 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0050 | 0,0055 | 900 (610 – 950) |
| H8 | M/A | 0,24 | 0,026 | 0,034 | 0,044 | 0,050 | 0,070 | 0,085 | 0,10 | 0,11 | 270 (185 – 290) |
| | | 0,24 | 0,0010 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0050 | 0,004 | 0,0044 | 890 (610 – 950) |
| H21 | M/A | 0,24 | 0,026 | 0,034 | 0,044 | 0,050 | 0,070 | 0,085 | 0,10 | 0,11 | 270 (185 – 290) |
| | | 0,24 | 0,0010 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0050 | 0,004 | 0,0044 | 890 (610 – 950) |
| H31 | M/A | 0,24 | 0,022 | 0,030 | 0,038 | 0,046 | 0,060 | 0,075 | 0,085 | 0,095 | 205 (135 – 220) |
| | | 0,24 | 0,00085 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,003 | 0,0050 | 0,0038 | 670 (445 – 730) |
| TS1 | A/D | 0,24 | 0,022 | 0,030 | 0,038 | 0,046 | 0,060 | 0,075 | 0,085 | 0,095 | 205 (135 – 220) |
| | | 0,24 | 0,00085 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,003 | 0,0050 | 0,0038 | 670 (445 – 730) |
| TP1 | A/D | 0,24 | 0,022 | 0,030 | 0,038 | 0,046 | 0,060 | 0,075 | 0,085 | 0,095 | 205 (135 – 220) |
| | | 0,24 | 0,00085 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,003 | 0,0050 | 0,0038 | 670 (445 – 730) |
| GR1 | A/D | 0,24 | 0,022 | 0,030 | 0,038 | 0,046 | 0,060 | 0,075 | 0,085 | 0,095 | 205 (135 – 220) |
| | | 0,24 | 0,00085 | 0,0012 | 0,0015 | 0,0018 | 0,0024 | 0,003 | 0,0050 | 0,0038 | 670 (445 – 730) |

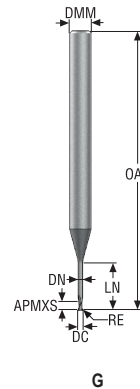
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

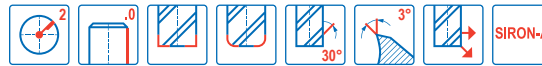
Universell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

JME542

Mini – Universell – Eckfräser – 2 Schneiden – DMM 4 – Zylindrisch – scharf oder Eckenradius




- Toleranzen:
- Rundlaufabweichung = <math><0,007\text{ mm}</math>
- DMM= h5
- DC= $\varnothing 0,2\text{-}\varnothing 0,4= 0,-0,01\text{ mm}</math>$
- DC= $\varnothing 0,5\text{-}\varnothing 3,0= 0,-0,013\text{ mm}</math>$
- RE= $\pm 0,005\text{ mm}</math>$



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | CA° | PCEDC | Zylindrisch |
|--------------------------|--------------------|------------------|-------------------|-----|-----|-------|------|------|------|------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | | |
| JME542002G1S.0Z2-SIRA | 03171095 | 1 | G | 0,2 | 4,0 | 0,3 | 45,0 | 0,4 | 0,18 | – | 14,41 | 2 | ■ |
| JME542003G1S.0Z2-SIRA | 03171096 | 1 | G | 0,3 | 4,0 | 0,45 | 45,0 | 0,6 | 0,28 | – | 14,0 | 2 | ■ |
| JME542004G1S.0Z2-SIRA | 03171128 | 1 | G | 0,4 | 4,0 | 0,6 | 45,0 | 0,8 | 0,37 | – | 13,5 | 2 | ■ |
| JME542005G1R005.0Z2-SIRA | 03171097 | 1 | G | 0,5 | 4,0 | 0,8 | 45,0 | 1,0 | 0,46 | 0,05 | 13,17 | 2 | ■ |
| JME542006G1R005.0Z2-SIRA | 03171098 | 1 | G | 0,6 | 4,0 | 0,9 | 45,0 | 1,2 | 0,56 | 0,05 | 12,76 | 2 | ■ |
| JME542008G1R005.0Z2-SIRA | 03171129 | 1 | G | 0,8 | 4,0 | 1,2 | 45,0 | 1,6 | 0,76 | 0,05 | 11,96 | 2 | ■ |
| JME542010G1R010.0Z2-SIRA | 03171099 | 1 | G | 1,0 | 4,0 | 1,5 | 50,0 | 2,0 | 0,95 | 0,1 | 11,22 | 2 | ■ |
| JME542012G1R010.0Z2-SIRA | 03171100 | 1 | G | 1,2 | 4,0 | 1,8 | 50,0 | 2,4 | 1,15 | 0,1 | 10,43 | 2 | ■ |
| JME542015G1R015.0Z2-SIRA | 03171130 | 1 | G | 1,5 | 4,0 | 2,3 | 50,0 | 3,0 | 1,45 | 0,15 | 9,2 | 2 | ■ |
| JME542005G3R005.0Z2-SIRA | 03171102 | 3 | G | 0,5 | 4,0 | 0,8 | 45,0 | 2,5 | 0,46 | 0,05 | 11,03 | 2 | ■ |
| JME542006G3R005.0Z2-SIRA | 03171103 | 3 | G | 0,6 | 4,0 | 0,9 | 45,0 | 3,0 | 0,56 | 0,05 | 10,36 | 2 | ■ |
| JME542008G3R005.0Z2-SIRA | 03171131 | 3 | G | 0,8 | 4,0 | 1,2 | 45,0 | 4,0 | 0,76 | 0,05 | 9,14 | 2 | ■ |
| JME542010G3R010.0Z2-SIRA | 03171104 | 3 | G | 1,0 | 4,0 | 1,5 | 50,0 | 5,0 | 0,95 | 0,1 | 8,09 | 2 | ■ |
| JME542012G3R010.0Z2-SIRA | 03171105 | 3 | G | 1,2 | 4,0 | 1,8 | 50,0 | 6,0 | 1,15 | 0,1 | 7,13 | 2 | ■ |
| JME542015G3R015.0Z2-SIRA | 03171132 | 3 | G | 1,5 | 4,0 | 2,3 | 50,0 | 7,5 | 1,45 | 0,15 | 5,89 | 2 | ■ |
| JME542020G3R015.0Z2-SIRA | 03171106 | 3 | G | 2,0 | 4,0 | 3,0 | 50,0 | 10,0 | 1,94 | 0,15 | 4,14 | 2 | ■ |
| JME542025G3R015.0Z2-SIRA | 03171108 | 3 | G | 2,5 | 4,0 | 3,8 | 50,0 | 12,5 | 2,4 | 0,15 | 2,79 | 2 | ■ |
| JME542030G3R015.0Z2-SIRA | 03171134 | 3 | G | 3,0 | 4,0 | 4,5 | 60,0 | 15,0 | 2,85 | 0,15 | 1,67 | 2 | ■ |
| JME542005G4R005.0Z2-SIRA | 03171109 | 4 | G | 0,5 | 4,0 | 0,8 | 45,0 | 4,0 | 0,46 | 0,05 | 9,49 | 2 | ■ |
| JME542006G4R005.0Z2-SIRA | 03171110 | 4 | G | 0,6 | 4,0 | 0,9 | 45,0 | 5,0 | 0,56 | 0,05 | 8,56 | 2 | ■ |
| JME542008G4R005.0Z2-SIRA | 03171135 | 4 | G | 0,8 | 4,0 | 1,2 | 45,0 | 7,0 | 0,76 | 0,05 | 7,05 | 2 | ■ |
| JME542010G4R010.0Z2-SIRA | 03171111 | 4 | G | 1,0 | 4,0 | 1,5 | 50,0 | 8,5 | 0,95 | 0,1 | 6,1 | 2 | ■ |
| JME542012G4R010.0Z2-SIRA | 03171112 | 4 | G | 1,2 | 4,0 | 1,8 | 50,0 | 10,0 | 1,15 | 0,1 | 5,27 | 2 | ■ |
| JME542015G4R015.0Z2-SIRA | 03171136 | 4 | G | 1,5 | 4,0 | 2,3 | 50,0 | 12,0 | 1,45 | 0,15 | 4,29 | 2 | ■ |
| JME542020G4R015.0Z2-SIRA | 03171113 | 4 | G | 2,0 | 4,0 | 3,0 | 60,0 | 16,0 | 1,94 | 0,15 | 2,9 | 2 | ■ |
| JME542030G4R015.0Z2-SIRA | 03171137 | 4 | G | 3,0 | 4,0 | 4,5 | 70,0 | 24,0 | 2,85 | 0,15 | 1,1 | 2 | ■ |
| JME542015G5R015.0Z2-SIRA | 03171115 | 5 | G | 1,5 | 4,0 | 2,3 | 60,0 | 15,0 | 1,45 | 0,15 | 3,64 | 2 | ■ |
| JME542020G5R015.0Z2-SIRA | 03171116 | 5 | G | 2,0 | 4,0 | 3,0 | 60,0 | 20,0 | 1,94 | 0,15 | 2,41 | 2 | ■ |
| JME542030G5R015.0Z2-SIRA | 03171117 | 5 | G | 3,0 | 4,0 | 4,5 | 70,0 | 30,0 | 2,85 | 0,15 | 0,9 | 2 | ■ |
| JME542015G6R015.0Z2-SIRA | 03171118 | 6 | G | 1,5 | 4,0 | 2,3 | 70,0 | 22,5 | 1,45 | 0,15 | 2,64 | 2 | ■ |
| JME542020G6R015.0Z2-SIRA | 03171139 | 6 | G | 2,0 | 4,0 | 3,0 | 70,0 | 30,0 | 1,94 | 0,15 | 1,7 | 2 | ■ |
| JME542030G6R015.0Z2-SIRA | 03171120 | 6 | G | 3,0 | 4,0 | 4,5 | 90,0 | 45,0 | 2,85 | 0,15 | 0,61 | 2 | ■ |

■ Lagerstandard.

Schnittdaten – JME542 Eckfräsen/Schruppen

| SMG |  | a_e/DC | a_p/DC | f_z | | | | | | | | | | | | v_c |
|-----|---|----------|----------|---------|---------|---------|---------|---------|---------|---------|---------|--------|--------|--------|--------|--------------------|
| | | | | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.8 | 1.0 | 1.2 | 1.8 | 2.0 | 2.5 | 3.0 | |
| P1 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 415 (370 – 460) |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1350 (1300 – 1500) |
| P2 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 405 (360 – 440) |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1325 (1200 – 1400) |
| P3 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 350 (310 – 380) |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1150 (1100 – 1200) |
| P4 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 305 (280 – 340) |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1000 (920 – 1100) |
| P5 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 290 (260 – 320) |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 950 (860 – 1000) |
| P6 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 330 (300 – 360) |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1075 (990 – 1100) |
| P7 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 310 (280 – 340) |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1025 (920 – 1100) |
| P8 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 290 (260 – 320) |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 950 (860 – 1000) |
| P11 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 300 (270 – 330) |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 980 (890 – 1000) |
| P12 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 175 (160 – 190) |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 570 (530 – 620) |
| M1 | E/M/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 220 (190 – 260) |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 720 (630 – 850) |
| M2 | E/M/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 180 (150 – 210) |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 590 (500 – 680) |
| M3 | E/M/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 180 (150 – 210) |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 590 (500 – 680) |
| M4 | E/M/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 135 (110 – 150) |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 445 (370 – 490) |
| M5 | E/M/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 110 (92 – 130) |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 360 (310 – 420) |
| N1 | E/M/A | 0.100 | 0.75 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 570 (500 – 640) |
| | | 0,100 | 0,75 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1875 (1700 – 2000) |
| N2 | E/M/A | 0.100 | 0.75 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 570 (500 – 640) |
| | | 0,100 | 0,75 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1875 (1700 – 2000) |
| N3 | E/M/A | 0.100 | 0.75 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 380 (340 – 420) |
| | | 0,100 | 0,75 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1250 (1200 – 1300) |
| N11 | E/M/A | 0.100 | 0.75 | 0.0050 | 0.0075 | 0.010 | 0.012 | 0.015 | 0.020 | 0.025 | 0.030 | 0.046 | 0.050 | 0.060 | 0.075 | 510 (440 – 580) |
| | | 0,100 | 0,75 | 0,00020 | 0,00030 | 0,00040 | 0,00048 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0018 | 0,0020 | 0,0024 | 0,0030 | 1675 (1500 – 1900) |
| S11 | E/M/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 295 (260 – 330) |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 970 (860 – 1000) |
| S12 | E/M/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 225 (200 – 250) |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 740 (660 – 820) |
| S13 | E/M/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 175 (160 – 200) |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 570 (530 – 650) |
| H3 | M/A | 0.0500 | 0.30 | 0.0036 | 0.0055 | 0.0070 | 0.0090 | 0.011 | 0.014 | 0.018 | 0.022 | 0.032 | 0.036 | 0.044 | 0.055 | 120 (90 – 140) |
| | | 0,0500 | 0,30 | 0,00014 | 0,00022 | 0,00028 | 0,00036 | 0,00044 | 0,00055 | 0,00070 | 0,00085 | 0,0013 | 0,0014 | 0,0017 | 0,0022 | 395 (300 – 450) |
| H5 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 255 (230 – 280) |
| | | 0,0500 | 0,44 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 840 (760 – 910) |
| H7 | M/A | 0.0500 | 0.30 | 0.0036 | 0.0055 | 0.0070 | 0.0090 | 0.011 | 0.014 | 0.018 | 0.022 | 0.032 | 0.036 | 0.044 | 0.055 | 120 (90 – 140) |
| | | 0,0500 | 0,30 | 0,00014 | 0,00022 | 0,00028 | 0,00036 | 0,00044 | 0,00055 | 0,00070 | 0,00085 | 0,0013 | 0,0014 | 0,0017 | 0,0022 | 395 (300 – 450) |
| H8 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 255 (230 – 280) |
| | | 0,0500 | 0,44 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 840 (760 – 910) |
| H11 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 325 (290 – 360) |
| | | 0,0500 | 0,44 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1075 (960 – 1100) |
| H12 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 295 (270 – 330) |
| | | 0,0500 | 0,44 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 970 (890 – 1000) |
| H21 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 255 (230 – 280) |
| | | 0,0500 | 0,44 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 840 (760 – 910) |
| H31 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 195 (170 – 210) |
| | | 0,0500 | 0,44 | 0,00016 | 0,000 | | | | | | | | | | | |

Schnittdaten – JME542 Nutfräsen

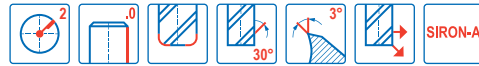
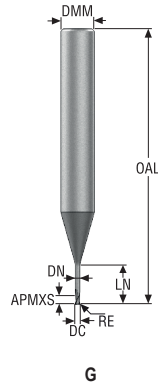
| SMG | | a _p /DC | f _z | | | | | | | | | | | | v _c |
|-----|-------|--------------------|----------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|--------|--------|-----------------|
| | | | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.8 | 1.0 | 1.2 | 1.8 | 2.0 | 2.5 | 3.0 | |
| P1 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 255 (230 – 280) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| P2 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 250 (230 – 270) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| P3 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 215 (200 – 230) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| P4 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 190 (170 – 200) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| P5 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 180 (170 – 200) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| P6 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 200 (180 – 220) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| P7 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 190 (170 – 210) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| P8 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 180 (170 – 200) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| P11 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 185 (170 – 200) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| P12 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.022 | 0.022 | 0.026 | 0.028 | 110 (98 – 120) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00085 | 0.00085 | 0.0010 | 0.0011 | 0.0011 |
| M1 | E/M/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 135 (120 – 160) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| M2 | E/M/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 110 (91 – 130) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| M3 | E/M/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 110 (91 – 130) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| M4 | E/M/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.036 | 80 (68 – 97) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0014 | 0.0014 |
| M5 | E/M/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.036 | 70 (57 – 81) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0014 | 0.0014 |
| N1 | E/M/A | 0.24 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 400 (350 – 440) |
| | | 0.24 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| N2 | E/M/A | 0.24 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 400 (350 – 440) |
| | | 0.24 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| N3 | E/M/A | 0.24 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 265 (240 – 290) |
| | | 0.24 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| N11 | E/M/A | 0.24 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.048 | 0.050 | 350 (300 – 400) |
| | | 0.24 | 0.00016 | 0.00024 | 0.00032 | 0.00040 | 0.00048 | 0.00065 | 0.00080 | 0.00095 | 0.0014 | 0.0016 | 0.0019 | 0.0020 | 0.0020 |
| S11 | E/M/A | 0.36 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 180 (160 – 200) |
| | | 0.36 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| S12 | E/M/A | 0.36 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 140 (120 – 150) |
| | | 0.36 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| S13 | E/M/A | 0.36 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.036 | 110 (93 – 120) |
| | | 0.36 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0014 | 0.0014 |
| H3 | M/A | 0.095 | 0.0024 | 0.0036 | 0.0048 | 0.0060 | 0.0070 | 0.0095 | 0.012 | 0.014 | 0.022 | 0.024 | 0.030 | 0.036 | 80 (61 – 100) |
| | | 0.095 | 0.000095 | 0.00014 | 0.00019 | 0.00024 | 0.00028 | 0.00038 | 0.00048 | 0.00055 | 0.00085 | 0.00095 | 0.0012 | 0.0014 | 0.0014 |
| H5 | M/A | 0.20 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 160 (150 – 180) |
| | | 0.20 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| H7 | M/A | 0.095 | 0.0024 | 0.0036 | 0.0048 | 0.0060 | 0.0070 | 0.0095 | 0.012 | 0.014 | 0.022 | 0.024 | 0.030 | 0.036 | 80 (61 – 100) |
| | | 0.095 | 0.000095 | 0.00014 | 0.00019 | 0.00024 | 0.00028 | 0.00038 | 0.00048 | 0.00055 | 0.00085 | 0.00095 | 0.0012 | 0.0014 | 0.0014 |
| H8 | M/A | 0.20 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 160 (150 – 180) |
| | | 0.20 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| H11 | M/A | 0.20 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 205 (180 – 230) |
| | | 0.20 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| H12 | M/A | 0.20 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 190 (170 – 210) |
| | | 0.20 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| H21 | M/A | 0.20 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 160 (150 – 180) |
| | | 0.20 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 0.0016 |
| H31 | M/A | 0.20 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.036 | 120 (110 – 130) |
| | | 0.20 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0014 | 0.0014 |
| GR1 | A | 0.50 | 0.0020 | 0.0030 | 0.0040 | 0.0050 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.018 | 0.020 | 0.025 | 0.030 | 350 (300 – 400) |
| | | 0.50 | 0.000080 | 0.00012 | 0.00016 | 0.00020 | 0.00024 | 0.00032 | 0.00040 | 0.00048 | 0.00070 | 0.00080 | 0.0010 | 0.0012 | 0.0012 |

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 561 - 568

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c = m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JME562

Mini – Universell – Eckfräser – 2 Schneiden – DMM 6 – Zylindrisch – Eckenradius



- Toleranzen:
- Rundlaufabweichung = <0,007 mm
- DMM= h5
- DC= 0,-0,013 mm
- RE= ±0,005 mm

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | CA° | PCEDC Zylindrisch |
|--------------------------|----------------|--------------|---------------|-----|-----|-------|------|------|------|------|-------|-------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JME562005G2R005.0Z2-SIRA | 03171145 | 2 | G | 0,5 | 6,0 | 0,8 | 50,0 | 1,5 | 0,46 | 0,05 | 13,48 | 2 ■ |
| JME562006G2R005.0Z2-SIRA | 03171146 | 2 | G | 0,6 | 6,0 | 0,9 | 50,0 | 2,0 | 0,56 | 0,05 | 12,9 | 2 ■ |
| JME562008G2R005.0Z2-SIRA | 03171147 | 2 | G | 0,8 | 6,0 | 1,2 | 50,0 | 2,5 | 0,76 | 0,05 | 12,28 | 2 ■ |
| JME562010G2R010.0Z2-SIRA | 03171148 | 2 | G | 1,0 | 6,0 | 1,5 | 50,0 | 4,0 | 0,95 | 0,1 | 10,85 | 2 ■ |
| JME562012G2R010.0Z2-SIRA | 03171150 | 2 | G | 1,2 | 6,0 | 1,8 | 50,0 | 4,5 | 1,15 | 0,1 | 10,31 | 2 ■ |
| JME562015G2R015.0Z2-SIRA | 03171151 | 2 | G | 1,5 | 6,0 | 2,3 | 50,0 | 5,0 | 1,45 | 0,15 | 9,67 | 2 ■ |
| JME562018G2R015.0Z2-SIRA | 03171152 | 2 | G | 1,8 | 6,0 | 2,7 | 50,0 | 5,4 | 1,75 | 0,15 | 9,12 | 2 ■ |
| JME562020G2R015.0Z2-SIRA | 03171153 | 2 | G | 2,0 | 6,0 | 3,0 | 50,0 | 6,0 | 1,94 | 0,15 | 8,53 | 2 ■ |
| JME562025G2R015.0Z2-SIRA | 03171154 | 2 | G | 2,5 | 6,0 | 3,8 | 60,0 | 7,5 | 2,4 | 0,15 | 7,15 | 2 ■ |
| JME562030G2R015.0Z2-SIRA | 03171155 | 2 | G | 3,0 | 6,0 | 4,5 | 60,0 | 9,0 | 2,85 | 0,15 | 5,81 | 2 ■ |
| JME562005G4R005.0Z2-SIRA | 03171156 | 4 | G | 0,5 | 6,0 | 0,8 | 50,0 | 3,5 | 0,46 | 0,05 | 11,54 | 2 ■ |
| JME562006G4R005.0Z2-SIRA | 03171157 | 4 | G | 0,6 | 6,0 | 0,9 | 50,0 | 4,2 | 0,56 | 0,05 | 10,93 | 2 ■ |
| JME562008G4R005.0Z2-SIRA | 03171158 | 4 | G | 0,8 | 6,0 | 1,2 | 50,0 | 5,6 | 0,76 | 0,05 | 9,81 | 2 ■ |
| JME562010G4R010.0Z2-SIRA | 03171159 | 4 | G | 1,0 | 6,0 | 1,5 | 50,0 | 7,0 | 0,95 | 0,1 | 8,86 | 2 ■ |
| JME562012G4R010.0Z2-SIRA | 03171160 | 4 | G | 1,2 | 6,0 | 1,8 | 50,0 | 8,4 | 1,15 | 0,1 | 8,0 | 2 ■ |
| JME562015G4R015.0Z2-SIRA | 03171162 | 4 | G | 1,5 | 6,0 | 2,3 | 50,0 | 10,5 | 1,45 | 0,15 | 6,86 | 2 ■ |
| JME562020G4R015.0Z2-SIRA | 03171163 | 4 | G | 2,0 | 6,0 | 3,0 | 60,0 | 14,0 | 1,94 | 0,15 | 5,36 | 2 ■ |
| JME562030G4R015.0Z2-SIRA | 03171165 | 4 | G | 3,0 | 6,0 | 4,5 | 70,0 | 21,0 | 2,85 | 0,15 | 3,22 | 2 ■ |
| JME562005G5R005.0Z2-SIRA | 03171166 | 5 | G | 0,5 | 6,0 | 0,8 | 50,0 | 5,0 | 0,46 | 0,05 | 10,42 | 2 ■ |
| JME562006G5R005.0Z2-SIRA | 03171167 | 5 | G | 0,6 | 6,0 | 0,9 | 50,0 | 6,0 | 0,56 | 0,05 | 9,71 | 2 ■ |
| JME562008G5R005.0Z2-SIRA | 03171168 | 5 | G | 0,8 | 6,0 | 1,2 | 50,0 | 8,0 | 0,76 | 0,05 | 8,48 | 2 ■ |
| JME562010G5R010.0Z2-SIRA | 03171169 | 5 | G | 1,0 | 6,0 | 1,5 | 50,0 | 10,0 | 0,95 | 0,1 | 7,48 | 2 ■ |
| JME562012G5R010.0Z2-SIRA | 03171170 | 5 | G | 1,2 | 6,0 | 1,8 | 50,0 | 12,0 | 1,15 | 0,1 | 6,62 | 2 ■ |
| JME562015G5R015.0Z2-SIRA | 03171171 | 5 | G | 1,5 | 6,0 | 2,3 | 60,0 | 15,0 | 1,45 | 0,15 | 5,54 | 2 ■ |
| JME562020G5R015.0Z2-SIRA | 03171172 | 5 | G | 2,0 | 6,0 | 3,0 | 60,0 | 20,0 | 1,94 | 0,15 | 4,19 | 2 ■ |
| JME562030G5R015.0Z2-SIRA | 03171174 | 5 | G | 3,0 | 6,0 | 4,5 | 70,0 | 30,0 | 2,85 | 0,15 | 2,41 | 2 ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

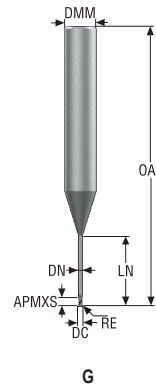
X-Heads

Minimaster Plus

Minimaster

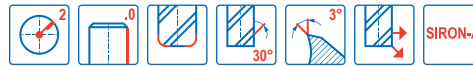
JME562

Mini – Universell – Eckfräser – 2 Schneiden – DMM 6 – Zylindrisch – Eckenradius



G

- Toleranzen:
- Rundlaufabweichung = <math><0,007\text{ mm}</math>
- DMM= h5
- DC= 0,-0,013 mm
- RE= $\pm 0,005\text{ mm}$



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | CA° | PCEDC Zylindrisch |
|--------------------------|----------------|--------------|---------------|-----|-----|-------|-------|------|------|------|------|-------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JME562010G6R010.0Z2-SIRA | 03171175 | 6 | G | 1,0 | 6,0 | 1,5 | 60,0 | 15,0 | 0,95 | 0,1 | 5,94 | 2 ■ |
| JME562012G6R010.0Z2-SIRA | 03171176 | 6 | G | 1,2 | 6,0 | 1,8 | 60,0 | 18,0 | 1,15 | 0,1 | 5,14 | 2 ■ |
| JME562015G6R015.0Z2-SIRA | 03171177 | 6 | G | 1,5 | 6,0 | 2,3 | 70,0 | 22,5 | 1,45 | 0,15 | 4,2 | 2 ■ |
| JME562020G6R015.0Z2-SIRA | 03171178 | 6 | G | 2,0 | 6,0 | 3,0 | 80,0 | 30,0 | 1,94 | 0,15 | 3,07 | 2 ■ |
| JME562030G6R015.0Z2-SIRA | 03171180 | 6 | G | 3,0 | 6,0 | 4,5 | 90,0 | 45,0 | 2,85 | 0,15 | 1,7 | 2 ■ |
| JME562010G7R010.0Z2-SIRA | 03171181 | 7 | G | 1,0 | 6,0 | 1,5 | 60,0 | 20,0 | 0,95 | 0,1 | 4,93 | 2 ■ |
| JME562012G7R010.0Z2-SIRA | 03171182 | 7 | G | 1,2 | 6,0 | 1,8 | 80,0 | 24,0 | 1,15 | 0,1 | 4,2 | 2 ■ |
| JME562015G7R015.0Z2-SIRA | 03171183 | 7 | G | 1,5 | 6,0 | 2,3 | 80,0 | 30,0 | 1,45 | 0,15 | 3,38 | 2 ■ |
| JME562020G7R015.0Z2-SIRA | 03171184 | 7 | G | 2,0 | 6,0 | 3,0 | 80,0 | 40,0 | 1,94 | 0,15 | 2,42 | 2 ■ |
| JME562030G7R015.0Z2-SIRA | 03171186 | 7 | G | 3,0 | 6,0 | 4,5 | 100,0 | 60,0 | 2,85 | 0,15 | 1,31 | 2 ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite


Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JME562 Eckfräsen/Schuppen

| SMG |  | a_e/DC | a_p/DC | f_z | | | | | | | | | | | | v_c | |
|-----|---|----------|----------|---------|---------|---------|---------|---------|---------|---------|---------|--------|--------|--------|--------|--------------------|-------------------------------|
| | | | | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.8 | 1.0 | 1.2 | 1.8 | 2.0 | 2.5 | 3.0 | | |
| P1 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 415 (370 – 460) | Universell |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1350 (1300 – 1500) | |
| P2 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 405 (360 – 440) | Stahl und Guss |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1325 (1200 – 1400) | |
| P3 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 350 (310 – 380) | Stahl und Guss |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1150 (1100 – 1200) | |
| P4 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 305 (280 – 340) | Stahl und Guss |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1000 (920 – 1100) | |
| P5 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 290 (260 – 320) | Stahl und Guss |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 950 (860 – 1000) | |
| P6 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 330 (300 – 360) | Stahl und Guss |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1075 (990 – 1100) | |
| P7 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 310 (280 – 340) | Stahl und Guss |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1025 (920 – 1100) | |
| P8 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 290 (260 – 320) | Stahl und Guss |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 950 (860 – 1000) | |
| P11 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 300 (270 – 330) | Roßstrei und ISO-S-Werkstoffe |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 980 (890 – 1000) | |
| P12 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 175 (160 – 190) | Roßstrei und ISO-S-Werkstoffe |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 570 (530 – 620) | |
| M1 | E/M/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 220 (190 – 260) | NE-Metalle |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 720 (630 – 850) | |
| M2 | E/M/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 180 (150 – 210) | NE-Metalle |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 590 (500 – 680) | |
| M3 | E/M/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 180 (150 – 210) | NE-Metalle |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 590 (500 – 680) | |
| M4 | E/M/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 135 (110 – 150) | NE-Metalle |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 445 (370 – 490) | |
| M5 | E/M/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 110 (92 – 130) | NE-Metalle |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 360 (310 – 420) | |
| N1 | E/M/A | 0.100 | 0.75 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 570 (500 – 640) | Harter |
| | | 0,100 | 0,75 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1875 (1700 – 2000) | |
| N2 | E/M/A | 0.100 | 0.75 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 570 (500 – 640) | Harter |
| | | 0,100 | 0,75 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1875 (1700 – 2000) | |
| N3 | E/M/A | 0.100 | 0.75 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 380 (340 – 420) | Harter |
| | | 0,100 | 0,75 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1250 (1200 – 1300) | |
| N11 | E/M/A | 0.100 | 0.75 | 0.0050 | 0.0075 | 0.010 | 0.012 | 0.015 | 0.020 | 0.025 | 0.030 | 0.046 | 0.050 | 0.060 | 0.075 | 510 (440 – 580) | Kunststoffe und Composite |
| | | 0,100 | 0,75 | 0,00020 | 0,00030 | 0,00040 | 0,00048 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0018 | 0,0020 | 0,0024 | 0,0030 | 1675 (1500 – 1900) | |
| S11 | E/M/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 295 (260 – 330) | Kunststoffe und Composite |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 970 (860 – 1000) | |
| S12 | E/M/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 225 (200 – 250) | Kunststoffe und Composite |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 740 (660 – 820) | |
| S13 | E/M/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 175 (160 – 200) | Kunststoffe und Composite |
| | | 0,0500 | 0,60 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 570 (530 – 650) | |
| H3 | M/A | 0.0500 | 0.30 | 0.0036 | 0.0055 | 0.0070 | 0.0090 | 0.011 | 0.014 | 0.018 | 0.022 | 0.032 | 0.036 | 0.044 | 0.055 | 120 (90 – 140) | Graphit |
| | | 0,0500 | 0,30 | 0,00014 | 0,00022 | 0,00028 | 0,00036 | 0,00044 | 0,00055 | 0,00070 | 0,00085 | 0,0013 | 0,0014 | 0,0017 | 0,0022 | 395 (300 – 450) | |
| H5 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 255 (230 – 280) | Graphit |
| | | 0,0500 | 0,44 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 840 (760 – 910) | |
| H7 | M/A | 0.0500 | 0.30 | 0.0036 | 0.0055 | 0.0070 | 0.0090 | 0.011 | 0.014 | 0.018 | 0.022 | 0.032 | 0.036 | 0.044 | 0.055 | 120 (90 – 140) | Graphit |
| | | 0,0500 | 0,30 | 0,00014 | 0,00022 | 0,00028 | 0,00036 | 0,00044 | 0,00055 | 0,00070 | 0,00085 | 0,0013 | 0,0014 | 0,0017 | 0,0022 | 395 (300 – 450) | |
| H8 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 255 (230 – 280) | Graphit |
| | | 0,0500 | 0,44 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 840 (760 – 910) | |
| H11 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 325 (290 – 360) | X-Heads |
| | | 0,0500 | 0,44 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1075 (960 – 1100) | |
| H12 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 295 (270 – 330) | X-Heads |
| | | 0,0500 | 0,44 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 970 (890 – 1000) | |
| H21 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 255 (230 – 280) | X-Heads |
| | | 0,0500 | 0,44 | 0,00016 | 0 | | | | | | | | | | | | |

Schnittdaten – JME562 Nutfräsen

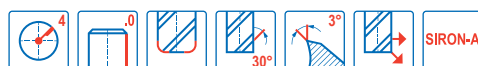
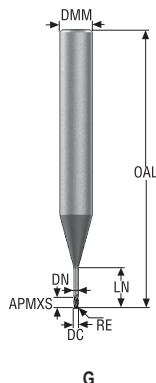
| SMG | a _p /DC | f _z | | | | | | | | | | | | | v _c |
|-----|--------------------|----------------|----------|---------|---------|---------|---------|---------|---------|---------|---------|---------|--------|--------|--------------------|
| | | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.8 | 1.0 | 1.2 | 1.8 | 2.0 | 2.5 | 3.0 | | |
| P1 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 255 (230 – 280) |
| P2 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 840 (760 – 910) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 250 (230 – 270) |
| P3 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 820 (760 – 880) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 215 (200 – 230) |
| P4 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 710 (660 – 750) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 190 (170 – 200) |
| P5 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 620 (560 – 650) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 180 (170 – 200) |
| P6 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 590 (560 – 650) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 200 (180 – 220) |
| P7 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 660 (600 – 720) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 190 (170 – 210) |
| P8 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 620 (560 – 680) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 180 (170 – 200) |
| P11 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 590 (560 – 650) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 185 (170 – 200) |
| P12 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.022 | 0.022 | 0.026 | 0.028 | 110 (98 – 120) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00085 | 0.00085 | 0.0010 | 0.0011 | 360 (330 – 390) |
| M1 | E/M/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 135 (120 – 160) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 445 (400 – 520) |
| M2 | E/M/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 110 (91 – 130) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 360 (300 – 420) |
| M3 | E/M/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 110 (91 – 130) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 360 (300 – 420) |
| M4 | E/M/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.036 | 80 (68 – 97) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0014 | 260 (230 – 310) |
| M5 | E/M/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.036 | 70 (57 – 81) |
| | | 0.32 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0014 | 230 (190 – 260) |
| N1 | E/M/A | 0.24 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 400 (350 – 440) |
| | | 0.24 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 1300 (1200 – 1400) |
| N2 | E/M/A | 0.24 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 400 (350 – 440) |
| | | 0.24 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 1300 (1200 – 1400) |
| N3 | E/M/A | 0.24 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 265 (240 – 290) |
| | | 0.24 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 870 (790 – 950) |
| N11 | E/M/A | 0.24 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.048 | 0.050 | 350 (300 – 400) |
| | | 0.24 | 0.00016 | 0.00024 | 0.00032 | 0.00040 | 0.00048 | 0.00065 | 0.00080 | 0.00095 | 0.0014 | 0.0016 | 0.0019 | 0.0020 | 1150 (990 – 1300) |
| S11 | E/M/A | 0.36 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 180 (160 – 200) |
| | | 0.36 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 590 (530 – 650) |
| S12 | E/M/A | 0.36 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 140 (120 – 150) |
| | | 0.36 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 460 (400 – 490) |
| S13 | E/M/A | 0.36 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.036 | 110 (93 – 120) |
| | | 0.36 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0014 | 360 (310 – 390) |
| H3 | M/A | 0.095 | 0.0024 | 0.0036 | 0.0048 | 0.0060 | 0.0070 | 0.0095 | 0.012 | 0.014 | 0.022 | 0.024 | 0.030 | 0.036 | 80 (61 – 100) |
| | | 0.095 | 0.000095 | 0.00014 | 0.00019 | 0.00024 | 0.00028 | 0.00038 | 0.00048 | 0.00055 | 0.00085 | 0.00095 | 0.0012 | 0.0014 | 260 (210 – 320) |
| H5 | M/A | 0.20 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 160 (150 – 180) |
| | | 0.20 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 520 (500 – 590) |
| H7 | M/A | 0.095 | 0.0024 | 0.0036 | 0.0048 | 0.0060 | 0.0070 | 0.0095 | 0.012 | 0.014 | 0.022 | 0.024 | 0.030 | 0.036 | 80 (61 – 100) |
| | | 0.095 | 0.000095 | 0.00014 | 0.00019 | 0.00024 | 0.00028 | 0.00038 | 0.00048 | 0.00055 | 0.00085 | 0.00095 | 0.0012 | 0.0014 | 260 (210 – 320) |
| H8 | M/A | 0.20 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 160 (150 – 180) |
| | | 0.20 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 520 (500 – 590) |
| H11 | M/A | 0.20 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 205 (180 – 230) |
| | | 0.20 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 670 (600 – 750) |
| H12 | M/A | 0.20 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 190 (170 – 210) |
| | | 0.20 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 620 (560 – 680) |
| H21 | M/A | 0.20 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 160 (150 – 180) |
| | | 0.20 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0016 | 520 (500 – 590) |
| H31 | M/A | 0.20 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.036 | 120 (110 – 130) |
| | | 0.20 | 0.00010 | 0.00016 | 0.00020 | 0.00026 | 0.00032 | 0.00040 | 0.00050 | 0.00065 | 0.00095 | 0.0010 | 0.0013 | 0.0014 | 395 (370 – 420) |
| GR1 | A | 0.50 | 0.0020 | 0.0030 | 0.0040 | 0.0050 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.018 | 0.020 | 0.025 | 0.030 | 350 (300 – 400) |
| | | 0.50 | 0.000080 | 0.00012 | 0.00016 | 0.00020 | 0.00024 | 0.00032 | 0.00040 | 0.00048 | 0.00070 | 0.00080 | 0.0010 | 0.0012 | 1150 (990 – 1300) |

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

JME564

Mini – Universell – Eckfräser – 4 Schneiden – DMM 6 – Zylindrisch – Eckenradius



- Toleranzen:
- Rundlaufabweichung = <math><0-0,007\text{ mm}</math>
- DMM= h5
- DC= 0,-0,013 mm
- RE= $\pm 0,005\text{ mm}$

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | CA° | PCEDC Zylindrisch |
|--------------------------|----------------|--------------|---------------|-----|-----|-------|------|------|------|------|-------|-------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JME564005G2R005.0Z4-SIRA | 03227166 | 2 | G | 0,5 | 6,0 | 1,0 | 50,0 | 1,5 | 0,46 | 0,05 | 13,48 | 4 ■ |
| JME564006G2R005.0Z4-SIRA | 03227271 | 2 | G | 0,6 | 6,0 | 1,2 | 50,0 | 2,0 | 0,56 | 0,05 | 12,9 | 4 ■ |
| JME564008G2R005.0Z4-SIRA | 03171194 | 2 | G | 0,8 | 6,0 | 1,6 | 50,0 | 2,5 | 0,76 | 0,05 | 12,28 | 4 ■ |
| JME564010G2R010.0Z4-SIRA | 03171195 | 2 | G | 1,0 | 6,0 | 2,0 | 50,0 | 4,0 | 0,95 | 0,1 | 10,85 | 4 ■ |
| JME564012G2R010.0Z4-SIRA | 03171196 | 2 | G | 1,2 | 6,0 | 2,4 | 50,0 | 4,5 | 1,15 | 0,1 | 10,31 | 4 ■ |
| JME564015G2R015.0Z4-SIRA | 03171197 | 2 | G | 1,5 | 6,0 | 3,0 | 50,0 | 5,0 | 1,45 | 0,15 | 9,67 | 4 ■ |
| JME564020G2R015.0Z4-SIRA | 03171198 | 2 | G | 2,0 | 6,0 | 4,0 | 50,0 | 6,0 | 1,94 | 0,15 | 8,53 | 4 ■ |
| JME564025G2R015.0Z4-SIRA | 03171199 | 2 | G | 2,5 | 6,0 | 5,0 | 60,0 | 7,5 | 2,4 | 0,15 | 7,15 | 4 ■ |
| JME564030G2R015.0Z4-SIRA | 03171200 | 2 | G | 3,0 | 6,0 | 6,0 | 60,0 | 9,0 | 2,85 | 0,15 | 5,81 | 4 ■ |
| JME564005G4R005.0Z4-SIRA | 03171201 | 4 | G | 0,5 | 6,0 | 1,0 | 50,0 | 3,5 | 0,46 | 0,05 | 11,54 | 4 ■ |
| JME564006G4R005.0Z4-SIRA | 03171202 | 4 | G | 0,6 | 6,0 | 1,2 | 50,0 | 4,2 | 0,56 | 0,05 | 10,93 | 4 ■ |
| JME564008G4R005.0Z4-SIRA | 03171203 | 4 | G | 0,8 | 6,0 | 1,6 | 50,0 | 5,6 | 0,76 | 0,05 | 9,81 | 4 ■ |
| JME564010G4R010.0Z4-SIRA | 03171204 | 4 | G | 1,0 | 6,0 | 2,0 | 50,0 | 7,0 | 0,95 | 0,1 | 8,86 | 4 ■ |
| JME564012G4R010.0Z4-SIRA | 03171205 | 4 | G | 1,2 | 6,0 | 2,4 | 50,0 | 8,4 | 1,15 | 0,1 | 8,0 | 4 ■ |
| JME564015G4R015.0Z4-SIRA | 03171206 | 4 | G | 1,5 | 6,0 | 3,0 | 50,0 | 10,5 | 1,45 | 0,15 | 6,86 | 4 ■ |
| JME564020G4R015.0Z4-SIRA | 03171207 | 4 | G | 2,0 | 6,0 | 4,0 | 60,0 | 14,0 | 1,94 | 0,15 | 5,36 | 4 ■ |
| JME564030G4R015.0Z4-SIRA | 03171209 | 4 | G | 3,0 | 6,0 | 6,0 | 70,0 | 21,0 | 2,85 | 0,15 | 3,22 | 4 ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JME564 Eckfräsen/Schruppen

| SMG | | a _p /DC | a _e /DC | f _z | | | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|---------|---------|---------|---------|---------|--------|--------|--------|--------------------|
| | | | | 0.5 | 0.6 | 0.8 | 1.0 | 1.2 | 1.5 | 2.0 | 2.5 | 3 | |
| P1 | M/E/A | 0.0500 | 0.50 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 395 (360 – 430) |
| | | 0,0500 | 0,50 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1300 (1200 – 1400) |
| P2 | M/E/A | 0.0500 | 0.50 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 385 (350 – 420) |
| | | 0,0500 | 0,50 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1275 (1200 – 1300) |
| P3 | M/E/A | 0.0500 | 0.50 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 330 (300 – 360) |
| | | 0,0500 | 0,50 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1075 (990 – 1100) |
| P4 | M/E/A | 0.0500 | 0.50 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 290 (260 – 320) |
| | | 0,0500 | 0,50 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 950 (860 – 1000) |
| P5 | M/E/A | 0.0500 | 0.50 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 280 (250 – 300) |
| | | 0,0500 | 0,50 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 920 (830 – 980) |
| P6 | M/E/A | 0.0500 | 0.50 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 310 (280 – 340) |
| | | 0,0500 | 0,50 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1025 (920 – 1100) |
| P7 | M/E/A | 0.0500 | 0.50 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 295 (270 – 320) |
| | | 0,0500 | 0,50 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 970 (890 – 1000) |
| P8 | M/E/A | 0.0500 | 0.50 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 280 (250 – 300) |
| | | 0,0500 | 0,50 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 920 (830 – 980) |
| P11 | M/E/A | 0.0500 | 0.50 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 285 (260 – 310) |
| | | 0,0500 | 0,50 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 940 (860 – 1000) |
| P12 | M/E/A | 0.0500 | 0.50 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 170 (160 – 180) |
| | | 0,0500 | 0,50 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 560 (530 – 590) |
| M1 | E/M/A | 0.0250 | 0.50 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 235 (200 – 280) |
| | | 0,0250 | 0,50 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 770 (660 – 910) |
| M2 | E/M/A | 0.0250 | 0.50 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 190 (160 – 220) |
| | | 0,0250 | 0,50 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 620 (530 – 720) |
| M3 | E/M/A | 0.0250 | 0.50 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 190 (160 – 220) |
| | | 0,0250 | 0,50 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 620 (530 – 720) |
| M4 | E/M/A | 0.0250 | 0.50 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 145 (120 – 160) |
| | | 0,0250 | 0,50 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 475 (400 – 520) |
| M5 | E/M/A | 0.0250 | 0.50 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 120 (99 – 140) |
| | | 0,0250 | 0,50 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 395 (330 – 450) |
| N1 | E/M/A | 0.100 | 0.90 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 550 (490 – 610) |
| | | 0,100 | 0,90 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1800 (1700 – 2000) |
| N2 | E/M/A | 0.100 | 0.90 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 550 (490 – 610) |
| | | 0,100 | 0,90 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1800 (1700 – 2000) |
| N3 | E/M/A | 0.100 | 0.90 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 365 (330 – 410) |
| | | 0,100 | 0,90 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1200 (1100 – 1300) |
| N11 | E/M/A | 0.100 | 0.90 | 0.012 | 0.015 | 0.020 | 0.025 | 0.030 | 0.038 | 0.050 | 0.060 | 0.075 | 490 (430 – 560) |
| | | 0,100 | 0,90 | 0,00048 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0015 | 0,0020 | 0,0024 | 0,0030 | 1600 (1500 – 1800) |
| S11 | E/M/A | 0.0500 | 0.60 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 285 (250 – 320) |
| | | 0,0500 | 0,60 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 940 (830 – 1000) |
| S12 | E/M/A | 0.0500 | 0.60 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 220 (190 – 250) |
| | | 0,0500 | 0,60 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 720 (630 – 820) |
| S13 | E/M/A | 0.0500 | 0.60 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 170 (150 – 190) |
| | | 0,0500 | 0,60 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 560 (500 – 620) |
| H3 | M/A | 0.0500 | 0.060 | 0.0090 | 0.011 | 0.014 | 0.018 | 0.022 | 0.026 | 0.036 | 0.038 | 0.042 | 125 (95 – 150) |
| | | 0,0500 | 0,060 | 0,00036 | 0,00044 | 0,00055 | 0,00070 | 0,00085 | 0,0010 | 0,0014 | 0,0015 | 0,0017 | 410 (320 – 490) |
| H5 | M/A | 0.0500 | 0.28 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 240 (210 – 260) |
| | | 0,0500 | 0,28 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 790 (690 – 850) |
| H7 | M/A | 0.0500 | 0.060 | 0.0090 | 0.011 | 0.014 | 0.018 | 0.022 | 0.026 | 0.036 | 0.038 | 0.042 | 125 (95 – 150) |
| | | 0,0500 | 0,060 | 0,00036 | 0,00044 | 0,00055 | 0,00070 | 0,00085 | 0,0010 | 0,0014 | 0,0015 | 0,0017 | 410 (320 – 490) |
| H8 | M/A | 0.0500 | 0.28 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.055 | 240 (210 – 260) |
| | | 0,0500 | 0,28 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0022 | 790 (690 – 850) |
| H11 | M/A | 0.0500 | 0.28 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 305 (270 – 340) |
| | | 0,0500 | 0,28 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1000 (890 – 1100) |
| H12 | M/A | 0.0500 | 0.28 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.055 | 275 (250 – 310) |
| | | 0,0500 | 0,28 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0022 | 900 (830 – 1000) |
| H21 | M/A | 0.0500 | 0.28 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.055 | 240 (210 – 260) |
| | | 0,0500 | 0,28 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0022 | 790 (690 – 850) |
| H31 | M/A | 0.0500 | 0.28 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.038 | 0.044 | 0.048 | 180 (160 – 200) |
| | | 0,0500 | 0,28 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0015 | 0,0017 | 0,0019 | 590 (530 – 650) |
| GR1 | A | 0.500 | 0.65 | 0.0075 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.020 | 0.025 | 0.028 | 0.032 | 390 (340 – 440) |
| | | 0,500 | 0,50 | 0,00030 | 0,00036 | 0,00048 | 0,00060 | 0,00070 | 0,00085 | 0,0010 | 0,0011 | 0,0013 | 1300 (1200 – 1400) |

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Schnittdaten – JME564 Nutfräsen


| SMG |  | a _p /DC | f _z | | | | | | | | | v _c |
|-----|---|--------------------|----------------|---------|---------|---------|---------|---------|---------|---------|--------|--------------------|
| | | | 0.5 | 0.6 | 0.8 | 1.0 | 1.2 | 1.5 | 2.0 | 2.5 | 3 | |
| P1 | M/E/A | 0.038 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.040 | 250 (230 – 270) |
| | | 0,038 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 820 (760 – 880) |
| P2 | M/E/A | 0.038 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.040 | 245 (220 – 270) |
| | | 0,038 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 800 (730 – 880) |
| P3 | M/E/A | 0.038 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.040 | 210 (190 – 230) |
| | | 0,038 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 690 (630 – 750) |
| P4 | M/E/A | 0.038 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.040 | 185 (170 – 200) |
| | | 0,038 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 610 (560 – 650) |
| P5 | M/E/A | 0.038 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.040 | 175 (160 – 190) |
| | | 0,038 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 570 (530 – 620) |
| P6 | M/E/A | 0.038 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.040 | 200 (180 – 220) |
| | | 0,038 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 660 (600 – 720) |
| P7 | M/E/A | 0.038 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.040 | 185 (170 – 200) |
| | | 0,038 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 610 (560 – 650) |
| P8 | M/E/A | 0.038 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.040 | 175 (160 – 190) |
| | | 0,038 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 570 (530 – 620) |
| P11 | M/E/A | 0.038 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.040 | 180 (170 – 200) |
| | | 0,038 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 590 (560 – 650) |
| P12 | M/E/A | 0.038 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.019 | 0.024 | 0.026 | 0.030 | 105 (96 – 110) |
| | | 0,038 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00075 | 0,00095 | 0,0010 | 0,0012 | 345 (320 – 360) |
| M1 | E/M/A | 0.038 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.040 | 135 (110 – 150) |
| | | 0,038 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 445 (370 – 490) |
| M2 | E/M/A | 0.038 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.040 | 110 (89 – 120) |
| | | 0,038 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 360 (300 – 390) |
| M3 | E/M/A | 0.038 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.040 | 110 (89 – 120) |
| | | 0,038 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 360 (300 – 390) |
| M4 | E/M/A | 0.038 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.038 | 80 (67 – 95) |
| | | 0,038 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0015 | 260 (220 – 310) |
| M5 | E/M/A | 0.038 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.038 | 65 (56 – 79) |
| | | 0,038 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0015 | 215 (190 – 250) |
| N1 | E/M/A | 0.15 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.040 | 390 (350 – 440) |
| | | 0,15 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 1275 (1200 – 1400) |
| N2 | E/M/A | 0.15 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.040 | 390 (350 – 440) |
| | | 0,15 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 1275 (1200 – 1400) |
| N3 | E/M/A | 0.15 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.040 | 260 (230 – 290) |
| | | 0,15 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 850 (760 – 950) |
| N11 | E/M/A | 0.15 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.040 | 0.048 | 0.055 | 345 (300 – 390) |
| | | 0,15 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0019 | 0,0022 | 1125 (990 – 1200) |
| S11 | E/M/A | 0.11 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.040 | 180 (160 – 200) |
| | | 0,11 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 590 (530 – 650) |
| S12 | E/M/A | 0.11 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.040 | 135 (120 – 150) |
| | | 0,11 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 445 (400 – 490) |
| S13 | E/M/A | 0.11 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.036 | 105 (92 – 120) |
| | | 0,11 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0014 | 345 (310 – 390) |
| H3 | M/A | 0.0060 | 0.0060 | 0.0070 | 0.0095 | 0.012 | 0.014 | 0.018 | 0.024 | 0.030 | 0.036 | 80 (59 – 98) |
| | | 0,0060 | 0,00024 | 0,00028 | 0,00038 | 0,00048 | 0,00055 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 260 (200 – 320) |
| H5 | M/A | 0.020 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.040 | 160 (140 – 170) |
| | | 0,020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 520 (460 – 550) |
| H7 | M/A | 0.0060 | 0.0060 | 0.0070 | 0.0095 | 0.012 | 0.014 | 0.018 | 0.024 | 0.030 | 0.036 | 80 (59 – 98) |
| | | 0,0060 | 0,00024 | 0,00028 | 0,00038 | 0,00048 | 0,00055 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 260 (200 – 320) |
| H8 | M/A | 0.020 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.030 | 0.032 | 160 (140 – 170) |
| | | 0,020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0012 | 0,0013 | 520 (460 – 550) |
| H11 | M/A | 0.020 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.040 | 200 (180 – 220) |
| | | 0,020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 660 (600 – 720) |
| H12 | M/A | 0.020 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.030 | 0.032 | 185 (170 – 200) |
| | | 0,020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0012 | 0,0013 | 610 (560 – 650) |
| H21 | M/A | 0.020 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.030 | 0.032 | 160 (140 – 170) |
| | | 0,020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0012 | 0,0013 | 520 (460 – 550) |
| H31 | M/A | 0.020 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.019 | 0.022 | 0.025 | 0.028 | 120 (110 – 130) |
| | | 0,020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00075 | 0,00085 | 0,0010 | 0,0011 | 395 (370 – 420) |
| GR1 | A | 0.20 | 0.0050 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.015 | 0.020 | 0.024 | 0.026 | 325 (280 – 370) |
| | | 0,20 | 0,00020 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00060 | 0,00080 | 0,00095 | 0,0010 | 1075 (920 – 1200) |

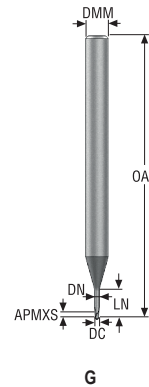
Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_s = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

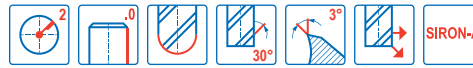
Universell
Stahl und Guss
Stahl und Guss
Rohtre und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

JMB542

Mini – Universell – Kugelkopf – 2 Schneiden – DMM 4 – Zylindrisch



- Toleranzen:
- Rundlaufabweichung $\leq 0,007$ mm
- DMM= h5
- DC= 0,-0,01 mm
- RE= $\pm 0,005$ mm



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | CA° | PCEDC Zylindrisch |
|-----------------------|--------------------|------------------|-------------------|-----|-----|-------|------|------|------|------|-------|-------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JMB542002G1B.0Z2-SIRA | 03171221 | 1 | G | 0,2 | 4,0 | 0,2 | 45,0 | 0,4 | 0,18 | 0,1 | 14,57 | 2 ■ |
| JMB542003G1B.0Z2-SIRA | 03171222 | 1 | G | 0,3 | 4,0 | 0,3 | 45,0 | 0,6 | 0,28 | 0,15 | 14,24 | 2 ■ |
| JMB542004G1B.0Z2-SIRA | 03171223 | 1 | G | 0,4 | 4,0 | 0,4 | 45,0 | 0,8 | 0,37 | 0,2 | 13,81 | 2 ■ |
| JMB542005G1B.0Z2-SIRA | 03171224 | 1 | G | 0,5 | 4,0 | 0,5 | 45,0 | 1,0 | 0,46 | 0,25 | 13,47 | 2 ■ |
| JMB542006G1B.0Z2-SIRA | 03171225 | 1 | G | 0,6 | 4,0 | 0,6 | 45,0 | 1,2 | 0,56 | 0,3 | 13,14 | 2 ■ |
| JMB542008G1B.0Z2-SIRA | 03171226 | 1 | G | 0,8 | 4,0 | 0,8 | 45,0 | 1,6 | 0,76 | 0,4 | 12,46 | 2 ■ |
| JMB542010G1B.0Z2-SIRA | 03171228 | 1 | G | 1,0 | 4,0 | 1,0 | 50,0 | 2,0 | 0,95 | 0,5 | 11,77 | 2 ■ |
| JMB542012G1B.0Z2-SIRA | 03171229 | 1 | G | 1,2 | 4,0 | 1,2 | 50,0 | 2,4 | 1,15 | 0,6 | 11,07 | 2 ■ |
| JMB542015G1B.0Z2-SIRA | 03171230 | 1 | G | 1,5 | 4,0 | 1,5 | 50,0 | 3,0 | 1,45 | 0,75 | 9,88 | 2 ■ |
| JMB542005G3B.0Z2-SIRA | 03171231 | 3 | G | 0,5 | 4,0 | 0,5 | 45,0 | 2,5 | 0,46 | 0,25 | 11,25 | 2 ■ |
| JMB542006G3B.0Z2-SIRA | 03171233 | 3 | G | 0,6 | 4,0 | 0,6 | 45,0 | 3,0 | 0,56 | 0,3 | 10,61 | 2 ■ |
| JMB542008G3B.0Z2-SIRA | 03171234 | 3 | G | 0,8 | 4,0 | 0,8 | 45,0 | 4,0 | 0,76 | 0,4 | 9,44 | 2 ■ |
| JMB542010G3B.0Z2-SIRA | 03171235 | 3 | G | 1,0 | 4,0 | 1,0 | 50,0 | 5,0 | 0,95 | 0,5 | 8,38 | 2 ■ |
| JMB542012G3B.0Z2-SIRA | 03171236 | 3 | G | 1,2 | 4,0 | 1,2 | 50,0 | 6,0 | 1,15 | 0,6 | 7,44 | 2 ■ |
| JMB542015G3B.0Z2-SIRA | 03171237 | 3 | G | 1,5 | 4,0 | 1,5 | 50,0 | 7,5 | 1,45 | 0,75 | 6,13 | 2 ■ |
| JMB542020G3B.0Z2-SIRA | 03171238 | 3 | G | 2,0 | 4,0 | 2,0 | 50,0 | 10,0 | 1,94 | 1,0 | 4,4 | 2 ■ |
| JMB542030G3B.0Z2-SIRA | 03171240 | 3 | G | 3,0 | 4,0 | 3,0 | 60,0 | 15,0 | 2,85 | 1,5 | 1,81 | 2 ■ |
| JMB542005G4B.0Z2-SIRA | 03171241 | 4 | G | 0,5 | 4,0 | 0,5 | 45,0 | 4,0 | 0,46 | 0,25 | 9,65 | 2 ■ |
| JMB542006G4B.0Z2-SIRA | 03171242 | 4 | G | 0,6 | 4,0 | 0,6 | 45,0 | 5,0 | 0,56 | 0,3 | 8,74 | 2 ■ |
| JMB542008G4B.0Z2-SIRA | 03171243 | 4 | G | 0,8 | 4,0 | 0,8 | 45,0 | 7,0 | 0,76 | 0,4 | 7,23 | 2 ■ |
| JMB542010G4B.0Z2-SIRA | 03171244 | 4 | G | 1,0 | 4,0 | 1,0 | 50,0 | 8,5 | 0,95 | 0,5 | 6,27 | 2 ■ |
| JMB542012G4B.0Z2-SIRA | 03171245 | 4 | G | 1,2 | 4,0 | 1,2 | 50,0 | 10,0 | 1,15 | 0,6 | 5,44 | 2 ■ |
| JMB542015G4B.0Z2-SIRA | 03171246 | 4 | G | 1,5 | 4,0 | 1,5 | 50,0 | 12,0 | 1,45 | 0,75 | 4,44 | 2 ■ |
| JMB542020G4B.0Z2-SIRA | 03171247 | 4 | G | 2,0 | 4,0 | 2,0 | 60,0 | 16,0 | 1,94 | 1,0 | 3,02 | 2 ■ |
| JMB542030G4B.0Z2-SIRA | 03171249 | 4 | G | 3,0 | 4,0 | 3,0 | 70,0 | 24,0 | 2,85 | 1,5 | 1,16 | 2 ■ |
| JMB542015G5B.0Z2-SIRA | 03171250 | 5 | G | 1,5 | 4,0 | 1,5 | 60,0 | 15,0 | 1,45 | 0,75 | 3,75 | 2 ■ |
| JMB542020G5B.0Z2-SIRA | 03171251 | 5 | G | 2,0 | 4,0 | 2,0 | 60,0 | 20,0 | 1,94 | 1,0 | 2,5 | 2 ■ |
| JMB542030G5B.0Z2-SIRA | 03171253 | 5 | G | 3,0 | 4,0 | 3,0 | 70,0 | 30,0 | 2,85 | 1,5 | 0,93 | 2 ■ |
| JMB542015G6B.0Z2-SIRA | 03171254 | 6 | G | 1,5 | 4,0 | 1,5 | 70,0 | 22,5 | 1,45 | 0,75 | 2,7 | 2 ■ |
| JMB542020G6B.0Z2-SIRA | 03171255 | 6 | G | 2,0 | 4,0 | 2,0 | 70,0 | 30,0 | 1,94 | 1,0 | 1,74 | 2 ■ |
| JMB542030G6B.0Z2-SIRA | 03171257 | 6 | G | 3,0 | 4,0 | 3,0 | 90,0 | 45,0 | 2,85 | 1,5 | 0,63 | 2 ■ |

■ Lagerstandard.

Schnittdaten – JMB542 Kopierfräsen/Schruppen


| SMG |  | a_e/DC | a_p/DC | f_z | | | | | | | | | | | | v_c |
|-----|---|----------|----------|--------|--------|--------|--------|--------|--------|--------|--------|-------|-------|-------|-------|--------------------|
| | | | | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.8 | 1.0 | 1.2 | 1.8 | 2.0 | 2.5 | 3.0 | |
| P1 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 365 (330 – 400) |
| | | 0,0500 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 1200 (1100 – 1300) |
| P2 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 355 (320 – 390) |
| | | 0,0500 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 1175 (1100 – 1200) |
| P3 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 305 (280 – 330) |
| | | 0,0500 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 1000 (920 – 1000) |
| P4 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 270 (240 – 290) |
| | | 0,0500 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 890 (790 – 950) |
| P5 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 255 (230 – 280) |
| | | 0,0500 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 840 (760 – 910) |
| P6 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 290 (260 – 310) |
| | | 0,0500 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 950 (860 – 1000) |
| P7 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 270 (250 – 300) |
| | | 0,0500 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 890 (830 – 980) |
| P8 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 255 (230 – 280) |
| | | 0,0500 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 840 (760 – 910) |
| P11 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 265 (240 – 290) |
| | | 0,0500 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 870 (790 – 950) |
| P12 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 155 (140 – 170) |
| | | 0,0500 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 510 (460 – 550) |
| M1 | E/M/A | 0.0250 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 215 (180 – 250) |
| | | 0,0250 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 710 (600 – 820) |
| M2 | E/M/A | 0.0250 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 175 (150 – 200) |
| | | 0,0250 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 570 (500 – 650) |
| M3 | E/M/A | 0.0250 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 175 (150 – 200) |
| | | 0,0250 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 570 (500 – 650) |
| M4 | E/M/A | 0.0250 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 130 (110 – 150) |
| | | 0,0250 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 425 (370 – 490) |
| M5 | E/M/A | 0.0250 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 110 (90 – 120) |
| | | 0,0250 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 360 (300 – 390) |
| N1 | E/M/A | 0.100 | 0.75 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 485 (430 – 540) |
| | | 0,100 | 0,75 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 1600 (1500 – 1700) |
| N2 | E/M/A | 0.100 | 0.75 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 485 (430 – 540) |
| | | 0,100 | 0,75 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 1600 (1500 – 1700) |
| N3 | E/M/A | 0.100 | 0.75 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 325 (290 – 360) |
| | | 0,100 | 0,75 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 1075 (960 – 1100) |
| N11 | E/M/A | 0.100 | 0.75 | 0.0050 | 0.0075 | 0.010 | 0.012 | 0.015 | 0.020 | 0.025 | 0.030 | 0.046 | 0.050 | 0.060 | 0.075 | 430 (370 – 480) |
| | | 0,100 | 0,75 | 0,0020 | 0,0030 | 0,0040 | 0,0048 | 0,0060 | 0,0080 | 0,010 | 0,012 | 0,018 | 0,020 | 0,024 | 0,030 | 1400 (1300 – 1500) |
| S11 | E/M/A | 0.0250 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 290 (250 – 330) |
| | | 0,0250 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 950 (830 – 1000) |
| S12 | E/M/A | 0.0250 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 225 (200 – 250) |
| | | 0,0250 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 740 (660 – 820) |
| S13 | E/M/A | 0.0250 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 175 (150 – 190) |
| | | 0,0250 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 570 (500 – 620) |
| H3 | M/A | 0.0500 | 0.30 | 0.0036 | 0.0055 | 0.0070 | 0.0090 | 0.011 | 0.014 | 0.018 | 0.022 | 0.032 | 0.036 | 0.044 | 0.055 | 120 (90 – 140) |
| | | 0,0500 | 0,30 | 0,0014 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0055 | 0,0070 | 0,0085 | 0,013 | 0,014 | 0,017 | 0,022 | 395 (300 – 450) |
| H5 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 235 (210 – 260) |
| | | 0,0500 | 0,44 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 770 (690 – 850) |
| H7 | M/A | 0.0500 | 0.30 | 0.0036 | 0.0055 | 0.0070 | 0.0090 | 0.011 | 0.014 | 0.018 | 0.022 | 0.032 | 0.036 | 0.044 | 0.055 | 120 (90 – 140) |
| | | 0,0500 | 0,30 | 0,0014 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0055 | 0,0070 | 0,0085 | 0,013 | 0,014 | 0,017 | 0,022 | 395 (300 – 450) |
| H8 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 235 (210 – 260) |
| | | 0,0500 | 0,44 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 770 (690 – 850) |
| H11 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 300 (270 – 330) |
| | | 0,0500 | 0,44 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 980 (890 – 1000) |
| H12 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 275 (240 – 300) |
| | | 0,0500 | 0,44 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 900 (790 – 980) |
| H21 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 235 (210 – 260) |
| | | 0,0500 | 0,44 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 770 (690 – 850) |
| H31 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 180 (160 – 200) |
| | | 0,0500 | 0,44 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 590 (530 – 650) |
| GR1 | A | 0.500 | 0.50 | 0.0030 | 0.0044 | 0.0060 | 0.0075 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.028 | 0.030 | 0.038 | 0.040 | 405 (350 – 460) |
| | | 0,500 | 0,50 | 0,0012 | 0,0017 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,011 | 0,012 | 0,015 | 0,016 | 1325 (1200 – 1500) |

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

 $v_c =$ m/min (sf/min) $f_z =$ mm/Zahn (Zoll/Zahn) $a_p =$ mm/DC (Zoll/DC) = Faktor $a_e =$ mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Universell

Stahl und Guss

Stahlwerkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JMB542 Nutfräsen


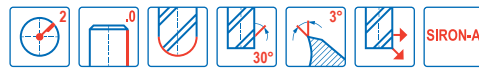
| SMG |  | a _p /DC | f _z | | | | | | | | | | | | v _c |
|-----|---|--------------------|----------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|--------|--------|--------------------|
| | | | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.8 | 1.0 | 1.2 | 1.8 | 2.0 | 2.5 | 3.0 | |
| P1 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 255 (230 – 280) |
| | | 0.32 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 840 (760 – 910) |
| P2 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 250 (230 – 270) |
| | | 0.32 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 820 (760 – 880) |
| P3 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 215 (200 – 230) |
| | | 0.32 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 710 (660 – 750) |
| P4 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 190 (170 – 200) |
| | | 0.32 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 620 (560 – 650) |
| P5 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 180 (170 – 200) |
| | | 0.32 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 590 (560 – 650) |
| P6 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 200 (180 – 220) |
| | | 0.32 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 660 (600 – 720) |
| P7 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 190 (170 – 210) |
| | | 0.32 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 620 (560 – 680) |
| P8 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 180 (170 – 200) |
| | | 0.32 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 590 (560 – 650) |
| P11 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 185 (170 – 200) |
| | | 0.32 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 610 (560 – 650) |
| P12 | M/E/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 110 (98 – 120) |
| | | 0.32 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 360 (330 – 390) |
| M1 | E/M/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 135 (120 – 160) |
| | | 0.32 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 445 (400 – 520) |
| M2 | E/M/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 110 (90 – 130) |
| | | 0.32 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 360 (300 – 420) |
| M3 | E/M/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 110 (90 – 130) |
| | | 0.32 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 360 (300 – 420) |
| M4 | E/M/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 80 (68 – 97) |
| | | 0.32 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 260 (230 – 310) |
| M5 | E/M/A | 0.32 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 70 (57 – 81) |
| | | 0.32 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 230 (190 – 260) |
| N1 | E/M/A | 0.24 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 400 (350 – 440) |
| | | 0.24 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 1300 (1200 – 1400) |
| N2 | E/M/A | 0.26 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 400 (350 – 440) |
| | | 0.26 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 1300 (1200 – 1400) |
| N3 | E/M/A | 0.26 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 265 (240 – 290) |
| | | 0.26 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 870 (790 – 950) |
| N11 | E/M/A | 0.24 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 350 (300 – 390) |
| | | 0.24 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 1150 (990 – 1200) |
| S11 | E/M/A | 0.36 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 180 (160 – 200) |
| | | 0.36 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 590 (530 – 650) |
| S12 | E/M/A | 0.36 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 140 (120 – 150) |
| | | 0.36 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 460 (400 – 490) |
| S13 | E/M/A | 0.36 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 105 (93 – 120) |
| | | 0.36 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 345 (310 – 390) |
| H3 | M/A | 0.10 | 0.0024 | 0.0036 | 0.0048 | 0.0060 | 0.0070 | 0.0095 | 0.012 | 0.014 | 0.022 | 0.024 | 0.030 | 0.036 | 80 (61 – 100) |
| | | 0.10 | 0,000095 | 0,00014 | 0,00019 | 0,00024 | 0,00028 | 0,00038 | 0,00048 | 0,00055 | 0,00085 | 0,00095 | 0,0012 | 0,0014 | 260 (210 – 320) |
| H5 | M/A | 0.20 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 160 (150 – 180) |
| | | 0.20 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 520 (500 – 590) |
| H7 | M/A | 0.10 | 0.0024 | 0.0036 | 0.0048 | 0.0060 | 0.0070 | 0.0095 | 0.012 | 0.014 | 0.022 | 0.024 | 0.030 | 0.036 | 80 (61 – 100) |
| | | 0.10 | 0,000095 | 0,00014 | 0,00019 | 0,00024 | 0,00028 | 0,00038 | 0,00048 | 0,00055 | 0,00085 | 0,00095 | 0,0012 | 0,0014 | 260 (210 – 320) |
| H8 | M/A | 0.20 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 160 (150 – 180) |
| | | 0.20 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 520 (500 – 590) |
| H11 | M/A | 0.20 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 205 (180 – 230) |
| | | 0.20 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 670 (600 – 750) |
| H12 | M/A | 0.20 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 190 (170 – 210) |
| | | 0.20 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 620 (560 – 680) |
| H21 | M/A | 0.20 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 160 (150 – 180) |
| | | 0.20 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 520 (500 – 590) |
| H31 | M/A | 0.20 | 0.0026 | 0.0040 | 0.0050 | 0.0065 | 0.0080 | 0.010 | 0.013 | 0.016 | 0.024 | 0.026 | 0.032 | 0.040 | 120 (110 – 130) |
| | | 0.20 | 0,00010 | 0,00016 | 0,00020 | 0,00026 | 0,00032 | 0,00040 | 0,00050 | 0,00065 | 0,00095 | 0,0010 | 0,0013 | 0,0016 | 395 (370 – 420) |
| GR1 | A | 0.50 | 0.0020 | 0.0030 | 0.0040 | 0.0050 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.018 | 0.020 | 0.025 | 0.030 | 350 (300 – 390) |
| | | 0.50 | 0,000080 | 0,00012 | 0,00016 | 0,00020 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00070 | 0,00080 | 0,0010 | 0,0012 | 1150 (990 – 1200) |

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 561 - 568

SMG =

JMB562

Mini – Universell – Kugelkopf – 2 Schneiden – DMM 6 – Zylindrisch



- Toleranzen:
- Rundlaufabweichung =<0,007 mm
- DMM= h5
- DC= 0,-0,01 mm
- RE= ±0,005 mm

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | CA° | PCEDC Zylindrisch |
|-----------------------|----------------|--------------|---------------|-----|-----|-------|------|------|------|------|-------|-------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | |
| JMB562005G2B.0Z2-SIRA | 03171261 | 2 | G | 0,5 | 6,0 | 0,5 | 50,0 | 1,5 | 0,46 | 0,25 | 13,69 | 2 ■ |
| JMB562006G2B.0Z2-SIRA | 03171262 | 2 | G | 0,6 | 6,0 | 0,6 | 50,0 | 2,0 | 0,56 | 0,3 | 13,13 | 2 ■ |
| JMB562008G2B.0Z2-SIRA | 03171263 | 2 | G | 0,8 | 6,0 | 0,8 | 50,0 | 2,5 | 0,76 | 0,4 | 12,6 | 2 ■ |
| JMB562010G2B.0Z2-SIRA | 03171264 | 2 | G | 1,0 | 6,0 | 1,0 | 50,0 | 4,0 | 0,95 | 0,5 | 11,15 | 2 ■ |
| JMB562012G2B.0Z2-SIRA | 03171265 | 2 | G | 1,2 | 6,0 | 1,2 | 50,0 | 4,5 | 1,15 | 0,6 | 10,67 | 2 ■ |
| JMB562015G2B.0Z2-SIRA | 03171266 | 2 | G | 1,5 | 6,0 | 1,5 | 50,0 | 5,0 | 1,45 | 0,75 | 10,07 | 2 ■ |
| JMB562018G2B.0Z2-SIRA | 03171267 | 2 | G | 1,8 | 6,0 | 1,8 | 50,0 | 5,4 | 1,75 | 0,9 | 9,61 | 2 ■ |
| JMB562020G2B.0Z2-SIRA | 03171268 | 2 | G | 2,0 | 6,0 | 2,0 | 50,0 | 6,0 | 1,94 | 1,0 | 9,05 | 2 ■ |
| JMB562025G2B.0Z2-SIRA | 03171269 | 2 | G | 2,5 | 6,0 | 2,5 | 60,0 | 7,5 | 2,4 | 1,25 | 7,71 | 2 ■ |
| JMB562030G2B.0Z2-SIRA | 03171270 | 2 | G | 3,0 | 6,0 | 3,0 | 60,0 | 9,0 | 2,85 | 1,5 | 6,35 | 2 ■ |
| JMB562005G4B.0Z2-SIRA | 03171271 | 4 | G | 0,5 | 6,0 | 0,5 | 50,0 | 3,5 | 0,46 | 0,25 | 11,7 | 2 ■ |
| JMB562006G4B.0Z2-SIRA | 03171272 | 4 | G | 0,6 | 6,0 | 0,6 | 50,0 | 4,2 | 0,56 | 0,3 | 11,1 | 2 ■ |
| JMB562008G4B.0Z2-SIRA | 03171273 | 4 | G | 0,8 | 6,0 | 0,8 | 50,0 | 5,6 | 0,76 | 0,4 | 10,02 | 2 ■ |
| JMB562010G4B.0Z2-SIRA | 03171274 | 4 | G | 1,0 | 6,0 | 1,0 | 50,0 | 7,0 | 0,95 | 0,5 | 9,06 | 2 ■ |
| JMB562012G4B.0Z2-SIRA | 03171275 | 4 | G | 1,2 | 6,0 | 1,2 | 50,0 | 8,4 | 1,15 | 0,6 | 8,22 | 2 ■ |
| JMB562015G4B.0Z2-SIRA | 03171276 | 4 | G | 1,5 | 6,0 | 1,5 | 50,0 | 10,5 | 1,45 | 0,75 | 7,07 | 2 ■ |
| JMB562020G4B.0Z2-SIRA | 03171277 | 4 | G | 2,0 | 6,0 | 2,0 | 60,0 | 14,0 | 1,94 | 1,0 | 5,57 | 2 ■ |
| JMB562030G4B.0Z2-SIRA | 03171279 | 4 | G | 3,0 | 6,0 | 3,0 | 70,0 | 21,0 | 2,85 | 1,5 | 3,38 | 2 ■ |
| JMB562005G5B.0Z2-SIRA | 03171280 | 5 | G | 0,5 | 6,0 | 0,5 | 50,0 | 5,0 | 0,46 | 0,25 | 10,54 | 2 ■ |
| JMB562006G5B.0Z2-SIRA | 03171281 | 5 | G | 0,6 | 6,0 | 0,6 | 50,0 | 6,0 | 0,56 | 0,3 | 9,85 | 2 ■ |
| JMB562008G5B.0Z2-SIRA | 03171282 | 5 | G | 0,8 | 6,0 | 0,8 | 50,0 | 8,0 | 0,76 | 0,4 | 8,64 | 2 ■ |
| JMB562010G5B.0Z2-SIRA | 03171283 | 5 | G | 1,0 | 6,0 | 1,0 | 50,0 | 10,0 | 0,95 | 0,5 | 7,63 | 2 ■ |
| JMB562012G5B.0Z2-SIRA | 03171284 | 5 | G | 1,2 | 6,0 | 1,2 | 50,0 | 12,0 | 1,15 | 0,6 | 6,77 | 2 ■ |
| JMB562015G5B.0Z2-SIRA | 03171285 | 5 | G | 1,5 | 6,0 | 1,5 | 60,0 | 15,0 | 1,45 | 0,75 | 5,68 | 2 ■ |
| JMB562020G5B.0Z2-SIRA | 03171287 | 5 | G | 2,0 | 6,0 | 2,0 | 60,0 | 20,0 | 1,94 | 1,0 | 4,32 | 2 ■ |
| JMB562030G5B.0Z2-SIRA | 03171289 | 5 | G | 3,0 | 6,0 | 3,0 | 70,0 | 30,0 | 2,85 | 1,5 | 2,5 | 2 ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

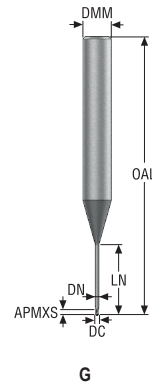
X-Heads

Minimaster Plus

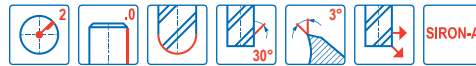
Minimaster

JMB562

Mini – Universell – Kugelkopf – 2 Schneiden – DMM 6 – Zylindrisch



- Toleranzen:
- Rundlaufabweichung = $\leq 0,007\text{ mm}$
- DMM= h5
- DC= 0,-0,01 mm
- RE= $\pm 0,005\text{ mm}$



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | CA° | PCEDC Zylindrisch |
|-----------------------|--------------------|------------------|-------------------|-----|-----|-------|-------|------|------|------|------|-------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JMB562010G6B.0Z2-SIRA | 03171290 | 6 | G | 1,0 | 6,0 | 1,0 | 60,0 | 15,0 | 0,95 | 0,5 | 6,04 | 2 ■ |
| JMB562012G6B.0Z2-SIRA | 03171291 | 6 | G | 1,2 | 6,0 | 1,2 | 60,0 | 18,0 | 1,15 | 0,6 | 5,24 | 2 ■ |
| JMB562015G6B.0Z2-SIRA | 03171292 | 6 | G | 1,5 | 6,0 | 1,5 | 70,0 | 22,5 | 1,45 | 0,75 | 4,28 | 2 ■ |
| JMB562020G6B.0Z2-SIRA | 03171293 | 6 | G | 2,0 | 6,0 | 2,0 | 80,0 | 30,0 | 1,94 | 1,0 | 3,14 | 2 ■ |
| JMB562030G6B.0Z2-SIRA | 03171295 | 6 | G | 3,0 | 6,0 | 3,0 | 90,0 | 45,0 | 2,85 | 1,5 | 1,74 | 2 ■ |
| JMB562010G7B.0Z2-SIRA | 03171296 | 7 | G | 1,0 | 6,0 | 1,0 | 60,0 | 20,0 | 0,95 | 0,5 | 4,99 | 2 ■ |
| JMB562012G7B.0Z2-SIRA | 03171297 | 7 | G | 1,2 | 6,0 | 1,2 | 80,0 | 24,0 | 1,15 | 0,6 | 4,27 | 2 ■ |
| JMB562015G7B.0Z2-SIRA | 03171298 | 7 | G | 1,5 | 6,0 | 1,5 | 80,0 | 30,0 | 1,45 | 0,75 | 3,43 | 2 ■ |
| JMB562020G7B.0Z2-SIRA | 03171299 | 7 | G | 2,0 | 6,0 | 2,0 | 80,0 | 40,0 | 1,94 | 1,0 | 2,47 | 2 ■ |
| JMB562030G7B.0Z2-SIRA | 03171301 | 7 | G | 3,0 | 6,0 | 3,0 | 100,0 | 60,0 | 2,85 | 1,5 | 1,34 | 2 ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JMB562 Kopierfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|-------|-------|-------|-------|--------------------|
| | | | | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.8 | 1.0 | 1.2 | 1.8 | 2.0 | 2.5 | 3.0 | |
| P1 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 365 (330 — 400) |
| | | 0,0500 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 1200 (1100 — 1300) |
| P2 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 355 (320 — 390) |
| | | 0,0500 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 1175 (1100 — 1200) |
| P3 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 305 (280 — 330) |
| | | 0,0500 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 1000 (920 — 1000) |
| P4 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 270 (240 — 290) |
| | | 0,0500 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 890 (790 — 950) |
| P5 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 255 (230 — 280) |
| | | 0,0500 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 840 (760 — 910) |
| P6 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 290 (260 — 310) |
| | | 0,0500 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 950 (860 — 1000) |
| P7 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 270 (250 — 300) |
| | | 0,0500 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 890 (830 — 980) |
| P8 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 255 (230 — 280) |
| | | 0,0500 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 840 (760 — 910) |
| P11 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 265 (240 — 290) |
| | | 0,0500 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 870 (790 — 950) |
| P12 | M/E/A | 0.0500 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 155 (140 — 170) |
| | | 0,0500 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 510 (460 — 550) |
| M1 | E/M/A | 0.0250 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 215 (180 — 250) |
| | | 0,0250 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 710 (600 — 820) |
| M2 | E/M/A | 0.0250 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 175 (150 — 200) |
| | | 0,0250 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 570 (500 — 650) |
| M3 | E/M/A | 0.0250 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 175 (150 — 200) |
| | | 0,0250 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 570 (500 — 650) |
| M4 | E/M/A | 0.0250 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 130 (110 — 150) |
| | | 0,0250 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 425 (370 — 490) |
| M5 | E/M/A | 0.0250 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 110 (90 — 120) |
| | | 0,0250 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 360 (300 — 390) |
| N1 | E/M/A | 0.100 | 0.75 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 485 (430 — 540) |
| | | 0,100 | 0,75 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 1600 (1500 — 1700) |
| N2 | E/M/A | 0.100 | 0.75 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 485 (430 — 540) |
| | | 0,100 | 0,75 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 1600 (1500 — 1700) |
| N3 | E/M/A | 0.100 | 0.75 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 325 (290 — 360) |
| | | 0,100 | 0,75 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 1075 (960 — 1100) |
| N11 | E/M/A | 0.100 | 0.75 | 0.0050 | 0.0075 | 0.010 | 0.012 | 0.015 | 0.020 | 0.025 | 0.030 | 0.046 | 0.050 | 0.060 | 0.075 | 430 (370 — 480) |
| | | 0,100 | 0,75 | 0,0020 | 0,0030 | 0,0040 | 0,0048 | 0,0060 | 0,0080 | 0,010 | 0,012 | 0,018 | 0,020 | 0,024 | 0,030 | 1400 (1300 — 1500) |
| S11 | E/M/A | 0.0250 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 290 (250 — 330) |
| | | 0,0250 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 950 (830 — 1000) |
| S12 | E/M/A | 0.0250 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 225 (200 — 250) |
| | | 0,0250 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 740 (660 — 820) |
| S13 | E/M/A | 0.0250 | 0.60 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 175 (150 — 190) |
| | | 0,0250 | 0,60 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 570 (500 — 620) |
| H3 | M/A | 0.0500 | 0.30 | 0.0036 | 0.0055 | 0.0070 | 0.0090 | 0.011 | 0.014 | 0.018 | 0.022 | 0.032 | 0.036 | 0.044 | 0.055 | 120 (90 — 140) |
| | | 0,0500 | 0,30 | 0,0014 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0055 | 0,0070 | 0,0085 | 0,013 | 0,014 | 0,017 | 0,022 | 395 (300 — 450) |
| H5 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 235 (210 — 260) |
| | | 0,0500 | 0,44 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 770 (690 — 850) |
| H7 | M/A | 0.0500 | 0.30 | 0.0036 | 0.0055 | 0.0070 | 0.0090 | 0.011 | 0.014 | 0.018 | 0.022 | 0.032 | 0.036 | 0.044 | 0.055 | 120 (90 — 140) |
| | | 0,0500 | 0,30 | 0,0014 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0055 | 0,0070 | 0,0085 | 0,013 | 0,014 | 0,017 | 0,022 | 395 (300 — 450) |
| H8 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 235 (210 — 260) |
| | | 0,0500 | 0,44 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 770 (690 — 850) |
| H11 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 300 (270 — 330) |
| | | 0,0500 | 0,44 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 980 (890 — 1000) |
| H12 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 275 (240 — 300) |
| | | 0,0500 | 0,44 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 900 (790 — 980) |
| H21 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 235 (210 — 260) |
| | | 0,0500 | 0,44 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 770 (690 — 850) |
| H31 | M/A | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.036 | 0.040 | 0.050 | 0.060 | 180 (160 — 200) |
| | | 0,0500 | 0,44 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,014 | 0,016 | 0,020 | 0,024 | 590 (530 — 650) |
| GR1 | A | 0.500 | 0.50 | 0.0030 | 0.0044 | 0.0060 | 0.0075 | 0.0090 | 0.012 | 0.015 | 0.018 | 0.028 | 0.030 | 0.038 | 0.040 | 405 (350 — 460) |
| | | 0,50 | | | | | | | | | | | | | | |

Schnittdaten – JMB562 Nutfräsen

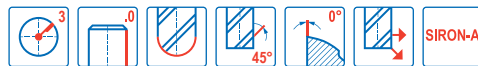
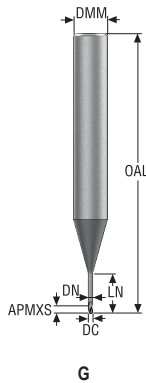
| SMG | | a _p /DC | f _z | | | | | | | | | | | | v _c |
|-----|-------|--------------------|--------------------|-------------------|-------------------|-------------------|-------------------|-------------------|------------------|------------------|------------------|------------------|-----------------|-----------------|---------------------------------------|
| | | | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.8 | 1.0 | 1.2 | 1.8 | 2.0 | 2.5 | 3.0 | |
| P1 | M/E/A | 0.32 0.32 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 255 (230 – 280) 840 (760 – 910) |
| P2 | M/E/A | 0.32 0.32 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 250 (230 – 270) 820 (760 – 880) |
| P3 | M/E/A | 0.32 0.32 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 215 (200 – 230) 710 (660 – 750) |
| P4 | M/E/A | 0.32 0.32 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 190 (170 – 200) 620 (560 – 650) |
| P5 | M/E/A | 0.32 0.32 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 180 (170 – 200) 590 (560 – 650) |
| P6 | M/E/A | 0.32 0.32 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 200 (180 – 220) 660 (600 – 720) |
| P7 | M/E/A | 0.32 0.32 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 190 (170 – 210) 620 (560 – 680) |
| P8 | M/E/A | 0.32 0.32 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 180 (170 – 200) 590 (560 – 650) |
| P11 | M/E/A | 0.32 0.32 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 185 (170 – 200) 610 (560 – 650) |
| P12 | M/E/A | 0.32 0.32 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 110 (98 – 120) 360 (330 – 390) |
| M1 | E/M/A | 0.32 0.32 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 135 (120 – 160) 445 (400 – 520) |
| M2 | E/M/A | 0.32 0.32 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 110 (90 – 130) 360 (300 – 420) |
| M3 | E/M/A | 0.32 0.32 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 110 (90 – 130) 360 (300 – 420) |
| M4 | E/M/A | 0.32 0.32 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 80 (68 – 97) 260 (230 – 310) |
| M5 | E/M/A | 0.32 0.32 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 70 (57 – 81) 230 (190 – 260) |
| N1 | E/M/A | 0.24 0.24 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 400 (350 – 440) 1300 (1200 – 1400) |
| N2 | E/M/A | 0.26 0.26 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 400 (350 – 440) 1300 (1200 – 1400) |
| N3 | E/M/A | 0.26 0.26 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 265 (240 – 290) 870 (790 – 950) |
| N11 | E/M/A | 0.24 0.24 | 0.0040 0,00016 | 0.0060 0,00024 | 0.0080 0,00032 | 0.010 0,00040 | 0.012 0,00048 | 0.016 0,00065 | 0.020 0,00080 | 0.024 0,00095 | 0.036 0,0014 | 0.040 0,0016 | 0.050 0,0020 | 0.060 0,0024 | 350 (300 – 390) 1150 (990 – 1200) |
| S11 | E/M/A | 0.36 0.36 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 180 (160 – 200) 590 (530 – 650) |
| S12 | E/M/A | 0.36 0.36 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 140 (120 – 150) 460 (400 – 490) |
| S13 | E/M/A | 0.36 0.36 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 105 (93 – 120) 345 (310 – 390) |
| H3 | M/A | 0.10 0.10 | 0.0024 0,000095 | 0.0036 0,00014 | 0.0048 0,00019 | 0.0060 0,00024 | 0.0070 0,00028 | 0.0095 0,00038 | 0.012 0,00048 | 0.014 0,00055 | 0.022 0,00085 | 0.024 0,00095 | 0.030 0,0012 | 0.036 0,0014 | 80 (61 – 100) 260 (210 – 320) |
| H5 | M/A | 0.20 0.20 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 160 (150 – 180) 520 (500 – 590) |
| H7 | M/A | 0.10 0.10 | 0.0024 0,000095 | 0.0036 0,00014 | 0.0048 0,00019 | 0.0060 0,00024 | 0.0070 0,00028 | 0.0095 0,00038 | 0.012 0,00048 | 0.014 0,00055 | 0.022 0,00085 | 0.024 0,00095 | 0.030 0,0012 | 0.036 0,0014 | 80 (61 – 100) 260 (210 – 320) |
| H8 | M/A | 0.20 0.20 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 160 (150 – 180) 520 (500 – 590) |
| H11 | M/A | 0.20 0.20 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 205 (180 – 230) 670 (600 – 750) |
| H12 | M/A | 0.20 0.20 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 190 (170 – 210) 620 (560 – 680) |
| H21 | M/A | 0.20 0.20 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 160 (150 – 180) 520 (500 – 590) |
| H31 | M/A | 0.20 0.20 | 0.0026 0,00010 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0065 0,00026 | 0.0080 0,00032 | 0.010 0,00040 | 0.013 0,00050 | 0.016 0,00065 | 0.024 0,00095 | 0.026 0,0010 | 0.032 0,0013 | 0.040 0,0016 | 120 (110 – 130) 395 (370 – 420) |
| GR1 | A | 0.50 0.50 | 0.0020 0,000080 | 0.0030 0,00012 | 0.0040 0,00016 | 0.0050 0,00020 | 0.0060 0,00024 | 0.0080 0,00032 | 0.010 0,00040 | 0.012 0,00048 | 0.018 0,00070 | 0.020 0,00080 | 0.025 0,0010 | 0.030 0,0012 | 350 (300 – 390) 1150 (990 – 1200) |

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 561 - 568

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c = m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JMB563

Mini – Universell – Kugelkopf – 3 Schneiden – DMM 6 – Zylindrisch



- Toleranzen:
- Rundlaufabweichung = <math><0,007\text{ mm}</math>
- DMM= h5
- DC= 0,-0,02 mm
- RE= $\pm 0,01\text{ mm}$

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | CA° | PCEDC Zylindrisch |
|-----------------------|----------------|--------------|---------------|-----|-----|-------|------|------|------|------|-------|-------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JMB563010G2B.0Z3-SIRA | 03171307 | 2 | G | 1,0 | 6,0 | 1,0 | 50,0 | 4,0 | 0,95 | 0,5 | 11,15 | 3 |
| JMB563012G2B.0Z3-SIRA | 03171308 | 2 | G | 1,2 | 6,0 | 1,2 | 50,0 | 4,5 | 1,15 | 0,6 | 10,67 | 3 |
| JMB563015G2B.0Z3-SIRA | 03171309 | 2 | G | 1,5 | 6,0 | 1,5 | 50,0 | 5,0 | 1,45 | 0,75 | 10,07 | 3 |
| JMB563020G2B.0Z3-SIRA | 03171310 | 2 | G | 2,0 | 6,0 | 2,0 | 50,0 | 6,0 | 1,94 | 1,0 | 9,05 | 3 |
| JMB563025G2B.0Z3-SIRA | 03171311 | 2 | G | 2,5 | 6,0 | 2,5 | 60,0 | 7,5 | 2,4 | 1,25 | 7,71 | 3 |
| JMB563030G2B.0Z3-SIRA | 03171312 | 2 | G | 3,0 | 6,0 | 3,0 | 60,0 | 9,0 | 2,85 | 1,5 | 6,35 | 3 |
| JMB563010G4B.0Z3-SIRA | 03171316 | 4 | G | 1,0 | 6,0 | 1,0 | 50,0 | 7,0 | 0,95 | 0,5 | 9,06 | 3 |
| JMB563012G4B.0Z3-SIRA | 03171317 | 4 | G | 1,2 | 6,0 | 1,2 | 50,0 | 8,4 | 1,15 | 0,6 | 8,22 | 3 |
| JMB563015G4B.0Z3-SIRA | 03171318 | 4 | G | 1,5 | 6,0 | 1,5 | 50,0 | 10,5 | 1,45 | 0,75 | 7,07 | 3 |
| JMB563020G4B.0Z3-SIRA | 03171319 | 4 | G | 2,0 | 6,0 | 2,0 | 60,0 | 14,0 | 1,94 | 1,0 | 5,57 | 3 |
| JMB563030G4B.0Z3-SIRA | 03171321 | 4 | G | 3,0 | 6,0 | 3,0 | 70,0 | 21,0 | 2,85 | 1,5 | 3,38 | 3 |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JMB563 Kopierfräsen/Schruppen

| SMG | | a _p /DC | a _e /DC | f _z | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|---------|---------|--------|--------|--------|--------------------|
| | | | | 1 | 1.2 | 1.5 | 2.0 | 2.5 | 3.0 | |
| P1 | M/E/A | 0.0500 | 0.38 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 460 (410 – 500) |
| | | 0,0500 | 0,38 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1500 (1400 – 1600) |
| P2 | M/E/A | 0.0500 | 0.38 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 445 (400 – 490) |
| | | 0,0500 | 0,38 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1450 (1400 – 1600) |
| P3 | M/E/A | 0.0500 | 0.38 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 385 (350 – 420) |
| | | 0,0500 | 0,38 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1275 (1200 – 1300) |
| P4 | M/E/A | 0.0500 | 0.38 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 340 (310 – 370) |
| | | 0,0500 | 0,38 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1125 (1100 – 1200) |
| P5 | M/E/A | 0.0500 | 0.38 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 325 (290 – 350) |
| | | 0,0500 | 0,38 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1075 (960 – 1100) |
| P6 | M/E/A | 0.0500 | 0.38 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 365 (330 – 400) |
| | | 0,0500 | 0,38 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1200 (1100 – 1300) |
| P7 | M/E/A | 0.0500 | 0.38 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 340 (310 – 380) |
| | | 0,0500 | 0,38 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1125 (1100 – 1200) |
| P8 | M/E/A | 0.0500 | 0.38 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 325 (290 – 350) |
| | | 0,0500 | 0,38 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1075 (960 – 1100) |
| P11 | M/E/A | 0.0250 | 0.38 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 230 (190 – 270) |
| | | 0,0250 | 0,38 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 750 (630 – 880) |
| P12 | M/E/A | 0.0250 | 0.38 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 135 (120 – 160) |
| | | 0,0250 | 0,38 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 445 (400 – 520) |
| M1 | E/M/A | 0.0250 | 0.38 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 270 (230 – 320) |
| | | 0,0250 | 0,38 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 890 (760 – 1000) |
| M2 | E/M/A | 0.0250 | 0.38 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 220 (180 – 250) |
| | | 0,0250 | 0,38 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 720 (600 – 820) |
| M3 | E/M/A | 0.0250 | 0.38 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 220 (180 – 250) |
| | | 0,0250 | 0,38 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 720 (600 – 820) |
| M4 | E/M/A | 0.0250 | 0.38 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 165 (140 – 190) |
| | | 0,0250 | 0,38 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 540 (460 – 620) |
| M5 | E/M/A | 0.0250 | 0.38 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 135 (120 – 160) |
| | | 0,0250 | 0,38 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 445 (400 – 520) |
| N1 | E/M/A | 0.100 | 0.65 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 590 (520 – 660) |
| | | 0,100 | 0,65 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1925 (1800 – 2100) |
| N2 | E/M/A | 0.100 | 0.65 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 590 (520 – 660) |
| | | 0,100 | 0,65 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1925 (1800 – 2100) |
| N3 | E/M/A | 0.100 | 0.65 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 395 (350 – 440) |
| | | 0,100 | 0,65 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1300 (1200 – 1400) |
| N11 | E/M/A | 0.100 | 0.65 | 0.025 | 0.030 | 0.038 | 0.050 | 0.060 | 0.075 | 520 (450 – 590) |
| | | 0,100 | 0,65 | 0,0010 | 0,0012 | 0,0015 | 0,0020 | 0,0024 | 0,0030 | 1700 (1500 – 1900) |
| S11 | E/M/A | 0.0250 | 0.46 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 345 (300 – 390) |
| | | 0,0250 | 0,46 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1125 (990 – 1200) |
| S12 | E/M/A | 0.0250 | 0.46 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 265 (230 – 300) |
| | | 0,0250 | 0,46 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 870 (760 – 980) |
| S13 | E/M/A | 0.0250 | 0.46 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 205 (180 – 230) |
| | | 0,0250 | 0,46 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 670 (600 – 750) |
| H3 | M/A | 0.0250 | 0.095 | 0.018 | 0.022 | 0.026 | 0.036 | 0.044 | 0.055 | 155 (120 – 190) |
| | | 0,0250 | 0,095 | 0,00070 | 0,00085 | 0,0010 | 0,0014 | 0,0017 | 0,0022 | 510 (400 – 620) |
| H5 | M/A | 0.0500 | 0.22 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 295 (260 – 330) |
| | | 0,0500 | 0,22 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 970 (860 – 1000) |
| H7 | M/A | 0.0250 | 0.095 | 0.018 | 0.022 | 0.026 | 0.036 | 0.044 | 0.055 | 155 (120 – 190) |
| | | 0,0250 | 0,095 | 0,00070 | 0,00085 | 0,0010 | 0,0014 | 0,0017 | 0,0022 | 510 (400 – 620) |
| H8 | M/A | 0.0500 | 0.22 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 295 (260 – 330) |
| | | 0,0500 | 0,22 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 970 (860 – 1000) |
| H11 | M/A | 0.0500 | 0.22 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 375 (330 – 420) |
| | | 0,0500 | 0,22 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1225 (1100 – 1300) |
| H12 | M/A | 0.0500 | 0.22 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 345 (310 – 380) |
| | | 0,0500 | 0,22 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 1125 (1100 – 1200) |
| H21 | M/A | 0.0500 | 0.22 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 295 (260 – 330) |
| | | 0,0500 | 0,22 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 970 (860 – 1000) |
| H31 | M/A | 0.0500 | 0.22 | 0.020 | 0.024 | 0.030 | 0.040 | 0.050 | 0.060 | 225 (200 – 250) |
| | | 0,0500 | 0,22 | 0,00080 | 0,00095 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 740 (660 – 820) |
| GR1 | A | 0.500 | 0.50 | 0.015 | 0.018 | 0.022 | 0.030 | 0.038 | 0.040 | 450 (390 – 510) |
| | | 0,500 | 0,50 | 0,00060 | 0,00070 | 0,00085 | 0,0012 | 0,0015 | 0,0016 | 1475 (1300 – 1600) |

Tabelle basierend auf LV1, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte



STAHL UND GUSS

Das vollständige Programm an Hochleistungsvollhartmetallfräsern für hohe Produktivität in Stahl und Guss besteht aus Schaft- und Kugelkopffräsern.

- JHP993, JHP951 und JH142 mit Fase oder Eckenradius
- JHB970, JH112, JH150, JH160 Kugelkopffräser

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

X-Heads

Minimaster Plus

Minimaster










Universell
 Stahl und Guss
 Rostfrei und ISO-S-Werkstoffe
 NE-Metalle
 Harter
 Kunststoffe und Composite
 Graphit
 X-Heads
 Minimaster Plus
 Minimaster

Werkzeugauswahl Stahl und Guss

| | |  |  |  |  |
|---------------------|-------------|---|---|---|---|
| Werkzeugbezeichnung | | JHP993 | JHP951 | JH142 | JHB970 |
| Seite(n) | | 192 | 198 | 202, 387 | 144, 205 |
| Produktfamilie | | HPM | HPM | HSM/TORNADO | HSM/TORNADO |
| Fräserausführung | |  |  |  |  |
| Aufnahmen | Zylindrisch | ■ | ■ | ■ | ■ |
| | Weldon | ■ | ■ | | |
| Schneidenzahl | | 3,4,5 | 3,4,5 | 2-4-5-6 | 2 |
| ICC | | | | | |
| | Metrisch | 4-25 | 3-20 | 2-12 | 2-16 |
| | Zoll | | | | |
| Verfügbare Längen | | 2,3 | 2 | 2,3,6 | 1,2,3 |
| Bearbeitung | |  |  | | |
| | |  |  | | |
| | | | |  |  |
| SMG | | | | | |
| P1 | | ● | ● | ● | ● |
| P2 | | ● | ● | ● | ● |
| P3 | | ● | ● | ● | ● |
| P4 | | ● | ● | ● | ● |
| P5 | | ● | ● | ● | ● |
| P6 | | ● | ● | ● | ● |
| P7 | | ● | ● | ● | ● |
| P8 | | ● | ● | ● | ● |
| P11-12 | | ○ | ○ | ● | ○ |
| K1 | | ● | ● | ● | ● |
| K2 | | ● | ● | ● | ● |
| K3 | | ● | ● | ● | ● |
| K4 | | ● | ● | ● | ● |
| K5 | | ● | ● | ● | ● |
| K6 | | ● | ● | ● | ● |
| K7 | | ● | ● | ● | ● |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
 ● Erste Wahl ○ Alternative

Werkzeugauswahl Stahl und Guss

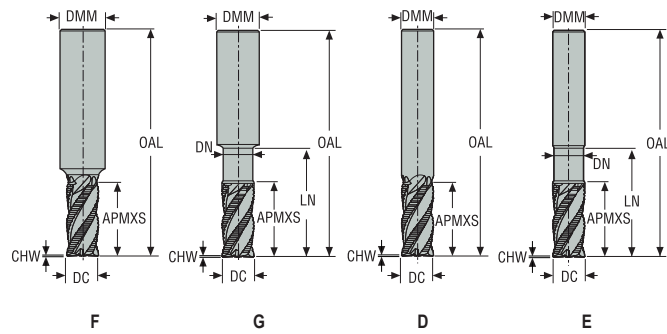
| | |  |  |  |
|---------------------|-------------|---|---|---|
| Werkzeugbezeichnung | | JH112 | JH150 | JH160 |
| Seite(n) | | 207, 390 | 393 | 395 |
| Produktfamilie | | HSM/TORNADO | HSM/TORNADO | HSM/TORNADO |
| Fräserausführung | |  |  |  |
| Aufnahmen | Zylindrisch | ■ | ■ | ■ |
| | Weldon | | | |
| Schneidenzahl | | 2 | 4 | 4 |
| ICC | | | | |
| | Metrisch | 2-12 | 6-12 | 3-12 |
| | Zoll | | | |
| Verfügbare Längen | | 1,2,3,4,5,6 | 2 | 2 |
| Bearbeitung | | | | |
| | |  |  |  |
| SMG | | | | |
| P1 | | | | • |
| P2 | | | | • |
| P3 | | | | • |
| P4 | | | | • |
| P5 | | | | • |
| P6 | | | | • |
| P7 | | | | • |
| P8 | | | | • |
| P11-12 | | | | ○ |
| K1 | | • | • | |
| K2 | | • | • | |
| K3 | | • | • | |
| K4 | | • | • | |
| K5 | | • | • | |
| K6 | | • | • | |
| K7 | | • | • | |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
 • Erste Wahl ○ Alternative

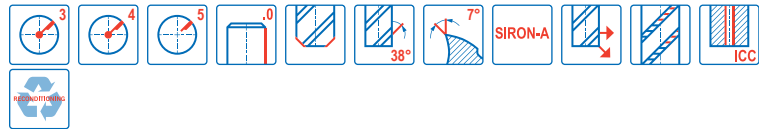
Universell
 Stahl und Guss
 Rostfrei und ISO-S-Werkstoffe
 NE-Metalle
 Harter
 Kunststoffe und Composite
 Graphit
 X-Heads
 Minimaster Plus
 Minimaster

JHP993

Hochleistungsfräser – Stahl – Eckfräser – 3-5 Schneiden – Zylindrisch – Fase



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,1 mm
- CHW= ±0,05 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Zylindrisch |
|-----------------------|--------------------|------------------|-------------------|-----|------|------|-------|-------|-------|------|------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| JHP993040F2C.0Z3-SIRA | 02826806 | 2 | F | - | 4,0 | 6,0 | 10,0 | 50,0 | 12,56 | 4,0 | 0,15 | 3 | ■ |
| JHP993050F2C.0Z4-SIRA | 02826808 | 2 | F | - | 5,0 | 6,0 | 12,0 | 55,0 | 14,75 | 5,0 | 0,15 | 4 | ■ |
| JHP993060D2C.0Z4-SIRA | 02826809 | 2 | D | - | 6,0 | 6,0 | 14,0 | 55,0 | - | - | 0,2 | 4 | ■ |
| JHP993075F2C.0Z4-SIRA | 02826811 | 2 | F | - | 7,5 | 8,0 | 17,0 | 60,0 | 20,0 | 7,5 | 0,2 | 4 | ■ |
| JHP993080D2C.0Z4-SIRA | 02826814 | 2 | D | ■ | 8,0 | 8,0 | 18,0 | 60,0 | - | - | 0,2 | 4 | ■ |
| JHP993080D2C.0Z4-SIRA | 02826812 | 2 | D | - | 8,0 | 8,0 | 18,0 | 60,0 | - | - | 0,2 | 4 | ■ |
| JHP993095F2C.0Z4-SIRA | 02826816 | 2 | F | - | 9,5 | 10,0 | 20,0 | 70,0 | 23,0 | 9,5 | 0,2 | 4 | ■ |
| JHP993100D2C.0Z4-SIRA | 02826818 | 2 | D | ■ | 10,0 | 10,0 | 22,0 | 70,0 | - | - | 0,2 | 4 | ■ |
| JHP993100D2C.0Z4-SIRA | 02826817 | 2 | D | - | 10,0 | 10,0 | 22,0 | 70,0 | - | - | 0,2 | 4 | ■ |
| JHP993115F2C.0Z4-SIRA | 02826820 | 2 | F | - | 11,5 | 12,0 | 25,0 | 80,0 | 28,0 | 11,5 | 0,2 | 4 | ■ |
| JHP993120D2C.0Z4-SIRA | 02826822 | 2 | D | ■ | 12,0 | 12,0 | 26,0 | 80,0 | - | - | 0,2 | 4 | ■ |
| JHP993120D2C.0Z4-SIRA | 02826821 | 2 | D | - | 12,0 | 12,0 | 26,0 | 80,0 | - | - | 0,2 | 4 | ■ |
| JHP993140D2C.0Z4-SIRA | 02826824 | 2 | D | - | 14,0 | 14,0 | 30,0 | 80,0 | - | - | 0,3 | 4 | ■ |
| JHP993160D2C.0Z4-SIRA | 02856501 | 2 | D | ■ | 16,0 | 16,0 | 34,0 | 90,0 | - | - | 0,3 | 4 | ■ |
| JHP993160D2C.0Z4-SIRA | 02856499 | 2 | D | - | 16,0 | 16,0 | 34,0 | 90,0 | - | - | 0,3 | 4 | ■ |
| JHP993160D2C.0Z5-SIRA | 02826825 | 2 | D | - | 16,0 | 16,0 | 34,0 | 90,0 | - | - | 0,3 | 5 | ■ |
| JHP993200D2C.0Z4-SIRA | 02856506 | 2 | D | ■ | 20,0 | 20,0 | 42,0 | 100,0 | - | - | 0,5 | 4 | ■ |
| JHP993200D2C.0Z4-SIRA | 02856505 | 2 | D | - | 20,0 | 20,0 | 42,0 | 100,0 | - | - | 0,5 | 4 | ■ |
| JHP993200D2C.0Z5-SIRA | 02826828 | 2 | D | - | 20,0 | 20,0 | 42,0 | 100,0 | - | - | 0,5 | 5 | ■ |
| JHP993250D2C.0Z4-SIRA | 02856510 | 2 | D | ■ | 25,0 | 25,0 | 52,0 | 125,0 | - | - | 0,5 | 4 | ■ |
| JHP993040G3C.0Z3-SIRA | 02826807 | 3 | G | - | 4,0 | 6,0 | 10,0 | 55,0 | 15,0 | 3,7 | 0,15 | 3 | ■ |
| JHP993060E3C.0Z4-SIRA | 02826810 | 3 | E | - | 6,0 | 6,0 | 14,0 | 65,0 | 24,0 | 5,6 | 0,2 | 4 | ■ |
| JHP993080E3C.0Z4-SIRA | 02826815 | 3 | E | - | 8,0 | 8,0 | 18,0 | 70,0 | 32,0 | 7,4 | 0,2 | 4 | ■ |
| JHP993100E3C.0Z4-SIRA | 02826819 | 3 | E | - | 10,0 | 10,0 | 22,0 | 85,0 | 40,0 | 9,4 | 0,2 | 4 | ■ |
| JHP993120E3C.0Z4-SIRA | 02826823 | 3 | E | - | 12,0 | 12,0 | 26,0 | 100,0 | 50,0 | 11,4 | 0,2 | 4 | ■ |
| JHP993160E3C.0Z4-SIRA | 02856502 | 3 | E | - | 16,0 | 16,0 | 34,0 | 110,0 | 60,0 | 15,4 | 0,3 | 4 | ■ |
| JHP993200E3C.0Z4-SIRA | 02856507 | 3 | E | - | 20,0 | 20,0 | 42,0 | 125,0 | 70,0 | 19,2 | 0,5 | 4 | ■ |

■ Lagerstandard.

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Harter

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Composits

Graphit

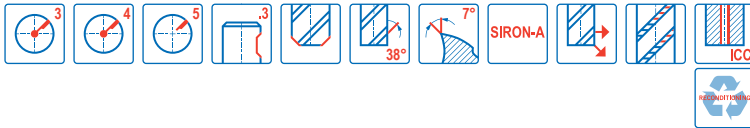
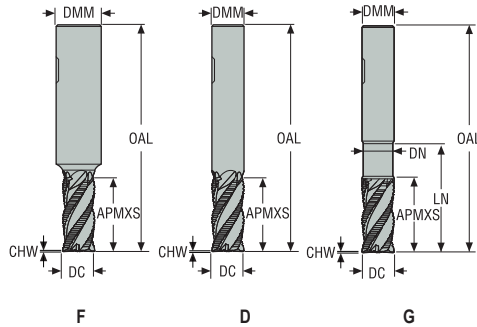
X-Heads

Minimaster Plus

Minimaster

JHP993

Hochleistungsfräser – Stahl – Eckfräser – 3-5 Schneiden – Weldon – Fase



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,1 mm
- CHW= ±0,05 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Weldon |
|------------------------|--------------------|------------------|-------------------|-----|------|------|-------|-------|-------|------|------|-------|--------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | mm | |
| JHP993040F2C.3Z3-SIRA | 02828150 | 2 | F | - | 4,0 | 6,0 | 10,0 | 50,0 | 12,56 | 4,0 | 0,15 | 3 | ■ |
| JHP993050F2C.3Z4-SIRA | 02828152 | 2 | F | - | 5,0 | 6,0 | 12,0 | 55,0 | 14,75 | 5,0 | 0,15 | 4 | ■ |
| JHP993060D2C.3Z4-SIRA | 02828153 | 2 | D | - | 6,0 | 6,0 | 14,0 | 55,0 | - | - | 0,2 | 4 | ■ |
| JHP993075F2C.3Z4-SIRA | 02828155 | 2 | F | - | 7,5 | 8,0 | 17,0 | 60,0 | 20,0 | 7,5 | 0,2 | 4 | ■ |
| JHP993080D2C.3Z4A-SIRA | 02828246 | 2 | D | ■ | 8,0 | 8,0 | 16,0 | 60,0 | - | - | 0,2 | 4 | □ |
| JHP993080D2C.3Z4-SIRA | 02828156 | 2 | D | - | 8,0 | 8,0 | 18,0 | 60,0 | - | - | 0,2 | 4 | ■ |
| JHP993095F2C.3Z4-SIRA | 02828158 | 2 | F | - | 9,5 | 10,0 | 20,0 | 70,0 | 23,0 | 9,5 | 0,2 | 4 | ■ |
| JHP993100D2C.3Z4A-SIRA | 02828247 | 2 | D | ■ | 10,0 | 10,0 | 22,0 | 70,0 | - | - | 0,2 | 4 | □ |
| JHP993100D2C.3Z4-SIRA | 02828159 | 2 | D | - | 10,0 | 10,0 | 22,0 | 70,0 | - | - | 0,2 | 4 | ■ |
| JHP993120D2C.3Z4A-SIRA | 02828248 | 2 | D | ■ | 12,0 | 12,0 | 26,0 | 80,0 | - | - | 0,2 | 4 | □ |
| JHP993120D2C.3Z4-SIRA | 02828162 | 2 | D | - | 12,0 | 12,0 | 26,0 | 80,0 | - | - | 0,2 | 4 | ■ |
| JHP993140D2C.3Z4-SIRA | 02828164 | 2 | D | - | 14,0 | 14,0 | 30,0 | 80,0 | - | - | 0,3 | 4 | ■ |
| JHP993160D2C.3Z4A-SIRA | 02856512 | 2 | D | ■ | 16,0 | 16,0 | 34,0 | 90,0 | - | - | 0,3 | 4 | □ |
| JHP993160D2C.3Z4-SIRA | 02856500 | 2 | D | - | 16,0 | 16,0 | 34,0 | 90,0 | - | - | 0,3 | 4 | ■ |
| JHP993160D2C.3Z5-SIRA | 02828165 | 2 | D | - | 16,0 | 16,0 | 34,0 | 90,0 | - | - | 0,3 | 5 | ■ |
| JHP993200D2C.3Z4A-SIRA | 02856513 | 2 | D | ■ | 20,0 | 20,0 | 42,0 | 100,0 | - | - | 0,5 | 4 | ■ |
| JHP993200D2C.3Z4-SIRA | 02856504 | 2 | D | - | 20,0 | 20,0 | 42,0 | 100,0 | - | - | 0,5 | 4 | ■ |
| JHP993200D2C.3Z5-SIRA | 02828167 | 2 | D | - | 20,0 | 20,0 | 42,0 | 100,0 | - | - | 0,5 | 5 | ■ |
| JHP993250D2C.3Z4A-SIRA | 02856514 | 2 | D | ■ | 25,0 | 25,0 | 52,0 | 125,0 | - | - | 0,5 | 4 | □ |
| JHP993250D2C.3Z4-SIRA | 02856509 | 2 | D | - | 25,0 | 25,0 | 52,0 | 125,0 | - | - | 0,5 | 4 | ■ |
| JHP993060E3C.3Z4-SIRA | 02828154 | 3 | E | - | 6,0 | 6,0 | 14,0 | 65,0 | 24,0 | 5,6 | 0,2 | 4 | ■ |
| JHP993080E3C.3Z4-SIRA | 02828157 | 3 | E | - | 8,0 | 8,0 | 18,0 | 70,0 | 32,0 | 7,4 | 0,2 | 4 | ■ |
| JHP993100E3C.3Z4-SIRA | 02828160 | 3 | E | - | 10,0 | 10,0 | 22,0 | 85,0 | 40,0 | 9,4 | 0,2 | 4 | ■ |
| JHP993120E3C.3Z4-SIRA | 02828163 | 3 | E | - | 12,0 | 12,0 | 26,0 | 100,0 | 50,0 | 11,4 | 0,2 | 4 | ■ |
| JHP993160E3C.3Z4-SIRA | 02856503 | 3 | E | - | 16,0 | 16,0 | 34,0 | 110,0 | 60,0 | 15,4 | 0,3 | 4 | ■ |
| JHP993200E3C.3Z4-SIRA | 02856508 | 3 | E | - | 20,0 | 20,0 | 42,0 | 125,0 | 70,0 | 19,2 | 0,5 | 4 | ■ |
| JHP993200E3C.3Z5-SIRA | 02828168 | 3 | E | - | 20,0 | 20,0 | 42,0 | 125,0 | 70,0 | 19,2 | 0,5 | 5 | ■ |
| JHP993250E3C.3Z4-SIRA | 02856511 | 3 | E | - | 25,0 | 25,0 | 52,0 | 150,0 | 90,0 | 24,0 | 0,5 | 4 | ■ |

■ Lagerstandard. □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JHP993 Eckfräsen PCEDC=3 und PCEDC=4

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | | 4 | 5 | 6 | 8 | 10 | 12 | 14 | 16 | 20 | 25 | |
| P1 | E/M/A | 0.400 | 1.7 | 0.044 | 0.055 | 0.065 | 0.090 | 0.11 | 0.13 | 0.15 | 0.16 | 0.19 | 0.22 | 230 (200 – 260) |
| | | 0,400 | 1,7 | 0,0017 | 0,0022 | 0,0026 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 0,0075 | 0,0085 | 750 (660 – 850) |
| P2 | E/M/A | 0.400 | 1.7 | 0.044 | 0.055 | 0.065 | 0.090 | 0.11 | 0.13 | 0.15 | 0.17 | 0.19 | 0.22 | 225 (200 – 250) |
| | | 0,400 | 1,7 | 0,0017 | 0,0022 | 0,0026 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 0,0075 | 0,0085 | 740 (660 – 820) |
| P3 | E/M/A | 0.400 | 1.7 | 0.042 | 0.055 | 0.065 | 0.085 | 0.11 | 0.13 | 0.14 | 0.16 | 0.18 | 0.20 | 195 (170 – 220) |
| | | 0,400 | 1,7 | 0,0017 | 0,0022 | 0,0026 | 0,0034 | 0,0044 | 0,0050 | 0,0055 | 0,0065 | 0,0070 | 0,0080 | 640 (560 – 720) |
| P4 | E/M/A | 0.400 | 1.7 | 0.042 | 0.050 | 0.060 | 0.085 | 0.10 | 0.12 | 0.14 | 0.15 | 0.18 | 0.20 | 175 (150 – 190) |
| | | 0,400 | 1,7 | 0,0017 | 0,0020 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 0,0055 | 0,0060 | 0,0070 | 0,0080 | 570 (500 – 620) |
| P5 | E/M/A | 0.400 | 1.7 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.14 | 0.15 | 0.17 | 0.20 | 165 (150 – 190) |
| | | 0,400 | 1,7 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0055 | 0,0060 | 0,0065 | 0,0080 | 540 (500 – 620) |
| P6 | E/M/A | 0.400 | 1.7 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.14 | 0.15 | 0.17 | 0.19 | 185 (160 – 210) |
| | | 0,400 | 1,7 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0055 | 0,0060 | 0,0065 | 0,0075 | 610 (530 – 680) |
| P7 | E/M/A | 0.400 | 1.7 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.14 | 0.15 | 0.17 | 0.19 | 175 (160 – 200) |
| | | 0,400 | 1,7 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0055 | 0,0060 | 0,0065 | 0,0075 | 570 (530 – 650) |
| P8 | E/M/A | 0.400 | 1.7 | 0.042 | 0.055 | 0.065 | 0.085 | 0.11 | 0.13 | 0.14 | 0.16 | 0.18 | 0.20 | 160 (140 – 180) |
| | | 0,400 | 1,7 | 0,0017 | 0,0022 | 0,0026 | 0,0034 | 0,0044 | 0,0050 | 0,0055 | 0,0065 | 0,0070 | 0,0080 | 520 (460 – 590) |
| P11 | E/M/A | 0.400 | 1.7 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.14 | 0.15 | 0.17 | 0.19 | 170 (150 – 190) |
| | | 0,400 | 1,7 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0055 | 0,0060 | 0,0065 | 0,0075 | 560 (500 – 620) |
| P12 | E/M/A | 0.400 | 1.7 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.080 | 0.095 | 0.10 | 0.12 | 0.13 | 110 (95 – 120) |
| | | 0,400 | 1,7 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0032 | 0,0038 | 0,0040 | 0,0048 | 0,0050 | 360 (320 – 390) |
| K1 | E/M/A | 0.400 | 1.7 | 0.044 | 0.055 | 0.065 | 0.090 | 0.11 | 0.13 | 0.15 | 0.17 | 0.19 | 0.22 | 225 (200 – 250) |
| | | 0,400 | 1,7 | 0,0017 | 0,0022 | 0,0026 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 0,0075 | 0,0085 | 740 (660 – 820) |
| K2 | E/M/A | 0.400 | 1.7 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.14 | 0.15 | 0.17 | 0.20 | 200 (180 – 220) |
| | | 0,400 | 1,7 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0055 | 0,0060 | 0,0065 | 0,0080 | 660 (600 – 720) |
| K3 | E/M/A | 0.400 | 1.7 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.14 | 0.15 | 0.17 | 0.20 | 170 (150 – 190) |
| | | 0,400 | 1,7 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0055 | 0,0060 | 0,0065 | 0,0080 | 560 (500 – 620) |
| K4 | E/M/A | 0.400 | 1.7 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.14 | 0.15 | 0.17 | 0.20 | 160 (140 – 180) |
| | | 0,400 | 1,7 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0055 | 0,0060 | 0,0065 | 0,0080 | 520 (460 – 590) |
| K5 | E/M/A | 0.400 | 1.7 | 0.036 | 0.046 | 0.055 | 0.075 | 0.090 | 0.11 | 0.12 | 0.14 | 0.16 | 0.18 | 100 (86 – 110) |
| | | 0,400 | 1,7 | 0,0014 | 0,0018 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0048 | 0,0055 | 0,0065 | 0,0070 | 330 (290 – 360) |
| K6 | E/M/A | 0.400 | 1.7 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.14 | 0.15 | 0.17 | 0.20 | 145 (130 – 160) |
| | | 0,400 | 1,7 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0055 | 0,0060 | 0,0065 | 0,0080 | 475 (430 – 520) |
| K7 | E/M/A | 0.400 | 1.7 | 0.036 | 0.046 | 0.055 | 0.075 | 0.090 | 0.11 | 0.12 | 0.14 | 0.16 | 0.18 | 125 (110 – 140) |
| | | 0,400 | 1,7 | 0,0014 | 0,0018 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0048 | 0,0055 | 0,0065 | 0,0070 | 410 (370 – 450) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – JHP993 Eckfräsen PCEDC=5

| SMG |  | a _e /DC | a _p /DC | f _z | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|-----------------|
| | | | | 16 | 20 | |
| P1 | E/M/A | 0,376 | 1,0 | 0,17 | 0,22 | 205 (180 – 230) |
| | | 0,376 | 1,0 | 0,0065 | 0,0085 | 670 (600 – 750) |
| P2 | E/M/A | 0,376 | 1,0 | 0,18 | 0,22 | 195 (170 – 220) |
| | | 0,376 | 1,0 | 0,0070 | 0,0085 | 640 (560 – 720) |
| P3 | E/M/A | 0,376 | 1,0 | 0,17 | 0,20 | 170 (150 – 190) |
| | | 0,376 | 1,0 | 0,0065 | 0,0080 | 560 (500 – 620) |
| P4 | E/M/A | 0,376 | 1,0 | 0,16 | 0,20 | 155 (140 – 170) |
| | | 0,376 | 1,0 | 0,0065 | 0,0080 | 510 (460 – 550) |
| P5 | E/M/A | 0,376 | 1,0 | 0,16 | 0,20 | 145 (130 – 160) |
| | | 0,376 | 1,0 | 0,0065 | 0,0080 | 475 (430 – 520) |
| P6 | E/M/A | 0,376 | 1,0 | 0,16 | 0,20 | 165 (150 – 180) |
| | | 0,376 | 1,0 | 0,0065 | 0,0080 | 540 (500 – 590) |
| P7 | E/M/A | 0,376 | 1,0 | 0,16 | 0,20 | 155 (140 – 170) |
| | | 0,376 | 1,0 | 0,0065 | 0,0080 | 510 (460 – 550) |
| P8 | E/M/A | 0,376 | 1,0 | 0,17 | 0,20 | 145 (130 – 160) |
| | | 0,376 | 1,0 | 0,0065 | 0,0080 | 475 (430 – 520) |
| P11 | E/M/A | 0,376 | 1,0 | 0,16 | 0,20 | 150 (130 – 170) |
| | | 0,376 | 1,0 | 0,0065 | 0,0080 | 490 (430 – 550) |
| P12 | E/M/A | 0,376 | 1,0 | 0,11 | 0,13 | 100 (85 – 110) |
| | | 0,376 | 1,0 | 0,0044 | 0,0050 | 330 (280 – 360) |
| K1 | E/M/A | 0,376 | 1,0 | 0,18 | 0,22 | 195 (170 – 220) |
| | | 0,376 | 1,0 | 0,0070 | 0,0085 | 640 (560 – 720) |
| K2 | E/M/A | 0,376 | 1,0 | 0,16 | 0,20 | 175 (160 – 200) |
| | | 0,376 | 1,0 | 0,0065 | 0,0080 | 570 (530 – 650) |
| K3 | E/M/A | 0,376 | 1,0 | 0,16 | 0,20 | 150 (130 – 170) |
| | | 0,376 | 1,0 | 0,0065 | 0,0080 | 490 (430 – 550) |
| K4 | E/M/A | 0,376 | 1,0 | 0,16 | 0,20 | 145 (130 – 160) |
| | | 0,376 | 1,0 | 0,0065 | 0,0080 | 475 (430 – 520) |
| K5 | E/M/A | 0,376 | 1,0 | 0,15 | 0,18 | 85 (75 – 99) |
| | | 0,376 | 1,0 | 0,0060 | 0,0070 | 280 (250 – 320) |
| K6 | E/M/A | 0,376 | 1,0 | 0,16 | 0,20 | 125 (110 – 140) |
| | | 0,376 | 1,0 | 0,0065 | 0,0080 | 410 (370 – 450) |
| K7 | E/M/A | 0,376 | 1,0 | 0,15 | 0,18 | 110 (96 – 120) |
| | | 0,376 | 1,0 | 0,0060 | 0,0070 | 360 (320 – 390) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Unversell
 Stahl und Guss
 Rostfrei und ISO-S-Werkstoffe
 NE-Metalle
 Harter
 Kunststoffe und Composite
 Graphit
 X-Heads
 Minmaster Plus
 Minmaster


Schnittdaten – JHP993 Nutfräsen PCEDC=3 und PCEDC=4

| SMG | | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|-------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | 4 | 5 | 6 | 8 | 10 | 12 | 14 | 16 | 20 | 25 | |
| P1 | E/M/A | 1.5 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.13 | 0.16 | 0.20 | 200 (180 – 220) |
| | | 1,5 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 0,0065 | 0,0080 | 660 (600 – 720) |
| P2 | E/M/A | 1.5 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.13 | 0.16 | 0.20 | 195 (170 – 220) |
| | | 1,5 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 0,0065 | 0,0080 | 640 (560 – 720) |
| P3 | E/M/A | 1.5 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.13 | 0.16 | 0.20 | 165 (150 – 190) |
| | | 1,5 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 0,0065 | 0,0080 | 540 (500 – 620) |
| P4 | E/M/A | 1.5 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.13 | 0.16 | 0.20 | 145 (130 – 160) |
| | | 1,5 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 0,0065 | 0,0080 | 475 (430 – 520) |
| P5 | E/M/A | 1.5 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.13 | 0.16 | 0.19 | 140 (130 – 160) |
| | | 1,5 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 460 (430 – 520) |
| P6 | E/M/A | 1.5 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.13 | 0.16 | 0.19 | 155 (140 – 170) |
| | | 1,5 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 510 (460 – 550) |
| P7 | E/M/A | 1.5 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.13 | 0.16 | 0.19 | 150 (130 – 160) |
| | | 1,5 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 490 (430 – 520) |
| P8 | E/M/A | 1.5 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.13 | 0.16 | 0.20 | 140 (130 – 160) |
| | | 1,5 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 0,0065 | 0,0080 | 460 (430 – 520) |
| P11 | E/M/A | 1.5 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.13 | 0.16 | 0.19 | 145 (130 – 160) |
| | | 1,5 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 475 (430 – 520) |
| P12 | E/M/A | 1.5 | 0.028 | 0.034 | 0.040 | 0.055 | 0.070 | 0.080 | 0.090 | 0.10 | 0.12 | 0.13 | 90 (76 – 100) |
| | | 1,5 | 0,0011 | 0,0013 | 0,0016 | 0,0022 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0048 | 0,0050 | 295 (250 – 320) |
| K1 | E/M/A | 1.5 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.13 | 0.16 | 0.20 | 195 (170 – 220) |
| | | 1,5 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 0,0065 | 0,0080 | 640 (560 – 720) |
| K2 | E/M/A | 1.5 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.13 | 0.16 | 0.19 | 170 (150 – 190) |
| | | 1,5 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 560 (500 – 620) |
| K3 | E/M/A | 1.5 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.13 | 0.16 | 0.19 | 145 (130 – 160) |
| | | 1,5 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 475 (430 – 520) |
| K4 | E/M/A | 1.5 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.13 | 0.16 | 0.19 | 135 (120 – 150) |
| | | 1,5 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 445 (400 – 490) |
| K5 | E/M/A | 1.5 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.13 | 0.15 | 0.17 | 80 (70 – 93) |
| | | 1,5 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 260 (230 – 300) |
| K6 | E/M/A | 1.5 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.13 | 0.16 | 0.19 | 120 (110 – 130) |
| | | 1,5 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 395 (370 – 420) |
| K7 | E/M/A | 1.5 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.13 | 0.15 | 0.17 | 105 (90 – 110) |
| | | 1,5 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 345 (300 – 360) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_b = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – JHP993 Nutfräsen PCEDC=5

| SMG |  | a _p /DC | | f _z | | v _c |
|-----|---|--------------------|--|----------------|--------|-----------------|
| | | | | 16 | 20 | |
| P1 | E/M/A | 0,44 | | 0,17 | 0,20 | 160 (140 – 180) |
| | | 0,44 | | 0,0065 | 0,0080 | 520 (460 – 590) |
| P2 | E/M/A | 0,44 | | 0,17 | 0,22 | 155 (140 – 170) |
| | | 0,44 | | 0,0065 | 0,0085 | 510 (460 – 550) |
| P3 | E/M/A | 0,44 | | 0,16 | 0,20 | 135 (120 – 150) |
| | | 0,44 | | 0,0065 | 0,0080 | 445 (400 – 490) |
| P4 | E/M/A | 0,44 | | 0,16 | 0,20 | 120 (110 – 130) |
| | | 0,44 | | 0,0065 | 0,0080 | 395 (370 – 420) |
| P5 | E/M/A | 0,44 | | 0,16 | 0,19 | 115 (99 – 130) |
| | | 0,44 | | 0,0065 | 0,0075 | 375 (330 – 420) |
| P6 | E/M/A | 0,44 | | 0,16 | 0,19 | 130 (120 – 140) |
| | | 0,44 | | 0,0065 | 0,0075 | 425 (400 – 450) |
| P7 | E/M/A | 0,44 | | 0,16 | 0,19 | 120 (110 – 130) |
| | | 0,44 | | 0,0065 | 0,0075 | 395 (370 – 420) |
| P8 | E/M/A | 0,44 | | 0,16 | 0,20 | 115 (99 – 130) |
| | | 0,44 | | 0,0065 | 0,0080 | 375 (330 – 420) |
| P11 | E/M/A | 0,44 | | 0,16 | 0,19 | 120 (110 – 130) |
| | | 0,44 | | 0,0065 | 0,0075 | 395 (370 – 420) |
| P12 | E/M/A | 0,44 | | 0,11 | 0,13 | 80 (68 – 89) |
| | | 0,44 | | 0,0044 | 0,0050 | 260 (230 – 290) |
| K1 | E/M/A | 0,44 | | 0,17 | 0,22 | 160 (140 – 180) |
| | | 0,44 | | 0,0065 | 0,0085 | 520 (460 – 590) |
| K2 | E/M/A | 0,44 | | 0,16 | 0,19 | 140 (120 – 150) |
| | | 0,44 | | 0,0065 | 0,0075 | 460 (400 – 490) |
| K3 | E/M/A | 0,44 | | 0,16 | 0,19 | 120 (110 – 130) |
| | | 0,44 | | 0,0065 | 0,0075 | 395 (370 – 420) |
| K4 | E/M/A | 0,44 | | 0,16 | 0,19 | 115 (97 – 120) |
| | | 0,44 | | 0,0065 | 0,0075 | 375 (320 – 390) |
| K5 | E/M/A | 0,44 | | 0,14 | 0,17 | 70 (60 – 79) |
| | | 0,44 | | 0,0055 | 0,0065 | 230 (200 – 250) |
| K6 | E/M/A | 0,44 | | 0,16 | 0,19 | 100 (86 – 110) |
| | | 0,44 | | 0,0065 | 0,0075 | 330 (290 – 360) |
| K7 | E/M/A | 0,44 | | 0,14 | 0,17 | 90 (77 – 100) |
| | | 0,44 | | 0,0055 | 0,0065 | 295 (260 – 320) |

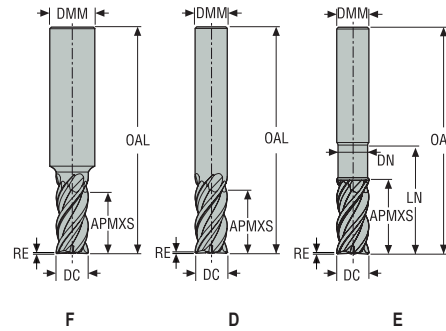
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

- Unversell
- Stahl und Guss
- Rostfrei und ISO-S-Werkstoffe
- NE-Metalle
- Harter
- Kunststoffe und Composite
- Graphit
- X-Heads
- Minimaster Plus
- Minimaster

JHP951

Hochleistungsfräser – Eckfräser – Stahl – 3-5 Schneiden – Zylindrisch – Eckenradius oder Fase



- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | CHW | RE | PCEDC | Zylindrisch |
|--------------------------|--------------------|------------------|-------------------|------|------|-------|------|-------|------|------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | | |
| JHP951030F2C.0Z3-SIRA | 02828192 | 2 | F | 3,0 | 6,0 | 8,0 | 50,0 | 10,25 | 3,0 | 0,1 | – | 3 | ■ |
| JHP951030F2R020.0Z3-SIRA | 02828191 | 2 | F | 3,0 | 6,0 | 8,0 | 50,0 | 10,25 | 3,0 | – | 0,2 | 3 | ■ |
| JHP951030F2R050.0Z3-SIRA | 02828190 | 2 | F | 3,0 | 6,0 | 8,0 | 50,0 | 10,25 | 3,0 | – | 0,5 | 3 | ■ |
| JHP951040F2C.0Z4-SIRA | 02828197 | 2 | F | 4,0 | 6,0 | 10,0 | 55,0 | 13,25 | 4,0 | 0,15 | – | 4 | ■ |
| JHP951040F2R020.0Z4-SIRA | 02828194 | 2 | F | 4,0 | 6,0 | 10,0 | 55,0 | 13,25 | 4,0 | – | 0,2 | 4 | ■ |
| JHP951040F2R050.0Z4-SIRA | 02828195 | 2 | F | 4,0 | 6,0 | 10,0 | 55,0 | 13,25 | 4,0 | – | 0,5 | 4 | ■ |
| JHP951050F2C.0Z4-SIRA | 02828201 | 2 | F | 5,0 | 6,0 | 12,0 | 55,0 | 15,25 | 5,0 | 0,2 | – | 4 | ■ |
| JHP951050F2R020.0Z4-SIRA | 02828199 | 2 | F | 5,0 | 6,0 | 12,0 | 55,0 | 15,25 | 5,0 | – | 0,2 | 4 | ■ |
| JHP951050F2R050.0Z4-SIRA | 02828198 | 2 | F | 5,0 | 6,0 | 12,0 | 55,0 | 15,25 | 5,0 | – | 0,5 | 4 | ■ |
| JHP951060D2C.0Z4-SIRA | 02828205 | 2 | D | 6,0 | 6,0 | 14,0 | 55,0 | – | – | 0,2 | – | 4 | ■ |
| JHP951060D2R020.0Z4-SIRA | 02828203 | 2 | D | 6,0 | 6,0 | 14,0 | 55,0 | – | – | – | 0,2 | 4 | ■ |
| JHP951060D2R050.0Z4-SIRA | 02828202 | 2 | D | 6,0 | 6,0 | 14,0 | 55,0 | – | – | – | 0,5 | 4 | ■ |
| JHP951080D2C.0Z4-SIRA | 02828212 | 2 | D | 8,0 | 8,0 | 18,0 | 60,0 | – | – | 0,3 | – | 4 | ■ |
| JHP951080D2R020.0Z4-SIRA | 02828209 | 2 | D | 8,0 | 8,0 | 18,0 | 60,0 | – | – | – | 0,2 | 4 | ■ |
| JHP951080D2R050.0Z4-SIRA | 02828207 | 2 | D | 8,0 | 8,0 | 18,0 | 60,0 | – | – | – | 0,5 | 4 | ■ |
| JHP951080D2R100.0Z4-SIRA | 02828208 | 2 | D | 8,0 | 8,0 | 18,0 | 60,0 | – | – | – | 1,0 | 4 | ■ |
| JHP951100E2C.0Z4-SIRA | 02828218 | 2 | E | 10,0 | 10,0 | 22,0 | 70,0 | 28,0 | 9,4 | 0,3 | – | 4 | ■ |
| JHP951100E2R050.0Z4-SIRA | 02828216 | 2 | E | 10,0 | 10,0 | 22,0 | 70,0 | 28,0 | 9,4 | – | 0,5 | 4 | ■ |
| JHP951100E2R100.0Z4-SIRA | 02828214 | 2 | E | 10,0 | 10,0 | 22,0 | 70,0 | 28,0 | 9,4 | – | 1,0 | 4 | ■ |
| JHP951120E2C.0Z4-SIRA | 02828226 | 2 | E | 12,0 | 12,0 | 26,0 | 80,0 | 33,0 | 11,4 | 0,4 | – | 4 | ■ |
| JHP951120E2R050.0Z4-SIRA | 02828224 | 2 | E | 12,0 | 12,0 | 26,0 | 80,0 | 33,0 | 11,4 | – | 0,5 | 4 | ■ |
| JHP951120E2R100.0Z4-SIRA | 02828222 | 2 | E | 12,0 | 12,0 | 26,0 | 80,0 | 33,0 | 11,4 | – | 1,0 | 4 | ■ |
| JHP951160E2C.0Z4-SIRA | 02927873 | 2 | E | 16,0 | 16,0 | 34,0 | 90,0 | 40,0 | 15,0 | 0,5 | – | 4 | ■ |
| JHP951160E2C.0Z5-SIRA | 02828232 | 2 | E | 16,0 | 16,0 | 34,0 | 90,0 | 40,0 | 15,4 | 0,5 | – | 5 | ■ |
| JHP951160E2R050.0Z4-SIRA | 02927875 | 2 | E | 16,0 | 16,0 | 34,0 | 90,0 | 40,0 | 15,0 | – | 0,5 | 4 | ■ |
| JHP951160E2R050.0Z5-SIRA | 02828230 | 2 | E | 16,0 | 16,0 | 34,0 | 90,0 | 40,0 | 15,4 | – | 0,5 | 5 | ■ |
| JHP951160E2R100.0Z4-SIRA | 02927876 | 2 | E | 16,0 | 16,0 | 34,0 | 90,0 | 40,0 | 15,0 | – | 1,0 | 4 | ■ |
| JHP951160E2R100.0Z5-SIRA | 02828231 | 2 | E | 16,0 | 16,0 | 34,0 | 90,0 | 40,0 | 15,4 | – | 1,0 | 5 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

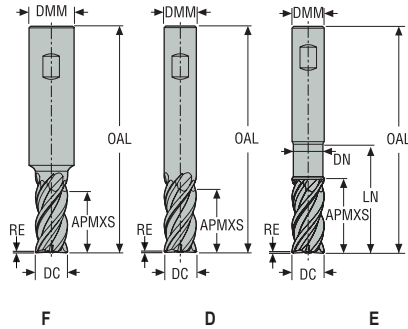
X-Heads

Minimaster Plus

Minimaster

JHP951

Hochleistungsfräser – Eckfräser – Stahl – 3-5 Schneiden – Weldon – Eckenradius oder Fase



- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | CHW | RE | PCEDC | Weldon |
|--------------------------|----------------|--------------|---------------|------|------|-------|-------|-------|------|------|-----|-------|--------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | | |
| JHP951030F2C.3Z3-SIRA | 02828193 | 2 | F | 3,0 | 6,0 | 8,0 | 50,0 | 10,25 | 3,0 | 0,1 | - | 3 | ■ |
| JHP951030F2R020.3Z3-SIRA | 02828260 | 2 | F | 3,0 | 6,0 | 8,0 | 50,0 | 10,25 | 3,0 | - | 0,2 | 3 | ■ |
| JHP951030F2R050.3Z3-SIRA | 02828259 | 2 | F | 3,0 | 6,0 | 8,0 | 50,0 | 10,25 | 3,0 | - | 0,5 | 3 | □ |
| JHP951040F2C.3Z4-SIRA | 02828196 | 2 | F | 4,0 | 6,0 | 10,0 | 55,0 | 13,25 | 4,0 | 0,15 | - | 4 | ■ |
| JHP951040F2R020.3Z4-SIRA | 02828261 | 2 | F | 4,0 | 6,0 | 10,0 | 55,0 | 13,25 | 4,0 | - | 0,2 | 4 | □ |
| JHP951040F2R050.3Z4-SIRA | 02828262 | 2 | F | 4,0 | 6,0 | 10,0 | 55,0 | 13,25 | 4,0 | - | 0,5 | 4 | □ |
| JHP951050F2C.3Z4-SIRA | 02828200 | 2 | F | 5,0 | 6,0 | 12,0 | 55,0 | 15,25 | 5,0 | 0,2 | - | 4 | ■ |
| JHP951050F2R020.3Z4-SIRA | 02828264 | 2 | F | 5,0 | 6,0 | 12,0 | 55,0 | 15,25 | 5,0 | - | 0,2 | 4 | □ |
| JHP951050F2R050.3Z4-SIRA | 02828263 | 2 | F | 5,0 | 6,0 | 12,0 | 55,0 | 15,25 | 5,0 | - | 0,5 | 4 | □ |
| JHP951060D2C.3Z4-SIRA | 02828206 | 2 | D | 6,0 | 6,0 | 14,0 | 55,0 | - | - | 0,2 | - | 4 | ■ |
| JHP951060D2R020.3Z4-SIRA | 02828266 | 2 | D | 6,0 | 6,0 | 14,0 | 55,0 | - | - | - | 0,2 | 4 | □ |
| JHP951060D2R050.3Z4-SIRA | 02828265 | 2 | D | 6,0 | 6,0 | 14,0 | 55,0 | - | - | - | 0,5 | 4 | □ |
| JHP951080D2C.3Z4-SIRA | 02828210 | 2 | D | 8,0 | 8,0 | 18,0 | 60,0 | - | - | 0,3 | - | 4 | ■ |
| JHP951080D2R020.3Z4-SIRA | 02828269 | 2 | D | 8,0 | 8,0 | 18,0 | 60,0 | - | - | - | 0,2 | 4 | □ |
| JHP951080D2R050.3Z4-SIRA | 02828267 | 2 | D | 8,0 | 8,0 | 18,0 | 60,0 | - | - | - | 0,5 | 4 | ■ |
| JHP951080D2R100.3Z4-SIRA | 02828268 | 2 | D | 8,0 | 8,0 | 18,0 | 60,0 | - | - | - | 1,0 | 4 | □ |
| JHP951100E2C.3Z4-SIRA | 02828220 | 2 | E | 10,0 | 10,0 | 22,0 | 70,0 | 28,0 | 9,4 | 0,3 | - | 4 | ■ |
| JHP951100E2R050.3Z4-SIRA | 02828271 | 2 | E | 10,0 | 10,0 | 22,0 | 70,0 | 28,0 | 9,4 | - | 0,5 | 4 | □ |
| JHP951100E2R100.3Z4-SIRA | 02828270 | 2 | E | 10,0 | 10,0 | 22,0 | 70,0 | 28,0 | 9,4 | - | 1,0 | 4 | □ |
| JHP951120E2C.3Z4-SIRA | 02828228 | 2 | E | 12,0 | 12,0 | 26,0 | 80,0 | 33,0 | 11,4 | 0,4 | - | 4 | ■ |
| JHP951120E2R050.3Z4-SIRA | 02828273 | 2 | E | 12,0 | 12,0 | 26,0 | 80,0 | 33,0 | 11,4 | - | 0,5 | 4 | □ |
| JHP951120E2R100.3Z4-SIRA | 02828272 | 2 | E | 12,0 | 12,0 | 26,0 | 80,0 | 33,0 | 11,4 | - | 1,0 | 4 | □ |
| JHP951160E2C.3Z4-SIRA | 02927874 | 2 | E | 16,0 | 16,0 | 34,0 | 90,0 | 40,0 | 15,0 | 0,5 | - | 4 | ■ |
| JHP951160E2C.3Z5-SIRA | 02828233 | 2 | E | 16,0 | 16,0 | 34,0 | 90,0 | 40,0 | 15,4 | 0,5 | - | 5 | ■ |
| JHP951160E2R050.3Z4-SIRA | 02927879 | 2 | E | 16,0 | 16,0 | 34,0 | 90,0 | 40,0 | 15,0 | - | 0,5 | 4 | □ |
| JHP951160E2R050.3Z5-SIRA | 02828275 | 2 | E | 16,0 | 16,0 | 34,0 | 90,0 | 40,0 | 15,4 | - | 0,5 | 5 | □ |
| JHP951160E2R100.3Z4-SIRA | 02927880 | 2 | E | 16,0 | 16,0 | 34,0 | 90,0 | 40,0 | 15,0 | - | 1,0 | 4 | □ |
| JHP951160E2R100.3Z5-SIRA | 02828276 | 2 | E | 16,0 | 16,0 | 34,0 | 90,0 | 40,0 | 15,4 | - | 1,0 | 5 | □ |
| JHP951200E2R050.3Z4-SIRA | 02927877 | 2 | E | 20,0 | 20,0 | 42,0 | 100,0 | 48,0 | 19,0 | - | 0,5 | 4 | ■ |
| JHP951200E2R050.3Z5-SIRA | 02828235 | 2 | E | 20,0 | 20,0 | 42,0 | 100,0 | 48,0 | 19,4 | - | 0,5 | 5 | ■ |
| JHP951200E2R100.3Z4-SIRA | 02927878 | 2 | E | 20,0 | 20,0 | 42,0 | 100,0 | 48,0 | 19,0 | - | 1,0 | 4 | ■ |
| JHP951200E2R100.3Z5-SIRA | 02828234 | 2 | E | 20,0 | 20,0 | 42,0 | 100,0 | 48,0 | 19,4 | - | 1,0 | 5 | ■ |

■ Lagerstandard. □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JHP951 Eckfräsen

| SMG | | a _p /DC | a _r /DC | f _z | | | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| P1 | E/M/A | 0.400 | 1.7 | 0.034 | 0.044 | 0.055 | 0.065 | 0.090 | 0.11 | 0.13 | 0.16 | 0.19 | 230 (200 – 260) |
| | | 0,400 | 1,7 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0036 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 750 (660 – 850) |
| P2 | E/M/A | 0.400 | 1.7 | 0.034 | 0.044 | 0.055 | 0.065 | 0.090 | 0.11 | 0.13 | 0.16 | 0.19 | 220 (200 – 250) |
| | | 0,400 | 1,7 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0036 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 720 (660 – 820) |
| P3 | E/M/A | 0.400 | 1.7 | 0.032 | 0.042 | 0.055 | 0.065 | 0.085 | 0.11 | 0.13 | 0.16 | 0.18 | 190 (170 – 210) |
| | | 0,400 | 1,7 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0034 | 0,0044 | 0,0050 | 0,0065 | 0,0070 | 620 (560 – 680) |
| P4 | E/M/A | 0.400 | 1.7 | 0.032 | 0.042 | 0.050 | 0.060 | 0.085 | 0.10 | 0.12 | 0.15 | 0.18 | 170 (150 – 190) |
| | | 0,400 | 1,7 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 0,0034 | 0,0040 | 0,0048 | 0,0060 | 0,0070 | 560 (500 – 620) |
| P5 | E/M/A | 0.400 | 1.7 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 165 (150 – 180) |
| | | 0,400 | 1,7 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 540 (500 – 590) |
| P6 | E/M/A | 0.400 | 1.7 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 185 (160 – 210) |
| | | 0,400 | 1,7 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 610 (530 – 680) |
| P7 | E/M/A | 0.400 | 1.7 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 175 (150 – 190) |
| | | 0,400 | 1,7 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 570 (500 – 620) |
| P8 | E/M/A | 0.400 | 1.7 | 0.032 | 0.042 | 0.055 | 0.065 | 0.085 | 0.11 | 0.13 | 0.16 | 0.18 | 160 (140 – 180) |
| | | 0,400 | 1,7 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0034 | 0,0044 | 0,0050 | 0,0065 | 0,0070 | 520 (460 – 590) |
| P11 | E/M/A | 0.400 | 1.7 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 170 (150 – 190) |
| | | 0,400 | 1,7 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 560 (500 – 620) |
| P12 | E/M/A | 0.400 | 1.7 | 0.020 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.080 | 0.10 | 0.12 | 110 (94 – 120) |
| | | 0,400 | 1,7 | 0,00080 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0032 | 0,0040 | 0,0048 | 360 (310 – 390) |
| K1 | E/M/A | 0.400 | 1.7 | 0.034 | 0.044 | 0.055 | 0.065 | 0.090 | 0.11 | 0.13 | 0.16 | 0.19 | 225 (200 – 250) |
| | | 0,400 | 1,7 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0036 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 740 (660 – 820) |
| K2 | E/M/A | 0.400 | 1.7 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 200 (180 – 220) |
| | | 0,400 | 1,7 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 660 (600 – 720) |
| K3 | E/M/A | 0.400 | 1.7 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 170 (150 – 190) |
| | | 0,400 | 1,7 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 560 (500 – 620) |
| K4 | E/M/A | 0.400 | 1.7 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 160 (140 – 180) |
| | | 0,400 | 1,7 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 520 (460 – 590) |
| K5 | E/M/A | 0.400 | 1.7 | 0.028 | 0.036 | 0.046 | 0.055 | 0.075 | 0.090 | 0.11 | 0.14 | 0.16 | 100 (85 – 110) |
| | | 0,400 | 1,7 | 0,0011 | 0,0014 | 0,0018 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0055 | 0,0065 | 330 (280 – 360) |
| K6 | E/M/A | 0.400 | 1.7 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 140 (130 – 160) |
| | | 0,400 | 1,7 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 460 (430 – 520) |
| K7 | E/M/A | 0.400 | 1.7 | 0.028 | 0.036 | 0.046 | 0.055 | 0.075 | 0.090 | 0.11 | 0.14 | 0.16 | 125 (110 – 140) |
| | | 0,400 | 1,7 | 0,0011 | 0,0014 | 0,0018 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0055 | 0,0065 | 410 (370 – 450) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_r = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – JHP951 Nutfräsen

| SMG |  | a _p /DC | f _z | | | | | | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| P1 | E/M/A | 1,5 | 0,024 | 0,032 | 0,040 | 0,048 | 0,065 | 0,080 | 0,095 | 0,13 | 0,16 | 195 (170 – 220) |
| | | 1,5 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 640 (560 – 720) |
| P2 | E/M/A | 1,5 | 0,024 | 0,032 | 0,040 | 0,048 | 0,065 | 0,080 | 0,095 | 0,13 | 0,16 | 190 (170 – 210) |
| | | 1,5 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 620 (560 – 680) |
| P3 | E/M/A | 1,5 | 0,024 | 0,032 | 0,040 | 0,048 | 0,065 | 0,080 | 0,095 | 0,13 | 0,16 | 165 (150 – 180) |
| | | 1,5 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 540 (500 – 590) |
| P4 | E/M/A | 1,5 | 0,024 | 0,032 | 0,040 | 0,048 | 0,065 | 0,080 | 0,095 | 0,13 | 0,16 | 145 (130 – 160) |
| | | 1,5 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 475 (430 – 520) |
| P5 | E/M/A | 1,5 | 0,024 | 0,032 | 0,040 | 0,048 | 0,065 | 0,080 | 0,095 | 0,13 | 0,16 | 140 (120 – 150) |
| | | 1,5 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 460 (400 – 490) |
| P6 | E/M/A | 1,5 | 0,024 | 0,032 | 0,040 | 0,048 | 0,065 | 0,080 | 0,095 | 0,13 | 0,16 | 155 (140 – 170) |
| | | 1,5 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 510 (460 – 550) |
| P7 | E/M/A | 1,5 | 0,024 | 0,032 | 0,040 | 0,048 | 0,065 | 0,080 | 0,095 | 0,13 | 0,16 | 145 (130 – 160) |
| | | 1,5 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 475 (430 – 520) |
| P8 | E/M/A | 1,5 | 0,024 | 0,032 | 0,040 | 0,048 | 0,065 | 0,080 | 0,095 | 0,13 | 0,16 | 140 (120 – 150) |
| | | 1,5 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 460 (400 – 490) |
| P11 | E/M/A | 1,5 | 0,024 | 0,032 | 0,040 | 0,048 | 0,065 | 0,080 | 0,095 | 0,13 | 0,16 | 145 (130 – 160) |
| | | 1,5 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 475 (430 – 520) |
| P12 | E/M/A | 1,5 | 0,020 | 0,028 | 0,034 | 0,040 | 0,055 | 0,070 | 0,080 | 0,10 | 0,12 | 85 (75 – 99) |
| | | 1,5 | 0,00080 | 0,0011 | 0,0013 | 0,0016 | 0,0022 | 0,0028 | 0,0032 | 0,0040 | 0,0048 | 280 (250 – 320) |
| K1 | E/M/A | 1,5 | 0,024 | 0,032 | 0,040 | 0,048 | 0,065 | 0,080 | 0,095 | 0,13 | 0,16 | 195 (170 – 220) |
| | | 1,5 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 640 (560 – 720) |
| K2 | E/M/A | 1,5 | 0,024 | 0,032 | 0,040 | 0,048 | 0,065 | 0,080 | 0,095 | 0,13 | 0,16 | 170 (150 – 190) |
| | | 1,5 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 560 (500 – 620) |
| K3 | E/M/A | 1,5 | 0,024 | 0,032 | 0,040 | 0,048 | 0,065 | 0,080 | 0,095 | 0,13 | 0,16 | 140 (130 – 160) |
| | | 1,5 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 460 (430 – 520) |
| K4 | E/M/A | 1,5 | 0,024 | 0,032 | 0,040 | 0,048 | 0,065 | 0,080 | 0,095 | 0,13 | 0,16 | 135 (120 – 150) |
| | | 1,5 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 445 (400 – 490) |
| K5 | E/M/A | 1,5 | 0,024 | 0,032 | 0,040 | 0,048 | 0,065 | 0,080 | 0,095 | 0,13 | 0,15 | 80 (70 – 92) |
| | | 1,5 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0060 | 260 (230 – 300) |
| K6 | E/M/A | 1,5 | 0,024 | 0,032 | 0,040 | 0,048 | 0,065 | 0,080 | 0,095 | 0,13 | 0,16 | 120 (110 – 130) |
| | | 1,5 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 395 (370 – 420) |
| K7 | E/M/A | 1,5 | 0,024 | 0,032 | 0,040 | 0,048 | 0,065 | 0,080 | 0,095 | 0,13 | 0,15 | 105 (89 – 110) |
| | | 1,5 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0060 | 345 (300 – 360) |

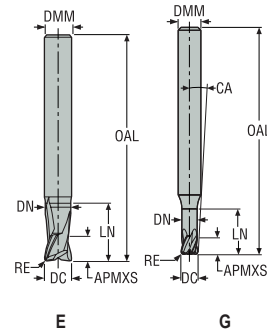
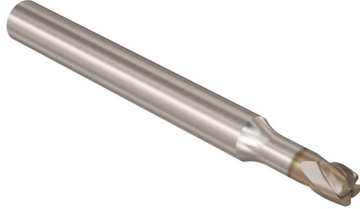
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

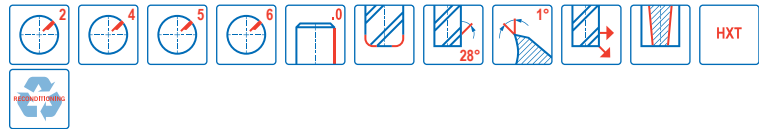
Unversell
 Stahl und Guss
 Rostfrei und ISO-S-Werkstoffe
 NE-Metalle
 Harter
 Kunststoffe und Composite
 Graphit
 X-Heads
 Minmaster Plus
 Minmaster

JH142

Hochgeschwindigkeitsfräsen – Hochpräzise – Torisch – Gehärteter Stahl – 2-6 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- Rundlaufabweichung = <math><0,005\text{ mm}</math>
- DMM = h5
- DC= 0-0,01 mm
- RE= $\pm 0,005\text{ mm}$
- Nachschleifen möglich, wenn DC $\geq \varnothing 6$ ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | CA° | PCEDC Zylindrisch | |
|------------------------|--------------------|------------------|-------------------|------|------|-------|------|------|------|-----|------|-------------------|---|
| | | | | mm | mm | mm | mm | mm | mm | mm | | | |
| JH142020G2R030.0Z2-HXT | 02968223 | 2 | G | 2,0 | 4,0 | 2,0 | 40,0 | 6,0 | 1,9 | 0,3 | 6,64 | 2 | ■ |
| JH142020G2R030.0Z4-HXT | 02968224 | 2 | G | 2,0 | 4,0 | 2,0 | 40,0 | 6,0 | 1,9 | 0,3 | 6,64 | 4 | ■ |
| JH142020G2R050.0Z2-HXT | 02968225 | 2 | G | 2,0 | 4,0 | 2,0 | 40,0 | 6,0 | 1,9 | 0,5 | 6,79 | 2 | ■ |
| JH142020G2R050.0Z4-HXT | 02968226 | 2 | G | 2,0 | 4,0 | 2,0 | 40,0 | 6,0 | 1,9 | 0,5 | 6,79 | 4 | ■ |
| JH142030G2R050.0Z2-HXT | 02968227 | 2 | G | 3,0 | 4,0 | 3,0 | 40,0 | 8,0 | 2,8 | 0,5 | 2,95 | 2 | ■ |
| JH142030G2R050.0Z4-HXT | 02968228 | 2 | G | 3,0 | 4,0 | 3,0 | 40,0 | 8,0 | 2,8 | 0,5 | 2,95 | 4 | ■ |
| JH142030G2R100.0Z2-HXT | 02968229 | 2 | G | 3,0 | 4,0 | 3,0 | 40,0 | 8,0 | 2,8 | 1,0 | 3,1 | 2 | ■ |
| JH142030G2R100.0Z4-HXT | 02968230 | 2 | G | 3,0 | 4,0 | 3,0 | 40,0 | 8,0 | 2,8 | 1,0 | 3,1 | 4 | ■ |
| JH142040G2R030.0Z2-HXT | 02968231 | 2 | G | 4,0 | 6,0 | 4,0 | 50,0 | 8,0 | 3,7 | 0,3 | 5,34 | 2 | ■ |
| JH142040G2R030.0Z4-HXT | 02970110 | 2 | G | 4,0 | 6,0 | 4,0 | 50,0 | 8,0 | 3,7 | 0,3 | 5,34 | 4 | ■ |
| JH142040G2R050.0Z4-HXT | 02968232 | 2 | G | 4,0 | 6,0 | 4,0 | 50,0 | 8,0 | 3,7 | 0,5 | 5,44 | 4 | ■ |
| JH142040G2R100.0Z4-HXT | 02968233 | 2 | G | 4,0 | 6,0 | 4,0 | 50,0 | 8,0 | 3,7 | 1,0 | 5,69 | 4 | ■ |
| JH142060E2R050.0Z4-HXT | 02968235 | 2 | E | 6,0 | 6,0 | 6,0 | 50,0 | 12,0 | 5,6 | 0,5 | - | 4 | ■ |
| JH142060E2R100.0Z4-HXT | 02968237 | 2 | E | 6,0 | 6,0 | 6,0 | 50,0 | 12,0 | 5,6 | 1,0 | - | 4 | ■ |
| JH142060E2R100.0Z5-HXT | 02968238 | 2 | E | 6,0 | 6,0 | 6,0 | 50,0 | 12,0 | 5,6 | 1,0 | - | 5 | ■ |
| JH142060E2R150.0Z5-HXT | 02968240 | 2 | E | 6,0 | 6,0 | 6,0 | 50,0 | 12,0 | 5,6 | 1,5 | - | 5 | ■ |
| JH142060E2R200.0Z5-HXT | 02968241 | 2 | E | 6,0 | 6,0 | 6,0 | 50,0 | 12,0 | 5,6 | 2,0 | - | 5 | ■ |
| JH142080E2R050.0Z5-HXT | 02968242 | 2 | E | 8,0 | 8,0 | 8,0 | 60,0 | 16,0 | 7,4 | 0,5 | - | 5 | ■ |
| JH142080E2R100.0Z5-HXT | 02968243 | 2 | E | 8,0 | 8,0 | 8,0 | 60,0 | 16,0 | 7,4 | 1,0 | - | 5 | ■ |
| JH142080E2R150.0Z5-HXT | 02968244 | 2 | E | 8,0 | 8,0 | 8,0 | 60,0 | 16,0 | 7,4 | 1,5 | - | 5 | ■ |
| JH142080E2R200.0Z5-HXT | 02968245 | 2 | E | 8,0 | 8,0 | 8,0 | 60,0 | 16,0 | 7,4 | 2,0 | - | 5 | ■ |
| JH142080E2R300.0Z5-HXT | 02968246 | 2 | E | 8,0 | 8,0 | 8,0 | 60,0 | 16,0 | 7,4 | 3,0 | - | 5 | ■ |
| JH142100E2R050.0Z5-HXT | 02968247 | 2 | E | 10,0 | 10,0 | 10,0 | 70,0 | 20,0 | 9,4 | 0,5 | - | 5 | ■ |
| JH142100E2R100.0Z5-HXT | 02968248 | 2 | E | 10,0 | 10,0 | 10,0 | 70,0 | 20,0 | 9,4 | 1,0 | - | 5 | ■ |
| JH142100E2R200.0Z5-HXT | 02968249 | 2 | E | 10,0 | 10,0 | 10,0 | 70,0 | 20,0 | 9,4 | 2,0 | - | 5 | ■ |
| JH142100E2R250.0Z5-HXT | 02968250 | 2 | E | 10,0 | 10,0 | 10,0 | 70,0 | 20,0 | 9,4 | 2,5 | - | 5 | ■ |
| JH142120E2R100.0Z6-HXT | 02968251 | 2 | E | 12,0 | 12,0 | 12,0 | 75,0 | 24,0 | 11,4 | 1,0 | - | 6 | ■ |
| JH142120E2R200.0Z6-HXT | 02968252 | 2 | E | 12,0 | 12,0 | 12,0 | 75,0 | 24,0 | 11,4 | 2,0 | - | 6 | ■ |
| JH142120E2R300.0Z6-HXT | 02968253 | 2 | E | 12,0 | 12,0 | 12,0 | 75,0 | 24,0 | 11,4 | 3,0 | - | 6 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

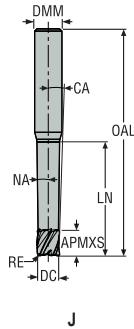
X-Heads

Minimaster Plus

Minimaster

JH142

Hochgeschwindigkeitsfräsen – Hochpräzise – Torisch – Gehärteter Stahl – 2-5 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | CA° | PCEDC Zylindrisch |
|------------------------|----------------|--------------|---------------|------|------|-------|-------|------|-----|-----|------|-------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | |
| JH142020J3R030.0Z2-HXT | 02968255 | 3 | J | 2,0 | 6,0 | 2,0 | 60,0 | 10,0 | 1,9 | 0,3 | 6,72 | 2 |
| JH142020J3R030.0Z4-HXT | 02968256 | 3 | J | 2,0 | 6,0 | 2,0 | 60,0 | 10,0 | 1,9 | 0,3 | 6,72 | 4 |
| JH142020J3R050.0Z2-HXT | 02968257 | 3 | J | 2,0 | 6,0 | 2,0 | 60,0 | 10,0 | 1,9 | 0,5 | 6,79 | 2 |
| JH142020J3R050.0Z4-HXT | 02968258 | 3 | J | 2,0 | 6,0 | 2,0 | 60,0 | 10,0 | 1,9 | 0,5 | 6,79 | 4 |
| JH142030J3R050.0Z2-HXT | 02968259 | 3 | J | 3,0 | 6,0 | 3,0 | 60,0 | 15,0 | 2,8 | 0,5 | 4,3 | 2 |
| JH142030J3R050.0Z4-HXT | 02968260 | 3 | J | 3,0 | 6,0 | 3,0 | 60,0 | 15,0 | 2,8 | 0,5 | 4,3 | 4 |
| JH142030J3R100.0Z2-HXT | 02968261 | 3 | J | 3,0 | 6,0 | 3,0 | 60,0 | 15,0 | 2,8 | 1,0 | 4,4 | 2 |
| JH142030J3R100.0Z4-HXT | 02968262 | 3 | J | 3,0 | 6,0 | 3,0 | 60,0 | 15,0 | 2,8 | 1,0 | 4,4 | 4 |
| JH142040J3R030.0Z2-HXT | 02968263 | 3 | J | 4,0 | 6,0 | 4,0 | 60,0 | 20,0 | 3,7 | 0,3 | 2,45 | 2 |
| JH142040J3R030.0Z4-HXT | 02970111 | 3 | J | 4,0 | 6,0 | 4,0 | 60,0 | 20,0 | 3,7 | 0,3 | 2,45 | 4 |
| JH142040J3R050.0Z2-HXT | 02968265 | 3 | J | 4,0 | 6,0 | 4,0 | 60,0 | 20,0 | 3,7 | 0,5 | 2,48 | 2 |
| JH142040J3R050.0Z4-HXT | 02968264 | 3 | J | 4,0 | 6,0 | 4,0 | 60,0 | 20,0 | 3,7 | 0,5 | 2,48 | 4 |
| JH142040J3R100.0Z2-HXT | 02968266 | 3 | J | 4,0 | 6,0 | 4,0 | 60,0 | 20,0 | 3,7 | 1,0 | 2,53 | 2 |
| JH142040J3R100.0Z4-HXT | 02968267 | 3 | J | 4,0 | 6,0 | 4,0 | 60,0 | 20,0 | 3,7 | 1,0 | 2,53 | 4 |
| JH142060J3R050.0Z4-HXT | 02968268 | 3 | J | 6,0 | 8,0 | 6,0 | 75,0 | 30,0 | 5,6 | 0,5 | 1,75 | 4 |
| JH142060J3R050.0Z5-HXT | 02968269 | 3 | J | 6,0 | 8,0 | 6,0 | 75,0 | 30,0 | 5,6 | 0,5 | 1,75 | 5 |
| JH142060J3R100.0Z4-HXT | 02968270 | 3 | J | 6,0 | 8,0 | 6,0 | 75,0 | 30,0 | 5,6 | 1,0 | 1,77 | 4 |
| JH142060J3R100.0Z5-HXT | 02968271 | 3 | J | 6,0 | 8,0 | 6,0 | 75,0 | 30,0 | 5,6 | 1,0 | 1,77 | 5 |
| JH142060J3R150.0Z5-HXT | 02968272 | 3 | J | 6,0 | 8,0 | 6,0 | 75,0 | 30,0 | 5,6 | 1,5 | 1,8 | 5 |
| JH142060J3R200.0Z5-HXT | 02968273 | 3 | J | 6,0 | 8,0 | 6,0 | 75,0 | 30,0 | 5,6 | 2,0 | 1,83 | 5 |
| JH142080J3R050.0Z5-HXT | 02968274 | 3 | J | 8,0 | 10,0 | 8,0 | 85,0 | 40,0 | 7,4 | 0,5 | 1,34 | 5 |
| JH142080J3R100.0Z5-HXT | 02968275 | 3 | J | 8,0 | 10,0 | 8,0 | 85,0 | 40,0 | 7,4 | 1,0 | 1,36 | 5 |
| JH142080J3R150.0Z5-HXT | 02968276 | 3 | J | 8,0 | 10,0 | 8,0 | 85,0 | 40,0 | 7,4 | 1,5 | 1,37 | 5 |
| JH142080J3R200.0Z5-HXT | 02968277 | 3 | J | 8,0 | 10,0 | 8,0 | 85,0 | 40,0 | 7,4 | 2,0 | 1,39 | 5 |
| JH142100J3R050.0Z5-HXT | 02968278 | 3 | J | 10,0 | 12,0 | 10,0 | 100,0 | 50,0 | 9,4 | 0,5 | 1,1 | 5 |
| JH142100J3R100.0Z5-HXT | 02968279 | 3 | J | 10,0 | 12,0 | 10,0 | 100,0 | 50,0 | 9,4 | 1,0 | 1,11 | 5 |
| JH142100J3R200.0Z5-HXT | 02968280 | 3 | J | 10,0 | 12,0 | 10,0 | 100,0 | 50,0 | 9,4 | 2,0 | 1,13 | 5 |
| JH142020J6R030.0Z4-HXT | 02968282 | 6 | J | 2,0 | 6,0 | 2,0 | 75,0 | 20,0 | 1,9 | 0,3 | 4,33 | 4 |
| JH142020J6R050.0Z4-HXT | 02968283 | 6 | J | 2,0 | 6,0 | 2,0 | 75,0 | 20,0 | 1,9 | 0,5 | 4,36 | 4 |
| JH142030J6R050.0Z4-HXT | 02968284 | 6 | J | 3,0 | 6,0 | 3,0 | 75,0 | 30,0 | 2,8 | 0,5 | 2,52 | 4 |
| JH142030J6R100.0Z4-HXT | 02968285 | 6 | J | 3,0 | 6,0 | 3,0 | 75,0 | 30,0 | 2,8 | 1,0 | 2,56 | 4 |
| JH142040J6R030.0Z4-HXT | 02968286 | 6 | J | 4,0 | 6,0 | 4,0 | 80,0 | 40,0 | 3,7 | 0,3 | 1,36 | 4 |
| JH142040J6R050.0Z4-HXT | 02968287 | 6 | J | 4,0 | 6,0 | 4,0 | 80,0 | 40,0 | 3,7 | 0,5 | 1,37 | 4 |
| JH142040J6R100.0Z4-HXT | 02968288 | 6 | J | 4,0 | 6,0 | 4,0 | 80,0 | 40,0 | 3,7 | 1,0 | 1,38 | 4 |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JH142 Kopierfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | v _c |
|-----|-----|--------------------|--------------------|----------------|---------|---------|--------|--------|--------|--------|--------|--------------------|
| | | | | 2 | 3 | 4 | 6 | 8 | 10 | 12 | 16 | |
| P1 | M/E | 0.0500 | 0.050 | 0.020 | 0.030 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 0.14 | 485 (460 – 530) |
| | | 0,0500 | 0,050 | 0,00080 | 0,0012 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0055 | 1600 (1600 – 1700) |
| P2 | M/E | 0.0500 | 0.050 | 0.020 | 0.030 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 470 (450 – 520) |
| | | 0,0500 | 0,050 | 0,00080 | 0,0012 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 1550 (1500 – 1700) |
| P3 | M/E | 0.0500 | 0.050 | 0.019 | 0.028 | 0.038 | 0.055 | 0.075 | 0.095 | 0.11 | 0.14 | 405 (390 – 450) |
| | | 0,0500 | 0,050 | 0,00075 | 0,0011 | 0,0015 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0055 | 1325 (1300 – 1400) |
| P4 | M/E | 0.0500 | 0.050 | 0.019 | 0.028 | 0.038 | 0.055 | 0.075 | 0.095 | 0.11 | 0.14 | 360 (340 – 390) |
| | | 0,0500 | 0,050 | 0,00075 | 0,0011 | 0,0015 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0055 | 1175 (1200 – 1200) |
| P5 | M/E | 0.0500 | 0.050 | 0.018 | 0.028 | 0.036 | 0.055 | 0.075 | 0.090 | 0.11 | 0.13 | 345 (330 – 380) |
| | | 0,0500 | 0,050 | 0,00070 | 0,0011 | 0,0014 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 1125 (1100 – 1200) |
| P6 | M/E | 0.0500 | 0.050 | 0.018 | 0.028 | 0.036 | 0.055 | 0.070 | 0.090 | 0.11 | 0.13 | 385 (370 – 420) |
| | | 0,0500 | 0,050 | 0,00070 | 0,0011 | 0,0014 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0050 | 1275 (1300 – 1300) |
| P7 | M/E | 0.0500 | 0.050 | 0.018 | 0.028 | 0.036 | 0.055 | 0.070 | 0.090 | 0.11 | 0.13 | 365 (350 – 400) |
| | | 0,0500 | 0,050 | 0,00070 | 0,0011 | 0,0014 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0050 | 1200 (1200 – 1300) |
| P8 | M/E | 0.0500 | 0.050 | 0.019 | 0.028 | 0.038 | 0.055 | 0.075 | 0.095 | 0.11 | 0.14 | 340 (330 – 380) |
| | | 0,0500 | 0,050 | 0,00075 | 0,0011 | 0,0015 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0055 | 1125 (1100 – 1200) |
| P11 | M/E | 0.0500 | 0.050 | 0.018 | 0.028 | 0.036 | 0.055 | 0.070 | 0.090 | 0.11 | 0.13 | 355 (340 – 390) |
| | | 0,0500 | 0,050 | 0,00070 | 0,0011 | 0,0014 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0050 | 1175 (1200 – 1200) |
| K1 | A/E | 0.0500 | 0.050 | 0.018 | 0.028 | 0.036 | 0.055 | 0.075 | 0.090 | 0.11 | 0.13 | 345 (330 – 380) |
| | | 0,0500 | 0,050 | 0,00070 | 0,0011 | 0,0014 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 1125 (1100 – 1200) |
| K2 | A/E | 0.0500 | 0.050 | 0.017 | 0.025 | 0.034 | 0.050 | 0.065 | 0.085 | 0.10 | 0.12 | 300 (290 – 330) |
| | | 0,0500 | 0,050 | 0,00065 | 0,0010 | 0,0013 | 0,0020 | 0,0026 | 0,0034 | 0,0040 | 0,0048 | 980 (960 – 1000) |
| K3 | A/E | 0.0500 | 0.050 | 0.017 | 0.025 | 0.034 | 0.050 | 0.065 | 0.085 | 0.10 | 0.12 | 255 (240 – 280) |
| | | 0,0500 | 0,050 | 0,00065 | 0,0010 | 0,0013 | 0,0020 | 0,0026 | 0,0034 | 0,0040 | 0,0048 | 840 (790 – 910) |
| K4 | A/E | 0.0500 | 0.050 | 0.017 | 0.025 | 0.034 | 0.050 | 0.065 | 0.085 | 0.10 | 0.12 | 245 (230 – 260) |
| | | 0,0500 | 0,050 | 0,00065 | 0,0010 | 0,0013 | 0,0020 | 0,0026 | 0,0034 | 0,0040 | 0,0048 | 800 (760 – 850) |
| K5 | A/E | 0.0500 | 0.050 | 0.018 | 0.028 | 0.036 | 0.055 | 0.075 | 0.090 | 0.11 | 0.13 | 345 (330 – 380) |
| | | 0,0500 | 0,050 | 0,00070 | 0,0011 | 0,0014 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 1125 (1100 – 1200) |
| K6 | A/E | 0.0500 | 0.050 | 0.020 | 0.030 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 500 (480 – 550) |
| | | 0,0500 | 0,050 | 0,00080 | 0,0012 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 1650 (1600 – 1800) |
| K7 | A/E | 0.0500 | 0.050 | 0.018 | 0.028 | 0.036 | 0.055 | 0.075 | 0.090 | 0.11 | 0.13 | 440 (420 – 490) |
| | | 0,0500 | 0,050 | 0,00070 | 0,0011 | 0,0014 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 1450 (1400 – 1600) |
| H3 | M/A | 0.0200 | 0.020 | 0.014 | 0.020 | 0.028 | 0.042 | 0.055 | 0.070 | 0.080 | 0.10 | 95 (72 – 110) |
| | | 0,0200 | 0,020 | 0,00055 | 0,00080 | 0,0011 | 0,0017 | 0,0022 | 0,0028 | 0,0032 | 0,0040 | 310 (240 – 360) |
| H5 | M/A | 0.0400 | 0.040 | 0.014 | 0.022 | 0.028 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 305 (290 – 330) |
| | | 0,0400 | 0,040 | 0,00055 | 0,00085 | 0,0011 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 1000 (960 – 1000) |
| H7 | M/A | 0.0200 | 0.020 | 0.014 | 0.020 | 0.028 | 0.042 | 0.055 | 0.070 | 0.080 | 0.10 | 95 (72 – 110) |
| | | 0,0200 | 0,020 | 0,00055 | 0,00080 | 0,0011 | 0,0017 | 0,0022 | 0,0028 | 0,0032 | 0,0040 | 310 (240 – 360) |
| H8 | M/A | 0.0400 | 0.040 | 0.011 | 0.016 | 0.022 | 0.032 | 0.042 | 0.055 | 0.065 | 0.080 | 310 (290 – 330) |
| | | 0,0400 | 0,040 | 0,00044 | 0,00065 | 0,00085 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 1025 (960 – 1000) |
| H11 | M/A | 0.0400 | 0.040 | 0.014 | 0.022 | 0.028 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 390 (360 – 420) |
| | | 0,0400 | 0,040 | 0,00055 | 0,00085 | 0,0011 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 1275 (1200 – 1300) |
| H12 | M/A | 0.0500 | 0.050 | 0.0095 | 0.014 | 0.019 | 0.028 | 0.038 | 0.046 | 0.055 | 0.070 | 345 (320 – 370) |
| | | 0,0500 | 0,050 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0018 | 0,0022 | 0,0028 | 1125 (1100 – 1200) |
| H21 | M/A | 0.0400 | 0.040 | 0.011 | 0.016 | 0.022 | 0.032 | 0.042 | 0.055 | 0.065 | 0.080 | 310 (290 – 330) |
| | | 0,0400 | 0,040 | 0,00044 | 0,00065 | 0,00085 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 1025 (960 – 1000) |
| H31 | M/A | 0.0300 | 0.030 | 0.013 | 0.019 | 0.025 | 0.038 | 0.050 | 0.065 | 0.075 | 0.090 | 140 (120 – 160) |
| | | 0,0300 | 0,030 | 0,00050 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 0,0036 | 460 (400 – 520) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

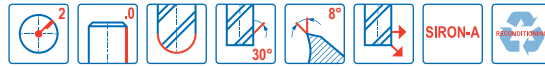
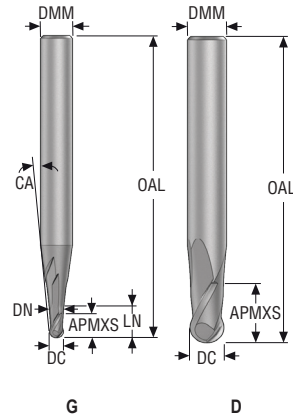
a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

JHB970

Hochgeschwindigkeitsfräsen – Universell – Kugelkopf – 2 Schneiden – Zylindrisch



- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | CA° | PCEDC | Zylindrisch |
|------------------|--------------|----------------|--------------|---------------|------|------|-------|-------|------|-----|-----|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | | | |
| JHB970020G1B.0Z2 | SIRA | 10072058 | 1 | G | 2,0 | 3,0 | 3,0 | 50,0 | 10,0 | 1,9 | 2,5 | 2 | ■ |
| JHB970030D1B.0Z2 | SIRA | 10072059 | 1 | D | 3,0 | 3,0 | 4,5 | 50,0 | – | – | – | 2 | ■ |
| JHB970040D1B.0Z2 | SIRA | 10072060 | 1 | D | 4,0 | 4,0 | 6,0 | 60,0 | – | – | – | 2 | ■ |
| JHB970050D1B.0Z2 | SIRA | 10072061 | 1 | D | 5,0 | 5,0 | 7,5 | 60,0 | – | – | – | 2 | ■ |
| JHB970060D1B.0Z2 | SIRA | 10072062 | 1 | D | 6,0 | 6,0 | 9,0 | 75,0 | – | – | – | 2 | ■ |
| JHB970020G2B.0Z2 | SIRA | 10072063 | 2 | G | 2,0 | 6,0 | 3,0 | 60,0 | 4,0 | 1,9 | 8,0 | 2 | ■ |
| JHB970025G2B.0Z2 | SIRA | 10072064 | 2 | G | 2,5 | 6,0 | 4,0 | 60,0 | 5,0 | 2,4 | 7,5 | 2 | ■ |
| JHB970030G2B.0Z2 | SIRA | 10072065 | 2 | G | 3,0 | 6,0 | 4,5 | 60,0 | 6,0 | 2,8 | 5,5 | 2 | ■ |
| JHB970035G2B.0Z2 | SIRA | 10072066 | 2 | G | 3,5 | 6,0 | 5,0 | 60,0 | 7,0 | 3,2 | 4,5 | 2 | ■ |
| JHB970040G2B.0Z2 | SIRA | 10072067 | 2 | G | 4,0 | 6,0 | 6,0 | 60,0 | 8,0 | 3,7 | 3,0 | 2 | ■ |
| JHB970050G2B.0Z2 | SIRA | 10072068 | 2 | G | 5,0 | 6,0 | 7,5 | 60,0 | 10,0 | 4,6 | 2,0 | 2 | ■ |
| JHB970060G2B.0Z2 | SIRA | 10072069 | 2 | G | 6,0 | 8,0 | 9,0 | 75,0 | 12,0 | 5,6 | 2,5 | 2 | ■ |
| JHB970080D2B.0Z2 | SIRA | 10072070 | 2 | D | 8,0 | 8,0 | 12,0 | 75,0 | – | – | – | 2 | ■ |
| JHB970100D2B.0Z2 | SIRA | 10072071 | 2 | D | 10,0 | 10,0 | 15,0 | 80,0 | – | – | – | 2 | ■ |
| JHB970120D2B.0Z2 | SIRA | 10072072 | 2 | D | 12,0 | 12,0 | 18,0 | 90,0 | – | – | – | 2 | ■ |
| JHB970160D2B.0Z2 | SIRA | 10072073 | 2 | D | 16,0 | 16,0 | 24,0 | 100,0 | – | – | – | 2 | ■ |
| JHB970020G3B.0Z2 | SIRA | 10072074 | 3 | G | 2,0 | 6,0 | 3,0 | 80,0 | 4,0 | 1,9 | 8,0 | 2 | ■ |
| JHB970030G3B.0Z2 | SIRA | 10072075 | 3 | G | 3,0 | 6,0 | 4,5 | 80,0 | 6,0 | 2,8 | 5,5 | 2 | ■ |
| JHB970040G3B.0Z2 | SIRA | 10072076 | 3 | G | 4,0 | 6,0 | 6,0 | 80,0 | 8,0 | 3,7 | 3,0 | 2 | ■ |
| JHB970060G3B.0Z2 | SIRA | 10072077 | 3 | G | 6,0 | 8,0 | 9,0 | 100,0 | 12,0 | 5,6 | 2,5 | 2 | ■ |
| JHB970080D3B.0Z2 | SIRA | 10072078 | 3 | D | 8,0 | 8,0 | 12,0 | 108,0 | – | – | – | 2 | ■ |
| JHB970100D3B.0Z2 | SIRA | 10072079 | 3 | D | 10,0 | 10,0 | 15,0 | 125,0 | – | – | – | 2 | ■ |
| JHB970120D3B.0Z2 | SIRA | 10072080 | 3 | D | 12,0 | 12,0 | 18,0 | 125,0 | – | – | – | 2 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JHB970 Kopierfräsen/Schruppen

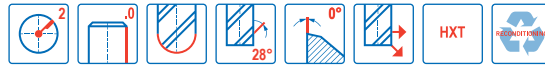
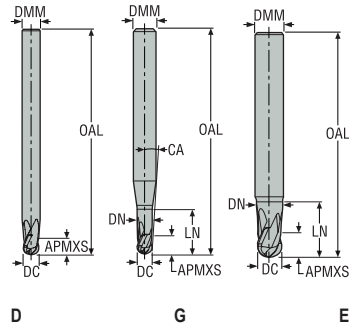
| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|--------|-----------------|
| | | | | 2 | 2.5 | 3 | 3.5 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | |
| P1 | M | 0.200 | 1.0 | 0.011 | 0.014 | 0.016 | 0.019 | 0.022 | 0.028 | 0.032 | 0.044 | 0.055 | 0.065 | 0.080 | 210 (190 – 230) |
| | | 0,200 | 1,0 | 0,00044 | 0,00055 | 0,00065 | 0,00075 | 0,00085 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 690 (630 – 750) |
| P2 | M | 0.200 | 1.0 | 0.011 | 0.014 | 0.017 | 0.019 | 0.022 | 0.028 | 0.034 | 0.044 | 0.055 | 0.065 | 0.080 | 205 (180 – 230) |
| | | 0,200 | 1,0 | 0,00044 | 0,00055 | 0,00065 | 0,00075 | 0,00085 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 670 (600 – 750) |
| P3 | M | 0.200 | 1.0 | 0.010 | 0.013 | 0.016 | 0.018 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 0.075 | 180 (160 – 200) |
| | | 0,200 | 1,0 | 0,00040 | 0,00050 | 0,00065 | 0,00070 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 590 (530 – 650) |
| P4 | M | 0.200 | 1.0 | 0.010 | 0.013 | 0.015 | 0.018 | 0.020 | 0.026 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 155 (140 – 170) |
| | | 0,200 | 1,0 | 0,00040 | 0,00050 | 0,00060 | 0,00070 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 510 (460 – 550) |
| P5 | M | 0.200 | 1.0 | 0.010 | 0.012 | 0.015 | 0.018 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 150 (140 – 170) |
| | | 0,200 | 1,0 | 0,00040 | 0,00048 | 0,00060 | 0,00065 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 490 (460 – 550) |
| P6 | M | 0.200 | 1.0 | 0.010 | 0.012 | 0.015 | 0.017 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 170 (150 – 190) |
| | | 0,200 | 1,0 | 0,00040 | 0,00048 | 0,00060 | 0,00065 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 560 (500 – 620) |
| P7 | M | 0.200 | 1.0 | 0.010 | 0.012 | 0.015 | 0.017 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 160 (140 – 180) |
| | | 0,200 | 1,0 | 0,00040 | 0,00048 | 0,00060 | 0,00065 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 520 (460 – 590) |
| P8 | M | 0.200 | 1.0 | 0.010 | 0.013 | 0.016 | 0.018 | 0.020 | 0.026 | 0.032 | 0.042 | 0.050 | 0.060 | 0.075 | 150 (140 – 170) |
| | | 0,200 | 1,0 | 0,00040 | 0,00050 | 0,00065 | 0,00070 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 490 (460 – 550) |
| P11 | M | 0.200 | 1.0 | 0.010 | 0.012 | 0.015 | 0.017 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 75 (67 – 86) |
| | | 0,200 | 1,0 | 0,00040 | 0,00048 | 0,00060 | 0,00065 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 245 (220 – 280) |
| P12 | M | 0.200 | 1.0 | 0.0070 | 0.0085 | 0.010 | 0.012 | 0.014 | 0.017 | 0.020 | 0.028 | 0.034 | 0.040 | 0.050 | 48 (42 – 53) |
| | | 0,200 | 1,0 | 0,00028 | 0,00034 | 0,00040 | 0,00048 | 0,00055 | 0,00065 | 0,00080 | 0,0011 | 0,0013 | 0,0016 | 0,0020 | 155 (140 – 170) |
| M1 | E | 0.200 | 1.0 | 0.0090 | 0.011 | 0.013 | 0.015 | 0.018 | 0.022 | 0.026 | 0.036 | 0.044 | 0.050 | 0.065 | 90 (80 – 100) |
| | | 0,200 | 1,0 | 0,00036 | 0,00044 | 0,00050 | 0,00060 | 0,00070 | 0,00085 | 0,0010 | 0,0014 | 0,0017 | 0,0020 | 0,0026 | 295 (270 – 320) |
| M2 | E | 0.200 | 1.0 | 0.0080 | 0.010 | 0.012 | 0.014 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 75 (65 – 85) |
| | | 0,200 | 1,0 | 0,00032 | 0,00040 | 0,00048 | 0,00055 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 245 (220 – 270) |
| M3 | E | 0.150 | 1.0 | 0.0060 | 0.0075 | 0.0090 | 0.010 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.044 | 65 (55 – 75) |
| | | 0,150 | 1,0 | 0,00024 | 0,00030 | 0,00036 | 0,00040 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0017 | 215 (190 – 240) |
| M4 | E | 0.150 | 1.0 | 0.0050 | 0.0065 | 0.0080 | 0.0090 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.038 | 49 (42 – 56) |
| | | 0,150 | 1,0 | 0,00020 | 0,00026 | 0,00032 | 0,00036 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0015 | 160 (140 – 180) |
| M5 | E | 0.150 | 1.0 | 0.0050 | 0.0065 | 0.0080 | 0.0090 | 0.010 | 0.013 | 0.016 | 0.020 | 0.026 | 0.032 | 0.038 | 41 (35 – 47) |
| | | 0,150 | 1,0 | 0,00020 | 0,00026 | 0,00032 | 0,00036 | 0,00040 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0015 | 135 (120 – 150) |
| S1 | E | 0.100 | 0.80 | 0.0060 | 0.0075 | 0.0090 | 0.010 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.044 | 50 (40 – 59) |
| | | 0,100 | 0,80 | 0,00024 | 0,00030 | 0,00036 | 0,00040 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0017 | 165 (140 – 190) |
| S2 | E | 0.100 | 0.80 | 0.0060 | 0.0075 | 0.0090 | 0.010 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.044 | 40 (33 – 48) |
| | | 0,100 | 0,80 | 0,00024 | 0,00030 | 0,00036 | 0,00040 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0017 | 130 (110 – 150) |
| S3 | E | 0.100 | 0.60 | 0.0040 | 0.0050 | 0.0060 | 0.0070 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.028 | 30 (20 – 39) |
| | | 0,100 | 0,60 | 0,00016 | 0,00020 | 0,00024 | 0,00028 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0011 | 100 (66 – 120) |
| S11 | E | 0.200 | 1.0 | 0.010 | 0.012 | 0.015 | 0.018 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 90 (79 – 100) |
| | | 0,200 | 1,0 | 0,00040 | 0,00048 | 0,00060 | 0,00065 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 295 (260 – 320) |
| S12 | E | 0.200 | 1.0 | 0.010 | 0.012 | 0.015 | 0.018 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 70 (61 – 80) |
| | | 0,200 | 1,0 | 0,00040 | 0,00048 | 0,00060 | 0,00065 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 230 (210 – 260) |
| S13 | E | 0.200 | 1.0 | 0.0085 | 0.011 | 0.013 | 0.015 | 0.017 | 0.022 | 0.026 | 0.034 | 0.044 | 0.050 | 0.065 | 55 (48 – 63) |
| | | 0,200 | 1,0 | 0,00034 | 0,00044 | 0,00050 | 0,00060 | 0,00065 | 0,00085 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0026 | 180 (160 – 200) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

JH112

Hochgeschwindigkeitsfräsen – Hochpräzise – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch



- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | CA° | PCEDC | Zylindrisch |
|---------------------|----------------|--------------|---------------|------|------|-------|-------|------|------|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | | | |
| JH112020G1B.0Z2-HXT | 02970112 | 1 | G | 2,0 | 4,0 | 2,0 | 40,0 | 4,0 | 1,9 | 6,45 | 2 | ■ |
| JH112030G1B.0Z2-HXT | 02970113 | 1 | G | 3,0 | 4,0 | 3,0 | 40,0 | 6,0 | 2,8 | 3,3 | 2 | ■ |
| JH112040D1B.0Z2-HXT | 02970114 | 1 | D | 4,0 | 4,0 | 4,0 | 40,0 | - | - | - | 2 | ■ |
| JH112050G1B.0Z2-HXT | 02970115 | 1 | G | 5,0 | 6,0 | 5,0 | 50,0 | 10,0 | 4,6 | 2,0 | 2 | ■ |
| JH112060D1B.0Z2-HXT | 02970116 | 1 | D | 6,0 | 6,0 | 6,0 | 50,0 | - | - | - | 2 | ■ |
| JH112080D1B.0Z2-HXT | 02970117 | 1 | D | 8,0 | 8,0 | 8,0 | 65,0 | - | - | - | 2 | ■ |
| JH112100D1B.0Z2-HXT | 02970118 | 1 | D | 10,0 | 10,0 | 10,0 | 65,0 | - | - | - | 2 | ■ |
| JH112020G2B.0Z2-HXT | 02970119 | 2 | G | 2,0 | 3,0 | 2,0 | 50,0 | 10,0 | 1,9 | 2,5 | 2 | ■ |
| JH112030D2B.0Z2-HXT | 02970120 | 2 | D | 3,0 | 3,0 | 3,0 | 50,0 | - | - | - | 2 | ■ |
| JH112040D2B.0Z2-HXT | 02970121 | 2 | D | 4,0 | 4,0 | 4,0 | 60,0 | - | - | - | 2 | ■ |
| JH112050D2B.0Z2-HXT | 02970122 | 2 | D | 5,0 | 5,0 | 5,0 | 60,0 | - | - | - | 2 | ■ |
| JH112060D2B.0Z2-HXT | 02970123 | 2 | D | 6,0 | 6,0 | 6,0 | 75,0 | - | - | - | 2 | ■ |
| JH112020G3B.0Z2-HXT | 02970124 | 3 | G | 2,0 | 6,0 | 2,0 | 60,0 | 4,0 | 1,9 | 8,12 | 2 | ■ |
| JH112025G3B.0Z2-HXT | 02970125 | 3 | G | 2,5 | 6,0 | 2,5 | 60,0 | 5,0 | 2,4 | 7,39 | 2 | ■ |
| JH112030G3B.0Z2-HXT | 02970126 | 3 | G | 3,0 | 6,0 | 3,0 | 60,0 | 6,0 | 2,8 | 5,5 | 2 | ■ |
| JH112035G3B.0Z2-HXT | 02968289 | 3 | G | 3,5 | 6,0 | 3,5 | 65,0 | 7,0 | 3,2 | 3,81 | 2 | ■ |
| JH112040G3B.0Z2-HXT | 02970127 | 3 | G | 4,0 | 6,0 | 4,0 | 65,0 | 8,0 | 3,7 | 3,34 | 2 | ■ |
| JH112050G3B.0Z2-HXT | 02970128 | 3 | G | 5,0 | 6,0 | 5,0 | 65,0 | 10,0 | 4,6 | 2,0 | 2 | ■ |
| JH112060G3B.0Z2-HXT | 02970129 | 3 | G | 6,0 | 8,0 | 6,0 | 75,0 | 12,0 | 5,6 | 2,78 | 2 | ■ |
| JH112080E3B.0Z2-HXT | 02968290 | 3 | E | 8,0 | 8,0 | 8,0 | 75,0 | 16,0 | 7,4 | - | 2 | ■ |
| JH112100E3B.0Z2-HXT | 02968291 | 3 | E | 10,0 | 10,0 | 10,0 | 80,0 | 20,0 | 9,4 | - | 2 | ■ |
| JH112120E3B.0Z2-HXT | 02968292 | 3 | E | 12,0 | 12,0 | 12,0 | 90,0 | 24,0 | 11,4 | - | 2 | ■ |
| JH112020G4B.0Z2-HXT | 02970130 | 4 | G | 2,0 | 6,0 | 2,0 | 80,0 | 20,0 | 1,9 | 3,82 | 2 | ■ |
| JH112030G4B.0Z2-HXT | 02970131 | 4 | G | 3,0 | 6,0 | 3,0 | 80,0 | 20,0 | 2,8 | 2,91 | 2 | ■ |
| JH112040G4B.0Z2-HXT | 02970132 | 4 | G | 4,0 | 6,0 | 4,0 | 80,0 | 20,0 | 3,7 | 1,97 | 2 | ■ |
| JH112050G4B.0Z2-HXT | 02970133 | 4 | G | 5,0 | 6,0 | 5,0 | 100,0 | 50,0 | 4,6 | 0,53 | 2 | ■ |
| JH112060D4B.0Z2-HXT | 02968293 | 4 | D | 6,0 | 6,0 | 6,0 | 100,0 | - | - | - | 2 | ■ |
| JH112080D4B.0Z2-HXT | 02968294 | 4 | D | 8,0 | 8,0 | 8,0 | 110,0 | - | - | - | 2 | ■ |
| JH112100D4B.0Z2-HXT | 02968295 | 4 | D | 10,0 | 10,0 | 10,0 | 125,0 | - | - | - | 2 | ■ |
| JH112120D4B.0Z2-HXT | 02968296 | 4 | D | 12,0 | 12,0 | 12,0 | 125,0 | - | - | - | 2 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

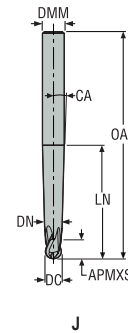
X-Heads

Minimaster Plus

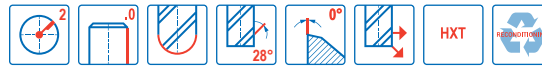
Minimaster

JH112

Hochgeschwindigkeitsfräsen – Hochpräzise – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch



- Toleranzen:
- Rundlaufabweichung = <math><0,005\text{ mm}</math>
- DMM = h5
- DC= 0-0,01 mm
- RE= $\pm 0,005\text{ mm}$
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | CA° | PCEDC | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|-----|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | | | |
| JH112020J5B.0Z2-HXT | 02970134 | 5 | J | 2,0 | 6,0 | 2,0 | 80,0 | 35,0 | 1,9 | 3,3 | 2 | ■ |
| JH112030J5B.0Z2-HXT | 02970135 | 5 | J | 3,0 | 6,0 | 3,0 | 80,0 | 40,0 | 2,8 | 2,2 | 2 | ■ |
| JH112040J5B.0Z2-HXT | 02970136 | 5 | J | 4,0 | 6,0 | 4,0 | 80,0 | 52,0 | 3,7 | 1,2 | 2 | ■ |
| JH112050J5B.0Z2-HXT | 02970137 | 5 | J | 5,0 | 8,0 | 5,0 | 100,0 | 56,0 | 4,6 | 1,6 | 2 | ■ |
| JH112060J5B.0Z2-HXT | 02970138 | 5 | J | 6,0 | 8,0 | 6,0 | 100,0 | 56,0 | 5,6 | 1,1 | 2 | ■ |
| JH112080J5B.0Z2-HXT | 02970139 | 5 | J | 8,0 | 10,0 | 8,0 | 125,0 | 62,0 | 7,4 | 1,0 | 2 | ■ |
| JH112100J5B.0Z2-HXT | 02970140 | 5 | J | 10,0 | 12,0 | 10,0 | 125,0 | 61,0 | 9,4 | 1,0 | 2 | ■ |
| JH112060J6B.0Z2-HXT | 02970141 | 6 | J | 6,0 | 10,0 | 6,0 | 125,0 | 62,0 | 5,6 | 2,0 | 2 | ■ |
| JH112080J6B.0Z2-HXT | 02970142 | 6 | J | 8,0 | 12,0 | 8,0 | 150,0 | 67,0 | 7,4 | 1,8 | 2 | ■ |
| JH112100J6B.0Z2-HXT | 02970143 | 6 | J | 10,0 | 12,0 | 10,0 | 150,0 | 79,0 | 9,4 | 0,8 | 2 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite


Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JH112 Kopierfräsen/ Feinbearbeitung

| SMG |  | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | 2 | 2.5 | 3 | 3.5 | 4 | 5 | 6 | 8 | 10 | 12 | |
| K1 | E | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 520 (500 – 730) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 1700 (1700 – 2300) |
| K2 | E | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 445 (430 – 630) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 1450 (1500 – 2000) |
| K3 | E | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 380 (360 – 530) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 1250 (1200 – 1700) |
| K4 | E | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 360 (350 – 510) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 1175 (1200 – 1600) |
| K5 | E | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 415 (370 – 610) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 1350 (1300 – 2000) |
| K6 | E | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 610 (550 – 900) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 2000 (1900 – 2900) |
| K7 | E | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 680 (560 – 790) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 2225 (1900 – 2500) |
| H3 | M | 0.16 | 0.028 | 0.036 | 0.042 | 0.048 | 0.055 | 0.070 | 0.085 | 0.11 | 0.14 | 0.17 | 155 (150 – 230) |
| | | 0,16 | 0,0011 | 0,0014 | 0,0017 | 0,0019 | 0,0022 | 0,0028 | 0,0034 | 0,0044 | 0,0055 | 0,0065 | 510 (500 – 750) |
| H5 | M | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 285 (240 – 330) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 940 (790 – 1000) |
| H7 | M | 0.16 | 0.028 | 0.036 | 0.042 | 0.048 | 0.055 | 0.070 | 0.085 | 0.11 | 0.14 | 0.17 | 155 (150 – 230) |
| | | 0,16 | 0,0011 | 0,0014 | 0,0017 | 0,0019 | 0,0022 | 0,0028 | 0,0034 | 0,0044 | 0,0055 | 0,0065 | 510 (500 – 750) |
| H8 | M | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 285 (240 – 330) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 940 (790 – 1000) |
| H11 | M | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 360 (300 – 420) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 1175 (990 – 1300) |
| H12 | M | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 330 (280 – 380) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 1075 (920 – 1200) |
| H21 | M | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 285 (240 – 330) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 940 (790 – 1000) |
| H31 | M | 0.30 | 0.026 | 0.032 | 0.040 | 0.046 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 300 (290 – 430) |
| | | 0,30 | 0,0010 | 0,0013 | 0,0016 | 0,0018 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 980 (960 – 1400) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Unversell
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

Schnittdaten – JH112 Kopierfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 2 | 2.5 | 3 | 3.5 | 4 | 5 | 6 | 8 | 10 | 12 | |
| K1 | E | 0.250 | 0.15 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 315 (310 – 450) |
| | | 0,250 | 0,15 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 1025 (1100 – 1400) |
| K2 | E | 0.250 | 0.15 | 0.028 | 0.036 | 0.044 | 0.050 | 0.060 | 0.070 | 0.085 | 0.12 | 0.14 | 0.17 | 280 (270 – 390) |
| | | 0,250 | 0,15 | 0,0011 | 0,0014 | 0,0017 | 0,0020 | 0,0024 | 0,0028 | 0,0034 | 0,0048 | 0,0055 | 0,0065 | 920 (890 – 1200) |
| K3 | E | 0.250 | 0.15 | 0.028 | 0.036 | 0.044 | 0.050 | 0.060 | 0.070 | 0.085 | 0.12 | 0.14 | 0.17 | 235 (230 – 330) |
| | | 0,250 | 0,15 | 0,0011 | 0,0014 | 0,0017 | 0,0020 | 0,0024 | 0,0028 | 0,0034 | 0,0048 | 0,0055 | 0,0065 | 770 (760 – 1000) |
| K4 | E | 0.250 | 0.15 | 0.028 | 0.036 | 0.044 | 0.050 | 0.060 | 0.070 | 0.085 | 0.12 | 0.14 | 0.17 | 225 (220 – 320) |
| | | 0,250 | 0,15 | 0,0011 | 0,0014 | 0,0017 | 0,0020 | 0,0024 | 0,0028 | 0,0034 | 0,0048 | 0,0055 | 0,0065 | 740 (730 – 1000) |
| K5 | E | 0.160 | 0.15 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 280 (250 – 410) |
| | | 0,160 | 0,15 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 920 (830 – 1300) |
| K6 | E | 0.160 | 0.15 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 415 (370 – 610) |
| | | 0,160 | 0,15 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 1350 (1300 – 2000) |
| K7 | E | 0.250 | 0.10 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 420 (350 – 490) |
| | | 0,250 | 0,10 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 1375 (1200 – 1600) |
| H3 | M | 0.120 | 0.040 | 0.028 | 0.036 | 0.042 | 0.048 | 0.055 | 0.070 | 0.085 | 0.11 | 0.14 | 0.17 | 110 (100 – 160) |
| | | 0,120 | 0,040 | 0,0011 | 0,0014 | 0,0017 | 0,0019 | 0,0022 | 0,0028 | 0,0034 | 0,0044 | 0,0055 | 0,0065 | 360 (330 – 520) |
| H5 | M | 0.250 | 0.10 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 175 (150 – 200) |
| | | 0,250 | 0,10 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 570 (500 – 650) |
| H7 | M | 0.120 | 0.040 | 0.028 | 0.036 | 0.042 | 0.048 | 0.055 | 0.070 | 0.085 | 0.11 | 0.14 | 0.17 | 110 (100 – 160) |
| | | 0,120 | 0,040 | 0,0011 | 0,0014 | 0,0017 | 0,0019 | 0,0022 | 0,0028 | 0,0034 | 0,0044 | 0,0055 | 0,0065 | 360 (330 – 520) |
| H8 | M | 0.250 | 0.10 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 175 (150 – 200) |
| | | 0,250 | 0,10 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 570 (500 – 650) |
| H11 | M | 0.250 | 0.10 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 225 (190 – 260) |
| | | 0,250 | 0,10 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 740 (630 – 850) |
| H12 | M | 0.250 | 0.10 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 205 (170 – 240) |
| | | 0,250 | 0,10 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 670 (560 – 780) |
| H21 | M | 0.250 | 0.10 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 175 (150 – 200) |
| | | 0,250 | 0,10 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 570 (500 – 650) |
| H31 | M | 0.200 | 0.10 | 0.026 | 0.032 | 0.040 | 0.046 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 200 (200 – 280) |
| | | 0,200 | 0,10 | 0,0010 | 0,0013 | 0,0016 | 0,0018 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 660 (660 – 910) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

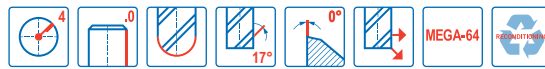
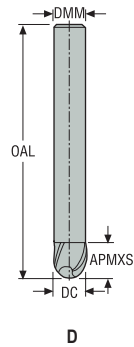
a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

JH150

Hochgeschwindigkeitsfräsen – Gehärteter Stahl – Kugelkopf – 4 Schneiden – Zylindrisch



- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | PCEDC | Zylindrisch |
|----------------|--------------------|------------------|-------------------|------|------|-------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | | |
| 150060-MEGA-64 | 00019198 | 2 | D | 6,0 | 6,0 | 6,0 | 80,0 | 4 | ■ |
| 150080-MEGA-64 | 00019208 | 2 | D | 8,0 | 8,0 | 8,0 | 85,0 | 4 | ■ |
| 150100-MEGA-64 | 00019219 | 2 | D | 10,0 | 10,0 | 10,0 | 100,0 | 4 | ■ |
| 150120-MEGA-64 | 00019254 | 2 | D | 12,0 | 12,0 | 12,0 | 100,0 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JH150 Kopierfräsen/Schruppen

| SMG | | a _p /DC | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------------------|
| | | | | 6 | 8 | 10 | 12 | |
| K1 | A | 0.300 | 0.15 | 0.10 | 0.14 | 0.17 | 0.20 | 290 (310 – 370) |
| | | 0,300 | 0,15 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 950 (1100 – 1200) |
| K2 | A | 0.300 | 0.15 | 0.10 | 0.14 | 0.17 | 0.20 | 250 (270 – 320) |
| | | 0,300 | 0,15 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 820 (890 – 1000) |
| K3 | A | 0.300 | 0.15 | 0.10 | 0.14 | 0.17 | 0.20 | 210 (230 – 270) |
| | | 0,300 | 0,15 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 690 (760 – 880) |
| K5 | A | 0.200 | 0.15 | 0.10 | 0.14 | 0.17 | 0.20 | 255 (270 – 330) |
| | | 0,200 | 0,15 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 840 (890 – 1000) |
| K6 | A | 0.200 | 0.15 | 0.10 | 0.14 | 0.17 | 0.20 | 375 (390 – 500) |
| | | 0,200 | 0,15 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1225 (1300 – 1600) |
| K7 | A | 0.200 | 0.15 | 0.10 | 0.14 | 0.17 | 0.20 | 325 (340 – 430) |
| | | 0,200 | 0,15 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1075 (1200 – 1400) |
| H3 | M | 0.0500 | 0.020 | 0.085 | 0.11 | 0.14 | 0.17 | 85 (88 – 120) |
| | | 0,0500 | 0,020 | 0,0034 | 0,0044 | 0,0055 | 0,0065 | 280 (290 – 390) |
| H5 | M | 0.200 | 0.060 | 0.10 | 0.14 | 0.17 | 0.20 | 180 (160 – 200) |
| | | 0,200 | 0,060 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 590 (530 – 650) |
| H7 | M | 0.0500 | 0.020 | 0.085 | 0.11 | 0.14 | 0.17 | 85 (88 – 120) |
| | | 0,0500 | 0,020 | 0,0034 | 0,0044 | 0,0055 | 0,0065 | 280 (290 – 390) |
| H8 | M | 0.200 | 0.060 | 0.10 | 0.14 | 0.17 | 0.20 | 180 (160 – 200) |
| | | 0,200 | 0,060 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 590 (530 – 650) |
| H11 | M | 0.200 | 0.060 | 0.10 | 0.14 | 0.17 | 0.20 | 230 (210 – 250) |
| | | 0,200 | 0,060 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 750 (690 – 820) |
| H12 | M | 0.200 | 0.060 | 0.10 | 0.14 | 0.17 | 0.20 | 210 (190 – 230) |
| | | 0,200 | 0,060 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 690 (630 – 750) |
| H21 | M | 0.200 | 0.060 | 0.10 | 0.14 | 0.17 | 0.20 | 180 (160 – 200) |
| | | 0,200 | 0,060 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 590 (530 – 650) |
| H31 | M | 0.150 | 0.060 | 0.090 | 0.12 | 0.15 | 0.18 | 125 (130 – 180) |
| | | 0,150 | 0,060 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 410 (430 – 590) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

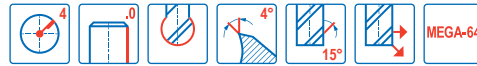
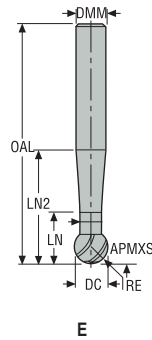
a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

JH160

Hochgeschwindigkeitsfräsen – Gehärteter Stahl – Kugelkopf – 4 Schneiden – Zylindrisch



- Toleranzen:
- DMM= h5
- DC= 0,02/-0,06 mm
- SA=250°

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | LN2 | DN | RE | PCEDC | Zylindrisch |
|----------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | | |
| 160030-MEGA-64 | 00040365 | 2 | E | 3,0 | 3,0 | 2,3 | 60,0 | 4,5 | 9,0 | 1,8 | 1,5 | 4 | ■ |
| 160040-MEGA-64 | 00040366 | 2 | E | 4,0 | 4,0 | 3,1 | 60,0 | 5,6 | 11,0 | 2,4 | 2,0 | 4 | ■ |
| 160050-MEGA-64 | 00040367 | 2 | E | 5,0 | 5,0 | 3,9 | 70,0 | 6,4 | 13,0 | 3,0 | 2,5 | 4 | ■ |
| 160060-MEGA-64 | 00040368 | 2 | E | 6,0 | 6,0 | 4,7 | 80,0 | 9,7 | 17,3 | 3,6 | 3,0 | 4 | ■ |
| 160080-MEGA-64 | 00040369 | 2 | E | 8,0 | 8,0 | 6,2 | 85,0 | 11,2 | 21,3 | 4,8 | 4,0 | 4 | ■ |
| 160100-MEGA-64 | 00040370 | 2 | E | 10,0 | 10,0 | 7,8 | 100,0 | 15,6 | 27,9 | 6,0 | 5,0 | 4 | ■ |
| 160120-MEGA-64 | 00040371 | 2 | E | 12,0 | 12,0 | 9,4 | 125,0 | 17,2 | 31,8 | 7,2 | 6,0 | 4 | ■ |

■ Lagerstandard.

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Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JH160 Kopierfräsen/ Feinbearbeitung

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 3 | 4 | 5 | 6 | 8 | 10 | 12 | |
| P1 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 550 (450 – 700) |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1800 (1500 – 2200) |
| P2 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 530 (440 – 680) |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1750 (1500 – 2200) |
| P3 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 460 (380 – 590) |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1500 (1300 – 1900) |
| P4 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 405 (340 – 520) |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1325 (1200 – 1700) |
| P5 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 385 (320 – 490) |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1275 (1100 – 1600) |
| P6 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 430 (360 – 520) |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1400 (1200 – 1800) |
| P7 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 410 (340 – 520) |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1350 (1100 – 1700) |
| P8 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 385 (320 – 490) |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1275 (1100 – 1600) |
| P11 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 395 (330 – 510) |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1300 (1100 – 1600) |
| P12 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 235 (200 – 300) |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 770 (660 – 980) |
| H3 | M/E/A | 0.0100 | 0.0075 | 0.040 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 85 (91 – 110) |
| | | 0,0100 | 0,0075 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 280 (300 – 360) |
| H5 | M/E/A | 0.0100 | 0.016 | 0.040 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 340 (320 – 360) |
| | | 0,0100 | 0,016 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 1125 (1100 – 1100) |
| H7 | M/E/A | 0.0100 | 0.0075 | 0.040 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 85 (91 – 110) |
| | | 0,0100 | 0,0075 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 280 (300 – 360) |
| H8 | M/E/A | 0.0100 | 0.016 | 0.040 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 340 (320 – 360) |
| | | 0,0100 | 0,016 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 1125 (1100 – 1100) |
| H11 | M/E/A | 0.0100 | 0.016 | 0.040 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 430 (400 – 460) |
| | | 0,0100 | 0,016 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 1400 (1400 – 1500) |
| H12 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 355 (340 – 380) |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1175 (1200 – 1200) |
| H21 | M/E/A | 0.0100 | 0.016 | 0.040 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 340 (320 – 360) |
| | | 0,0100 | 0,016 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 1125 (1100 – 1100) |
| H31 | M/E/A | 0.0100 | 0.016 | 0.040 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 165 (180 – 210) |
| | | 0,0100 | 0,016 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 540 (600 – 680) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte



ROSTFREI UND ISO-S-WERKSTOFFE














































Das vollständige Programm an Hochleistungsvollhartmetallfräsern für hohe Produktivität in Rostfrei und ISO-S-Werkstoffen besteht aus Schafffräsern, Kugelkopffräsern und Kreissegmentfräsern.

- JS754, JS755, JS720, JHP751, JHP760, JHP770, JHP780, JHP794, JCG790, JH770, JH740, JH710, JH790, JH730, JHP994, SHF712, SME714, SME716 und JCO710 mit Fase oder Eckenradius
- JS730, JH780, JHB720, JH721, JH722, SMB713, SMB714 und SMB716 Kugelkopffräser.
- JH724, JH726, JH734, JH736, JH744, JH746 Tonnenfräser.

| | | Werkzeugauswahl Rostfrei und S-Werkstoffe | | | | | | | |
|-------------------------------|---------------------|---|--------------------|--------------------|--------------------|--------|--------|--------|------|
| Universell | | | | | | | | | |
| | | | | | | | | | |
| Stahl und Guss | Werkzeugbezeichnung | JS754 | JS755 | JS720 | JS730 | JHP751 | JHP760 | JHP770 | |
| | Seite(n) | 220 | 237 | 248 | 261 | 265 | 268 | 272 | |
| Rostfrei und ISO-S-Werkstoffe | Produktfamilie | SOLID ² | SOLID ² | SOLID ² | SOLID ² | HPM | HPM | HPM | |
| | Fräserausführung | | | | | | | | |
| NE-Metalle | Aufnahmen | Zylindrisch | ■ | ■ | ■ | ■ | ■ | ■ | ■ |
| | | Weldon | ■ | ■ | ■ | □ | ■ | ■ | ■ |
| | | Safe-Lock | □ | □ | □ | □ | | | □ |
| | Schneidenzahl | 4 | 5 | 6-9 | 6 | 2-4 | 2,3,4 | 4-5 | |
| | ICC | ■ | | | | | ■ | ■ | |
| Harter | | Metrisch | 3-25 | 6-25 | 6-25 | 6-25 | 2-20 | 4-25 | 6-25 |
| | | Zoll | | | | | | | |
| | Verfügbare Längen | 2,3 | 2,3 | 2,3 | 2,3 | 1,2 | 2,3 | 2 | |
| Kunststoffe und Composite | Bearbeitung | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| X-Heads | SMG | | | | | | | | |
| | M1 | ● | ● | ● | ● | | ● | | |
| | M2 | ● | ● | ● | ● | | ● | | |
| | M3 | ● | ● | ● | ● | | ● | | |
| | M4 | ● | ● | ● | ● | | ● | | |
| | M5 | ● | ● | ● | ● | | ● | | |
| Minimaster Plus | S1 | ● | ● | ● | ● | ● | | | |
| | S2 | ● | ● | ● | ● | ● | | | |
| | S3 | ● | ● | ● | ● | ● | | | |
| | S11 | ● | ● | ● | ● | ● | | ● | |
| | S12 | ● | ● | ● | ● | ● | | ● | |
| | S13 | ● | ● | ● | ● | ● | | ● | |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage. □ Safe-Lock verfügbar, die Lieferzeit beträgt 6 Tage.
● Erste Wahl ○ Alternative

Werkzeugauswahl Rostfrei und S-Werkstoffe

| | | | | | | | | | |
|---------------------|---|---|---|---|---|---|---|---|---|
| |  |  |  |  |  |  |  |  |  |
| |  |  |  |  |  |  |  |  |  |
| Werkzeugbezeichnung | JHP780 | JHP794 | JCG790 | JH724 | JH726 | JH734 | JH736 | JH744 | JH746 |
| Seite(n) | 279 | 268 | 286 | 318 | 318 | 292 | 294 | 296 | 298 |
| Produktfamilie | HPM | HPM | Ceramic | HSM/TORNADO | HSM/TORNADO | HSM/TORNADO | HSM/TORNADO | HSM/TORNADO | HSM/TORNADO |
| Fräserausführung |  |  |  |  |  |  |  |  |  |
| Aufnahmen | Zylindrisch | ■ | ■ | ■ | ■ | ■ | ■ | ■ | ■ |
| | Weldon | ■ | ■ | | | | | | |
| | Safe-Lock | □ | | | | | | | |
| Schneidenzahl | 4 | 4 | 5-6 | 6 | 6 | 4 | 6 | 4 | 6 |
| ICC | ■ | ■ | | | | | | ■ | ■ |
| Metrisch | 6-25 | 6-25 | 6-25 | 10 | 10 | 6-16 | 10-16 | 4-16 | 10-16 |
| | Zoll | | | | | | | | |
| Verfügbare Längen | 2 | 2 | 2 | 2 | 2 | 2 | 2 | 2,4 | 2 |
| Bearbeitung |  |  |  | | | | | | |
| |  |  |  |  |  |  |  |  |  |
| | | | |  |  |  |  |  |  |
| SMG | | | | | | | | | |
| M1 | | • | | • | • | • | • | • | • |
| M2 | | • | | • | • | • | • | • | • |
| M3 | | • | | • | • | • | • | • | • |
| M4 | | • | | • | • | | | | |
| M5 | | • | | • | • | | | | |
| S1 | • | | • | • | • | | | | |
| S2 | • | | • | • | • | | | | |
| S3 | • | | • | • | • | | | | |
| S11 | | | | • | • | • | • | • | • |
| S12 | | | | • | • | • | • | • | • |
| S13 | | | | • | • | • | • | • | • |

























■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage. □ Safe-Lock verfügbar, die Lieferzeit beträgt 6 Tage.
 • Erste Wahl ○ Alternative

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 Harter
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 X-Heads
 Minimax Plus
 Minimax

| | | Werkzeugauswahl Rostfrei und S-Werkstoffe | | | | | | | |
|---------------------------|-------------|---|-------------|-------------|-------------|-------------|--------|-------------|--|
| Universell | | | | | | | | | |
| Stahl und Guss | | | | | | | | | |
| Werkzeugbezeichnung | | JH770 | JH740 | JH710 | JH790 | JH730 | JHP994 | JH780 | |
| Seite(n) | | 300 | 302 | 304 | 306 | 308 | 310 | 312 | |
| Produktfamilie | | HSM/TORNADO | HSM/TORNADO | HSM/TORNADO | HSM/TORNADO | HSM/TORNADO | HPM | HSM/TORNADO | |
| Fräserausführung | | | | | | | | | |
| Aufnahmen | Zylindrisch | ■ | ■ | ■ | ■ | ■ | ■ | ■ | |
| | Weldon | | | | | | | | |
| | Safe-Lock | | | | | | | | |
| Schneidenzahl | | 3,4,5,6 | 4-5 | 5 | 6 | 6-7 | 4 | 4 | |
| ICC | | | | | | | | | |
| Harter | Metrisch | 3-10 | 6-10 | 6-8 | 9,5 | 8-10 | 6-10 | 1,83-4,89 | |
| | Zoll | | | | | | | | |
| Verfügbare Längen | | 2 | 2 | 2 | 2-3 | 2 | 3 | 2 | |
| Kunststoffe und Composite | | | | | | | | | |
| Graphit | | SMG | | | | | | | |
| | | M1 | | | | | | | |
| | | M2 | | | | | | | |
| | | M3 | | | | | | | |
| | | M4 | | | | | | | |
| | | M5 | | | | | | | |
| X-Heads | | S1 | | | | | | | |
| | | S2 | ● | ● | ● | ● | ● | ● | |
| | | S3 | | | | | | | |
| | | S11 | ● | ● | ● | ● | ● | ● | |
| | | S12 | ● | ● | ● | ● | ● | ● | |
| | | S13 | | | | | | | |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage. □ Safe-Lock verfügbar, die Lieferzeit beträgt 6 Tage.
 ● Erste Wahl ○ Alternative

Werkzeugauswahl Rostfrei und S-Werkstoffe

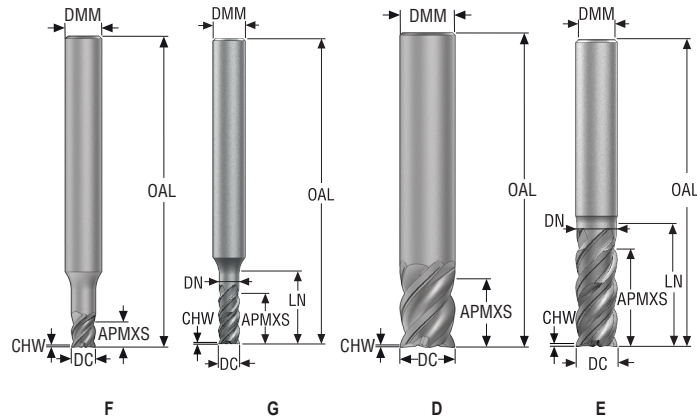
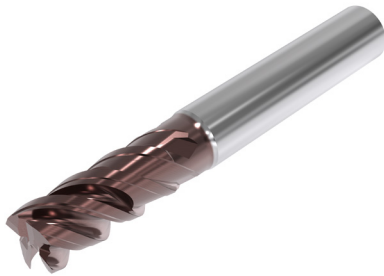
| | |  |  |  |  |  |  |
|---------------------|-------------|---|---|---|---|---|---|
| Werkzeugbezeichnung | | JHB720 | JH721 | JH722 | SHF712 | SME714/716 | SMB713/714/416 |
| Seite(n) | | 314 | 316 | 318 | 377 | 377 | 177 |
| Produktfamilie | | HSM/TORNADO | HSM/TORNADO | HSM/TORNADO | HFM | MINI | MINI |
| Fräserausführung | |  |  |  |  |  |  |
| Aufnahmen | Zylindrisch | ■ | ■ | ■ | ■ | ■ | ■ |
| | Weldon | | | | | | |
| | Safe-Lock | | | | | | |
| Schneidenzahl | | 3 | 6 | 6 | 3-4-5 | 3-4-5 | 4 |
| ICC | | | | | | | |
| | Metrisch | 2-16 | 6-8 | 10 | 1-10 | 1-10 | 0,5-3,0 |
| | Zoll | | | | | | |
| Verfügbare Längen | | 2 | 2 | 2 | 1,2,3,4 | 1,2,3,4 | 2,4 |
| Bearbeitung | | | | |  |  |  |
| | |  | | |  |  |  |
| | |  |  |  | |  |  |
| SMG | | | | | | | |
| M1 | | ● | | | | | |
| M2 | | ● | | | | | |
| M3 | | ● | | | | | |
| M4 | | ● | | | | | |
| M5 | | ● | | | | | |
| S1 | | ○ | | | | | |
| S2 | | ○ | ● | ● | ● | ● | ● |
| S3 | | ○ | | | | | |
| S11 | | ● | ● | ● | | | |
| S12 | | ● | ● | ● | ● | ● | ● |
| S13 | | ● | | | | | |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

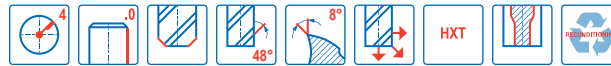
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Minimaster

JS754

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 4 Schneiden – Zylindrisch – Fase



- Toleranzen:
- DMM = h5
- DC= e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS754030F1C.0Z4-HXT | 10165556 | 1 | F | 3,0 | 6,0 | 4,0 | 50,0 | 6,0 | 3,05 | 0,035 | 4 | ■ |
| JS754040F1C.0Z4-HXT | 10164855 | 1 | F | 4,0 | 6,0 | 5,0 | 50,0 | 9,0 | 4,05 | 0,045 | 4 | ■ |
| JS754050F1C.0Z4-HXT | 10165557 | 1 | F | 5,0 | 6,0 | 7,0 | 50,0 | 10,0 | 5,05 | 0,055 | 4 | ■ |
| JS754060D1C.0Z4-HXT | 10164856 | 1 | D | 6,0 | 6,0 | 8,0 | 50,0 | – | – | 0,075 | 4 | ■ |
| JS754080D1C.0Z4-HXT | 10164857 | 1 | D | 8,0 | 8,0 | 11,0 | 58,0 | – | – | 0,1 | 4 | ■ |
| JS754100D1C.0Z4-HXT | 10164858 | 1 | D | 10,0 | 10,0 | 13,0 | 58,0 | – | – | 0,125 | 4 | ■ |
| JS754120D1C.0Z4-HXT | 10164859 | 1 | D | 12,0 | 12,0 | 15,0 | 67,0 | – | – | 0,15 | 4 | ■ |
| JS754160D1C.0Z4-HXT | 10164860 | 1 | D | 16,0 | 16,0 | 19,0 | 73,0 | – | – | 0,2 | 4 | ■ |
| JS754030G2C.0Z4-HXT | 03186807 | 2 | G | 3,0 | 6,0 | 6,0 | 57,0 | 10,0 | 2,85 | 0,035 | 4 | ■ |
| JS754040G2C.0Z4-HXT | 03186808 | 2 | G | 4,0 | 6,0 | 8,0 | 57,0 | 13,0 | 3,8 | 0,045 | 4 | ■ |
| JS754050G2C.0Z4-HXT | 03186809 | 2 | G | 5,0 | 6,0 | 10,0 | 57,0 | 16,0 | 4,75 | 0,055 | 4 | ■ |
| JS754060E2C.0Z4-HXT | 03186810 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,075 | 4 | ■ |
| JS754080E2C.0Z4-HXT | 03186811 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 0,1 | 4 | ■ |
| JS754100E2C.0Z4-HXT | 03186812 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,125 | 4 | ■ |
| JS754120E2C.0Z4-HXT | 03186813 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,15 | 4 | ■ |
| JS754160E2C.0Z4-HXT | 03186814 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 0,2 | 4 | ■ |
| JS754200E2C.0Z4-HXT | 03186815 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 0,25 | 4 | ■ |
| JS754250E2C.0Z4-HXT | 03186816 | 2 | E | 25,0 | 25,0 | 50,0 | 121,0 | 65,0 | 23,8 | 0,3 | 4 | ■ |
| JS754060E3C.0Z4-HXT | 03186823 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,075 | 4 | ■ |
| JS754080E3C.0Z4-HXT | 03186824 | 3 | E | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 0,1 | 4 | ■ |
| JS754100E3C.0Z4-HXT | 03186825 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 0,125 | 4 | ■ |
| JS754120E3C.0Z4-HXT | 03186826 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 0,15 | 4 | ■ |
| JS754160E3C.0Z4-HXT | 03186827 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 0,2 | 4 | ■ |
| JS754200E3C.0Z4-HXT | 03186828 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 0,25 | 4 | ■ |
| JS754250E3C.0Z4-HXT | 03186829 | 3 | E | 25,0 | 25,0 | 85,0 | 153,0 | 94,0 | 23,8 | 0,3 | 4 | ■ |

■ Lagerstandard.

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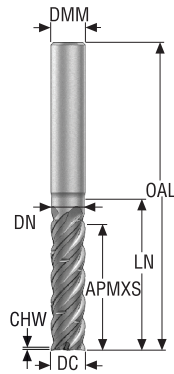
X-Heads

Minimaster Plus

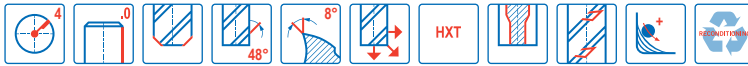
Minimaster

JS754

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 4 Schneiden – Zylindrisch – Fase – Spanteiler



E



- Toleranzen:
- DMM = h5
- DC= e7
- Spanteiler
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | Spanteiler | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Zylindrisch |
|----------------------|--------------------|------------------|-------------------|------------|------|------|-------|-------|------|------|-------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS754100E2C.0Z4C-HXT | 03186817 | 2 | E | ■ | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,125 | 4 | ■ |
| JS754120E2C.0Z4C-HXT | 03186818 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,15 | 4 | ■ |
| JS754060E3C.0Z4C-HXT | 03200550 | 3 | E | ■ | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,075 | 4 | ■ |
| JS754080E3C.0Z4C-HXT | 03200551 | 3 | E | ■ | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 0,1 | 4 | ■ |
| JS754100E3C.0Z4C-HXT | 03186830 | 3 | E | ■ | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 0,125 | 4 | ■ |
| JS754120E3C.0Z4C-HXT | 03186831 | 3 | E | ■ | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 0,15 | 4 | ■ |
| JS754160E3C.0Z4C-HXT | 03186832 | 3 | E | ■ | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 0,2 | 4 | ■ |
| JS754200E3C.0Z4C-HXT | 03186833 | 3 | E | ■ | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 0,25 | 4 | ■ |

■ Lagerstandard.

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Graphit

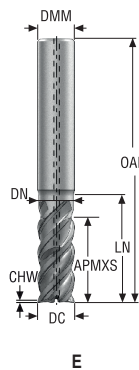
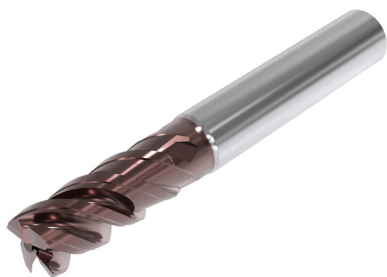
X-Heads

Minimaster Plus

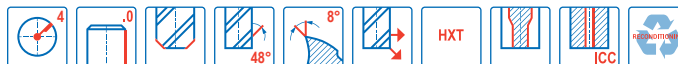
Minimaster

JS754

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 4 Schneiden – Zylindrisch – Fase – ICC



- Toleranzen:
- DMM = h5
- DC= e7
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Zylindrisch |
|----------------------|--------------------|------------------|-------------------|-----|------|------|-------|-------|------|------|-------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS754060E2C.0Z4A-HXT | 03186834 | 2 | E | ■ | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,075 | 4 | ■ |
| JS754080E2C.0Z4A-HXT | 03186835 | 2 | E | ■ | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 0,1 | 4 | ■ |
| JS754100E2C.0Z4A-HXT | 03186836 | 2 | E | ■ | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,125 | 4 | ■ |
| JS754120E2C.0Z4A-HXT | 03186837 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,15 | 4 | ■ |
| JS754160E2C.0Z4A-HXT | 03186838 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 0,2 | 4 | ■ |
| JS754200E2C.0Z4A-HXT | 03186839 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 0,25 | 4 | ■ |

■ Lagerstandard.

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Rostfrei und
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Harter

Kunststoffe und
Composite

Graphit

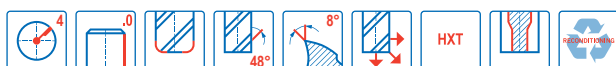
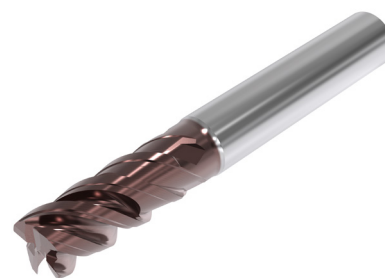
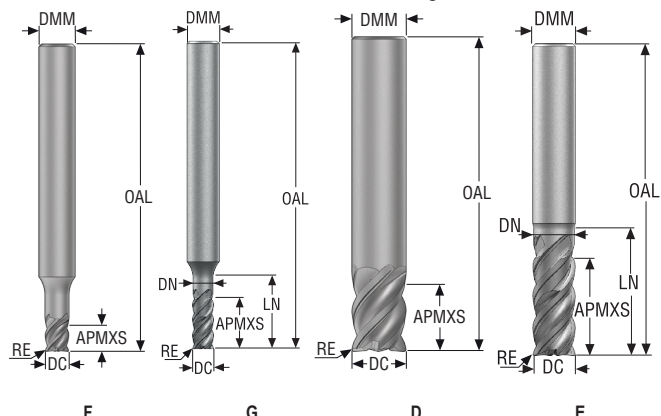
X-Heads

Minimaster Plus

Minimaster

JS754

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 4 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|------------------------|--------------------|------------------|-------------------|------|------|-------|------|------|------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS754030F1R020.0Z4-HXT | 10165558 | 1 | F | 3,0 | 6,0 | 4,0 | 50,0 | 6,0 | 3,05 | 0,2 | 4 | ■ |
| JS754040F1R020.0Z4-HXT | 10164867 | 1 | F | 4,0 | 6,0 | 5,0 | 50,0 | 9,0 | 4,05 | 0,2 | 4 | ■ |
| JS754050F1R020.0Z4-HXT | 10165559 | 1 | F | 5,0 | 6,0 | 7,0 | 50,0 | 10,0 | 5,05 | 0,2 | 4 | ■ |
| JS754060D1R020.0Z4-HXT | 10164868 | 1 | D | 6,0 | 6,0 | 8,0 | 50,0 | – | – | 0,2 | 4 | ■ |
| JS754060D1R050.0Z4-HXT | 10164869 | 1 | D | 6,0 | 6,0 | 8,0 | 50,0 | – | – | 0,5 | 4 | ■ |
| JS754080D1R050.0Z4-HXT | 10164871 | 1 | D | 8,0 | 8,0 | 11,0 | 58,0 | – | – | 0,5 | 4 | ■ |
| JS754100D1R050.0Z4-HXT | 10164873 | 1 | D | 10,0 | 10,0 | 13,0 | 58,0 | – | – | 0,5 | 4 | ■ |
| JS754100D1R100.0Z4-HXT | 10164874 | 1 | D | 10,0 | 10,0 | 13,0 | 58,0 | – | – | 1,0 | 4 | ■ |
| JS754120D1R050.0Z4-HXT | 10164875 | 1 | D | 12,0 | 12,0 | 15,0 | 67,0 | – | – | 0,5 | 4 | ■ |
| JS754120D1R100.0Z4-HXT | 10164876 | 1 | D | 12,0 | 12,0 | 15,0 | 67,0 | – | – | 1,0 | 4 | ■ |
| JS754160D1R050.0Z4-HXT | 10164877 | 1 | D | 16,0 | 16,0 | 19,0 | 73,0 | – | – | 0,5 | 4 | ■ |
| JS754160D1R100.0Z4-HXT | 10164878 | 1 | D | 16,0 | 16,0 | 19,0 | 73,0 | – | – | 1,0 | 4 | ■ |
| JS754030G2R020.0Z4-HXT | 03186840 | 2 | G | 3,0 | 6,0 | 6,0 | 57,0 | 10,0 | 2,85 | 0,2 | 4 | ■ |
| JS754040G2R020.0Z4-HXT | 03186841 | 2 | G | 4,0 | 6,0 | 8,0 | 57,0 | 13,0 | 3,8 | 0,2 | 4 | ■ |
| JS754050G2R020.0Z4-HXT | 03186842 | 2 | G | 5,0 | 6,0 | 10,0 | 57,0 | 16,0 | 4,75 | 0,2 | 4 | ■ |
| JS754060E2R020.0Z4-HXT | 03186843 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,2 | 4 | ■ |
| JS754060E2R050.0Z4-HXT | 03186844 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,5 | 4 | ■ |
| JS754060E2R100.0Z4-HXT | 03186845 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 1,0 | 4 | ■ |
| JS754080E2R050.0Z4-HXT | 03186846 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 0,5 | 4 | ■ |
| JS754080E2R100.0Z4-HXT | 03186847 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 1,0 | 4 | ■ |
| JS754100E2R050.0Z4-HXT | 03186848 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,5 | 4 | ■ |
| JS754100E2R100.0Z4-HXT | 03186849 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 1,0 | 4 | ■ |
| JS754100E2R150.0Z4-HXT | 03200552 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 1,5 | 4 | ■ |
| JS754100E2R200.0Z4-HXT | 03186850 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 2,0 | 4 | ■ |
| JS754100E2R300.0Z4-HXT | 03186851 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 3,0 | 4 | ■ |
| JS754120E2R050.0Z4-HXT | 03186852 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,5 | 4 | ■ |
| JS754120E2R100.0Z4-HXT | 03186853 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 1,0 | 4 | ■ |
| JS754120E2R150.0Z4-HXT | 03200553 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 1,5 | 4 | ■ |
| JS754120E2R200.0Z4-HXT | 03186854 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 2,0 | 4 | ■ |
| JS754120E2R300.0Z4-HXT | 03186855 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 3,0 | 4 | ■ |
| JS754160E2R050.0Z4-HXT | 03186856 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 0,5 | 4 | ■ |
| JS754160E2R100.0Z4-HXT | 03186857 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 1,0 | 4 | ■ |
| JS754160E2R200.0Z4-HXT | 03186858 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 2,0 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

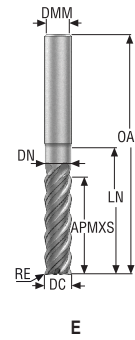
X-Heads

Minimaster Plus

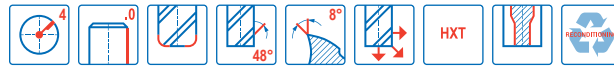
Minimaster

JS754

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 4 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

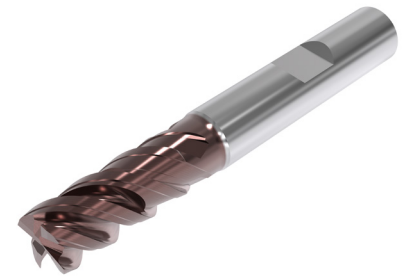
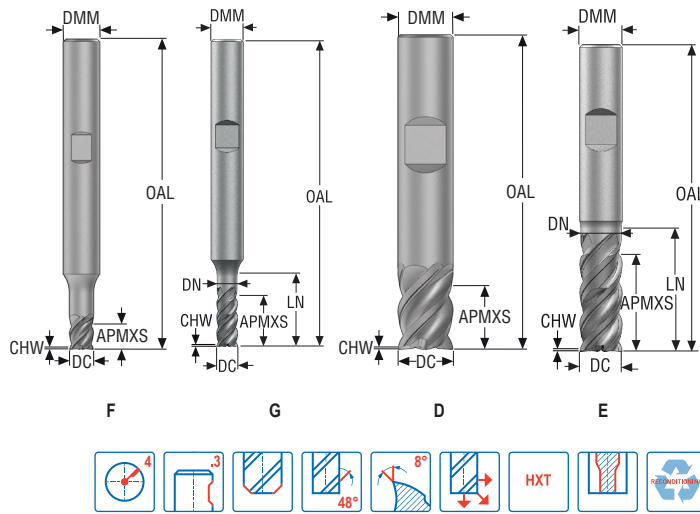


| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|------------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS754160E2R300.0Z4-HXT | 03186859 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 3,0 | 4 | ■ |
| JS754160E2R400.0Z4-HXT | 03186860 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 4,0 | 4 | ■ |
| JS754160E2R600.0Z4-HXT | 03186861 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 6,0 | 4 | ■ |
| JS754200E2R050.0Z4-HXT | 03186862 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 0,5 | 4 | ■ |
| JS754200E2R100.0Z4-HXT | 03186863 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 1,0 | 4 | ■ |
| JS754200E2R200.0Z4-HXT | 03186864 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 2,0 | 4 | ■ |
| JS754200E2R300.0Z4-HXT | 03186865 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 3,0 | 4 | ■ |
| JS754200E2R400.0Z4-HXT | 03186866 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 4,0 | 4 | ■ |
| JS754200E2R600.0Z4-HXT | 03186867 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 6,0 | 4 | ■ |
| JS754060E3R020.0Z4-HXT | 03186873 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,2 | 4 | ■ |
| JS754060E3R050.0Z4-HXT | 03186874 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,5 | 4 | ■ |
| JS754060E3R100.0Z4-HXT | 03186875 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 1,0 | 4 | ■ |
| JS754080E3R050.0Z4-HXT | 03186876 | 3 | E | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 0,5 | 4 | ■ |
| JS754080E3R100.0Z4-HXT | 03186877 | 3 | E | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 1,0 | 4 | ■ |
| JS754100E3R050.0Z4-HXT | 03186878 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 0,5 | 4 | ■ |
| JS754100E3R100.0Z4-HXT | 03186879 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 1,0 | 4 | ■ |
| JS754100E3R200.0Z4-HXT | 03186880 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 2,0 | 4 | ■ |
| JS754100E3R300.0Z4-HXT | 03186881 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 3,0 | 4 | ■ |
| JS754120E3R050.0Z4-HXT | 03186882 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 0,5 | 4 | ■ |
| JS754120E3R100.0Z4-HXT | 03186883 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 1,0 | 4 | ■ |
| JS754120E3R200.0Z4-HXT | 03186884 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 2,0 | 4 | ■ |
| JS754120E3R300.0Z4-HXT | 03186885 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 3,0 | 4 | ■ |
| JS754160E3R050.0Z4-HXT | 03186886 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 0,5 | 4 | ■ |
| JS754160E3R100.0Z4-HXT | 03186887 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 1,0 | 4 | ■ |
| JS754160E3R200.0Z4-HXT | 03186888 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 2,0 | 4 | ■ |
| JS754160E3R300.0Z4-HXT | 03186889 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 3,0 | 4 | ■ |
| JS754160E3R400.0Z4-HXT | 03186890 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 4,0 | 4 | ■ |
| JS754160E3R600.0Z4-HXT | 03186891 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 6,0 | 4 | ■ |
| JS754200E3R050.0Z4-HXT | 03186892 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 0,5 | 4 | ■ |
| JS754200E3R100.0Z4-HXT | 03186893 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 1,0 | 4 | ■ |
| JS754200E3R200.0Z4-HXT | 03186894 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 2,0 | 4 | ■ |
| JS754200E3R300.0Z4-HXT | 03186895 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 3,0 | 4 | ■ |
| JS754200E3R400.0Z4-HXT | 03186896 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 4,0 | 4 | ■ |
| JS754200E3R600.0Z4-HXT | 03186897 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 6,0 | 4 | ■ |

■ Lagerstandard.

JS754

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 4 Schneiden – Weldon – Fase



- Toleranzen:
- DMM = h5
- DC= e7
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Weldon |
|---------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-------|-------|--------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS754030F1C.3Z4-HXT | 10165658 | 1 | F | 3,0 | 6,0 | 4,0 | 50,0 | 6,0 | 3,05 | 0,035 | 4 | □ |
| JS754040F1C.3Z4-HXT | 10164861 | 1 | F | 4,0 | 6,0 | 5,0 | 50,0 | 9,0 | 4,05 | 0,045 | 4 | □ |
| JS754050F1C.3Z4-HXT | 10165660 | 1 | F | 5,0 | 6,0 | 7,0 | 50,0 | 10,0 | 5,05 | 0,055 | 4 | □ |
| JS754060D1C.3Z4-HXT | 10164862 | 1 | D | 6,0 | 6,0 | 8,0 | 50,0 | – | – | 0,075 | 4 | □ |
| JS754080D1C.3Z4-HXT | 10164863 | 1 | D | 8,0 | 8,0 | 11,0 | 58,0 | – | – | 0,1 | 4 | □ |
| JS754100D1C.3Z4-HXT | 10164864 | 1 | D | 10,0 | 10,0 | 13,0 | 58,0 | – | – | 0,125 | 4 | □ |
| JS754120D1C.3Z4-HXT | 10164865 | 1 | D | 12,0 | 12,0 | 15,0 | 67,0 | – | – | 0,15 | 4 | □ |
| JS754160D1C.3Z4-HXT | 10164866 | 1 | D | 16,0 | 16,0 | 19,0 | 73,0 | – | – | 0,2 | 4 | □ |
| JS754030G2C.3Z4-HXT | 03186975 | 2 | G | 3,0 | 6,0 | 6,0 | 57,0 | 10,0 | 2,85 | 0,035 | 4 | □ |
| JS754040G2C.3Z4-HXT | 03186976 | 2 | G | 4,0 | 6,0 | 8,0 | 57,0 | 13,0 | 3,8 | 0,045 | 4 | □ |
| JS754050G2C.3Z4-HXT | 03186977 | 2 | G | 5,0 | 6,0 | 10,0 | 57,0 | 16,0 | 4,75 | 0,055 | 4 | □ |
| JS754060E2C.3Z4-HXT | 03186978 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,075 | 4 | ■ |
| JS754080E2C.3Z4-HXT | 03186979 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 0,1 | 4 | ■ |
| JS754100E2C.3Z4-HXT | 03186980 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,125 | 4 | ■ |
| JS754120E2C.3Z4-HXT | 03186981 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,15 | 4 | ■ |
| JS754160E2C.3Z4-HXT | 03186982 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 0,2 | 4 | ■ |
| JS754200E2C.3Z4-HXT | 03186983 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 0,25 | 4 | ■ |
| JS754250E2C.3Z4-HXT | 03186984 | 2 | E | 25,0 | 25,0 | 50,0 | 121,0 | 65,0 | 23,8 | 0,3 | 4 | ■ |
| JS754060E3C.3Z4-HXT | 03186990 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,075 | 4 | ■ |
| JS754080E3C.3Z4-HXT | 03186991 | 3 | E | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 0,1 | 4 | ■ |
| JS754100E3C.3Z4-HXT | 03186992 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 0,125 | 4 | ■ |
| JS754120E3C.3Z4-HXT | 03186993 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 0,15 | 4 | ■ |
| JS754160E3C.3Z4-HXT | 03186994 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 0,2 | 4 | ■ |
| JS754200E3C.3Z4-HXT | 03186995 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 0,25 | 4 | ■ |
| JS754250E3C.3Z4-HXT | 03186996 | 3 | E | 25,0 | 25,0 | 85,0 | 153,0 | 94,0 | 23,8 | 0,3 | 4 | ■ |

■ Lagerstandard. □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

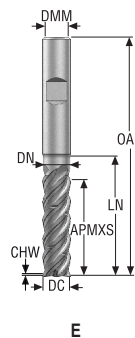
X-Heads

Minimaster Plus

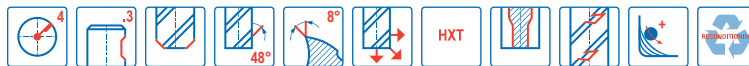
Minimaster

JS754

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 4 Schneiden – Weldon – Fase – Spanteiler



- Toleranzen:
- DMM = h5
- DC= e7
- Spanteiler
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | Spanteiler | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Weldon |
|----------------------|--------------------|------------------|-------------------|------------|------|------|-------|-------|------|------|-------|-------|--------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS754100E2C.3Z4C-HXT | 03186985 | 2 | E | ■ | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,125 | 4 | ■ |
| JS754120E2C.3Z4C-HXT | 03186986 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,15 | 4 | ■ |
| JS754060E3C.3Z4C-HXT | 03200562 | 3 | E | ■ | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,075 | 4 | ■ |
| JS754080E3C.3Z4C-HXT | 03200563 | 3 | E | ■ | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 0,1 | 4 | ■ |
| JS754100E3C.3Z4C-HXT | 03186997 | 3 | E | ■ | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 0,125 | 4 | ■ |
| JS754120E3C.3Z4C-HXT | 03186998 | 3 | E | ■ | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 0,15 | 4 | ■ |
| JS754160E3C.3Z4C-HXT | 03186999 | 3 | E | ■ | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 0,2 | 4 | ■ |
| JS754200E3C.3Z4C-HXT | 03187000 | 3 | E | ■ | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 0,25 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

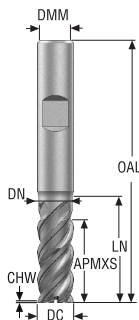
X-Heads

Minimaster Plus

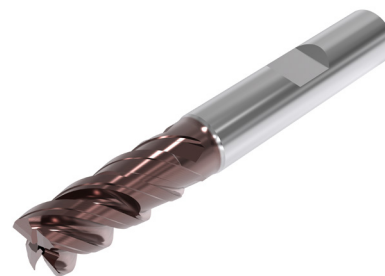
Minimaster

JS754

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 4 Schneiden – Weldon – Fase – ICC



E



- Toleranzen:
- DMM = h5
- DC= e7
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Weldon |
|----------------------|--------------------|------------------|-------------------|-----|------|------|-------|-------|------|------|-------|-------|--------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS754060E2C.3Z4A-HXT | 03187001 | 2 | E | ■ | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,075 | 4 | ■ |
| JS754080E2C.3Z4A-HXT | 03187002 | 2 | E | ■ | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 0,1 | 4 | ■ |
| JS754100E2C.3Z4A-HXT | 03187003 | 2 | E | ■ | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,125 | 4 | ■ |
| JS754120E2C.3Z4A-HXT | 03187004 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,15 | 4 | ■ |
| JS754160E2C.3Z4A-HXT | 03187005 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 0,2 | 4 | ■ |
| JS754200E2C.3Z4A-HXT | 03187006 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 0,25 | 4 | ■ |

■ Lagerstandard.

Unversell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

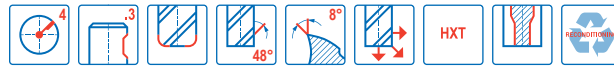
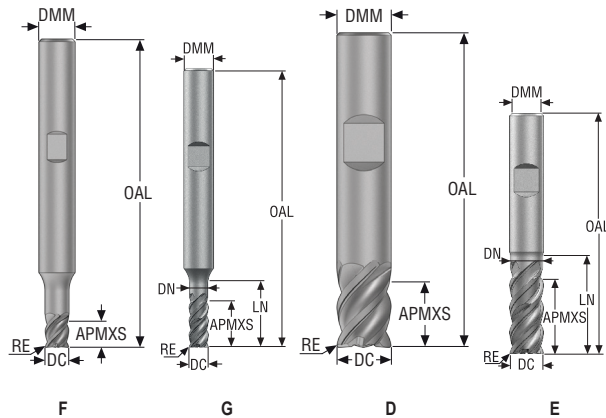
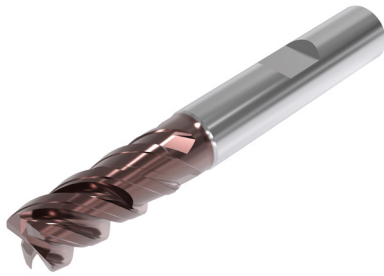
X-Heads

Minimaster Plus

Minimaster

JS754

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 4 Schneiden – Weldon – Eckenradius



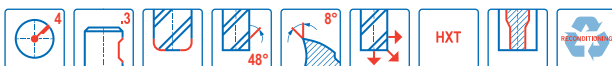
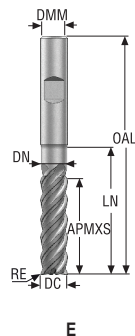
- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Weldon |
|------------------------|--------------------|------------------|-------------------|------|------|-------|------|------|------|-----|-------|-------------------------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS754030F1R020.3Z4-HXT | 10165560 | 1 | F | 3,0 | 6,0 | 4,0 | 50,0 | 6,0 | 3,05 | 0,2 | 4 | <input type="checkbox"/> |
| JS754040F1R020.3Z4-HXT | 10164879 | 1 | F | 4,0 | 6,0 | 5,0 | 50,0 | 9,0 | 4,05 | 0,2 | 4 | <input type="checkbox"/> |
| JS754050F1R020.3Z4-HXT | 10165561 | 1 | F | 5,0 | 6,0 | 7,0 | 50,0 | 10,0 | 5,05 | 0,2 | 4 | <input type="checkbox"/> |
| JS754060D1R020.3Z4-HXT | 10164880 | 1 | D | 6,0 | 6,0 | 8,0 | 50,0 | - | - | 0,2 | 4 | <input type="checkbox"/> |
| JS754060D1R050.3Z4-HXT | 10164881 | 1 | D | 6,0 | 6,0 | 8,0 | 50,0 | - | - | 0,5 | 4 | <input type="checkbox"/> |
| JS754080D1R050.3Z4-HXT | 10164883 | 1 | D | 8,0 | 8,0 | 11,0 | 58,0 | - | - | 0,5 | 4 | <input type="checkbox"/> |
| JS754100D1R050.3Z4-HXT | 10164885 | 1 | D | 10,0 | 10,0 | 13,0 | 58,0 | - | - | 0,5 | 4 | <input type="checkbox"/> |
| JS754100D1R100.3Z4-HXT | 10164886 | 1 | D | 10,0 | 10,0 | 13,0 | 58,0 | - | - | 1,0 | 4 | <input type="checkbox"/> |
| JS754120D1R050.3Z4-HXT | 10164887 | 1 | D | 12,0 | 12,0 | 15,0 | 67,0 | - | - | 0,5 | 4 | <input type="checkbox"/> |
| JS754120D1R100.3Z4-HXT | 10164888 | 1 | D | 12,0 | 12,0 | 15,0 | 67,0 | - | - | 1,0 | 4 | <input type="checkbox"/> |
| JS754160D1R050.3Z4-HXT | 10164889 | 1 | D | 16,0 | 16,0 | 19,0 | 73,0 | - | - | 0,5 | 4 | <input type="checkbox"/> |
| JS754160D1R100.3Z4-HXT | 10164890 | 1 | D | 16,0 | 16,0 | 19,0 | 73,0 | - | - | 1,0 | 4 | <input type="checkbox"/> |
| JS754030G2R020.3Z4-HXT | 03187007 | 2 | G | 3,0 | 6,0 | 6,0 | 57,0 | 10,0 | 2,85 | 0,2 | 4 | <input type="checkbox"/> |
| JS754040G2R020.3Z4-HXT | 03187008 | 2 | G | 4,0 | 6,0 | 8,0 | 57,0 | 13,0 | 3,8 | 0,2 | 4 | <input type="checkbox"/> |
| JS754050G2R020.3Z4-HXT | 03187009 | 2 | G | 5,0 | 6,0 | 10,0 | 57,0 | 16,0 | 4,75 | 0,2 | 4 | <input type="checkbox"/> |
| JS754060E2R020.3Z4-HXT | 03187010 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,2 | 4 | <input checked="" type="checkbox"/> |
| JS754060E2R050.3Z4-HXT | 03187011 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,5 | 4 | <input checked="" type="checkbox"/> |
| JS754060E2R100.3Z4-HXT | 03187012 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 1,0 | 4 | <input checked="" type="checkbox"/> |
| JS754080E2R050.3Z4-HXT | 03187013 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 0,5 | 4 | <input checked="" type="checkbox"/> |
| JS754080E2R100.3Z4-HXT | 03187014 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 1,0 | 4 | <input checked="" type="checkbox"/> |
| JS754100E2R050.3Z4-HXT | 03187015 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,5 | 4 | <input checked="" type="checkbox"/> |
| JS754100E2R100.3Z4-HXT | 03187016 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 1,0 | 4 | <input checked="" type="checkbox"/> |
| JS754100E2R150.3Z4-HXT | 03200564 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 1,5 | 4 | <input checked="" type="checkbox"/> |
| JS754100E2R200.3Z4-HXT | 03187017 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 2,0 | 4 | <input checked="" type="checkbox"/> |
| JS754100E2R300.3Z4-HXT | 03187018 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 3,0 | 4 | <input checked="" type="checkbox"/> |
| JS754120E2R050.3Z4-HXT | 03187019 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,5 | 4 | <input checked="" type="checkbox"/> |
| JS754120E2R100.3Z4-HXT | 03187020 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 1,0 | 4 | <input checked="" type="checkbox"/> |
| JS754120E2R150.3Z4-HXT | 03200565 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 1,5 | 4 | <input checked="" type="checkbox"/> |
| JS754120E2R200.3Z4-HXT | 03187021 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 2,0 | 4 | <input checked="" type="checkbox"/> |
| JS754120E2R300.3Z4-HXT | 03187022 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 3,0 | 4 | <input checked="" type="checkbox"/> |
| JS754160E2R050.3Z4-HXT | 03187023 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 0,5 | 4 | <input checked="" type="checkbox"/> |
| JS754160E2R100.3Z4-HXT | 03187024 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 1,0 | 4 | <input checked="" type="checkbox"/> |
| JS754160E2R200.3Z4-HXT | 03187025 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 2,0 | 4 | <input checked="" type="checkbox"/> |
| JS754160E2R300.3Z4-HXT | 03187026 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 3,0 | 4 | <input checked="" type="checkbox"/> |
| JS754160E2R400.3Z4-HXT | 03187027 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 4,0 | 4 | <input checked="" type="checkbox"/> |
| JS754160E2R600.3Z4-HXT | 03187028 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 6,0 | 4 | <input checked="" type="checkbox"/> |

■ Lagerstandard. □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS754

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 4 Schneiden – Weldon – Eckenradius



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Weldon |
|------------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-------|--------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS754200E2R050.3Z4-HXT | 03187029 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 0,5 | 4 | ■ |
| JS754200E2R100.3Z4-HXT | 03187030 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 1,0 | 4 | ■ |
| JS754200E2R200.3Z4-HXT | 03187031 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 2,0 | 4 | ■ |
| JS754200E2R300.3Z4-HXT | 03187032 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 3,0 | 4 | ■ |
| JS754200E2R400.3Z4-HXT | 03187033 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 4,0 | 4 | ■ |
| JS754200E2R600.3Z4-HXT | 03187034 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 6,0 | 4 | ■ |
| JS754060E3R020.3Z4-HXT | 03187040 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,2 | 4 | □ |
| JS754060E3R050.3Z4-HXT | 03187041 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,5 | 4 | □ |
| JS754060E3R100.3Z4-HXT | 03187042 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 1,0 | 4 | □ |
| JS754080E3R050.3Z4-HXT | 03187043 | 3 | E | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 0,5 | 4 | □ |
| JS754080E3R100.3Z4-HXT | 03187044 | 3 | E | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 1,0 | 4 | □ |
| JS754100E3R050.3Z4-HXT | 03187045 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 0,5 | 4 | □ |
| JS754100E3R100.3Z4-HXT | 03187046 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 1,0 | 4 | □ |
| JS754100E3R200.3Z4-HXT | 03187047 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 2,0 | 4 | □ |
| JS754100E3R300.3Z4-HXT | 03187049 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 3,0 | 4 | □ |
| JS754120E3R050.3Z4-HXT | 03187050 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 0,5 | 4 | □ |
| JS754120E3R100.3Z4-HXT | 03187051 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 1,0 | 4 | □ |
| JS754120E3R200.3Z4-HXT | 03187052 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 2,0 | 4 | □ |
| JS754120E3R300.3Z4-HXT | 03187053 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 3,0 | 4 | □ |
| JS754160E3R050.3Z4-HXT | 03187054 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 0,5 | 4 | □ |
| JS754160E3R100.3Z4-HXT | 03187055 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 1,0 | 4 | □ |
| JS754160E3R200.3Z4-HXT | 03187056 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 2,0 | 4 | □ |
| JS754160E3R300.3Z4-HXT | 03187057 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 3,0 | 4 | □ |
| JS754160E3R400.3Z4-HXT | 03187058 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 4,0 | 4 | □ |
| JS754160E3R600.3Z4-HXT | 03187059 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 6,0 | 4 | □ |
| JS754200E3R050.3Z4-HXT | 03187060 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 0,5 | 4 | □ |
| JS754200E3R100.3Z4-HXT | 03187061 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 1,0 | 4 | □ |
| JS754200E3R200.3Z4-HXT | 03187062 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 2,0 | 4 | □ |
| JS754200E3R300.3Z4-HXT | 03187063 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 3,0 | 4 | □ |
| JS754200E3R400.3Z4-HXT | 03187064 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 4,0 | 4 | □ |
| JS754200E3R600.3Z4-HXT | 03187065 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 6,0 | 4 | □ |

□ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

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Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

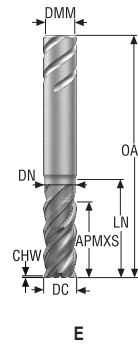
X-Heads

Minimaster Plus

Minimaster

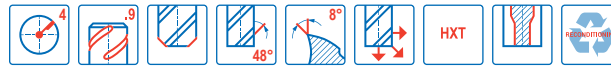
JS754

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 4 Schneiden – Safe-Lock – Fase



E

- Toleranzen:
- DMM = h5
- DC= e7
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Safe-Lock |
|---------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-------|-------|--------------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | |
| JS754060E2C.9Z4-HXT | 03187144 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,075 | 4 | <input type="checkbox"/> |
| JS754080E2C.9Z4-HXT | 03187145 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 0,1 | 4 | <input type="checkbox"/> |
| JS754100E2C.9Z4-HXT | 03187146 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,125 | 4 | <input type="checkbox"/> |
| JS754120E2C.9Z4-HXT | 03187147 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,15 | 4 | <input type="checkbox"/> |
| JS754160E2C.9Z4-HXT | 03187148 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 0,2 | 4 | <input type="checkbox"/> |
| JS754200E2C.9Z4-HXT | 03187149 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 0,25 | 4 | <input type="checkbox"/> |
| JS754250E2C.9Z4-HXT | 03187150 | 2 | E | 25,0 | 25,0 | 50,0 | 121,0 | 65,0 | 23,8 | 0,3 | 4 | <input type="checkbox"/> |
| JS754060E3C.9Z4-HXT | 03187153 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,075 | 4 | <input type="checkbox"/> |
| JS754080E3C.9Z4-HXT | 03187154 | 3 | E | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 0,1 | 4 | <input type="checkbox"/> |
| JS754100E3C.9Z4-HXT | 03187155 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 0,125 | 4 | <input type="checkbox"/> |
| JS754120E3C.9Z4-HXT | 03187156 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 0,15 | 4 | <input type="checkbox"/> |
| JS754160E3C.9Z4-HXT | 03187157 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 0,2 | 4 | <input type="checkbox"/> |
| JS754200E3C.9Z4-HXT | 03187158 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 0,25 | 4 | <input type="checkbox"/> |
| JS754250E3C.9Z4-HXT | 03187159 | 3 | E | 25,0 | 25,0 | 85,0 | 153,0 | 94,0 | 23,8 | 0,3 | 4 | <input type="checkbox"/> |

Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

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Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

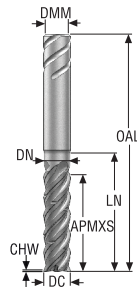
X-Heads

Minimaster Plus

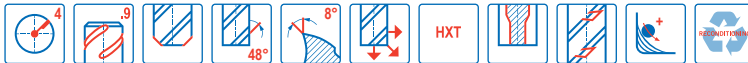
Minimaster

JS754

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 4 Schneiden – Safe-Lock – Fase – Spanteiler



E



- Toleranzen:
- DMM = h5
- DC= e7
- Spanteiler
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | Spanteiler | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Safe-Lock |
|----------------------|--------------------|------------------|-------------------|------------|------|------|-------|-------|------|------|-------|-------|--------------------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS754100E2C.9Z4C-HXT | 03187151 | 2 | E | ■ | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,125 | 4 | <input type="checkbox"/> |
| JS754120E2C.9Z4C-HXT | 03187152 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,15 | 4 | <input type="checkbox"/> |
| JS754060E3C.9Z4C-HXT | 03200571 | 3 | E | ■ | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,075 | 4 | <input type="checkbox"/> |
| JS754080E3C.9Z4C-HXT | 03200572 | 3 | E | ■ | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 0,1 | 4 | <input type="checkbox"/> |
| JS754100E3C.9Z4C-HXT | 03187160 | 3 | E | ■ | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 0,125 | 4 | <input type="checkbox"/> |
| JS754120E3C.9Z4C-HXT | 03187161 | 3 | E | ■ | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 0,15 | 4 | <input type="checkbox"/> |
| JS754160E3C.9Z4C-HXT | 03187162 | 3 | E | ■ | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 0,2 | 4 | <input type="checkbox"/> |
| JS754200E3C.9Z4C-HXT | 03187163 | 3 | E | ■ | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 0,25 | 4 | <input type="checkbox"/> |

Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

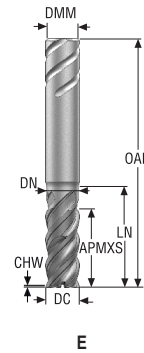
X-Heads

Minimaster Plus

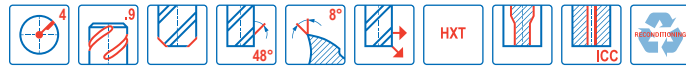
Minimaster

JS754

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 4 Schneiden – Safe-Lock – Fase – ICC



- Toleranzen:
- DMM = h5
- DC= e7
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Safe-Lock |
|----------------------|--------------------|------------------|-------------------|-----|------|------|-------|-------|------|------|-------|-------|--------------------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS754060E2C.9Z4A-HXT | 03187164 | 2 | E | ■ | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,075 | 4 | <input type="checkbox"/> |
| JS754080E2C.9Z4A-HXT | 03187165 | 2 | E | ■ | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 0,1 | 4 | <input type="checkbox"/> |
| JS754100E2C.9Z4A-HXT | 03187166 | 2 | E | ■ | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,125 | 4 | <input type="checkbox"/> |
| JS754120E2C.9Z4A-HXT | 03187167 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,15 | 4 | <input type="checkbox"/> |
| JS754160E2C.9Z4A-HXT | 03187168 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 0,2 | 4 | <input type="checkbox"/> |
| JS754200E2C.9Z4A-HXT | 03187169 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 0,25 | 4 | <input type="checkbox"/> |

Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.
ICC = mit interner Kühlschmiermittelzufuhr

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

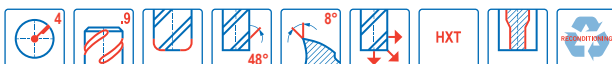
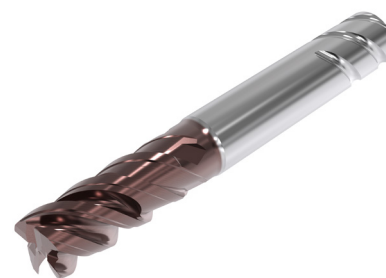
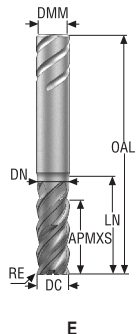
X-Heads

Minimaster Plus

Minimaster

JS754

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 4 Schneiden – Safe-Lock – Eckenradius



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Safe-Lock |
|------------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-------|--------------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS754060E2R020.9Z4-HXT | 03187170 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,2 | 4 | <input type="checkbox"/> |
| JS754060E2R050.9Z4-HXT | 03187171 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,5 | 4 | <input type="checkbox"/> |
| JS754060E2R100.9Z4-HXT | 03187172 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 1,0 | 4 | <input type="checkbox"/> |
| JS754080E2R050.9Z4-HXT | 03187173 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 0,5 | 4 | <input type="checkbox"/> |
| JS754080E2R100.9Z4-HXT | 03187174 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 1,0 | 4 | <input type="checkbox"/> |
| JS754100E2R050.9Z4-HXT | 03187175 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,5 | 4 | <input type="checkbox"/> |
| JS754100E2R100.9Z4-HXT | 03187176 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 1,0 | 4 | <input type="checkbox"/> |
| JS754100E2R150.9Z4-HXT | 03200573 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 1,5 | 4 | <input type="checkbox"/> |
| JS754100E2R200.9Z4-HXT | 03187177 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 2,0 | 4 | <input type="checkbox"/> |
| JS754100E2R300.9Z4-HXT | 03187178 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 3,0 | 4 | <input type="checkbox"/> |
| JS754120E2R050.9Z4-HXT | 03187179 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,5 | 4 | <input type="checkbox"/> |
| JS754120E2R100.9Z4-HXT | 03187180 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 1,0 | 4 | <input type="checkbox"/> |
| JS754120E2R150.9Z4-HXT | 03200832 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 1,5 | 4 | <input type="checkbox"/> |
| JS754120E2R200.9Z4-HXT | 03187181 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 2,0 | 4 | <input type="checkbox"/> |
| JS754120E2R300.9Z4-HXT | 03187182 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 3,0 | 4 | <input type="checkbox"/> |
| JS754160E2R050.9Z4-HXT | 03187183 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 0,5 | 4 | <input type="checkbox"/> |
| JS754160E2R100.9Z4-HXT | 03187184 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 1,0 | 4 | <input type="checkbox"/> |
| JS754160E2R200.9Z4-HXT | 03187185 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 2,0 | 4 | <input type="checkbox"/> |
| JS754160E2R300.9Z4-HXT | 03187186 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 3,0 | 4 | <input type="checkbox"/> |
| JS754160E2R400.9Z4-HXT | 03187187 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 4,0 | 4 | <input type="checkbox"/> |
| JS754160E2R600.9Z4-HXT | 03187188 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 6,0 | 4 | <input type="checkbox"/> |
| JS754200E2R050.9Z4-HXT | 03187189 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 0,5 | 4 | <input type="checkbox"/> |
| JS754200E2R100.9Z4-HXT | 03187190 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 1,0 | 4 | <input type="checkbox"/> |
| JS754200E2R200.9Z4-HXT | 03187191 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 2,0 | 4 | <input type="checkbox"/> |
| JS754200E2R300.9Z4-HXT | 03187192 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 3,0 | 4 | <input type="checkbox"/> |
| JS754200E2R400.9Z4-HXT | 03187193 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 4,0 | 4 | <input type="checkbox"/> |
| JS754200E2R600.9Z4-HXT | 03187194 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 6,0 | 4 | <input type="checkbox"/> |

Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

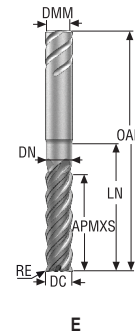
X-Heads

Minimaster Plus

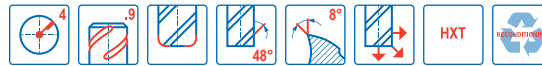
Minimaster

JS754

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 4 Schneiden – Safe-Lock – Eckenradius



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Safe-Lock |
|------------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-------|--------------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS754060E3R020.9Z4-HXT | 03187197 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,2 | 4 | <input type="checkbox"/> |
| JS754060E3R050.9Z4-HXT | 03187198 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,5 | 4 | <input type="checkbox"/> |
| JS754060E3R100.9Z4-HXT | 03187199 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 1,0 | 4 | <input type="checkbox"/> |
| JS754080E3R050.9Z4-HXT | 03187200 | 3 | E | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 0,5 | 4 | <input type="checkbox"/> |
| JS754080E3R100.9Z4-HXT | 03187201 | 3 | E | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 1,0 | 4 | <input type="checkbox"/> |
| JS754100E3R050.9Z4-HXT | 03187202 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 0,5 | 4 | <input type="checkbox"/> |
| JS754100E3R100.9Z4-HXT | 03187203 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 1,0 | 4 | <input type="checkbox"/> |
| JS754100E3R200.9Z4-HXT | 03187204 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 2,0 | 4 | <input type="checkbox"/> |
| JS754100E3R300.9Z4-HXT | 03187205 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 3,0 | 4 | <input type="checkbox"/> |
| JS754120E3R050.9Z4-HXT | 03187206 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 0,5 | 4 | <input type="checkbox"/> |
| JS754120E3R100.9Z4-HXT | 03187207 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 1,0 | 4 | <input type="checkbox"/> |
| JS754120E3R200.9Z4-HXT | 03187208 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 2,0 | 4 | <input type="checkbox"/> |
| JS754120E3R300.9Z4-HXT | 03187209 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 3,0 | 4 | <input type="checkbox"/> |
| JS754160E3R050.9Z4-HXT | 03187210 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 0,5 | 4 | <input type="checkbox"/> |
| JS754160E3R100.9Z4-HXT | 03187211 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 1,0 | 4 | <input type="checkbox"/> |
| JS754160E3R200.9Z4-HXT | 03187212 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 2,0 | 4 | <input type="checkbox"/> |
| JS754160E3R300.9Z4-HXT | 03187213 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 3,0 | 4 | <input type="checkbox"/> |
| JS754160E3R400.9Z4-HXT | 03187214 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 4,0 | 4 | <input type="checkbox"/> |
| JS754160E3R600.9Z4-HXT | 03187215 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 6,0 | 4 | <input type="checkbox"/> |
| JS754200E3R050.9Z4-HXT | 03187216 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 0,5 | 4 | <input type="checkbox"/> |
| JS754200E3R100.9Z4-HXT | 03187217 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 1,0 | 4 | <input type="checkbox"/> |
| JS754200E3R200.9Z4-HXT | 03187218 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 2,0 | 4 | <input type="checkbox"/> |
| JS754200E3R300.9Z4-HXT | 03187219 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 3,0 | 4 | <input type="checkbox"/> |
| JS754200E3R400.9Z4-HXT | 03187220 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 4,0 | 4 | <input type="checkbox"/> |
| JS754200E3R600.9Z4-HXT | 03187221 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 6,0 | 4 | <input type="checkbox"/> |

SafeLock verfügbar. Die Lieferzeit beträgt 6 Tage.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JS754 Eckfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|---------|---------|--------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | 25 | |
| P11 | M/A/D/E | 0.400 | 0.80 | 0.026 | 0.036 | 0.044 | 0.055 | 0.070 | 0.090 | 0.11 | 0.13 | 0.15 | 0.17 | 165 (130 – 180) |
| | | 0,400 | 0,80 | 0,0010 | 0,0014 | 0,0017 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 540 (430 – 590) |
| P12 | M/A/D/E | 0.400 | 0.80 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 0.12 | 105 (83 – 120) |
| | | 0,400 | 0,80 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0048 | 345 (280 – 390) |
| M1 | E | 0.400 | 1.0 | 0.020 | 0.026 | 0.034 | 0.040 | 0.055 | 0.065 | 0.080 | 0.10 | 0.11 | 0.13 | 110 (96 – 130) |
| | | 0,400 | 1,0 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0022 | 0,0026 | 0,0032 | 0,0040 | 0,0044 | 0,0050 | 360 (320 – 420) |
| M2 | E | 0.400 | 1.0 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 0.12 | 90 (79 – 110) |
| | | 0,400 | 1,0 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0048 | 295 (260 – 360) |
| M3 | E | 0.400 | 0.90 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 0.095 | 60 (44 – 76) |
| | | 0,400 | 0,90 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 0,0038 | 195 (150 – 240) |
| M4 | E | 0.400 | 0.90 | 0.013 | 0.018 | 0.022 | 0.026 | 0.036 | 0.044 | 0.055 | 0.065 | 0.075 | 0.085 | 46 (34 – 59) |
| | | 0,400 | 0,90 | 0,00050 | 0,00070 | 0,00085 | 0,0010 | 0,0014 | 0,0017 | 0,0022 | 0,0026 | 0,0030 | 0,0034 | 150 (120 – 190) |
| M5 | E | 0.400 | 0.90 | 0.013 | 0.018 | 0.022 | 0.026 | 0.036 | 0.044 | 0.055 | 0.065 | 0.075 | 0.085 | 39 (29 – 49) |
| | | 0,400 | 0,90 | 0,00050 | 0,00070 | 0,00085 | 0,0010 | 0,0014 | 0,0017 | 0,0022 | 0,0026 | 0,0030 | 0,0034 | 130 (96 – 160) |
| S1 | E | 0.150 | 0.50 | 0.026 | 0.034 | 0.044 | 0.050 | 0.070 | 0.085 | 0.10 | 0.13 | 0.15 | 0.17 | 50 (26 – 68) |
| | | 0,150 | 0,50 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0050 | 0,0060 | 0,0065 | 165 (86 – 220) |
| S2 | E | 0.150 | 0.50 | 0.026 | 0.034 | 0.044 | 0.050 | 0.070 | 0.085 | 0.10 | 0.13 | 0.15 | 0.17 | 41 (21 – 55) |
| | | 0,150 | 0,50 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0050 | 0,0060 | 0,0065 | 135 (96 – 180) |
| S3 | E | 0.150 | 0.50 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 0.14 | 0.15 | 36 (19 – 48) |
| | | 0,150 | 0,50 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0060 | 120 (63 – 150) |
| S11 | E | 0.400 | 0.70 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 0.12 | 110 (73 – 140) |
| | | 0,400 | 0,70 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0048 | 360 (240 – 450) |
| S12 | E | 0.400 | 0.70 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 0.12 | 85 (56 – 110) |
| | | 0,400 | 0,70 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0048 | 280 (190 – 360) |
| S13 | E | 0.400 | 0.70 | 0.016 | 0.022 | 0.026 | 0.032 | 0.042 | 0.055 | 0.065 | 0.080 | 0.090 | 0.10 | 65 (44 – 87) |
| | | 0,400 | 0,70 | 0,00065 | 0,00085 | 0,0010 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 0,0040 | 215 (150 – 280) |

Schnittdaten – JS754 Nutfräsen

| SMG | | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---------|--------------------|----------------|---------|---------|---------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | 25 | |
| P11 | M/A/D/E | 0.80 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.13 | 150 (120 – 170) |
| | | 0,80 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0050 | 490 (400 – 550) |
| P12 | M/A/D/E | 0.80 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.11 | 90 (69 – 100) |
| | | 0,80 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0044 | 295 (230 – 320) |
| M1 | E | 0.80 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.10 | 95 (85 – 120) |
| | | 0,80 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0040 | 310 (280 – 390) |
| M2 | E | 0.80 | 0.012 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.10 | 80 (69 – 97) |
| | | 0,80 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0040 | 260 (230 – 310) |
| M3 | E | 0.60 | 0.0095 | 0.012 | 0.015 | 0.019 | 0.025 | 0.030 | 0.038 | 0.050 | 0.060 | 0.075 | 55 (39 – 67) |
| | | 0,60 | 0,00038 | 0,00048 | 0,00060 | 0,00075 | 0,0010 | 0,0012 | 0,0015 | 0,0020 | 0,0024 | 0,0030 | 180 (130 – 210) |
| M4 | E | 0.60 | 0.0095 | 0.012 | 0.015 | 0.019 | 0.025 | 0.030 | 0.038 | 0.050 | 0.060 | 0.075 | 40 (29 – 50) |
| | | 0,60 | 0,00038 | 0,00048 | 0,00060 | 0,00075 | 0,0010 | 0,0012 | 0,0015 | 0,0020 | 0,0024 | 0,0030 | 130 (96 – 160) |
| M5 | E | 0.60 | 0.0095 | 0.012 | 0.015 | 0.019 | 0.025 | 0.030 | 0.038 | 0.050 | 0.060 | 0.075 | 33 (25 – 42) |
| | | 0,60 | 0,00038 | 0,00048 | 0,00060 | 0,00075 | 0,0010 | 0,0012 | 0,0015 | 0,0020 | 0,0024 | 0,0030 | 110 (83 – 130) |
| S1 | E | 0.30 | 0.0095 | 0.012 | 0.015 | 0.019 | 0.025 | 0.030 | 0.038 | 0.050 | 0.060 | 0.075 | 41 (21 – 54) |
| | | 0,30 | 0,00038 | 0,00048 | 0,00060 | 0,00075 | 0,0010 | 0,0012 | 0,0015 | 0,0020 | 0,0024 | 0,0030 | 135 (69 – 170) |
| S2 | E | 0.30 | 0.0095 | 0.012 | 0.015 | 0.019 | 0.025 | 0.030 | 0.038 | 0.050 | 0.060 | 0.075 | 33 (17 – 43) |
| | | 0,30 | 0,00038 | 0,00048 | 0,00060 | 0,00075 | 0,0010 | 0,0012 | 0,0015 | 0,0020 | 0,0024 | 0,0030 | 110 (56 – 140) |
| S3 | E | 0.30 | 0.0095 | 0.012 | 0.015 | 0.019 | 0.025 | 0.030 | 0.038 | 0.050 | 0.060 | 0.075 | 28 (15 – 37) |
| | | 0,30 | 0,00038 | 0,00048 | 0,00060 | 0,00075 | 0,0010 | 0,0012 | 0,0015 | 0,0020 | 0,0024 | 0,0030 | 90 (50 – 120) |
| S11 | E | 0.50 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.042 | 0.050 | 0.065 | 0.080 | 0.10 | 95 (63 – 120) |
| | | 0,50 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 310 (210 – 390) |
| S12 | E | 0.50 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.042 | 0.050 | 0.065 | 0.080 | 0.10 | 70 (48 – 95) |
| | | 0,50 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 230 (160 – 310) |
| S13 | E | 0.50 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.042 | 0.050 | 0.065 | 0.080 | 0.10 | 55 (38 – 74) |
| | | 0,50 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 180 (130 – 240) |

Bei einem Radius mit mehr als 15% DC, fz um 20% reduzieren

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – JS754_2C Dynamisches Fräsen $a_e/DC=0,05-0,1$

| SMG | | a_e/DC | a_p/DC | f_z | | v_c |
|-----|---------|----------|----------|--------|--------|-----------------|
| | | | | 10 | 12 | |
| P11 | M/A/D/E | 0.100 | 2.0 | 0.15 | 0.17 | 265 (220 – 290) |
| | | 0,100 | 2,0 | 0,0060 | 0,0065 | 870 (730 – 950) |
| P12 | M/A/D/E | 0.100 | 2.0 | 0.10 | 0.12 | 170 (150 – 190) |
| | | 0,100 | 2,0 | 0,0040 | 0,0048 | 560 (500 – 620) |
| M1 | E | 0.100 | 2.0 | 0.11 | 0.13 | 205 (180 – 230) |
| | | 0,100 | 2,0 | 0,0044 | 0,0050 | 670 (600 – 750) |
| M2 | E | 0.100 | 2.0 | 0.10 | 0.12 | 170 (150 – 190) |
| | | 0,100 | 2,0 | 0,0040 | 0,0048 | 560 (500 – 620) |
| M3 | E | 0.100 | 2.0 | 0.10 | 0.12 | 130 (120 – 150) |
| | | 0,100 | 2,0 | 0,0040 | 0,0048 | 425 (400 – 490) |
| M4 | E | 0.100 | 2.0 | 0.085 | 0.10 | 100 (86 – 110) |
| | | 0,100 | 2,0 | 0,0034 | 0,0040 | 330 (290 – 360) |
| M5 | E | 0.100 | 2.0 | 0.085 | 0.10 | 85 (72 – 96) |
| | | 0,100 | 2,0 | 0,0034 | 0,0040 | 280 (240 – 310) |
| S1 | E | 0.0500 | 2.0 | 0.085 | 0.10 | 70 (43 – 99) |
| | | 0,0500 | 2,0 | 0,0034 | 0,0040 | 230 (150 – 320) |
| S2 | E | 0.0500 | 2.0 | 0.085 | 0.10 | 60 (35 – 80) |
| | | 0,0500 | 2,0 | 0,0034 | 0,0040 | 195 (120 – 260) |
| S3 | E | 0.0500 | 2.0 | 0.080 | 0.095 | 50 (31 – 70) |
| | | 0,0500 | 2,0 | 0,0032 | 0,0038 | 165 (110 – 220) |
| S11 | E | 0.0800 | 2.0 | 0.070 | 0.085 | 165 (140 – 190) |
| | | 0,0800 | 2,0 | 0,0028 | 0,0034 | 540 (460 – 620) |
| S12 | E | 0.0800 | 2.0 | 0.070 | 0.085 | 125 (110 – 150) |
| | | 0,0800 | 2,0 | 0,0028 | 0,0034 | 410 (370 – 490) |
| S13 | E | 0.0800 | 2.0 | 0.060 | 0.070 | 100 (84 – 110) |
| | | 0,0800 | 2,0 | 0,0024 | 0,0028 | 330 (280 – 360) |

Schnittdaten – JS754_3C Dynamisches Fräsen $a_e/DC=0,05-0,1$

| SMG | | a_e/DC | a_p/DC | f_z | | | | | | v_c |
|-----|---------|----------|----------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | | 6 | 8 | 10 | 12 | 16 | 20 | |
| P11 | M/A/D/E | 0.100 | 4.0 | 0.090 | 0.12 | 0.15 | 0.17 | 0.22 | 0.25 | 265 (220 – 290) |
| | | 0,100 | 4,0 | 0,0036 | 0,0048 | 0,0060 | 0,0065 | 0,0085 | 0,010 | 870 (730 – 950) |
| P12 | M/A/D/E | 0.100 | 4.0 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 170 (140 – 180) |
| | | 0,100 | 4,0 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 560 (460 – 590) |
| M1 | E | 0.100 | 4.0 | 0.065 | 0.090 | 0.11 | 0.13 | 0.16 | 0.19 | 205 (170 – 230) |
| | | 0,100 | 4,0 | 0,0026 | 0,0036 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 670 (560 – 750) |
| M2 | E | 0.100 | 4.0 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 170 (140 – 190) |
| | | 0,100 | 4,0 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 560 (460 – 620) |
| M3 | E | 0.100 | 4.0 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 130 (110 – 150) |
| | | 0,100 | 4,0 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 425 (370 – 490) |
| M4 | E | 0.100 | 4.0 | 0.050 | 0.070 | 0.085 | 0.10 | 0.13 | 0.15 | 100 (86 – 110) |
| | | 0,100 | 4,0 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0050 | 0,0060 | 330 (290 – 360) |
| M5 | E | 0.100 | 4.0 | 0.050 | 0.070 | 0.085 | 0.10 | 0.13 | 0.15 | 85 (72 – 96) |
| | | 0,100 | 4,0 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0050 | 0,0060 | 280 (240 – 310) |
| S1 | E | 0.0500 | 4.0 | 0.050 | 0.070 | 0.085 | 0.10 | 0.13 | 0.15 | 70 (43 – 99) |
| | | 0,0500 | 4,0 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0050 | 0,0060 | 230 (150 – 320) |
| S2 | E | 0.0500 | 4.0 | 0.050 | 0.070 | 0.085 | 0.10 | 0.13 | 0.15 | 55 (35 – 80) |
| | | 0,0500 | 4,0 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0050 | 0,0060 | 180 (120 – 260) |
| S3 | E | 0.0500 | 4.0 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 0.14 | 50 (30 – 70) |
| | | 0,0500 | 4,0 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 165 (99 – 220) |
| S11 | E | 0.0800 | 4.0 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 165 (140 – 190) |
| | | 0,0800 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 540 (460 – 620) |
| S12 | E | 0.0800 | 4.0 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 125 (110 – 150) |
| | | 0,0800 | 4,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 410 (370 – 490) |
| S13 | E | 0.0800 | 4.0 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 100 (84 – 110) |
| | | 0,0800 | 4,0 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 330 (280 – 360) |

Bei einem Radius mit mehr als 15% DC, f_z um 20% reduzieren

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

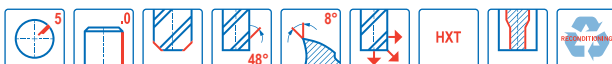
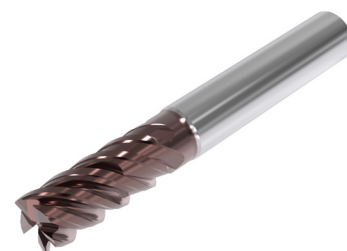
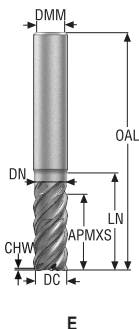
a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

JS755

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 5 Schneiden – Zylindrisch – Fase



- Toleranzen:
- DMM = h5
- DC= e7
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS755060E2C.0Z5-HXT | 03186907 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,075 | 5 | ■ |
| JS755080E2C.0Z5-HXT | 03186908 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 0,1 | 5 | ■ |
| JS755100E2C.0Z5-HXT | 03186909 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,125 | 5 | ■ |
| JS755120E2C.0Z5-HXT | 03186910 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,15 | 5 | ■ |
| JS755160E2C.0Z5-HXT | 03186911 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 0,2 | 5 | ■ |
| JS755200E2C.0Z5-HXT | 03186912 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 0,25 | 5 | ■ |
| JS755250E2C.0Z5-HXT | 03186913 | 2 | E | 25,0 | 25,0 | 50,0 | 121,0 | 65,0 | 23,8 | 0,3 | 5 | ■ |
| JS755060E3C.0Z5-HXT | 03186914 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,075 | 5 | ■ |
| JS755080E3C.0Z5-HXT | 03186915 | 3 | E | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 0,1 | 5 | ■ |
| JS755100E3C.0Z5-HXT | 03186916 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 0,125 | 5 | ■ |
| JS755120E3C.0Z5-HXT | 03186917 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 0,15 | 5 | ■ |
| JS755160E3C.0Z5-HXT | 03186918 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 0,2 | 5 | ■ |
| JS755200E3C.0Z5-HXT | 03186919 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 0,25 | 5 | ■ |
| JS755250E3C.0Z5-HXT | 03186920 | 3 | E | 25,0 | 25,0 | 85,0 | 153,0 | 94,0 | 23,8 | 0,3 | 5 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

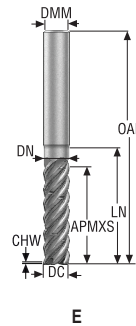
X-Heads

Minimaster Plus

Minimaster

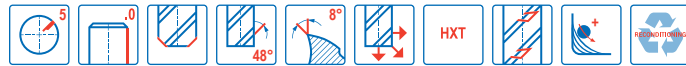
JS755

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 5 Schneiden – Zylindrisch – Fase – Spanteiler



E

- Toleranzen:
- DMM = h5
- DC= e7
- Spanteiler
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | Spanteiler | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Zylindrisch |
|----------------------|--------------------|------------------|-------------------|------------|------|------|-------|-------|------|------|-------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS755100E3C.0Z5C-HXT | 03186921 | 3 | E | ■ | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 0,125 | 5 | ■ |
| JS755120E3C.0Z5C-HXT | 03186922 | 3 | E | ■ | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 0,15 | 5 | ■ |
| JS755160E3C.0Z5C-HXT | 03186923 | 3 | E | ■ | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 0,2 | 5 | ■ |
| JS755200E3C.0Z5C-HXT | 03186924 | 3 | E | ■ | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 0,25 | 5 | ■ |

■ Lagerstandard.

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Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

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Harter

Kunststoffe und Composite

Graphit

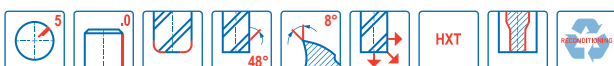
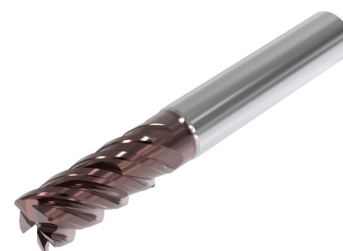
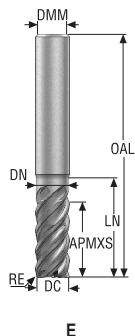
X-Heads

Minimaster Plus

Minimaster

JS755

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 5 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|------------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS755060E2R020.0Z5-HXT | 03186925 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,2 | 5 | ■ |
| JS755060E2R050.0Z5-HXT | 03186926 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,5 | 5 | ■ |
| JS755060E2R100.0Z5-HXT | 03186927 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 1,0 | 5 | ■ |
| JS755080E2R050.0Z5-HXT | 03186928 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 0,5 | 5 | ■ |
| JS755080E2R100.0Z5-HXT | 03186929 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 1,0 | 5 | ■ |
| JS755100E2R050.0Z5-HXT | 03186930 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,5 | 5 | ■ |
| JS755100E2R100.0Z5-HXT | 03186931 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 1,0 | 5 | ■ |
| JS755100E2R200.0Z5-HXT | 03186932 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 2,0 | 5 | ■ |
| JS755100E2R300.0Z5-HXT | 03186933 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 3,0 | 5 | ■ |
| JS755120E2R050.0Z5-HXT | 03186934 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,5 | 5 | ■ |
| JS755120E2R100.0Z5-HXT | 03186935 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 1,0 | 5 | ■ |
| JS755120E2R200.0Z5-HXT | 03186936 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 2,0 | 5 | ■ |
| JS755120E2R300.0Z5-HXT | 03186937 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 3,0 | 5 | ■ |
| JS755160E2R050.0Z5-HXT | 03186938 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 0,5 | 5 | ■ |
| JS755160E2R100.0Z5-HXT | 03186939 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 1,0 | 5 | ■ |
| JS755160E2R600.0Z5-HXT | 03186940 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 6,0 | 5 | ■ |
| JS755200E2R050.0Z5-HXT | 03186941 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 0,5 | 5 | ■ |
| JS755200E2R100.0Z5-HXT | 03186942 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 1,0 | 5 | ■ |
| JS755200E2R600.0Z5-HXT | 03186943 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 6,0 | 5 | ■ |

■ Lagerstandard.

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Rostfrei und ISO-S-Werkstoffe

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Harter

Kunststoffe und Composite

Graphit

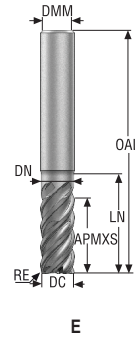
X-Heads

Minimaster Plus

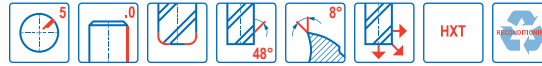
Minimaster

JS755

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 5 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|------------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS755060E3R020.0Z5-HXT | 03186946 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,2 | 5 | ■ |
| JS755060E3R050.0Z5-HXT | 03186947 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,5 | 5 | ■ |
| JS755060E3R100.0Z5-HXT | 03186948 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 1,0 | 5 | ■ |
| JS755080E3R050.0Z5-HXT | 03186949 | 3 | E | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 0,5 | 5 | ■ |
| JS755080E3R100.0Z5-HXT | 03186950 | 3 | E | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 1,0 | 5 | ■ |
| JS755100E3R050.0Z5-HXT | 03186951 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 0,5 | 5 | ■ |
| JS755100E3R100.0Z5-HXT | 03186952 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 1,0 | 5 | ■ |
| JS755100E3R200.0Z5-HXT | 03186953 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 2,0 | 5 | ■ |
| JS755100E3R300.0Z5-HXT | 03186954 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 3,0 | 5 | ■ |
| JS755120E3R050.0Z5-HXT | 03186955 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 0,5 | 5 | ■ |
| JS755120E3R100.0Z5-HXT | 03186956 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 1,0 | 5 | ■ |
| JS755120E3R200.0Z5-HXT | 03186957 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 2,0 | 5 | ■ |
| JS755120E3R300.0Z5-HXT | 03186958 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 3,0 | 5 | ■ |
| JS755160E3R050.0Z5-HXT | 03186959 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 0,5 | 5 | ■ |
| JS755160E3R600.0Z5-HXT | 03186960 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 6,0 | 5 | ■ |
| JS755200E3R050.0Z5-HXT | 03186961 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 0,5 | 5 | ■ |
| JS755200E3R600.0Z5-HXT | 03186962 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 6,0 | 5 | ■ |

■ Lagerstandard.

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Harder

Kunststoffe und
Composite

Graphit

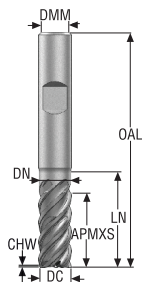
X-Heads

Minimaster Plus

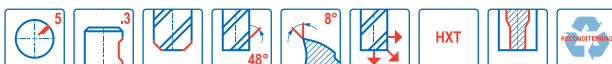
Minimaster

JS755

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 5 Schneiden – Weldon – Fase



E



- Toleranzen:
- DMM = h5
- DC= e7
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Weldon |
|---------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-------|-------|--------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS755060E2C.3Z5-HXT | 03187083 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,075 | 5 | ■ |
| JS755080E2C.3Z5-HXT | 03187084 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 0,1 | 5 | ■ |
| JS755100E2C.3Z5-HXT | 03187085 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,125 | 5 | ■ |
| JS755120E2C.3Z5-HXT | 03187086 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,15 | 5 | ■ |
| JS755160E2C.3Z5-HXT | 03187087 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 0,2 | 5 | ■ |
| JS755200E2C.3Z5-HXT | 03187088 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 0,25 | 5 | ■ |
| JS755250E2C.3Z5-HXT | 03187089 | 2 | E | 25,0 | 25,0 | 50,0 | 121,0 | 65,0 | 23,8 | 0,3 | 5 | ■ |
| JS755060E3C.3Z5-HXT | 03187090 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,075 | 5 | ■ |
| JS755080E3C.3Z5-HXT | 03187091 | 3 | E | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 0,1 | 5 | ■ |
| JS755100E3C.3Z5-HXT | 03187092 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 0,125 | 5 | ■ |
| JS755120E3C.3Z5-HXT | 03187093 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 0,15 | 5 | ■ |
| JS755160E3C.3Z5-HXT | 03187094 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 0,2 | 5 | ■ |
| JS755200E3C.3Z5-HXT | 03187095 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 0,25 | 5 | ■ |
| JS755250E3C.3Z5-HXT | 03187096 | 3 | E | 25,0 | 25,0 | 85,0 | 153,0 | 94,0 | 23,8 | 0,3 | 5 | ■ |

■ Lagerstandard.

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Rostfrei und ISO-S-Werkstoffe

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Graphit

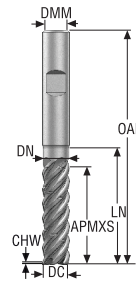
X-Heads

Minimaster Plus

Minimaster

JS755

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 5 Schneiden – Weldon – Fase – Spanteiler



E

- Toleranzen:
- DMM = h5
- DC= e7
- Spanteiler
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | Spanteiler | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Weldon |
|----------------------|--------------------|------------------|-------------------|------------|------|------|-------|-------|------|------|-------|-------|--------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS755100E3C.3Z5C-HXT | 03187097 | 3 | E | ■ | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 0,125 | 5 | ■ |
| JS755120E3C.3Z5C-HXT | 03187098 | 3 | E | ■ | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 0,15 | 5 | ■ |
| JS755160E3C.3Z5C-HXT | 03187099 | 3 | E | ■ | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 0,2 | 5 | ■ |
| JS755200E3C.3Z5C-HXT | 03187100 | 3 | E | ■ | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 0,25 | 5 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

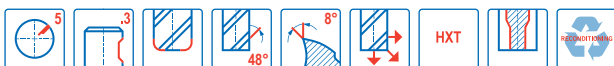
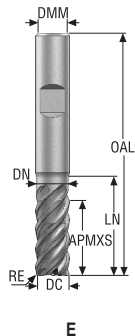
X-Heads

Minimaster Plus

Minimaster

JS755

Hochleistungsfräser – Eckfräser – ISO– M und ISO– S – 5 Schneiden – Weldon – Eckenradius



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Weldon |
|------------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-------|--------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS755060E2R020.3Z5-HXT | 03187101 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,2 | 5 | ■ |
| JS755060E2R050.3Z5-HXT | 03187102 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,5 | 5 | ■ |
| JS755060E2R100.3Z5-HXT | 03187103 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 1,0 | 5 | ■ |
| JS755080E2R050.3Z5-HXT | 03187104 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 0,5 | 5 | ■ |
| JS755080E2R100.3Z5-HXT | 03187105 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 1,0 | 5 | ■ |
| JS755100E2R050.3Z5-HXT | 03187106 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,5 | 5 | ■ |
| JS755100E2R100.3Z5-HXT | 03187107 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 1,0 | 5 | ■ |
| JS755100E2R200.3Z5-HXT | 03187108 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 2,0 | 5 | ■ |
| JS755100E2R300.3Z5-HXT | 03187109 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 3,0 | 5 | ■ |
| JS755120E2R050.3Z5-HXT | 03187110 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,5 | 5 | ■ |
| JS755120E2R100.3Z5-HXT | 03187111 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 1,0 | 5 | ■ |
| JS755120E2R200.3Z5-HXT | 03187112 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 2,0 | 5 | ■ |
| JS755120E2R300.3Z5-HXT | 03187113 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 3,0 | 5 | ■ |
| JS755160E2R050.3Z5-HXT | 03187114 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 0,5 | 5 | ■ |
| JS755160E2R100.3Z5-HXT | 03187115 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 1,0 | 5 | ■ |
| JS755160E2R600.3Z5-HXT | 03187116 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 6,0 | 5 | ■ |
| JS755200E2R050.3Z5-HXT | 03187117 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 0,5 | 5 | ■ |
| JS755200E2R100.3Z5-HXT | 03187118 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 1,0 | 5 | ■ |
| JS755200E2R600.3Z5-HXT | 03187119 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 6,0 | 5 | ■ |
| JS755060E3R020.3Z5-HXT | 03187122 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,2 | 5 | □ |
| JS755060E3R050.3Z5-HXT | 03187123 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,5 | 5 | □ |
| JS755060E3R100.3Z5-HXT | 03187124 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 1,0 | 5 | □ |
| JS755080E3R050.3Z5-HXT | 03187125 | 3 | E | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 0,5 | 5 | □ |
| JS755080E3R100.3Z5-HXT | 03187126 | 3 | E | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 1,0 | 5 | □ |
| JS755100E3R050.3Z5-HXT | 03187127 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 0,5 | 5 | □ |
| JS755100E3R100.3Z5-HXT | 03187128 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 1,0 | 5 | □ |
| JS755100E3R200.3Z5-HXT | 03187129 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 2,0 | 5 | □ |
| JS755100E3R300.3Z5-HXT | 03187130 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 3,0 | 5 | □ |
| JS755120E3R050.3Z5-HXT | 03187131 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 0,5 | 5 | □ |
| JS755120E3R100.3Z5-HXT | 03187132 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 1,0 | 5 | □ |
| JS755120E3R200.3Z5-HXT | 03187133 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 2,0 | 5 | □ |
| JS755120E3R300.3Z5-HXT | 03187134 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 3,0 | 5 | □ |
| JS755160E3R050.3Z5-HXT | 03187135 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 0,5 | 5 | □ |
| JS755160E3R600.3Z5-HXT | 03187136 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 6,0 | 5 | □ |
| JS755200E3R050.3Z5-HXT | 03187137 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 0,5 | 5 | □ |
| JS755200E3R600.3Z5-HXT | 03187138 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 6,0 | 5 | □ |

■ Lagerstandard. □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

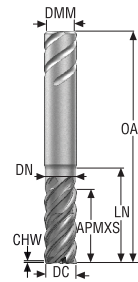
X-Heads

Minimaster Plus

Minimaster

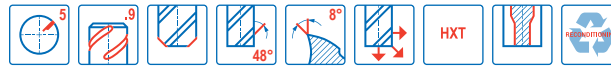
JS755

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 5 Schneiden – Safe-Lock – Fase



E

- Toleranzen:
- DMM = h5
- DC= e7
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Safe-Lock |
|---------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-------|-------|--------------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS755060E2C.9Z5-HXT | 03187235 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,075 | 5 | <input type="checkbox"/> |
| JS755080E2C.9Z5-HXT | 03187236 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 0,1 | 5 | <input type="checkbox"/> |
| JS755100E2C.9Z5-HXT | 03187237 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,125 | 5 | <input type="checkbox"/> |
| JS755120E2C.9Z5-HXT | 03187238 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,15 | 5 | <input type="checkbox"/> |
| JS755160E2C.9Z5-HXT | 03187239 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 0,2 | 5 | <input type="checkbox"/> |
| JS755200E2C.9Z5-HXT | 03187240 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 0,25 | 5 | <input type="checkbox"/> |
| JS755250E2C.9Z5-HXT | 03187241 | 2 | E | 25,0 | 25,0 | 50,0 | 121,0 | 65,0 | 23,8 | 0,3 | 5 | <input type="checkbox"/> |
| JS755060E3C.9Z5-HXT | 03187242 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,075 | 5 | <input type="checkbox"/> |
| JS755080E3C.9Z5-HXT | 03187243 | 3 | E | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 0,1 | 5 | <input type="checkbox"/> |
| JS755100E3C.9Z5-HXT | 03187244 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 0,125 | 5 | <input type="checkbox"/> |
| JS755120E3C.9Z5-HXT | 03187245 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 0,15 | 5 | <input type="checkbox"/> |
| JS755160E3C.9Z5-HXT | 03187246 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 0,2 | 5 | <input type="checkbox"/> |
| JS755200E3C.9Z5-HXT | 03187247 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 0,25 | 5 | <input type="checkbox"/> |
| JS755250E3C.9Z5-HXT | 03187248 | 3 | E | 25,0 | 25,0 | 85,0 | 153,0 | 94,0 | 23,8 | 0,3 | 5 | <input type="checkbox"/> |

Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und Composite

Graphit

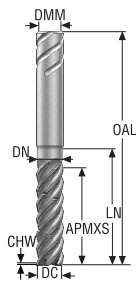
X-Heads

Minimaster Plus

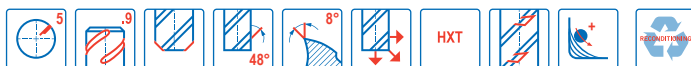
Minimaster

JS755

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 5 Schneiden – Safe-Lock – Fase – Spanteiler



E



- Toleranzen:
- DMM = h5
- DC= e7
- Spanteiler
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | Spanteiler | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Safe-Lock |
|----------------------|--------------------|------------------|-------------------|------------|------|------|-------|-------|------|------|-------|-------|--------------------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS755100E3C.9Z5C-HXT | 03187249 | 3 | E | ■ | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 0,125 | 5 | <input type="checkbox"/> |
| JS755120E3C.9Z5C-HXT | 03187250 | 3 | E | ■ | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 0,15 | 5 | <input type="checkbox"/> |
| JS755160E3C.9Z5C-HXT | 03187252 | 3 | E | ■ | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 0,2 | 5 | <input type="checkbox"/> |
| JS755200E3C.9Z5C-HXT | 03187253 | 3 | E | ■ | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 0,25 | 5 | <input type="checkbox"/> |

Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

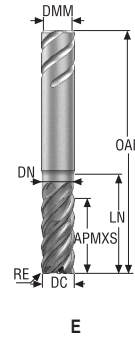
X-Heads

Minimaster Plus

Minimaster

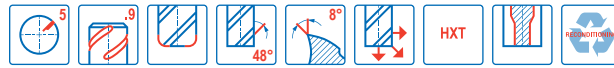
JS755

Hochleistungsfräser – Eckfräser – ISO- M und ISO- S – 5 Schneiden – Safe-Lock – Eckenradius



E

- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Safe-Lock |
|------------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-------|--------------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS755060E2R020.9Z5-HXT | 03187254 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,2 | 5 | <input type="checkbox"/> |
| JS755060E2R050.9Z5-HXT | 03187255 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 0,5 | 5 | <input type="checkbox"/> |
| JS755060E2R100.9Z5-HXT | 03187256 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 18,0 | 5,7 | 1,0 | 5 | <input type="checkbox"/> |
| JS755080E2R050.9Z5-HXT | 03187257 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 0,5 | 5 | <input type="checkbox"/> |
| JS755080E2R100.9Z5-HXT | 03187258 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 25,0 | 7,6 | 1,0 | 5 | <input type="checkbox"/> |
| JS755100E2R050.9Z5-HXT | 03187259 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,5 | 5 | <input type="checkbox"/> |
| JS755100E2R100.9Z5-HXT | 03187260 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 1,0 | 5 | <input type="checkbox"/> |
| JS755100E2R200.9Z5-HXT | 03187261 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 2,0 | 5 | <input type="checkbox"/> |
| JS755100E2R300.9Z5-HXT | 03187262 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 3,0 | 5 | <input type="checkbox"/> |
| JS755120E2R050.9Z5-HXT | 03187263 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,5 | 5 | <input type="checkbox"/> |
| JS755120E2R100.9Z5-HXT | 03187264 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 1,0 | 5 | <input type="checkbox"/> |
| JS755120E2R200.9Z5-HXT | 03187265 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 2,0 | 5 | <input type="checkbox"/> |
| JS755120E2R300.9Z5-HXT | 03187266 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 3,0 | 5 | <input type="checkbox"/> |
| JS755160E2R050.9Z5-HXT | 03187267 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 0,5 | 5 | <input type="checkbox"/> |
| JS755160E2R100.9Z5-HXT | 03187269 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 1,0 | 5 | <input type="checkbox"/> |
| JS755160E2R600.9Z5-HXT | 03187270 | 2 | E | 16,0 | 16,0 | 32,0 | 92,0 | 42,0 | 15,2 | 6,0 | 5 | <input type="checkbox"/> |
| JS755200E2R050.9Z5-HXT | 03187271 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 0,5 | 5 | <input type="checkbox"/> |
| JS755200E2R100.9Z5-HXT | 03187272 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 1,0 | 5 | <input type="checkbox"/> |
| JS755200E2R600.9Z5-HXT | 03187273 | 2 | E | 20,0 | 20,0 | 40,0 | 104,0 | 51,0 | 19,0 | 6,0 | 5 | <input type="checkbox"/> |
| JS755060E3R020.9Z5-HXT | 03187276 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,2 | 5 | <input type="checkbox"/> |
| JS755060E3R050.9Z5-HXT | 03187277 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 0,5 | 5 | <input type="checkbox"/> |
| JS755060E3R100.9Z5-HXT | 03187279 | 3 | E | 6,0 | 6,0 | 21,0 | 65,0 | 26,0 | 5,7 | 1,0 | 5 | <input type="checkbox"/> |
| JS755080E3R050.9Z5-HXT | 03187280 | 3 | E | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 0,5 | 5 | <input type="checkbox"/> |
| JS755080E3R100.9Z5-HXT | 03187281 | 3 | E | 8,0 | 8,0 | 32,0 | 75,0 | 37,0 | 7,6 | 1,0 | 5 | <input type="checkbox"/> |
| JS755100E3R050.9Z5-HXT | 03187282 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 0,5 | 5 | <input type="checkbox"/> |
| JS755100E3R100.9Z5-HXT | 03187283 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 1,0 | 5 | <input type="checkbox"/> |
| JS755100E3R200.9Z5-HXT | 03187284 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 2,0 | 5 | <input type="checkbox"/> |
| JS755100E3R300.9Z5-HXT | 03187285 | 3 | E | 10,0 | 10,0 | 40,0 | 89,0 | 47,0 | 9,5 | 3,0 | 5 | <input type="checkbox"/> |
| JS755120E3R050.9Z5-HXT | 03187286 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 0,5 | 5 | <input type="checkbox"/> |
| JS755120E3R100.9Z5-HXT | 03187287 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 1,0 | 5 | <input type="checkbox"/> |
| JS755120E3R200.9Z5-HXT | 03187288 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 2,0 | 5 | <input type="checkbox"/> |
| JS755120E3R300.9Z5-HXT | 03187289 | 3 | E | 12,0 | 12,0 | 45,0 | 100,0 | 53,0 | 11,4 | 3,0 | 5 | <input type="checkbox"/> |
| JS755160E3R050.9Z5-HXT | 03187290 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 0,5 | 5 | <input type="checkbox"/> |
| JS755160E3R600.9Z5-HXT | 03187291 | 3 | E | 16,0 | 16,0 | 55,0 | 115,0 | 65,0 | 15,2 | 6,0 | 5 | <input type="checkbox"/> |
| JS755200E3R050.9Z5-HXT | 03187292 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 0,5 | 5 | <input type="checkbox"/> |
| JS755200E3R600.9Z5-HXT | 03187293 | 3 | E | 20,0 | 20,0 | 61,0 | 125,0 | 72,0 | 19,0 | 6,0 | 5 | <input type="checkbox"/> |

Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

Schnittdaten – JS755 Eckfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | v _c | |
|-----|---------|--------------------|--------------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|------------------------------------|
| | | | | 6 | 8 | 10 | 12 | 16 | 20 | | 25 |
| P11 | M/A/D/E | 0.400 0,400 | 1.1 1,1 | 0.044 0,0017 | 0.060 0,0024 | 0.075 0,0030 | 0.085 0,0034 | 0.11 0,0044 | 0.12 0,0048 | 0.14 0,0055 | 135 (97 – 150) 445 (320 – 490) |
| P12 | M/A/D/E | 0.400 0,400 | 1.1 1,1 | 0.030 0,0012 | 0.040 0,0016 | 0.050 0,0020 | 0.060 0,0024 | 0.075 0,0030 | 0.085 0,0034 | 0.095 0,0038 | 85 (63 – 99) 280 (210 – 320) |
| M1 | E | 0.400 0,400 | 1.1 1,1 | 0.032 0,0013 | 0.044 0,0017 | 0.055 0,0022 | 0.065 0,0026 | 0.080 0,0032 | 0.095 0,0038 | 0.11 0,0044 | 170 (150 – 190) 560 (500 – 620) |
| M2 | E | 0.400 0,400 | 1.1 1,1 | 0.030 0,0012 | 0.040 0,0016 | 0.050 0,0020 | 0.060 0,0024 | 0.075 0,0030 | 0.085 0,0034 | 0.095 0,0038 | 140 (120 – 150) 460 (400 – 490) |
| M3 | E | 0.400 0,400 | 1.1 1,1 | 0.030 0,0012 | 0.040 0,0016 | 0.050 0,0020 | 0.060 0,0024 | 0.075 0,0030 | 0.085 0,0034 | 0.095 0,0038 | 110 (92 – 120) 360 (310 – 390) |
| M4 | E | 0.400 0,400 | 1.1 1,1 | 0.026 0,0010 | 0.034 0,0013 | 0.044 0,0017 | 0.050 0,0020 | 0.065 0,0026 | 0.075 0,0030 | 0.085 0,0034 | 85 (71 – 95) 280 (240 – 310) |
| M5 | E | 0.400 0,400 | 1.1 1,1 | 0.026 0,0010 | 0.034 0,0013 | 0.044 0,0017 | 0.050 0,0020 | 0.065 0,0026 | 0.075 0,0030 | 0.085 0,0034 | 70 (59 – 79) 230 (200 – 250) |
| S1 | E | 0.0300 0,0300 | 2.0 2,0 | 0.046 0,0018 | 0.060 0,0024 | 0.075 0,0030 | 0.090 0,0036 | 0.11 0,0044 | 0.13 0,0050 | 0.14 0,0055 | 70 (48 – 110) 230 (160 – 360) |
| S2 | E | 0.0300 0,0300 | 2.0 2,0 | 0.046 0,0018 | 0.060 0,0024 | 0.075 0,0030 | 0.090 0,0036 | 0.11 0,0044 | 0.13 0,0050 | 0.14 0,0055 | 60 (39 – 89) 195 (130 – 290) |
| S3 | E | 0.0300 0,0300 | 2.0 2,0 | 0.042 0,0017 | 0.055 0,0022 | 0.070 0,0028 | 0.085 0,0034 | 0.10 0,0040 | 0.12 0,0048 | 0.13 0,0050 | 50 (34 – 78) 165 (120 – 250) |
| S11 | E | 0.400 0,400 | 1.1 1,1 | 0.030 0,0012 | 0.040 0,0016 | 0.050 0,0020 | 0.060 0,0024 | 0.075 0,0030 | 0.085 0,0034 | 0.095 0,0038 | 140 (120 – 160) 460 (400 – 520) |
| S12 | E | 0.400 0,400 | 1.1 1,1 | 0.030 0,0012 | 0.040 0,0016 | 0.050 0,0020 | 0.060 0,0024 | 0.075 0,0030 | 0.085 0,0034 | 0.095 0,0038 | 110 (91 – 120) 360 (300 – 390) |
| S13 | E | 0.400 0,400 | 1.1 1,1 | 0.026 0,0010 | 0.034 0,0013 | 0.044 0,0017 | 0.050 0,0020 | 0.065 0,0026 | 0.075 0,0030 | 0.085 0,0034 | 85 (73 – 100) 280 (240 – 320) |

Schnittdaten – JS755_3C Dynamisches Fräsen a_e/DC=0,05-0,1

| SMG | | a _e /DC | a _p /DC | f _z | | | | v _c |
|-----|---------|--------------------|--------------------|-----------------|-----------------|-----------------|----------------|------------------------------------|
| | | | | 10 | 12 | 16 | 20 | |
| P11 | M/A/D/E | 0.100 0,100 | 4.0 4,0 | 0.15 0,0060 | 0.17 0,0065 | 0.22 0,0085 | 0.25 0,010 | 265 (220 – 290) 870 (730 – 950) |
| P12 | M/A/D/E | 0.100 0,100 | 4.0 4,0 | 0.10 0,0040 | 0.12 0,0048 | 0.15 0,0060 | 0.17 0,0065 | 170 (140 – 180) 560 (460 – 590) |
| M1 | E | 0.100 0,100 | 4.0 4,0 | 0.11 0,0044 | 0.13 0,0050 | 0.16 0,0065 | 0.19 0,0075 | 205 (170 – 220) 670 (560 – 720) |
| M2 | E | 0.100 0,100 | 4.0 4,0 | 0.10 0,0040 | 0.12 0,0048 | 0.15 0,0060 | 0.17 0,0065 | 170 (140 – 180) 560 (460 – 590) |
| M3 | E | 0.100 0,100 | 4.0 4,0 | 0.10 0,0040 | 0.12 0,0048 | 0.15 0,0060 | 0.17 0,0065 | 130 (110 – 140) 425 (370 – 450) |
| M4 | E | 0.100 0,100 | 4.0 4,0 | 0.085 0,0034 | 0.10 0,0040 | 0.13 0,0050 | 0.15 0,0060 | 100 (85 – 110) 330 (280 – 360) |
| M5 | E | 0.100 0,100 | 4.0 4,0 | 0.085 0,0034 | 0.10 0,0040 | 0.13 0,0050 | 0.15 0,0060 | 85 (71 – 96) 280 (240 – 310) |
| S1 | E | 0.0500 0,0500 | 4.0 4,0 | 0.085 0,0034 | 0.10 0,0040 | 0.13 0,0050 | 0.15 0,0060 | 70 (43 – 99) 230 (150 – 320) |
| S2 | E | 0.0500 0,0500 | 4.0 4,0 | 0.085 0,0034 | 0.10 0,0040 | 0.13 0,0050 | 0.15 0,0060 | 55 (35 – 80) 180 (120 – 260) |
| S3 | E | 0.0500 0,0500 | 4.0 4,0 | 0.080 0,0032 | 0.095 0,0038 | 0.12 0,0048 | 0.14 0,0055 | 50 (31 – 70) 165 (110 – 220) |
| S11 | E | 0.0800 0,0800 | 4.0 4,0 | 0.070 0,0028 | 0.085 0,0034 | 0.10 0,0040 | 0.12 0,0048 | 160 (140 – 190) 520 (460 – 620) |
| S12 | E | 0.0800 0,0800 | 4.0 4,0 | 0.070 0,0028 | 0.085 0,0034 | 0.10 0,0040 | 0.12 0,0048 | 125 (110 – 140) 410 (370 – 450) |
| S13 | E | 0.0800 0,0800 | 4.0 4,0 | 0.060 0,0024 | 0.070 0,0028 | 0.090 0,0036 | 0.10 0,0040 | 100 (83 – 110) 330 (280 – 360) |

Bei einem Radius mit mehr als 15% DC, fz um 20% reduzieren

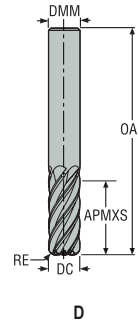
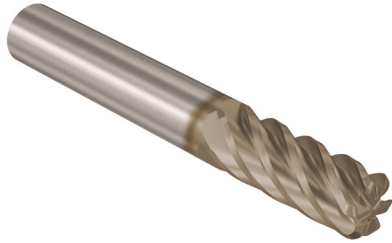
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c = m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

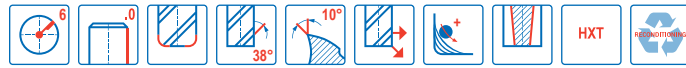
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Stahl und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

JS720

Hochleistungsfräser – Titan – Eckfräser – 6 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM = h5
- DC = e7
- RE = ±0,02 mm
- Nachschleifen möglich

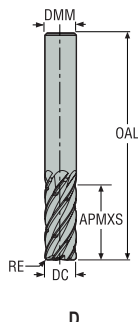


| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | RE | PCEDC | Zylindrisch |
|------------------------|--------------------|------------------|-------------------|------|------|-------|-------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | | |
| JS720060D2R050.0Z6-HXT | 03060293 | 2 | D | 6,0 | 6,0 | 17,0 | 57,0 | 0,5 | 6 | ■ |
| JS720060D2R100.0Z6-HXT | 03060294 | 2 | D | 6,0 | 6,0 | 17,0 | 57,0 | 1,0 | 6 | ■ |
| JS720080D2R050.0Z6-HXT | 03060295 | 2 | D | 8,0 | 8,0 | 23,0 | 63,0 | 0,5 | 6 | ■ |
| JS720080D2R100.0Z6-HXT | 03061294 | 2 | D | 8,0 | 8,0 | 23,0 | 63,0 | 1,0 | 6 | ■ |
| JS720100D2R050.0Z6-HXT | 03060296 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 0,5 | 6 | ■ |
| JS720100D2R100.0Z6-HXT | 03060298 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 1,0 | 6 | ■ |
| JS720100D2R200.0Z6-HXT | 03060299 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 2,0 | 6 | ■ |
| JS720100D2R300.0Z6-HXT | 03060300 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 3,0 | 6 | ■ |
| JS720120D2R050.0Z6-HXT | 03060301 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 0,5 | 6 | ■ |
| JS720120D2R100.0Z6-HXT | 03060304 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 1,0 | 6 | ■ |
| JS720120D2R200.0Z6-HXT | 03060305 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 2,0 | 6 | ■ |
| JS720120D2R300.0Z6-HXT | 03060306 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 3,0 | 6 | ■ |
| JS720160D2R050.0Z6-HXT | 03060307 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 0,5 | 6 | ■ |
| JS720160D2R100.0Z6-HXT | 03060309 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 1,0 | 6 | ■ |
| JS720160D2R200.0Z6-HXT | 03060310 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 2,0 | 6 | ■ |
| JS720160D2R300.0Z6-HXT | 03060311 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 3,0 | 6 | ■ |
| JS720160D2R400.0Z6-HXT | 03060312 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 4,0 | 6 | ■ |
| JS720160D2R600.0Z6-HXT | 03060313 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 6,0 | 6 | ■ |
| JS720250D2R300.0Z6-HXT | 03169498 | 2 | D | 25,0 | 25,0 | 50,0 | 125,0 | 3,0 | 6 | ■ |
| JS720160D3R300.0Z6-HXT | 03169497 | 3 | D | 16,0 | 16,0 | 65,0 | 130,0 | 3,0 | 6 | ■ |
| JS720200D3R050.0Z6-HXT | 03060314 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 0,5 | 6 | ■ |
| JS720200D3R100.0Z6-HXT | 03060316 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 1,0 | 6 | ■ |
| JS720200D3R200.0Z6-HXT | 03060317 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 2,0 | 6 | ■ |
| JS720200D3R300.0Z6-HXT | 03060318 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 3,0 | 6 | ■ |
| JS720200D3R400.0Z6-HXT | 03060319 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 4,0 | 6 | ■ |
| JS720200D3R500.0Z6-HXT | 03060320 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 5,0 | 6 | ■ |
| JS720200D3R600.0Z6-HXT | 03060321 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 6,0 | 6 | ■ |
| JS720250D3R050.0Z6-HXT | 03060322 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 0,5 | 6 | ■ |
| JS720250D3R100.0Z6-HXT | 03060323 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 1,0 | 6 | ■ |
| JS720250D3R200.0Z6-HXT | 03060324 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 2,0 | 6 | ■ |
| JS720250D3R300.0Z6-HXT | 03060325 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 3,0 | 6 | ■ |
| JS720250D3R400.0Z6-HXT | 03060326 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 4,0 | 6 | ■ |
| JS720250D3R600.0Z6-HXT | 03060327 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 6,0 | 6 | ■ |

■ Lagerstandard.

JS720

Hochleistungsfräser – Titan – Eckfräser – 6 Schneiden – Zylindrisch – Eckenradius – Spanteiler



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Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster



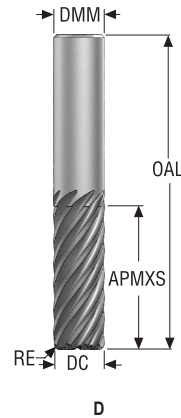
- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Spanteiler
- Nachschleifen möglich

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | Spanteiler | DC | DMM | APMXS | OAL | RE | PCEDC | Zylindrisch |
|-------------------------|----------------|--------------|---------------|------------|------|------|-------|-------|-----|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | | |
| JS720100D2R050.0Z6C-HXT | 03060297 | 2 | D | ■ | 10,0 | 10,0 | 26,0 | 72,0 | 0,5 | 6 | ■ |
| JS720120D2R050.0Z6C-HXT | 03060302 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 0,5 | 6 | ■ |
| JS720120D2R100.0Z6C-HXT | 03298280 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 1,0 | 6 | ■ |
| JS720120D2R200.0Z6C-HXT | 03298281 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 2,0 | 6 | ■ |
| JS720120D2R250.0Z6C-HXT | 03298282 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 2,5 | 6 | ■ |
| JS720120D2R300.0Z6C-HXT | 03298283 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 3,0 | 6 | ■ |
| JS720120D2R310.0Z6C-HXT | 03298284 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 3,1 | 6 | ■ |
| JS720160D2R050.0Z6C-HXT | 03060308 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 0,5 | 6 | ■ |
| JS720160D2R100.0Z6C-HXT | 03298285 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 1,0 | 6 | ■ |
| JS720160D2R200.0Z6C-HXT | 03298286 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 2,0 | 6 | ■ |
| JS720160D2R250.0Z6C-HXT | 03298287 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 2,5 | 6 | ■ |
| JS720160D2R300.0Z6C-HXT | 03298288 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 3,0 | 6 | ■ |
| JS720160D2R310.0Z6C-HXT | 03298289 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 3,1 | 6 | ■ |
| JS720160D2R400.0Z6C-HXT | 03298290 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 4,0 | 6 | ■ |
| JS720160D2R600.0Z6C-HXT | 03298291 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 6,0 | 6 | ■ |
| JS720200D3R050.0Z6C-HXT | 03060315 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 0,5 | 6 | ■ |
| JS720200D3R100.0Z6C-HXT | 03298292 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 1,0 | 6 | ■ |
| JS720200D3R200.0Z6C-HXT | 03298293 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 2,0 | 6 | ■ |
| JS720200D3R250.0Z6C-HXT | 03298294 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 2,5 | 6 | ■ |
| JS720200D3R300.0Z6C-HXT | 03298295 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 3,0 | 6 | ■ |
| JS720200D3R310.0Z6C-HXT | 03298296 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 3,1 | 6 | ■ |
| JS720200D3R400.0Z6C-HXT | 03298297 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 4,0 | 6 | ■ |
| JS720200D3R500.0Z6C-HXT | 03298298 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 5,0 | 6 | ■ |
| JS720200D3R600.0Z6C-HXT | 03298299 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 6,0 | 6 | ■ |
| JS720250D3R050.0Z6C-HXT | 03066270 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 0,5 | 6 | ■ |
| JS720250D3R100.0Z6C-HXT | 03298300 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 1,0 | 6 | ■ |
| JS720250D3R200.0Z6C-HXT | 03298301 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 2,0 | 6 | ■ |
| JS720250D3R300.0Z6C-HXT | 03298302 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 3,0 | 6 | ■ |
| JS720250D3R400.0Z6C-HXT | 03298303 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 4,0 | 6 | ■ |
| JS720250D3R600.0Z6C-HXT | 03298304 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 6,0 | 6 | ■ |

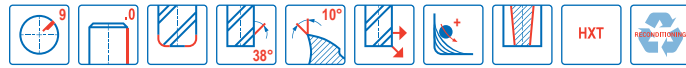
■ Lagerstandard.

JS720

Hochleistungsfräser – Titan – Eckfräser – 9 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM = h5
- DC = e7
- RE = ±0,02 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | RE | PCEDC | Zylindrisch |
|------------------------|--------------------|------------------|-------------------|------|------|-------|-------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | | |
| JS720100D2R050.0Z9-HXT | 10067510 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 0,5 | 9 | ■ |
| JS720100D2R100.0Z9-HXT | 10067511 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 1,0 | 9 | ■ |
| JS720100D2R200.0Z9-HXT | 10067512 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 2,0 | 9 | ■ |
| JS720120D2R050.0Z9-HXT | 10067513 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 0,5 | 9 | ■ |
| JS720120D2R100.0Z9-HXT | 10067514 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 1,0 | 9 | ■ |
| JS720120D2R200.0Z9-HXT | 10067515 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 2,0 | 9 | ■ |
| JS720160D2R100.0Z9-HXT | 10008152 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 1,0 | 9 | ■ |
| JS720160D2R200.0Z9-HXT | 10008153 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 2,0 | 9 | ■ |
| JS720160D2R300.0Z9-HXT | 10008154 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 3,0 | 9 | ■ |
| JS720250D2R100.0Z9-HXT | 10008155 | 2 | D | 25,0 | 25,0 | 50,0 | 125,0 | 1,0 | 9 | ■ |
| JS720250D2R200.0Z9-HXT | 10008156 | 2 | D | 25,0 | 25,0 | 50,0 | 125,0 | 2,0 | 9 | ■ |
| JS720250D2R300.0Z9-HXT | 10008157 | 2 | D | 25,0 | 25,0 | 50,0 | 125,0 | 3,0 | 9 | ■ |
| JS720100D3R050.0Z9-HXT | 10067516 | 3 | D | 10,0 | 10,0 | 40,0 | 89,0 | 0,5 | 9 | ■ |
| JS720100D3R100.0Z9-HXT | 10067517 | 3 | D | 10,0 | 10,0 | 40,0 | 89,0 | 1,0 | 9 | ■ |
| JS720100D3R200.0Z9-HXT | 10067518 | 3 | D | 10,0 | 10,0 | 40,0 | 89,0 | 2,0 | 9 | ■ |
| JS720120D3R050.0Z9-HXT | 10067519 | 3 | D | 12,0 | 12,0 | 45,0 | 100,0 | 0,5 | 9 | ■ |
| JS720120D3R100.0Z9-HXT | 10067520 | 3 | D | 12,0 | 12,0 | 45,0 | 100,0 | 1,0 | 9 | ■ |
| JS720120D3R200.0Z9-HXT | 10067521 | 3 | D | 12,0 | 12,0 | 45,0 | 100,0 | 2,0 | 9 | ■ |
| JS720160D3R100.0Z9-HXT | 10008158 | 3 | D | 16,0 | 16,0 | 65,0 | 130,0 | 1,0 | 9 | ■ |
| JS720160D3R200.0Z9-HXT | 10008159 | 3 | D | 16,0 | 16,0 | 65,0 | 130,0 | 2,0 | 9 | ■ |
| JS720160D3R300.0Z9-HXT | 10008160 | 3 | D | 16,0 | 16,0 | 65,0 | 130,0 | 3,0 | 9 | ■ |
| JS720200D3R100.0Z9-HXT | 10008161 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 1,0 | 9 | ■ |
| JS720200D3R200.0Z9-HXT | 10008162 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 2,0 | 9 | ■ |
| JS720200D3R300.0Z9-HXT | 10008163 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 3,0 | 9 | ■ |
| JS720250D3R100.0Z9-HXT | 10008164 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 1,0 | 9 | ■ |
| JS720250D3R200.0Z9-HXT | 10008165 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 2,0 | 9 | ■ |
| JS720250D3R300.0Z9-HXT | 10008166 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 3,0 | 9 | ■ |

■ Lagerstandard.

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Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und
Composite

Graphit

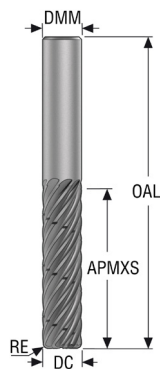
X-Heads

Minimaster Plus

Minimaster

JS720

Hochleistungsfräser – Titan – Eckfräser – 9 Schneiden – Zylindrisch – Eckenradius – Spanteiler



D



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | Spanteiler | DC | DMM | APMXS | OAL | RE | PCEDC | Zylindrisch |
|-------------------------|--------------------|------------------|-------------------|------------|------|------|-------|-------|-----|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | | |
| JS720100D3R050.0Z9C-HXT | 10067522 | 3 | D | ■ | 10,0 | 10,0 | 40,0 | 89,0 | 0,5 | 9 | ■ |
| JS720100D3R100.0Z9C-HXT | 10067523 | 3 | D | ■ | 10,0 | 10,0 | 40,0 | 89,0 | 1,0 | 9 | ■ |
| JS720100D3R200.0Z9C-HXT | 10067524 | 3 | D | ■ | 10,0 | 10,0 | 40,0 | 89,0 | 2,0 | 9 | ■ |
| JS720120D3R050.0Z9C-HXT | 10067525 | 3 | D | ■ | 12,0 | 12,0 | 45,0 | 100,0 | 0,5 | 9 | ■ |
| JS720120D3R100.0Z9C-HXT | 10067526 | 3 | D | ■ | 12,0 | 12,0 | 45,0 | 100,0 | 1,0 | 9 | ■ |
| JS720120D3R200.0Z9C-HXT | 10067527 | 3 | D | ■ | 12,0 | 12,0 | 45,0 | 100,0 | 2,0 | 9 | ■ |
| JS720160D3R100.0Z9C-HXT | 10067528 | 3 | D | ■ | 16,0 | 16,0 | 65,0 | 130,0 | 1,0 | 9 | ■ |
| JS720160D3R200.0Z9C-HXT | 10067529 | 3 | D | ■ | 16,0 | 16,0 | 65,0 | 130,0 | 2,0 | 9 | ■ |
| JS720160D3R300.0Z9C-HXT | 10067530 | 3 | D | ■ | 16,0 | 16,0 | 65,0 | 130,0 | 3,0 | 9 | ■ |
| JS720200D3R100.0Z9C-HXT | 10067531 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 1,0 | 9 | ■ |
| JS720200D3R200.0Z9C-HXT | 10067532 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 2,0 | 9 | ■ |
| JS720200D3R300.0Z9C-HXT | 10067533 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 3,0 | 9 | ■ |
| JS720250D3R100.0Z9C-HXT | 10067534 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 1,0 | 9 | ■ |
| JS720250D3R200.0Z9C-HXT | 10067535 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 2,0 | 9 | ■ |
| JS720250D3R300.0Z9C-HXT | 10067536 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 3,0 | 9 | ■ |

■ Lagerstandard.

Universell

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Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

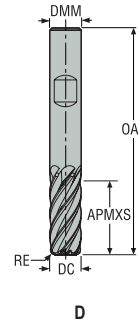
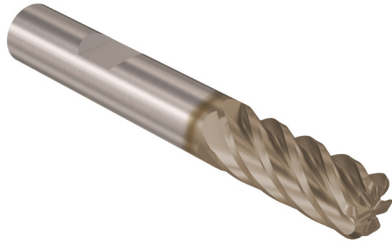
X-Heads

Minimaster Plus

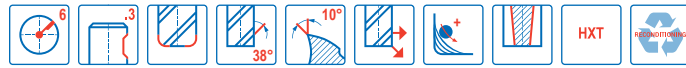
Minimaster

JS720

Hochleistungsfräser – Titan – Eckfräser – 6 Schneiden – Weldon – Eckenradius



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

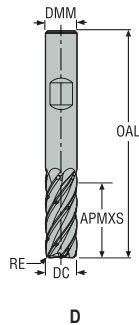


| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | RE | PCEDC | Weldon |
|------------------------|--------------------|------------------|-------------------|------|------|-------|-------|-----|-------|-------------------------------------|
| | | | | mm | mm | mm | mm | mm | | |
| JS720060D2R050.3Z6-HXT | 03060339 | 2 | D | 6,0 | 6,0 | 17,0 | 57,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720060D2R100.3Z6-HXT | 03060340 | 2 | D | 6,0 | 6,0 | 17,0 | 57,0 | 1,0 | 6 | <input type="checkbox"/> |
| JS720080D2R050.3Z6-HXT | 03060341 | 2 | D | 8,0 | 8,0 | 23,0 | 63,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720080D2R100.3Z6-HXT | 03061295 | 2 | D | 8,0 | 8,0 | 23,0 | 63,0 | 1,0 | 6 | <input type="checkbox"/> |
| JS720100D2R050.3Z6-HXT | 03060342 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720100D2R100.3Z6-HXT | 03060344 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 1,0 | 6 | <input type="checkbox"/> |
| JS720100D2R200.3Z6-HXT | 03060345 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 2,0 | 6 | <input type="checkbox"/> |
| JS720100D2R300.3Z6-HXT | 03060346 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 3,0 | 6 | <input type="checkbox"/> |
| JS720120D2R050.3Z6-HXT | 03060347 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720120D2R100.3Z6-HXT | 03060349 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 1,0 | 6 | <input type="checkbox"/> |
| JS720120D2R200.3Z6-HXT | 03060350 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 2,0 | 6 | <input type="checkbox"/> |
| JS720120D2R300.3Z6-HXT | 03060351 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 3,0 | 6 | <input type="checkbox"/> |
| JS720160D2R050.3Z6-HXT | 03060352 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720160D2R100.3Z6-HXT | 03060354 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 1,0 | 6 | <input type="checkbox"/> |
| JS720160D2R200.3Z6-HXT | 03060355 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 2,0 | 6 | <input type="checkbox"/> |
| JS720160D2R300.3Z6-HXT | 03060356 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 3,0 | 6 | <input type="checkbox"/> |
| JS720160D2R400.3Z6-HXT | 03060357 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 4,0 | 6 | <input type="checkbox"/> |
| JS720160D2R600.3Z6-HXT | 03060358 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 6,0 | 6 | <input type="checkbox"/> |
| JS720200D3R050.3Z6-HXT | 03060359 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720200D3R100.3Z6-HXT | 03060361 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 1,0 | 6 | <input type="checkbox"/> |
| JS720200D3R200.3Z6-HXT | 03060362 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 2,0 | 6 | <input type="checkbox"/> |
| JS720200D3R300.3Z6-HXT | 03060363 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 3,0 | 6 | <input checked="" type="checkbox"/> |
| JS720200D3R400.3Z6-HXT | 03060364 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 4,0 | 6 | <input type="checkbox"/> |
| JS720200D3R500.3Z6-HXT | 03060365 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 5,0 | 6 | <input type="checkbox"/> |
| JS720200D3R600.3Z6-HXT | 03060366 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 6,0 | 6 | <input type="checkbox"/> |
| JS720250D3R050.3Z6-HXT | 03060367 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720250D3R100.3Z6-HXT | 03060368 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 1,0 | 6 | <input type="checkbox"/> |
| JS720250D3R200.3Z6-HXT | 03060369 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 2,0 | 6 | <input type="checkbox"/> |
| JS720250D3R300.3Z6-HXT | 03060370 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 3,0 | 6 | <input type="checkbox"/> |
| JS720250D3R400.3Z6-HXT | 03060371 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 4,0 | 6 | <input checked="" type="checkbox"/> |
| JS720250D3R600.3Z6-HXT | 03060372 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 6,0 | 6 | <input type="checkbox"/> |

Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS720

Hochleistungsfräser – Titan – Eckfräser – 6 Schneiden – Weldon – Eckenradius – Spanteiler



Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster



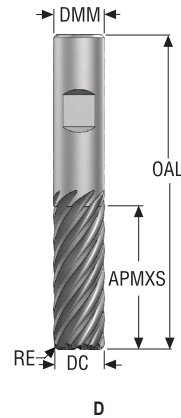
- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Spanteiler
- Nachschleifen möglich

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | Spanteiler | DC | DMM | APMXS | OAL | RE | PCEDC | Weldon |
|-------------------------|----------------|--------------|---------------|------------|------|------|-------|-------|-----|-------|--------------------------|
| | | | | | mm | mm | mm | mm | mm | | |
| JS720100D2R050.3Z6C-HXT | 03060343 | 2 | D | ■ | 10,0 | 10,0 | 26,0 | 72,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720120D2R050.3Z6C-HXT | 03060348 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720120D2R100.3Z6C-HXT | 03298308 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 1,0 | 6 | <input type="checkbox"/> |
| JS720120D2R200.3Z6C-HXT | 03298309 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 2,0 | 6 | <input type="checkbox"/> |
| JS720120D2R250.3Z6C-HXT | 03298310 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 2,5 | 6 | <input type="checkbox"/> |
| JS720120D2R300.3Z6C-HXT | 03298311 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 3,0 | 6 | <input type="checkbox"/> |
| JS720120D2R310.3Z6C-HXT | 03298312 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 3,1 | 6 | <input type="checkbox"/> |
| JS720160D2R050.3Z6C-HXT | 03060353 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 0,5 | 6 | ■ |
| JS720160D2R100.3Z6C-HXT | 03298313 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 1,0 | 6 | ■ |
| JS720160D2R200.3Z6C-HXT | 03298314 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 2,0 | 6 | ■ |
| JS720160D2R250.3Z6C-HXT | 03298315 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 2,5 | 6 | ■ |
| JS720160D2R300.3Z6C-HXT | 03298316 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 3,0 | 6 | ■ |
| JS720160D2R310.3Z6C-HXT | 03298317 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 3,1 | 6 | ■ |
| JS720160D2R400.3Z6C-HXT | 03298318 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 4,0 | 6 | ■ |
| JS720160D2R600.3Z6C-HXT | 03298319 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 6,0 | 6 | ■ |
| JS720200D3R050.3Z6C-HXT | 03060360 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 0,5 | 6 | ■ |
| JS720200D3R100.3Z6C-HXT | 03298320 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 1,0 | 6 | ■ |
| JS720200D3R200.3Z6C-HXT | 03298321 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 2,0 | 6 | ■ |
| JS720200D3R250.3Z6C-HXT | 03298322 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 2,5 | 6 | ■ |
| JS720200D3R300.3Z6C-HXT | 03298323 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 3,0 | 6 | ■ |
| JS720200D3R310.3Z6C-HXT | 03298324 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 3,1 | 6 | ■ |
| JS720200D3R400.3Z6C-HXT | 03298325 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 4,0 | 6 | ■ |
| JS720200D3R500.3Z6C-HXT | 03298326 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 5,0 | 6 | ■ |
| JS720200D3R600.3Z6C-HXT | 03298327 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 6,0 | 6 | ■ |
| JS720250D3R050.3Z6C-HXT | 03066460 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 0,5 | 6 | ■ |
| JS720250D3R100.3Z6C-HXT | 03298328 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 1,0 | 6 | ■ |
| JS720250D3R200.3Z6C-HXT | 03298329 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 2,0 | 6 | ■ |
| JS720250D3R300.3Z6C-HXT | 03298330 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 3,0 | 6 | ■ |
| JS720250D3R400.3Z6C-HXT | 03298331 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 4,0 | 6 | ■ |
| JS720250D3R600.3Z6C-HXT | 03298332 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 6,0 | 6 | ■ |

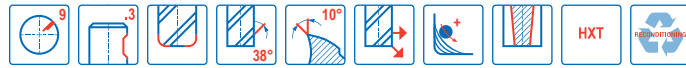
Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

JS720

Hochleistungsfräser – Titan – Eckfräser – 9 Schneiden – Weldon – Eckenradius



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | RE | PCEDC | Weldon |
|------------------------|--------------------|------------------|-------------------|------|------|-------|-------|-----|-------|--------------------------|
| | | | | mm | mm | mm | mm | mm | | |
| JS720100D2R050.3Z9-HXT | 10067881 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 0,5 | 9 | <input type="checkbox"/> |
| JS720100D2R100.3Z9-HXT | 10067882 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720100D2R200.3Z9-HXT | 10067883 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720120D2R050.3Z9-HXT | 10067884 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 0,5 | 9 | <input type="checkbox"/> |
| JS720120D2R100.3Z9-HXT | 10067885 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720120D2R200.3Z9-HXT | 10067886 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720160D2R100.3Z9-HXT | 10008279 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720160D2R200.3Z9-HXT | 10008280 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720160D2R300.3Z9-HXT | 10008281 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 3,0 | 9 | <input type="checkbox"/> |
| JS720250D2R100.3Z9-HXT | 10008282 | 2 | D | 25,0 | 25,0 | 50,0 | 125,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720250D2R200.3Z9-HXT | 10008283 | 2 | D | 25,0 | 25,0 | 50,0 | 125,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720250D2R300.3Z9-HXT | 10008284 | 2 | D | 25,0 | 25,0 | 50,0 | 125,0 | 3,0 | 9 | <input type="checkbox"/> |
| JS720100D3R050.3Z9-HXT | 10067887 | 3 | D | 10,0 | 10,0 | 40,0 | 89,0 | 0,5 | 9 | <input type="checkbox"/> |
| JS720100D3R100.3Z9-HXT | 10067888 | 3 | D | 10,0 | 10,0 | 40,0 | 89,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720100D3R200.3Z9-HXT | 10067889 | 3 | D | 10,0 | 10,0 | 40,0 | 89,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720120D3R050.3Z9-HXT | 10067890 | 3 | D | 12,0 | 12,0 | 45,0 | 100,0 | 0,5 | 9 | <input type="checkbox"/> |
| JS720120D3R100.3Z9-HXT | 10067891 | 3 | D | 12,0 | 12,0 | 45,0 | 100,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720120D3R200.3Z9-HXT | 10067892 | 3 | D | 12,0 | 12,0 | 45,0 | 100,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720160D3R100.3Z9-HXT | 10008285 | 3 | D | 16,0 | 16,0 | 65,0 | 130,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720160D3R200.3Z9-HXT | 10008286 | 3 | D | 16,0 | 16,0 | 65,0 | 130,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720160D3R300.3Z9-HXT | 10008287 | 3 | D | 16,0 | 16,0 | 65,0 | 130,0 | 3,0 | 9 | <input type="checkbox"/> |
| JS720200D3R100.3Z9-HXT | 10008288 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720200D3R200.3Z9-HXT | 10008289 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720200D3R300.3Z9-HXT | 10008290 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 3,0 | 9 | <input type="checkbox"/> |
| JS720250D3R100.3Z9-HXT | 10008292 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720250D3R200.3Z9-HXT | 10008293 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720250D3R300.3Z9-HXT | 10008294 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 3,0 | 9 | <input type="checkbox"/> |

Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und
Composite

Graphit

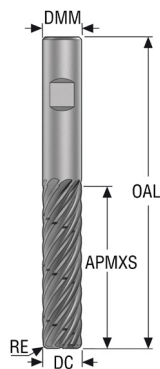
X-Heads

Minimaster Plus

Minimaster

JS720

Hochleistungsfräser – Titan – Eckfräser – 9 Schneiden – Weldon – Eckenradius – Spanteiler



D



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | Spanteiler | DC | DMM | APMXS | OAL | RE | PCEDC | Weldon |
|-------------------------|--------------------|------------------|-------------------|------------|------|------|-------|-------|-----|-------|--------------------------|
| | | | | | mm | mm | mm | mm | mm | | |
| JS720100D3R050.3Z9C-HXT | 10067893 | 3 | D | ■ | 10,0 | 10,0 | 40,0 | 89,0 | 0,5 | 9 | <input type="checkbox"/> |
| JS720100D3R100.3Z9C-HXT | 10067894 | 3 | D | ■ | 10,0 | 10,0 | 40,0 | 89,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720100D3R200.3Z9C-HXT | 10067895 | 3 | D | ■ | 10,0 | 10,0 | 40,0 | 89,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720120D3R050.3Z9C-HXT | 10067897 | 3 | D | ■ | 12,0 | 12,0 | 45,0 | 100,0 | 0,5 | 9 | <input type="checkbox"/> |
| JS720120D3R100.3Z9C-HXT | 10067898 | 3 | D | ■ | 12,0 | 12,0 | 45,0 | 100,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720120D3R200.3Z9C-HXT | 10067899 | 3 | D | ■ | 12,0 | 12,0 | 45,0 | 100,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720160D3R100.3Z9C-HXT | 10067900 | 3 | D | ■ | 16,0 | 16,0 | 65,0 | 130,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720160D3R200.3Z9C-HXT | 10067901 | 3 | D | ■ | 16,0 | 16,0 | 65,0 | 130,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720160D3R300.3Z9C-HXT | 10067902 | 3 | D | ■ | 16,0 | 16,0 | 65,0 | 130,0 | 3,0 | 9 | <input type="checkbox"/> |
| JS720200D3R100.3Z9C-HXT | 10067903 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720200D3R200.3Z9C-HXT | 10067904 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720200D3R300.3Z9C-HXT | 10067905 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 3,0 | 9 | <input type="checkbox"/> |
| JS720250D3R100.3Z9C-HXT | 10067906 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720250D3R200.3Z9C-HXT | 10067907 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720250D3R300.3Z9C-HXT | 10067908 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 3,0 | 9 | <input type="checkbox"/> |

■ Lagerstandard.

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Kunststoffe und Composite

Graphit

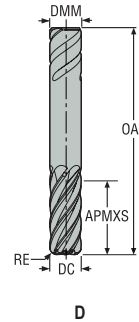
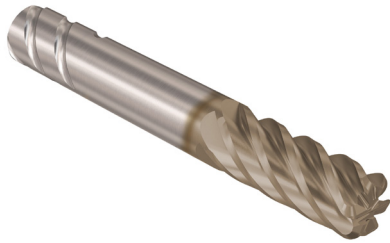
X-Heads

Minimaster Plus

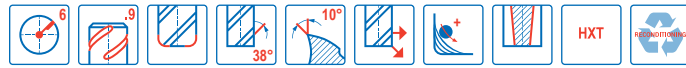
Minimaster

JS720

Hochleistungsfräser – Titan – Eckfräser – 6 Schneiden – Safe-Lock – Eckenradius



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | RE | PCEDC | Safe-Lock |
|------------------------|--------------------|------------------|-------------------|------|------|-------|-------|-----|-------|--------------------------|
| | | | | mm | mm | mm | mm | mm | | |
| JS720060D2R050.9Z6-HXT | 03060374 | 2 | D | 6,0 | 6,0 | 17,0 | 57,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720060D2R100.9Z6-HXT | 03060375 | 2 | D | 6,0 | 6,0 | 17,0 | 57,0 | 1,0 | 6 | <input type="checkbox"/> |
| JS720080D2R050.9Z6-HXT | 03060376 | 2 | D | 8,0 | 8,0 | 23,0 | 63,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720080D2R100.9Z6-HXT | 03061296 | 2 | D | 8,0 | 8,0 | 23,0 | 63,0 | 1,0 | 6 | <input type="checkbox"/> |
| JS720100D2R050.9Z6-HXT | 03060377 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720100D2R100.9Z6-HXT | 03060379 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 1,0 | 6 | <input type="checkbox"/> |
| JS720100D2R200.9Z6-HXT | 03060380 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 2,0 | 6 | <input type="checkbox"/> |
| JS720100D2R300.9Z6-HXT | 03060381 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 3,0 | 6 | <input type="checkbox"/> |
| JS720120D2R050.9Z6-HXT | 03060382 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720120D2R100.9Z6-HXT | 03060384 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 1,0 | 6 | <input type="checkbox"/> |
| JS720120D2R200.9Z6-HXT | 03060385 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 2,0 | 6 | <input type="checkbox"/> |
| JS720120D2R300.9Z6-HXT | 03060386 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 3,0 | 6 | <input type="checkbox"/> |
| JS720160D2R050.9Z6-HXT | 03060387 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720160D2R100.9Z6-HXT | 03060389 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 1,0 | 6 | <input type="checkbox"/> |
| JS720160D2R200.9Z6-HXT | 03060390 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 2,0 | 6 | <input type="checkbox"/> |
| JS720160D2R300.9Z6-HXT | 03060391 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 3,0 | 6 | <input type="checkbox"/> |
| JS720160D2R400.9Z6-HXT | 03060392 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 4,0 | 6 | <input type="checkbox"/> |
| JS720160D2R600.9Z6-HXT | 03060393 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 6,0 | 6 | <input type="checkbox"/> |
| JS720200D3R050.9Z6-HXT | 03060394 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720200D3R100.9Z6-HXT | 03060396 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 1,0 | 6 | <input type="checkbox"/> |
| JS720200D3R200.9Z6-HXT | 03060397 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 2,0 | 6 | <input type="checkbox"/> |
| JS720200D3R300.9Z6-HXT | 03060398 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 3,0 | 6 | <input type="checkbox"/> |
| JS720200D3R400.9Z6-HXT | 03060399 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 4,0 | 6 | <input type="checkbox"/> |
| JS720200D3R500.9Z6-HXT | 03060400 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 5,0 | 6 | <input type="checkbox"/> |
| JS720200D3R600.9Z6-HXT | 03060401 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 6,0 | 6 | <input type="checkbox"/> |
| JS720250D3R050.9Z6-HXT | 03060402 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720250D3R100.9Z6-HXT | 03060403 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 1,0 | 6 | <input type="checkbox"/> |
| JS720250D3R200.9Z6-HXT | 03060404 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 2,0 | 6 | <input type="checkbox"/> |
| JS720250D3R300.9Z6-HXT | 03060405 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 3,0 | 6 | <input type="checkbox"/> |
| JS720250D3R400.9Z6-HXT | 03060406 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 4,0 | 6 | <input type="checkbox"/> |
| JS720250D3R600.9Z6-HXT | 03060407 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 6,0 | 6 | <input type="checkbox"/> |

Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

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Graphit

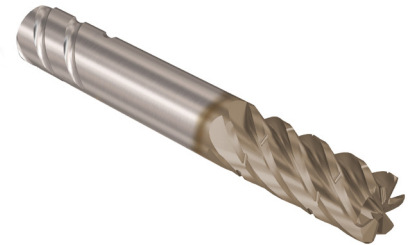
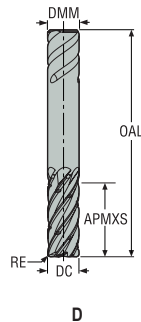
X-Heads

Minimaster Plus

Minimaster

JS720

Hochleistungsfräser – Titan – Eckfräser – 6 Schneiden – Safe-Lock – Eckenradius – Spanteiler



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Graphit

X-Heads

Minimaster Plus

Minimaster



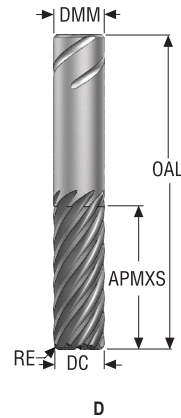
- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Spanteiler
- Nachschleifen möglich

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | Spanteiler | DC | DMM | APMXS | OAL | RE | PCEDC | Safe-Lock |
|-------------------------|----------------|--------------|---------------|------------|------|------|-------|-------|-----|-------|--------------------------|
| | | | | | mm | mm | mm | mm | mm | | |
| JS720100D2R050.9Z6C-HXT | 03060378 | 2 | D | ■ | 10,0 | 10,0 | 26,0 | 72,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720120D2R050.9Z6C-HXT | 03060383 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720120D2R100.9Z6C-HXT | 03298334 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 1,0 | 6 | <input type="checkbox"/> |
| JS720120D2R200.9Z6C-HXT | 03298335 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 2,0 | 6 | <input type="checkbox"/> |
| JS720120D2R250.9Z6C-HXT | 03298336 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 2,5 | 6 | <input type="checkbox"/> |
| JS720120D2R300.9Z6C-HXT | 03298337 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 3,0 | 6 | <input type="checkbox"/> |
| JS720120D2R310.9Z6C-HXT | 03298338 | 2 | D | ■ | 12,0 | 12,0 | 30,0 | 83,0 | 3,1 | 6 | <input type="checkbox"/> |
| JS720160D2R050.9Z6C-HXT | 03060388 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720160D2R100.9Z6C-HXT | 03298339 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 1,0 | 6 | <input type="checkbox"/> |
| JS720160D2R200.9Z6C-HXT | 03298340 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 2,0 | 6 | <input type="checkbox"/> |
| JS720160D2R250.9Z6C-HXT | 03298341 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 2,5 | 6 | <input type="checkbox"/> |
| JS720160D2R300.9Z6C-HXT | 03298342 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 3,0 | 6 | <input type="checkbox"/> |
| JS720160D2R310.9Z6C-HXT | 03298343 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 3,1 | 6 | <input type="checkbox"/> |
| JS720160D2R400.9Z6C-HXT | 03298344 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 4,0 | 6 | <input type="checkbox"/> |
| JS720160D2R600.9Z6C-HXT | 03298345 | 2 | D | ■ | 16,0 | 16,0 | 44,0 | 99,0 | 6,0 | 6 | <input type="checkbox"/> |
| JS720200D3R050.9Z6C-HXT | 03060395 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720200D3R100.9Z6C-HXT | 03298346 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 1,0 | 6 | <input type="checkbox"/> |
| JS720200D3R200.9Z6C-HXT | 03298347 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 2,0 | 6 | <input type="checkbox"/> |
| JS720200D3R250.9Z6C-HXT | 03298348 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 2,5 | 6 | <input type="checkbox"/> |
| JS720200D3R300.9Z6C-HXT | 03298349 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 3,0 | 6 | <input type="checkbox"/> |
| JS720200D3R310.9Z6C-HXT | 03298350 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 3,1 | 6 | <input type="checkbox"/> |
| JS720200D3R400.9Z6C-HXT | 03298351 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 4,0 | 6 | <input type="checkbox"/> |
| JS720200D3R500.9Z6C-HXT | 03298352 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 5,0 | 6 | <input type="checkbox"/> |
| JS720200D3R600.9Z6C-HXT | 03298353 | 3 | D | ■ | 20,0 | 20,0 | 62,0 | 121,0 | 6,0 | 6 | <input type="checkbox"/> |
| JS720250D3R050.9Z6C-HXT | 03066461 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 0,5 | 6 | <input type="checkbox"/> |
| JS720250D3R100.9Z6C-HXT | 03298354 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 1,0 | 6 | <input type="checkbox"/> |
| JS720250D3R200.9Z6C-HXT | 03298355 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 2,0 | 6 | <input type="checkbox"/> |
| JS720250D3R300.9Z6C-HXT | 03298356 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 3,0 | 6 | <input type="checkbox"/> |
| JS720250D3R400.9Z6C-HXT | 03298357 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 4,0 | 6 | <input type="checkbox"/> |
| JS720250D3R600.9Z6C-HXT | 03298358 | 3 | D | ■ | 25,0 | 25,0 | 78,0 | 146,0 | 6,0 | 6 | <input type="checkbox"/> |

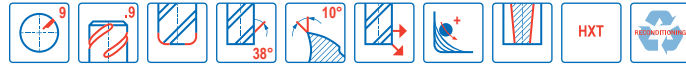
■ Lagerstandard.

JS720

Hochleistungsfräser – Titan – Eckfräser – 9 Schneiden – Safe-Lock – Eckenradius



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | RE | PCEDC | Safe-Lock |
|------------------------|--------------------|------------------|-------------------|------|------|-------|-------|-----|-------|--------------------------|
| | | | | mm | mm | mm | mm | mm | | |
| JS720100D2R050.9Z9-HXT | 10067909 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 0,5 | 9 | <input type="checkbox"/> |
| JS720100D2R100.9Z9-HXT | 10067910 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720100D2R200.9Z9-HXT | 10067911 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720120D2R050.9Z9-HXT | 10067912 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 0,5 | 9 | <input type="checkbox"/> |
| JS720120D2R100.9Z9-HXT | 10067913 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720120D2R200.9Z9-HXT | 10067914 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720160D2R100.9Z9-HXT | 10008295 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720160D2R200.9Z9-HXT | 10008296 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720160D2R300.9Z9-HXT | 10008297 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 3,0 | 9 | <input type="checkbox"/> |
| JS720250D2R100.9Z9-HXT | 10008298 | 2 | D | 25,0 | 25,0 | 50,0 | 125,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720250D2R200.9Z9-HXT | 10008299 | 2 | D | 25,0 | 25,0 | 50,0 | 125,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720250D2R300.9Z9-HXT | 10008300 | 2 | D | 25,0 | 25,0 | 50,0 | 125,0 | 3,0 | 9 | <input type="checkbox"/> |
| JS720100D3R050.9Z9-HXT | 10067915 | 3 | D | 10,0 | 10,0 | 40,0 | 89,0 | 0,5 | 9 | <input type="checkbox"/> |
| JS720100D3R100.9Z9-HXT | 10067916 | 3 | D | 10,0 | 10,0 | 40,0 | 89,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720100D3R200.9Z9-HXT | 10067917 | 3 | D | 10,0 | 10,0 | 40,0 | 89,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720120D3R050.9Z9-HXT | 10067918 | 3 | D | 12,0 | 12,0 | 45,0 | 100,0 | 0,5 | 9 | <input type="checkbox"/> |
| JS720120D3R100.9Z9-HXT | 10067919 | 3 | D | 12,0 | 12,0 | 45,0 | 100,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720120D3R200.9Z9-HXT | 10067921 | 3 | D | 12,0 | 12,0 | 45,0 | 100,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720160D3R100.9Z9-HXT | 10008301 | 3 | D | 16,0 | 16,0 | 65,0 | 130,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720160D3R200.9Z9-HXT | 10008302 | 3 | D | 16,0 | 16,0 | 65,0 | 130,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720160D3R300.9Z9-HXT | 10008303 | 3 | D | 16,0 | 16,0 | 65,0 | 130,0 | 3,0 | 9 | <input type="checkbox"/> |
| JS720200D3R100.9Z9-HXT | 10008304 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720200D3R200.9Z9-HXT | 10008305 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720200D3R300.9Z9-HXT | 10008306 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 3,0 | 9 | <input type="checkbox"/> |
| JS720250D3R100.9Z9-HXT | 10008307 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 1,0 | 9 | <input type="checkbox"/> |
| JS720250D3R200.9Z9-HXT | 10008308 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 2,0 | 9 | <input type="checkbox"/> |
| JS720250D3R300.9Z9-HXT | 10008309 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 3,0 | 9 | <input type="checkbox"/> |

Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

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Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JS720 Eckfräsen PCEDC =6

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | v _c | |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|----------------|-----------------|
| | | | | 6 | 8 | 10 | 12 | 16 | 20 | | 25 |
| M1 | E | 0.400 | 1.1 | 0.032 | 0.044 | 0.055 | 0.065 | 0.080 | 0.095 | 0.11 | 110 (85 – 140) |
| | | 0,400 | 1,1 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 360 (280 – 450) |
| M2 | E | 0.400 | 1.1 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 0.095 | 90 (70 – 110) |
| | | 0,400 | 1,1 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 0,0038 | 295 (230 – 360) |
| M3 | E | 0.400 | 1.1 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 0.095 | 70 (55 – 99) |
| | | 0,400 | 1,1 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 0,0038 | 230 (190 – 320) |
| M4 | E | 0.400 | 1.1 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 0.095 | 80 (60 – 99) |
| | | 0,400 | 1,1 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 0,0038 | 260 (200 – 320) |
| M5 | E | 0.400 | 1.1 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 0.095 | 65 (50 – 83) |
| | | 0,400 | 1,1 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 0,0038 | 215 (170 – 270) |
| S1 | E | 0.0500 | 2.6 | 0.046 | 0.060 | 0.075 | 0.090 | 0.11 | 0.13 | 0.14 | 43 (29 – 71) |
| | | 0,0500 | 2,6 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0055 | 140 (96 – 230) |
| S2 | E | 0.0500 | 2.6 | 0.046 | 0.060 | 0.075 | 0.090 | 0.11 | 0.13 | 0.14 | 34 (23 – 57) |
| | | 0,0500 | 2,6 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0055 | 110 (76 – 180) |
| S3 | E | 0.0500 | 2.6 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 30 (20 – 49) |
| | | 0,0500 | 2,6 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 100 (66 – 160) |
| S11 | E | 0.400 | 1.1 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 0.095 | 105 (78 – 120) |
| | | 0,400 | 1,1 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 0,0038 | 345 (260 – 390) |
| S12 | E | 0.400 | 1.1 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 0.095 | 80 (60 – 99) |
| | | 0,400 | 1,1 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 0,0038 | 260 (200 – 320) |
| S13 | E | 0.400 | 1.1 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 0.095 | 80 (60 – 99) |
| | | 0,400 | 1,1 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 0,0038 | 260 (200 – 320) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JS720 Eckfräsen dynamisches Fräsen $a_p/DC=0,07$ PCEDC =6

| SMG | | a_p/DC | f_z | | | | | | | v_c |
|-----|---|----------|--------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | 6 | 8 | 10 | 12 | 16 | 20 | 25 | |
| M1 | E | 1.9 | 0.065 | 0.085 | 0.11 | 0.13 | 0.16 | 0.18 | 0.20 | 140 (110 – 180) |
| | | 1.9 | 0.0026 | 0.0034 | 0.0044 | 0.0050 | 0.0065 | 0.0070 | 0.0080 | 460 (370 – 590) |
| M2 | E | 1.9 | 0.060 | 0.080 | 0.095 | 0.12 | 0.14 | 0.16 | 0.19 | 115 (91 – 150) |
| | | 1.9 | 0.0024 | 0.0032 | 0.0038 | 0.0048 | 0.0055 | 0.0065 | 0.0075 | 375 (300 – 490) |
| M3 | E | 1.9 | 0.060 | 0.080 | 0.095 | 0.12 | 0.14 | 0.16 | 0.19 | 90 (72 – 120) |
| | | 1.9 | 0.0024 | 0.0032 | 0.0038 | 0.0048 | 0.0055 | 0.0065 | 0.0075 | 295 (240 – 390) |
| M4 | E | 1.9 | 0.060 | 0.080 | 0.095 | 0.12 | 0.14 | 0.16 | 0.19 | 105 (78 – 120) |
| | | 1.9 | 0.0024 | 0.0032 | 0.0038 | 0.0048 | 0.0055 | 0.0065 | 0.0075 | 345 (260 – 390) |
| M5 | E | 1.9 | 0.060 | 0.080 | 0.095 | 0.12 | 0.14 | 0.16 | 0.19 | 85 (65 – 100) |
| | | 1.9 | 0.0024 | 0.0032 | 0.0038 | 0.0048 | 0.0055 | 0.0065 | 0.0075 | 280 (220 – 320) |
| S1 | E | 2.6 | 0.038 | 0.050 | 0.065 | 0.075 | 0.095 | 0.11 | 0.12 | 41 (28 – 68) |
| | | 2.6 | 0.0015 | 0.0020 | 0.0026 | 0.0030 | 0.0038 | 0.0044 | 0.0048 | 135 (92 – 220) |
| S2 | E | 2.6 | 0.038 | 0.050 | 0.065 | 0.075 | 0.095 | 0.11 | 0.12 | 33 (22 – 54) |
| | | 2.6 | 0.0015 | 0.0020 | 0.0026 | 0.0030 | 0.0038 | 0.0044 | 0.0048 | 110 (73 – 170) |
| S3 | E | 2.6 | 0.036 | 0.048 | 0.060 | 0.070 | 0.085 | 0.10 | 0.11 | 29 (20 – 47) |
| | | 2.6 | 0.0014 | 0.0019 | 0.0024 | 0.0028 | 0.0034 | 0.0040 | 0.0044 | 95 (66 – 150) |
| S11 | E | 1.9 | 0.060 | 0.080 | 0.095 | 0.12 | 0.14 | 0.16 | 0.19 | 135 (110 – 160) |
| | | 1.9 | 0.0024 | 0.0032 | 0.0038 | 0.0048 | 0.0055 | 0.0065 | 0.0075 | 445 (370 – 520) |
| S12 | E | 1.9 | 0.060 | 0.080 | 0.095 | 0.12 | 0.14 | 0.16 | 0.19 | 105 (78 – 120) |
| | | 1.9 | 0.0024 | 0.0032 | 0.0038 | 0.0048 | 0.0055 | 0.0065 | 0.0075 | 345 (260 – 390) |
| S13 | E | 1.9 | 0.060 | 0.080 | 0.095 | 0.12 | 0.14 | 0.16 | 0.19 | 105 (78 – 120) |
| | | 1.9 | 0.0024 | 0.0032 | 0.0038 | 0.0048 | 0.0055 | 0.0065 | 0.0075 | 345 (260 – 390) |

Schnittdaten – JS720 Eckfräsen dynamisches Fräsen $a_p/DC=0,07$ PCEDC =9

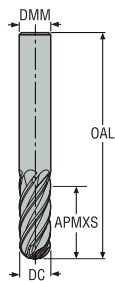
| SMG | | a_p/DC | f_z | | | | | v_c |
|-----|---|----------|--------|--------|--------|--------|--------|-----------------|
| | | | 10 | 12 | 16 | 20 | 25 | |
| M1 | E | 2.0 | 0.11 | 0.13 | 0.16 | 0.18 | 0.20 | 125 (98 – 160) |
| | | 2.0 | 0.0044 | 0.0050 | 0.0065 | 0.0070 | 0.0080 | 410 (330 – 520) |
| M2 | E | 2.0 | 0.095 | 0.12 | 0.14 | 0.16 | 0.19 | 105 (82 – 130) |
| | | 2.0 | 0.0038 | 0.0048 | 0.0055 | 0.0065 | 0.0075 | 345 (270 – 420) |
| M3 | E | 2.0 | 0.095 | 0.12 | 0.14 | 0.16 | 0.19 | 80 (64 – 110) |
| | | 2.0 | 0.0038 | 0.0048 | 0.0055 | 0.0065 | 0.0075 | 260 (210 – 360) |
| M4 | E | 2.0 | 0.095 | 0.12 | 0.14 | 0.16 | 0.19 | 95 (70 – 110) |
| | | 2.0 | 0.0038 | 0.0048 | 0.0055 | 0.0065 | 0.0075 | 310 (230 – 360) |
| M5 | E | 2.0 | 0.095 | 0.12 | 0.14 | 0.16 | 0.19 | 75 (59 – 96) |
| | | 2.0 | 0.0038 | 0.0048 | 0.0055 | 0.0065 | 0.0075 | 245 (200 – 310) |
| S1 | E | 2.8 | 0.065 | 0.075 | 0.095 | 0.11 | 0.12 | 37 (25 – 61) |
| | | 2.8 | 0.0026 | 0.0030 | 0.0038 | 0.0044 | 0.0048 | 120 (83 – 200) |
| S2 | E | 2.8 | 0.065 | 0.075 | 0.095 | 0.11 | 0.12 | 30 (20 – 49) |
| | | 2.8 | 0.0026 | 0.0030 | 0.0038 | 0.0044 | 0.0048 | 100 (66 – 160) |
| S3 | E | 2.8 | 0.060 | 0.070 | 0.085 | 0.10 | 0.11 | 26 (18 – 43) |
| | | 2.8 | 0.0024 | 0.0028 | 0.0034 | 0.0040 | 0.0044 | 85 (60 – 140) |
| S11 | E | 2.0 | 0.095 | 0.12 | 0.14 | 0.16 | 0.19 | 120 (91 – 150) |
| | | 2.0 | 0.0038 | 0.0048 | 0.0055 | 0.0065 | 0.0075 | 395 (300 – 490) |
| S12 | E | 2.0 | 0.095 | 0.12 | 0.14 | 0.16 | 0.19 | 95 (70 – 110) |
| | | 2.0 | 0.0038 | 0.0048 | 0.0055 | 0.0065 | 0.0075 | 310 (230 – 360) |
| S13 | E | 2.0 | 0.095 | 0.12 | 0.14 | 0.16 | 0.19 | 95 (70 – 110) |
| | | 2.0 | 0.0038 | 0.0048 | 0.0055 | 0.0065 | 0.0075 | 310 (230 – 360) |

Schnittdaten, siehe Seite 561 - 568

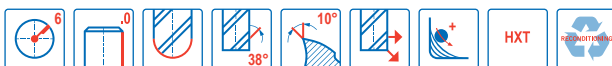
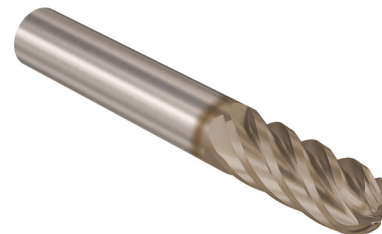
SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 $v_c = m/min (sf/min)$
 $f_z = mm/Zahn (Zoll/Zahn)$
 $a_p = mm/DC (Zoll/DC) = \text{Faktor}$
 $a_e = mm/DC (Zoll/DC) = \text{Faktor}$
 Alle Schnittdaten sind Richtwerte

JS730

Hochleistungsfräser – Titan – Kugelkopf – 6 Schneiden – Zylindrisch



D



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Zwei Schneiden zur Mitte
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | PCEDC | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|------|------|-------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | | |
| JS730060D2B.0Z6-HXT | 03067605 | 2 | D | 6,0 | 6,0 | 17,0 | 57,0 | 6 | ■ |
| JS730080D2B.0Z6-HXT | 03067606 | 2 | D | 8,0 | 8,0 | 23,0 | 63,0 | 6 | ■ |
| JS730100D2B.0Z6-HXT | 03067607 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 6 | ■ |
| JS730120D2B.0Z6-HXT | 03067608 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 6 | ■ |
| JS730160D2B.0Z6-HXT | 03067609 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 6 | ■ |
| JS730200D3B.0Z6-HXT | 03067610 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 6 | ■ |
| JS730250D3B.0Z6-HXT | 03067611 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 6 | ■ |

■ Lagerstandard.

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Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

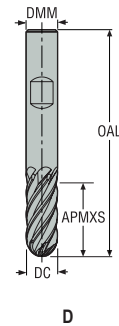
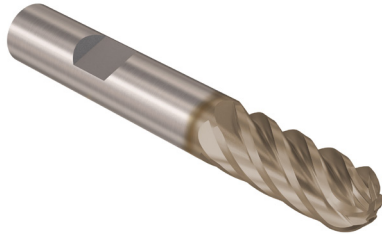
X-Heads

Minimaster Plus

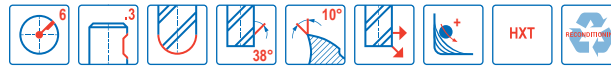
Minimaster

JS730

Hochleistungsfräser – Titan – Kugelkopf – 6 Schneiden – Weldon



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Zwei Schneiden zur Mitte
- Nachschleifen möglich



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | PCEDC | Weldon |
|---------------------|----------------|--------------|---------------|------|------|-------|-------|-------|--------------------------|
| | | | | mm | mm | mm | mm | | |
| JS730060D2B.3Z6-HXT | 03067778 | 2 | D | 6,0 | 6,0 | 17,0 | 57,0 | 6 | <input type="checkbox"/> |
| JS730080D2B.3Z6-HXT | 03067779 | 2 | D | 8,0 | 8,0 | 23,0 | 63,0 | 6 | <input type="checkbox"/> |
| JS730100D2B.3Z6-HXT | 03067780 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 6 | <input type="checkbox"/> |
| JS730120D2B.3Z6-HXT | 03067781 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 6 | <input type="checkbox"/> |
| JS730160D2B.3Z6-HXT | 03067782 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 6 | <input type="checkbox"/> |
| JS730200D3B.3Z6-HXT | 03067783 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 6 | <input type="checkbox"/> |
| JS730250D3B.3Z6-HXT | 03067784 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 6 | <input type="checkbox"/> |

Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

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Harter

Kunststoffe und Composite

Graphit

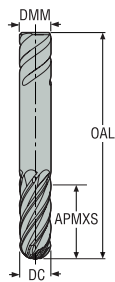
X-Heads

Minimaster Plus

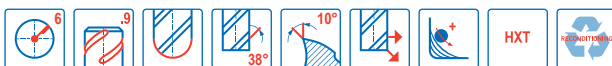
Minimaster

JS730

Hochleistungsfräser – Titan – Kugelkopf – 6 Schneiden – Safe-Lock



D



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Zwei Schneiden zur Mitte
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | PCEDC | Safe-Lock |
|---------------------|--------------------|------------------|-------------------|------|------|-------|-------|-------|--------------------------|
| | | | | mm | mm | mm | mm | | |
| JS730060D2B.9Z6-HXT | 03067785 | 2 | D | 6,0 | 6,0 | 17,0 | 57,0 | 6 | <input type="checkbox"/> |
| JS730080D2B.9Z6-HXT | 03067786 | 2 | D | 8,0 | 8,0 | 23,0 | 63,0 | 6 | <input type="checkbox"/> |
| JS730100D2B.9Z6-HXT | 03067787 | 2 | D | 10,0 | 10,0 | 26,0 | 72,0 | 6 | <input type="checkbox"/> |
| JS730120D2B.9Z6-HXT | 03067788 | 2 | D | 12,0 | 12,0 | 30,0 | 83,0 | 6 | <input type="checkbox"/> |
| JS730160D2B.9Z6-HXT | 03067789 | 2 | D | 16,0 | 16,0 | 44,0 | 99,0 | 6 | <input type="checkbox"/> |
| JS730200D3B.9Z6-HXT | 03067790 | 3 | D | 20,0 | 20,0 | 62,0 | 121,0 | 6 | <input type="checkbox"/> |
| JS730250D3B.9Z6-HXT | 03067791 | 3 | D | 25,0 | 25,0 | 78,0 | 146,0 | 6 | <input type="checkbox"/> |

SafeLock verfügbar. Die Lieferzeit beträgt 6 Tage.

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Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JS730 Eckfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | | 6 | 8 | 10 | 12 | 16 | 20 | 25 | |
| M1 | E | 0.100 | 1.8 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 0.14 | 0.15 | 140 (89 – 150) |
| | | 0,100 | 1,8 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0060 | 460 (300 – 490) |
| M2 | E | 0.150 | 2.2 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 0.095 | 110 (70 – 120) |
| | | 0,150 | 2,2 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 0,0038 | 360 (230 – 390) |
| M3 | E | 0.100 | 1.8 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 0.14 | 0.15 | 85 (55 – 99) |
| M4 | E | 0.100 | 1.8 | 0.0019 | 0.0026 | 0.0032 | 0.0038 | 0.0048 | 0.0055 | 0.0060 | 280 (190 – 320) |
| | | 0,100 | 1,8 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 295 (190 – 320) |
| M5 | E | 0.100 | 1.8 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 90 (57 – 100) |
| | | 0,100 | 1,8 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 245 (160 – 270) |
| S1 | E | 0.150 | 2.2 | 0.032 | 0.044 | 0.055 | 0.065 | 0.080 | 0.090 | 0.10 | 43 (29 – 70) |
| | | 0,150 | 2,2 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 0,0040 | 140 (96 – 220) |
| S2 | E | 0.150 | 2.2 | 0.032 | 0.044 | 0.055 | 0.065 | 0.080 | 0.090 | 0.10 | 34 (23 – 57) |
| | | 0,150 | 2,2 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 0,0040 | 110 (76 – 180) |
| S3 | E | 0.150 | 2.2 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 0.095 | 30 (20 – 49) |
| | | 0,150 | 2,2 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 0,0038 | 100 (66 – 160) |
| S11 | E | 0.300 | 1.2 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 0.095 | 130 (79 – 130) |
| | | 0,300 | 1,2 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 0,0038 | 425 (260 – 420) |
| S12 | E | 0.300 | 1.2 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 0.095 | 100 (61 – 100) |
| | | 0,300 | 1,2 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 0,0038 | 330 (210 – 320) |
| S13 | E | 0.300 | 1.2 | 0.026 | 0.034 | 0.044 | 0.050 | 0.065 | 0.075 | 0.085 | 100 (62 – 100) |
| | | 0,300 | 1,2 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 0,0034 | 330 (210 – 320) |

Schnittdaten – JS730 Eckfräsen dynamisches Fräsen a_p/DC=0,07

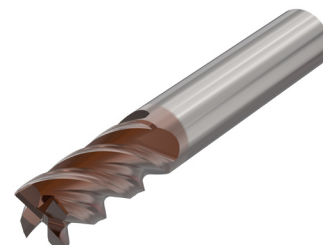
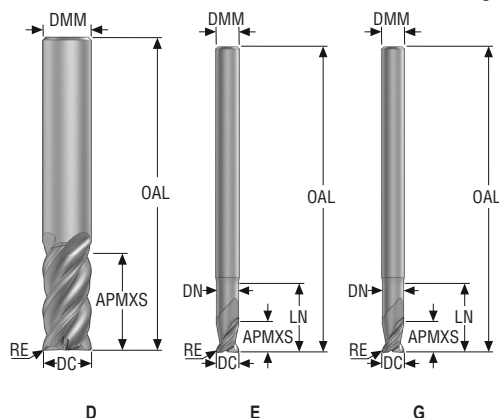
| SMG | | a _p /DC | f _z | | | | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | 6 | 8 | 10 | 12 | 16 | 20 | 25 | |
| M1 | E | 1.9 | 0.055 | 0.075 | 0.095 | 0.11 | 0.14 | 0.16 | 0.18 | 145 (93 – 150) |
| | | 1,9 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0055 | 0,0065 | 0,0070 | 475 (310 – 490) |
| M2 | E | 2.2 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 125 (78 – 130) |
| | | 2,2 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 410 (260 – 420) |
| M3 | E | 1.9 | 0.055 | 0.075 | 0.095 | 0.11 | 0.14 | 0.16 | 0.18 | 90 (58 – 100) |
| | | 1,9 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0055 | 0,0065 | 0,0070 | 295 (200 – 320) |
| M4 | E | 1.9 | 0.050 | 0.065 | 0.080 | 0.095 | 0.12 | 0.14 | 0.16 | 95 (59 – 100) |
| | | 1,9 | 0,0020 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0065 | 310 (200 – 320) |
| M5 | E | 1.9 | 0.050 | 0.065 | 0.080 | 0.095 | 0.12 | 0.14 | 0.16 | 80 (50 – 89) |
| | | 1,9 | 0,0020 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0065 | 260 (170 – 290) |
| S1 | E | 2.2 | 0.046 | 0.060 | 0.075 | 0.090 | 0.11 | 0.13 | 0.15 | 47 (32 – 79) |
| | | 2,2 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 155 (110 – 250) |
| S2 | E | 2.2 | 0.046 | 0.060 | 0.075 | 0.090 | 0.11 | 0.13 | 0.15 | 38 (26 – 63) |
| | | 2,2 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 125 (86 – 200) |
| S3 | E | 2.2 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.12 | 0.13 | 33 (23 – 55) |
| | | 2,2 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 110 (76 – 180) |
| S11 | E | 1.9 | 0.050 | 0.070 | 0.085 | 0.10 | 0.13 | 0.15 | 0.17 | 150 (94 – 150) |
| | | 1,9 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0050 | 0,0060 | 0,0065 | 490 (310 – 490) |
| S12 | E | 1.9 | 0.050 | 0.070 | 0.085 | 0.10 | 0.13 | 0.15 | 0.17 | 115 (72 – 110) |
| | | 1,9 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0050 | 0,0060 | 0,0065 | 375 (240 – 360) |
| S13 | E | 1.9 | 0.046 | 0.060 | 0.075 | 0.090 | 0.11 | 0.13 | 0.15 | 120 (74 – 120) |
| | | 1,9 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 395 (250 – 390) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

JHP751

Hochleistungsfräser – Titan – Eckfräser – 2-4 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|---------------------|--------------|----------------|--------------|---------------|------|------|-------|-------|------|------|-----|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JHP751080D1R040.0Z4 | HXT | 10105487 | 1 | D | 8,0 | 8,0 | 16,0 | 58,0 | - | - | 0,4 | 4 | ■ |
| JHP751100D1R040.0Z4 | HXT | 10105548 | 1 | D | 10,0 | 10,0 | 20,0 | 66,0 | - | - | 0,4 | 4 | ■ |
| JHP751100D1R150.0Z4 | HXT | 10105549 | 1 | D | 10,0 | 10,0 | 20,0 | 66,0 | - | - | 1,5 | 4 | ■ |
| JHP751120D1R040.0Z4 | HXT | 10105550 | 1 | D | 12,0 | 12,0 | 24,0 | 75,0 | - | - | 0,4 | 4 | ■ |
| JHP751120D1R150.0Z4 | HXT | 10105552 | 1 | D | 12,0 | 12,0 | 24,0 | 75,0 | - | - | 1,5 | 4 | ■ |
| JHP751160D1R040.0Z4 | HXT | 10105581 | 1 | D | 16,0 | 16,0 | 32,0 | 92,0 | - | - | 0,4 | 4 | ■ |
| JHP751160D1R150.0Z4 | HXT | 10105582 | 1 | D | 16,0 | 16,0 | 32,0 | 92,0 | - | - | 1,5 | 4 | ■ |
| JHP751200D1R080.0Z4 | HXT | 10105583 | 1 | D | 20,0 | 20,0 | 40,0 | 104,0 | - | - | 0,8 | 4 | ■ |
| JHP751020G2R020.0Z2 | HXT | 10105584 | 2 | G | 2,0 | 3,0 | 3,0 | 38,0 | 6,0 | 1,9 | 0,2 | 2 | ■ |
| JHP751030G2R020.0Z2 | HXT | 10105585 | 2 | E | 3,0 | 3,0 | 4,5 | 38,0 | 9,0 | 2,8 | 0,2 | 2 | ■ |
| JHP751040G2R020.0Z2 | HXT | 10105586 | 2 | G | 4,0 | 6,0 | 6,0 | 50,0 | 9,0 | 3,7 | 0,2 | 2 | ■ |
| JHP751050G2R030.0Z2 | HXT | 10105587 | 2 | G | 5,0 | 6,0 | 7,5 | 50,0 | 9,0 | 4,6 | 0,3 | 2 | ■ |
| JHP751060E2R030.0Z3 | HXT | 10105588 | 2 | E | 6,0 | 6,0 | 9,0 | 57,0 | 19,0 | 5,6 | 0,3 | 3 | ■ |
| JHP751080E2R040.0Z4 | HXT | 10105589 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 24,0 | 7,4 | 0,4 | 4 | ■ |
| JHP751100E2R040.0Z4 | HXT | 10105590 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 30,0 | 9,4 | 0,4 | 4 | ■ |
| JHP751100E2R080.0Z4 | HXT | 10105591 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 30,0 | 9,4 | 0,8 | 4 | ■ |
| JHP751100E2R200.0Z4 | HXT | 10105593 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 30,0 | 9,4 | 2,0 | 4 | ■ |
| JHP751120E2R040.0Z4 | HXT | 10105594 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,4 | 4 | ■ |
| JHP751120E2R080.0Z4 | HXT | 10105595 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,8 | 4 | ■ |
| JHP751120E2R310.0Z4 | HXT | 10105596 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 3,1 | 4 | ■ |
| JHP751140E2R080.0Z4 | HXT | 10105597 | 2 | E | 14,0 | 14,0 | 28,0 | 92,0 | 45,0 | 13,4 | 0,8 | 4 | ■ |
| JHP751160E2R040.0Z4 | HXT | 10105598 | 2 | E | 16,0 | 16,0 | 32,0 | 104,0 | 52,0 | 15,4 | 0,4 | 4 | ■ |
| JHP751160E2R080.0Z4 | HXT | 10105599 | 2 | E | 16,0 | 16,0 | 32,0 | 104,0 | 52,0 | 15,4 | 0,8 | 4 | ■ |
| JHP751160E2R200.0Z4 | HXT | 10105600 | 2 | E | 16,0 | 16,0 | 32,0 | 104,0 | 52,0 | 15,4 | 2,0 | 4 | ■ |
| JHP751200E2R080.0Z4 | HXT | 10105601 | 2 | E | 20,0 | 20,0 | 40,0 | 129,0 | 75,0 | 19,4 | 0,8 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

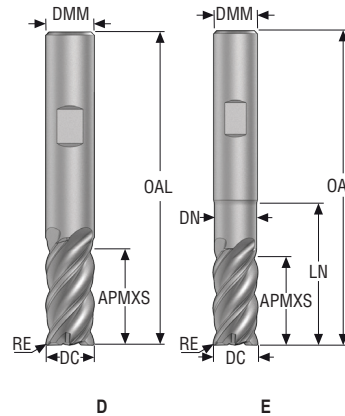
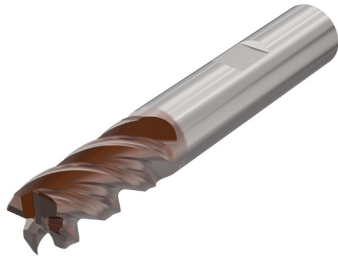
X-Heads

Minimaster Plus

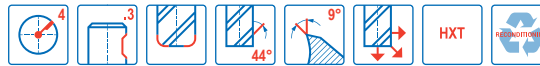
Minimaster

JHP751

Hochleistungsfräser – Titan – Eckfräser – 2-4 Schneiden – Weldon – Eckenradius



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Weldon |
|---------------------|--------------|----------------|--------------|---------------|------|------|-------|-------|------|------|-----|-------|--------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JHP751080D1R040.3Z4 | HXT | 10105739 | 1 | D | 8,0 | 8,0 | 16,0 | 58,0 | - | - | 0,4 | 4 | ■ |
| JHP751100D1R040.3Z4 | HXT | 10105740 | 1 | D | 10,0 | 10,0 | 20,0 | 66,0 | - | - | 0,4 | 4 | ■ |
| JHP751100D1R150.3Z4 | HXT | 10105742 | 1 | D | 10,0 | 10,0 | 20,0 | 66,0 | - | - | 1,5 | 4 | ■ |
| JHP751120D1R040.3Z4 | HXT | 10105743 | 1 | D | 12,0 | 12,0 | 24,0 | 75,0 | - | - | 0,4 | 4 | ■ |
| JHP751120D1R150.3Z4 | HXT | 10105744 | 1 | D | 12,0 | 12,0 | 24,0 | 75,0 | - | - | 1,5 | 4 | ■ |
| JHP751160D1R040.3Z4 | HXT | 10105745 | 1 | D | 16,0 | 16,0 | 32,0 | 92,0 | - | - | 0,4 | 4 | ■ |
| JHP751160D1R150.3Z4 | HXT | 10105746 | 1 | D | 16,0 | 16,0 | 32,0 | 92,0 | - | - | 1,5 | 4 | ■ |
| JHP751200D1R080.3Z4 | HXT | 10105747 | 1 | D | 20,0 | 20,0 | 40,0 | 104,0 | - | - | 0,8 | 4 | ■ |
| JHP751080E2R040.3Z4 | HXT | 10105748 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 24,0 | 7,4 | 0,4 | 4 | ■ |
| JHP751100E2R040.3Z4 | HXT | 10105749 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 30,0 | 9,4 | 0,4 | 4 | ■ |
| JHP751100E2R080.3Z4 | HXT | 10105750 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 30,0 | 9,4 | 0,8 | 4 | ■ |
| JHP751100E2R200.3Z4 | HXT | 10105751 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 30,0 | 9,4 | 2,0 | 4 | ■ |
| JHP751120E2R040.3Z4 | HXT | 10105752 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,4 | 4 | ■ |
| JHP751120E2R080.3Z4 | HXT | 10105753 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 0,8 | 4 | ■ |
| JHP751120E2R310.3Z4 | HXT | 10105754 | 2 | E | 12,0 | 12,0 | 24,0 | 83,0 | 35,0 | 11,4 | 3,1 | 4 | ■ |
| JHP751140E2R080.3Z4 | HXT | 10105755 | 2 | E | 14,0 | 14,0 | 28,0 | 92,0 | 45,0 | 13,4 | 0,8 | 4 | ■ |
| JHP751160E2R040.3Z4 | HXT | 10105756 | 2 | E | 16,0 | 16,0 | 32,0 | 104,0 | 52,0 | 15,4 | 0,4 | 4 | ■ |
| JHP751160E2R080.3Z4 | HXT | 10105757 | 2 | E | 16,0 | 16,0 | 32,0 | 104,0 | 52,0 | 15,4 | 0,8 | 4 | ■ |
| JHP751160E2R200.3Z4 | HXT | 10105758 | 2 | E | 16,0 | 16,0 | 32,0 | 104,0 | 52,0 | 15,4 | 2,0 | 4 | ■ |
| JHP751200E2R080.3Z4 | HXT | 10105759 | 2 | E | 20,0 | 20,0 | 40,0 | 129,0 | 75,0 | 19,4 | 0,8 | 4 | ■ |

■ Lagerstandard.

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NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JHP751 Eckfräsen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|---------|---------|--------|--------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 14 | 16 | 20 | |
| S1 | E/M/A | 0.0600 | 1,2 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 48 (33 – 64) |
| | | 0,0600 | 1,2 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 155 (110 – 200) |
| S2 | E/M/A | 0.0600 | 1,2 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 39 (26 – 51) |
| | | 0,0600 | 1,2 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 130 (86 – 160) |
| S3 | E/M/A | 0.0400 | 1,2 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 33 (26 – 50) |
| | | 0,0400 | 1,2 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 110 (86 – 160) |
| S11 | E/M/A | 0.0800 | 1,2 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 145 (130 – 180) |
| | | 0,0800 | 1,2 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 475 (430 – 590) |
| S12 | E/M/A | 0.0800 | 1,2 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 110 (95 – 140) |
| | | 0,0800 | 1,2 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 360 (320 – 450) |
| S13 | E/M/A | 0.0800 | 1,2 | 0.014 | 0.020 | 0.028 | 0.034 | 0.042 | 0.055 | 0.070 | 0.085 | 0.095 | 0.10 | 0.12 | 90 (76 – 110) |
| | | 0,0800 | 1,2 | 0,00055 | 0,00080 | 0,0011 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0038 | 0,0040 | 0,0048 | 295 (250 – 360) |

Schnittdaten – JHP751 Nutfräsen

| SMG | | a _p /DC | f _z | | | | | | | | | | | v _c |
|-----|-------|--------------------|----------------|---------|---------|---------|---------|---------|---------|--------|--------|--------|--------|-----------------|
| | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 14 | 16 | 20 | |
| S1 | E/M/A | 0.44 | 0.0075 | 0.011 | 0.015 | 0.019 | 0.022 | 0.030 | 0.038 | 0.044 | 0.050 | 0.055 | 0.065 | 30 (20 – 39) |
| | | 0,44 | 0,00030 | 0,00044 | 0,00060 | 0,00075 | 0,00085 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0022 | 0,0026 | 100 (66 – 120) |
| S2 | E/M/A | 0.44 | 0.0075 | 0.011 | 0.015 | 0.019 | 0.022 | 0.030 | 0.038 | 0.044 | 0.050 | 0.055 | 0.065 | 24 (17 – 32) |
| | | 0,44 | 0,00030 | 0,00044 | 0,00060 | 0,00075 | 0,00085 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0022 | 0,0026 | 80 (56 – 100) |
| S3 | E/M/A | 0.34 | 0.0046 | 0.0070 | 0.0095 | 0.012 | 0.014 | 0.019 | 0.024 | 0.028 | 0.032 | 0.034 | 0.040 | 20 (15 – 29) |
| | | 0,34 | 0,00018 | 0,00028 | 0,00038 | 0,00048 | 0,00055 | 0,00075 | 0,00095 | 0,0011 | 0,0013 | 0,0013 | 0,0016 | 65 (50 – 95) |
| S11 | E/M/A | 0.70 | 0.0085 | 0.013 | 0.017 | 0.022 | 0.026 | 0.034 | 0.044 | 0.050 | 0.055 | 0.065 | 0.075 | 90 (78 – 110) |
| | | 0,70 | 0,00034 | 0,00050 | 0,00065 | 0,00085 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0022 | 0,0026 | 0,0030 | 295 (260 – 360) |
| S12 | E/M/A | 0.70 | 0.0085 | 0.013 | 0.017 | 0.022 | 0.026 | 0.034 | 0.044 | 0.050 | 0.055 | 0.065 | 0.075 | 70 (60 – 89) |
| | | 0,70 | 0,00034 | 0,00050 | 0,00065 | 0,00085 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0022 | 0,0026 | 0,0030 | 230 (200 – 290) |
| S13 | E/M/A | 0.70 | 0.0075 | 0.011 | 0.015 | 0.019 | 0.022 | 0.030 | 0.038 | 0.044 | 0.050 | 0.055 | 0.065 | 55 (48 – 71) |
| | | 0,70 | 0,00030 | 0,00044 | 0,00060 | 0,00075 | 0,00085 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0022 | 0,0026 | 180 (160 – 230) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

 v_c = m/min (sf/min)

 f_z = mm/Zahn (Zoll/Zahn)

 a_p = mm/DC (Zoll/DC) = Faktor

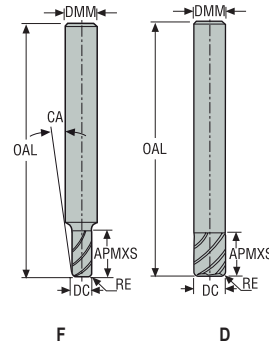
 a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

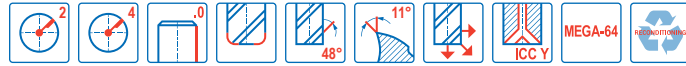
 Universell
 Stahl und Guss
 Rostfrei und ISO-S-Werkstoffe
 NE-Metalle
 Harter
 Kunststoffe und Composite
 Graphit
 X-Heads
 Minimaster Plus
 Minimaster

JHP760

Hochleistungsfräser – ISO-M – Eckfräser – 2-4 Schneiden – Zylindrisch – Eckenradius – ICC



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,03 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DC | DMM | APMXS | OAL | RE | CA° | PCEDC | Zylindrisch |
|--------------------------|--------------------|------------------|-------------------|-----|------|------|-------|-------|-----|------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | | | |
| 760040R020Z2.0A-MEGA-64 | 02734051 | 2 | F | ■ | 4,0 | 6,0 | 8,0 | 50,0 | 0,2 | 4,0° | 2 | ■ |
| 760040R040Z2.0A-MEGA-64 | 02623413 | 2 | F | ■ | 4,0 | 6,0 | 8,0 | 50,0 | 0,4 | 4,0° | 2 | ■ |
| 760050R020Z2.0A-MEGA-64 | 02734052 | 2 | F | ■ | 5,0 | 6,0 | 10,0 | 50,0 | 0,2 | 2,0° | 2 | ■ |
| 760050R040Z2.0A-MEGA-64 | 02623435 | 2 | F | ■ | 5,0 | 6,0 | 10,0 | 50,0 | 0,4 | 2,0° | 2 | ■ |
| 760060R020Z4.0A-MEGA-64 | 02734053 | 2 | D | ■ | 6,0 | 6,0 | 12,0 | 50,0 | 0,2 | - | 4 | ■ |
| 760060R040Z4.0A-MEGA-64 | 02623433 | 2 | D | ■ | 6,0 | 6,0 | 12,0 | 50,0 | 0,4 | - | 4 | ■ |
| 760080R040Z4.0A-MEGA-64 | 02623436 | 2 | D | ■ | 8,0 | 8,0 | 16,0 | 55,0 | 0,4 | - | 4 | ■ |
| 760080R100Z4.0A-MEGA-64 | 02623437 | 2 | D | ■ | 8,0 | 8,0 | 16,0 | 55,0 | 1,0 | - | 4 | ■ |
| 760100R040Z4.0A-MEGA-64 | 02623460 | 2 | D | ■ | 10,0 | 10,0 | 20,0 | 65,0 | 0,4 | - | 4 | ■ |
| 760100R100Z4.0A-MEGA-64 | 02623463 | 2 | D | ■ | 10,0 | 10,0 | 20,0 | 65,0 | 1,0 | - | 4 | ■ |
| 760100R150Z4.0A-MEGA-64 | 02623466 | 2 | D | ■ | 10,0 | 10,0 | 20,0 | 65,0 | 1,5 | - | 4 | ■ |
| 760120R040Z4.0A-MEGA-64 | 02623819 | 2 | D | ■ | 12,0 | 12,0 | 24,0 | 75,0 | 0,4 | - | 4 | ■ |
| 760120R100Z4.0A-MEGA-64 | 02623825 | 2 | D | ■ | 12,0 | 12,0 | 24,0 | 75,0 | 1,0 | - | 4 | ■ |
| 760120R150Z4.0A-MEGA-64 | 02623828 | 2 | D | ■ | 12,0 | 12,0 | 24,0 | 75,0 | 1,5 | - | 4 | ■ |
| 760120R310Z4.0A-MEGA-64 | 02623833 | 2 | D | ■ | 12,0 | 12,0 | 24,0 | 75,0 | 3,1 | - | 4 | ■ |
| 760200R040Z4.0A-MEGA-64 | 02734055 | 2 | D | ■ | 20,0 | 20,0 | 45,0 | 100,0 | 0,4 | - | 4 | ■ |
| 760200R080Z4.0A-MEGA-64 | 02623852 | 2 | D | ■ | 20,0 | 20,0 | 45,0 | 100,0 | 0,8 | - | 4 | ■ |
| 760L080R040Z4.0A-MEGA-64 | 02623438 | 3 | D | ■ | 8,0 | 8,0 | 28,0 | 65,0 | 0,4 | - | 4 | ■ |
| 760L100R040Z4.0A-MEGA-64 | 02623461 | 3 | D | ■ | 10,0 | 10,0 | 36,0 | 75,0 | 0,4 | - | 4 | ■ |
| 760L100R100Z4.0A-MEGA-64 | 02623464 | 3 | D | ■ | 10,0 | 10,0 | 36,0 | 75,0 | 1,0 | - | 4 | ■ |
| 760L100R150Z4.0A-MEGA-64 | 02623467 | 3 | D | ■ | 10,0 | 10,0 | 36,0 | 75,0 | 1,5 | - | 4 | ■ |
| 760L100R200Z4.0A-MEGA-64 | 02623472 | 3 | D | ■ | 10,0 | 10,0 | 36,0 | 75,0 | 2,0 | - | 4 | ■ |
| 760L100R310Z4.0A-MEGA-64 | 02623807 | 3 | D | ■ | 10,0 | 10,0 | 36,0 | 75,0 | 3,1 | - | 4 | ■ |
| 760L120R040Z4.0A-MEGA-64 | 02623821 | 3 | D | ■ | 12,0 | 12,0 | 42,0 | 90,0 | 0,4 | - | 4 | ■ |
| 760L120R100Z4.0A-MEGA-64 | 02623826 | 3 | D | ■ | 12,0 | 12,0 | 42,0 | 90,0 | 1,0 | - | 4 | ■ |
| 760L120R150Z4.0A-MEGA-64 | 02623829 | 3 | D | ■ | 12,0 | 12,0 | 42,0 | 90,0 | 1,5 | - | 4 | ■ |
| 760L120R400Z4.0A-MEGA-64 | 02623838 | 3 | D | ■ | 12,0 | 12,0 | 42,0 | 90,0 | 4,0 | - | 4 | ■ |
| 760L160R040Z4.0A-MEGA-64 | 02623840 | 3 | D | ■ | 16,0 | 16,0 | 50,0 | 100,0 | 0,4 | - | 4 | ■ |
| 760L160R100Z4.0A-MEGA-64 | 02623842 | 3 | D | ■ | 16,0 | 16,0 | 50,0 | 100,0 | 1,0 | - | 4 | ■ |
| 760L160R150Z4.0A-MEGA-64 | 02623844 | 3 | D | ■ | 16,0 | 16,0 | 50,0 | 100,0 | 1,5 | - | 4 | ■ |

■ Lagerstandard.
ICC = mit interner Kühlschmiermittelzufuhr

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und Composite

Graphit

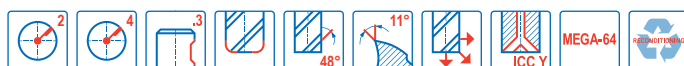
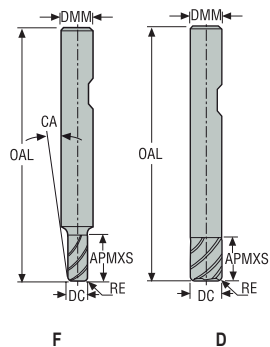
X-Heads

Minimaster Plus

Minimaster

JHP760

Hochleistungsfräser – ISO-M – Eckfräser – 2-4 Schneiden – Weldon – Eckenradius – ICC



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,03 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | ICC | DC | DMM | APMXS | OAL | RE | CA° | PCEDC | Weldon |
|--------------------------|----------------|--------------|---------------|-----|------|------|-------|-------|-----|-------|-------|--------|
| | | | | | mm | mm | mm | mm | mm | | | |
| 760040R020Z2.0A-MEGA-64W | 02734065 | 2 | F | ■ | 4,0 | 6,0 | 8,0 | 50,0 | 0,2 | 4,0 ° | 2 | □ |
| 760040R040Z2.0A-MEGA-64W | 02669339 | 2 | F | ■ | 4,0 | 6,0 | 8,0 | 50,0 | 0,4 | 4,0 ° | 2 | □ |
| 760050R020Z2.0A-MEGA-64W | 02734068 | 2 | F | ■ | 5,0 | 6,0 | 10,0 | 50,0 | 0,2 | 2,0 ° | 2 | □ |
| 760050R040Z2.0A-MEGA-64W | 02669340 | 2 | F | ■ | 5,0 | 6,0 | 10,0 | 50,0 | 0,4 | 2,0 ° | 2 | □ |
| 760060R020Z4.0A-MEGA-64W | 02734069 | 2 | D | ■ | 6,0 | 6,0 | 12,0 | 50,0 | 0,2 | - | 4 | □ |
| 760060R040Z4.0A-MEGA-64W | 02669341 | 2 | D | ■ | 6,0 | 6,0 | 12,0 | 50,0 | 0,4 | - | 4 | □ |
| 760080R040Z4.0A-MEGA-64W | 02669343 | 2 | D | ■ | 8,0 | 8,0 | 16,0 | 55,0 | 0,4 | - | 4 | □ |
| 760080R100Z4.0A-MEGA-64W | 02669344 | 2 | D | ■ | 8,0 | 8,0 | 16,0 | 55,0 | 1,0 | - | 4 | □ |
| 760100R040Z4A-MEGA-64 | 02623442 | 2 | D | ■ | 10,0 | 10,0 | 20,0 | 65,0 | 0,4 | - | 4 | ■ |
| 760100R100Z4A-MEGA-64 | 02623462 | 2 | D | ■ | 10,0 | 10,0 | 20,0 | 65,0 | 1,0 | - | 4 | ■ |
| 760100R150Z4A-MEGA-64 | 02623465 | 2 | D | ■ | 10,0 | 10,0 | 20,0 | 65,0 | 1,5 | - | 4 | ■ |
| 760120R040Z4A-MEGA-64 | 02623817 | 2 | D | ■ | 12,0 | 12,0 | 24,0 | 75,0 | 0,4 | - | 4 | ■ |
| 760120R100Z4A-MEGA-64 | 02623824 | 2 | D | ■ | 12,0 | 12,0 | 24,0 | 75,0 | 1,0 | - | 4 | ■ |
| 760120R150Z4A-MEGA-64 | 02623827 | 2 | D | ■ | 12,0 | 12,0 | 24,0 | 75,0 | 1,5 | - | 4 | ■ |
| 760120R400Z4A-MEGA-64 | 02623835 | 2 | D | ■ | 12,0 | 12,0 | 24,0 | 75,0 | 4,0 | - | 4 | ■ |
| 760160R040Z4A-MEGA-64 | 02623839 | 2 | D | ■ | 16,0 | 16,0 | 40,0 | 90,0 | 0,4 | - | 4 | ■ |
| 760160R100Z4A-MEGA-64 | 02623841 | 2 | D | ■ | 16,0 | 16,0 | 40,0 | 90,0 | 1,0 | - | 4 | ■ |
| 760160R150Z4A-MEGA-64 | 02623843 | 2 | D | ■ | 16,0 | 16,0 | 40,0 | 90,0 | 1,5 | - | 4 | ■ |
| 760160R200Z4A-MEGA-64 | 02623845 | 2 | D | ■ | 16,0 | 16,0 | 40,0 | 90,0 | 2,0 | - | 4 | ■ |
| 760200R040Z4A-MEGA-64 | 02734054 | 2 | D | ■ | 20,0 | 20,0 | 45,0 | 100,0 | 0,4 | - | 4 | ■ |
| 760200R080Z4A-MEGA-64 | 02623851 | 2 | D | ■ | 20,0 | 20,0 | 45,0 | 100,0 | 0,8 | - | 4 | ■ |

■ Lagerstandard. □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.
ICC = mit interner Kühlschmiermittelzufuhr

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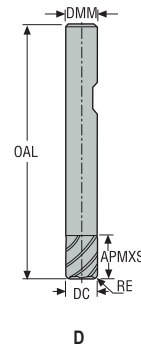
X-Heads

Minimaster Plus

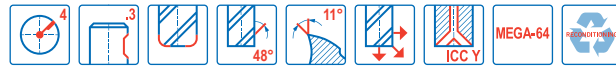
Minimaster

JHP760

Hochleistungsfräser – ISO-S – Eckfräser – 2-4 Schneiden – Weldon – Eckenradius – ICC



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,03 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DC | DMM | APMXS | OAL | RE | PCEDC | Weldon |
|---------------------------|--------------------|------------------|-------------------|-----|------|------|-------|-------|-----|-------|--------------------------|
| | | | | | mm | mm | mm | mm | mm | | |
| 760L080R040Z4.0A-MEGA-64W | 02720459 | 3 | D | ■ | 8,0 | 8,0 | 28,0 | 65,0 | 0,4 | 4 | <input type="checkbox"/> |
| 760L100R040Z4.0A-MEGA-64W | 02669345 | 3 | D | ■ | 10,0 | 10,0 | 36,0 | 75,0 | 0,4 | 4 | <input type="checkbox"/> |
| 760L100R100Z4.0A-MEGA-64W | 02669346 | 3 | D | ■ | 10,0 | 10,0 | 36,0 | 75,0 | 1,0 | 4 | <input type="checkbox"/> |
| 760L100R150Z4.0A-MEGA-64W | 02669347 | 3 | D | ■ | 10,0 | 10,0 | 36,0 | 75,0 | 1,5 | 4 | <input type="checkbox"/> |
| 760L100R200Z4.0A-MEGA-64W | 02669348 | 3 | D | ■ | 10,0 | 10,0 | 36,0 | 75,0 | 2,0 | 4 | <input type="checkbox"/> |
| 760L120R040Z4.0A-MEGA-64W | 02669350 | 3 | D | ■ | 12,0 | 12,0 | 42,0 | 90,0 | 0,4 | 4 | <input type="checkbox"/> |
| 760L120R100Z4.0A-MEGA-64W | 02669351 | 3 | D | ■ | 12,0 | 12,0 | 42,0 | 90,0 | 1,0 | 4 | <input type="checkbox"/> |
| 760L120R150Z4.0A-MEGA-64W | 02669352 | 3 | D | ■ | 12,0 | 12,0 | 42,0 | 90,0 | 1,5 | 4 | <input type="checkbox"/> |
| 760L160R040Z4.0A-MEGA-64W | 02669356 | 3 | D | ■ | 16,0 | 16,0 | 50,0 | 100,0 | 0,4 | 4 | <input type="checkbox"/> |
| 760L160R100Z4.0A-MEGA-64W | 02669357 | 3 | D | ■ | 16,0 | 16,0 | 50,0 | 100,0 | 1,0 | 4 | <input type="checkbox"/> |
| 760L160R150Z4.0A-MEGA-64W | 02669358 | 3 | D | ■ | 16,0 | 16,0 | 50,0 | 100,0 | 1,5 | 4 | <input type="checkbox"/> |

Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.
ICC = mit interner Kühlschmiermittelzufuhr

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Minimaster Plus

Minimaster

Schnittdaten – JHP760 Eckfräsen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | 25 | |
| M1 | E | 0.300 | 1.5 | 0.036 | 0.044 | 0.055 | 0.070 | 0.090 | 0.10 | 0.13 | 0.15 | 0.17 | 120 (97 – 130) |
| | | 0,300 | 1,5 | 0,0014 | 0,0017 | 0,0022 | 0,0028 | 0,0036 | 0,0040 | 0,0050 | 0,0060 | 0,0065 | 395 (320 – 420) |
| M2 | E | 0.300 | 1.5 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 0.13 | 0.15 | 100 (81 – 110) |
| | | 0,300 | 1,5 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0050 | 0,0060 | 330 (270 – 360) |
| M3 | E | 0.300 | 1.4 | 0.026 | 0.032 | 0.038 | 0.050 | 0.065 | 0.075 | 0.095 | 0.11 | 0.12 | 75 (58 – 91) |
| | | 0,300 | 1,4 | 0,0010 | 0,0013 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 245 (200 – 290) |
| M4 | E | 0.300 | 1.4 | 0.022 | 0.028 | 0.034 | 0.046 | 0.055 | 0.065 | 0.085 | 0.095 | 0.11 | 60 (45 – 70) |
| | | 0,300 | 1,4 | 0,00085 | 0,0011 | 0,0013 | 0,0018 | 0,0022 | 0,0026 | 0,0034 | 0,0038 | 0,0044 | 195 (150 – 220) |
| M5 | E | 0.300 | 1.4 | 0.022 | 0.028 | 0.034 | 0.046 | 0.055 | 0.065 | 0.085 | 0.095 | 0.11 | 48 (37 – 59) |
| | | 0,300 | 1,4 | 0,00085 | 0,0011 | 0,0013 | 0,0018 | 0,0022 | 0,0026 | 0,0034 | 0,0038 | 0,0044 | 155 (130 – 190) |

Schnittdaten – JHP760 Nutfräsen

| SMG |  | a _p /DC | f _z | | | | | | | | | v _c |
|-----|---|--------------------|----------------|---------|---------|---------|--------|--------|--------|--------|--------|-----------------|
| | | | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | 25 | |
| M1 | E | 1.0 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.10 | 110 (92 – 130) |
| | | 1,0 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0040 | 360 (310 – 420) |
| M2 | E | 1.0 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.10 | 90 (74 – 100) |
| | | 1,0 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0040 | 295 (250 – 320) |
| M3 | E | 0.80 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.075 | 70 (54 – 85) |
| | | 0,80 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0030 | 230 (180 – 270) |
| M4 | E | 0.80 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.075 | 50 (40 – 63) |
| | | 0,80 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0030 | 165 (140 – 200) |
| M5 | E | 0.80 | 0.012 | 0.015 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.075 | 43 (34 – 53) |
| | | 0,80 | 0,00048 | 0,00060 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0030 | 140 (120 – 170) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

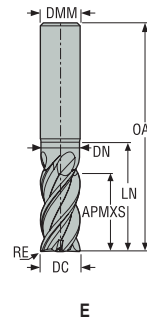
a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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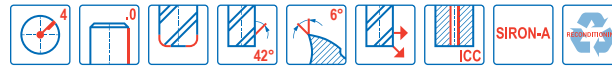
JHP770

Hochleistungsfräser – Titan – Eckfräser – 4-5 Schneiden – Zylindrisch – Eckenradius – ICC



E

- Toleranzen:
- DMM = h5
- DC = e7
- RE = ±0,02 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|---------------------------|--------------------|------------------|-------------------|-----|------|------|-------|-------|------|------|-----|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JHP770060E2R030.0Z4A-SIRA | 02760645 | 2 | E | ■ | 6,0 | 6,0 | 12,0 | 60,0 | 18,0 | 5,6 | 0,3 | 4 | ■ |
| JHP770080E2R040.0Z4A-SIRA | 02760653 | 2 | E | ■ | 8,0 | 8,0 | 16,0 | 65,0 | 24,0 | 7,4 | 0,4 | 4 | ■ |
| JHP770080E2R050.0Z4A-SIRA | 02823416 | 2 | E | ■ | 8,0 | 8,0 | 16,0 | 65,0 | 24,0 | 7,4 | 0,5 | 4 | ■ |
| JHP770100E2R040.0Z4A-SIRA | 02760654 | 2 | E | ■ | 10,0 | 10,0 | 20,0 | 75,0 | 30,0 | 9,4 | 0,4 | 4 | ■ |
| JHP770100E2R050.0Z4A-SIRA | 02823417 | 2 | E | ■ | 10,0 | 10,0 | 20,0 | 75,0 | 30,0 | 9,4 | 0,5 | 4 | ■ |
| JHP770120E2R040.0Z4A-SIRA | 02760656 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,4 | 0,4 | 4 | ■ |
| JHP770120E2R050.0Z4A-SIRA | 02823419 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,4 | 0,5 | 4 | ■ |
| JHP770120E2R100.0Z4A-SIRA | 02823420 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,4 | 1,0 | 4 | ■ |
| JHP770120E2R250.0Z4A-SIRA | 02760659 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,4 | 2,5 | 4 | ■ |
| JHP770140E2R050.0Z4A-SIRA | 02823421 | 2 | E | ■ | 14,0 | 14,0 | 28,0 | 95,0 | 42,0 | 13,4 | 0,5 | 4 | ■ |
| JHP770160E2R040.0Z4A-SIRA | 02760661 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 0,4 | 4 | ■ |
| JHP770160E2R050.0Z4A-SIRA | 02823422 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 0,5 | 4 | ■ |
| JHP770160E2R080.0Z4A-SIRA | 02760662 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 0,8 | 4 | ■ |
| JHP770160E2R100.0Z4A-SIRA | 02823423 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 1,0 | 4 | ■ |
| JHP770160E2R250.0Z4A-SIRA | 02760663 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 2,5 | 4 | ■ |
| JHP770160E2R310.0Z4A-SIRA | 02760664 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 3,1 | 4 | ■ |
| JHP770160E2R400.0Z4A-SIRA | 02760665 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 4,0 | 4 | ■ |
| JHP770200E2R050.0Z4A-SIRA | 02823424 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 0,5 | 4 | ■ |
| JHP770200E2R100.0Z4A-SIRA | 02823425 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 1,0 | 4 | ■ |
| JHP770200E2R250.0Z4A-SIRA | 02760668 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 2,5 | 4 | ■ |
| JHP770200E2R310.0Z4A-SIRA | 02760669 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 3,1 | 4 | ■ |
| JHP770200E2R400.0Z4A-SIRA | 02760670 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 4,0 | 4 | ■ |

■ Lagerstandard.

Anmerkung: bei Eckenradius >15% DC → a_p = -30%, f_z = -20%
ICC = mit interner Kühlschmiermittelzufuhr

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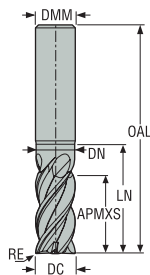
X-Heads

Minimaster Plus

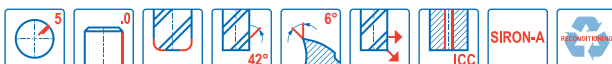
Minimaster

JHP770

Hochleistungsfräser – Titan – Eckfräser – 4-5 Schneiden – Zylindrisch – Eckenradius – ICC



E



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|---------------------------|--------------------|------------------|-------------------|-----|------|------|-------|-------|------|------|-----|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JHP770160E2R050.0Z5A-SIRA | 02810129 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 0,5 | 5 | ■ |
| JHP770160E2R100.0Z5A-SIRA | 02810130 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 1,0 | 5 | ■ |
| JHP770160E2R250.0Z5A-SIRA | 02810131 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 2,5 | 5 | ■ |
| JHP770160E2R310.0Z5A-SIRA | 02810132 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 3,1 | 5 | ■ |
| JHP770160E2R400.0Z5A-SIRA | 02810133 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 4,0 | 5 | ■ |
| JHP770200E2R050.0Z5A-SIRA | 02810134 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 0,5 | 5 | ■ |
| JHP770200E2R100.0Z5A-SIRA | 02810135 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 1,0 | 5 | ■ |
| JHP770200E2R250.0Z5A-SIRA | 02810136 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 2,5 | 5 | ■ |
| JHP770200E2R310.0Z5A-SIRA | 02810137 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 3,1 | 5 | ■ |
| JHP770200E2R400.0Z5A-SIRA | 02810138 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 4,0 | 5 | ■ |
| JHP770250E2R050.0Z5A-SIRA | 02810139 | 2 | E | ■ | 25,0 | 25,0 | 50,0 | 130,0 | 65,0 | 24,4 | 0,5 | 5 | ■ |

■ Lagerstandard.

Anmerkung: bei Eckenradius >15% DC → a_p=-30%, f_z=-20%
ICC = mit interner Kühlschmiermittelzufuhr

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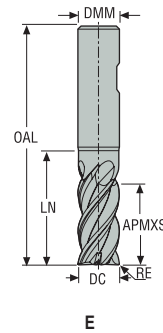
X-Heads

Minimaster Plus

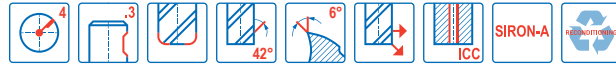
Minimaster

JHP770

Hochleistungsfräser – Titan – Eckfräser – 4-5 Schneiden – Weldon – Eckenradius – ICC



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | ICC | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Weldon |
|---------------------------|----------------|--------------|---------------|-----|------|------|-------|-------|------|------|-----|-------|--------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JHP770060E2R030.3Z4A-SIRA | 02760796 | 2 | E | ■ | 6,0 | 6,0 | 12,0 | 60,0 | 18,0 | 5,6 | 0,3 | 4 | ■ |
| JHP770080E2R040.3Z4A-SIRA | 02760799 | 2 | E | ■ | 8,0 | 8,0 | 16,0 | 65,0 | 24,0 | 7,4 | 0,4 | 4 | □ |
| JHP770080E2R050.3Z4A-SIRA | 02823428 | 2 | E | ■ | 8,0 | 8,0 | 16,0 | 65,0 | 24,0 | 7,4 | 0,5 | 4 | ■ |
| JHP770100E2R040.3Z4A-SIRA | 02760801 | 2 | E | ■ | 10,0 | 10,0 | 20,0 | 75,0 | 30,0 | 9,4 | 0,4 | 4 | □ |
| JHP770100E2R050.3Z4A-SIRA | 02823429 | 2 | E | ■ | 10,0 | 10,0 | 20,0 | 75,0 | 30,0 | 9,4 | 0,5 | 4 | ■ |
| JHP770120E2R040.3Z4A-SIRA | 02760803 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,4 | 0,4 | 4 | □ |
| JHP770120E2R050.3Z4A-SIRA | 02823431 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,4 | 0,5 | 4 | ■ |
| JHP770120E2R100.3Z4A-SIRA | 02823432 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,4 | 1,0 | 4 | ■ |
| JHP770120E2R250.3Z4A-SIRA | 02760805 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,4 | 2,5 | 4 | □ |
| JHP770140E2R050.3Z4A-SIRA | 02823433 | 2 | E | ■ | 14,0 | 14,0 | 28,0 | 95,0 | 42,0 | 13,4 | 0,5 | 4 | ■ |
| JHP770160E2R040.3Z4A-SIRA | 02760807 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 0,4 | 4 | □ |
| JHP770160E2R050.3Z4A-SIRA | 02823434 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 0,5 | 4 | ■ |
| JHP770160E2R080.3Z4A-SIRA | 02760809 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 0,8 | 4 | □ |
| JHP770160E2R100.3Z4A-SIRA | 02823435 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 1,0 | 4 | ■ |
| JHP770160E2R250.3Z4A-SIRA | 02760810 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 2,5 | 4 | ■ |
| JHP770160E2R310.3Z4A-SIRA | 02760811 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 3,1 | 4 | □ |
| JHP770160E2R400.3Z4A-SIRA | 02760817 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 4,0 | 4 | □ |
| JHP770200E2R050.3Z4A-SIRA | 02823436 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 0,5 | 4 | ■ |
| JHP770200E2R100.3Z4A-SIRA | 02823437 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 1,0 | 4 | ■ |
| JHP770200E2R250.3Z4A-SIRA | 02760823 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 2,5 | 4 | □ |
| JHP770200E2R310.3Z4A-SIRA | 02760824 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 3,1 | 4 | □ |
| JHP770200E2R400.3Z4A-SIRA | 02760825 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 4,0 | 4 | □ |

■ Lagerstandard. □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.
Anmerkung: bei Eckenradius >15% von DC → a_p=-30%, f_z=-20%
ICC = mit interner Kühlschmiermittelzufuhr

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Kunststoffe und Composite

Graphit

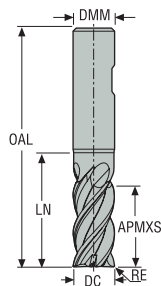
X-Heads

Minimaster Plus

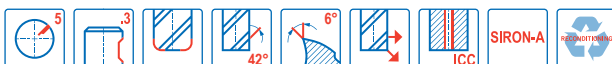
Minimaster

JHP770

Hochleistungsfräser – Titan – Eckfräser – 4-5 Schneiden – Weldon – Eckenradius – ICC



E



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | ICC | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Weldon |
|---------------------------|----------------|--------------|---------------|-----|------|------|-------|-------|------|------|-----|-------|--------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JHP770160E2R050.3Z5A-SIRA | 02810143 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 0,5 | 5 | ■ |
| JHP770160E2R100.3Z5A-SIRA | 02810144 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 1,0 | 5 | ■ |
| JHP770160E2R250.3Z5A-SIRA | 02810145 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 2,5 | 5 | □ |
| JHP770160E2R310.3Z5A-SIRA | 02810146 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 3,1 | 5 | ■ |
| JHP770160E2R400.3Z5A-SIRA | 02810147 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 4,0 | 5 | □ |
| JHP770200E2R050.3Z5A-SIRA | 02810148 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 0,5 | 5 | ■ |
| JHP770200E2R100.3Z5A-SIRA | 02810149 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 1,0 | 5 | ■ |
| JHP770200E2R250.3Z5A-SIRA | 02810150 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 2,5 | 5 | □ |
| JHP770200E2R310.3Z5A-SIRA | 02810151 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 3,1 | 5 | ■ |
| JHP770200E2R400.3Z5A-SIRA | 02810152 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 4,0 | 5 | ■ |
| JHP770250E2R050.3Z5A-SIRA | 02810153 | 2 | E | ■ | 25,0 | 25,0 | 50,0 | 130,0 | 65,0 | 24,4 | 0,5 | 5 | ■ |
| JHP770250E2R100.3Z5A-SIRA | 02810154 | 2 | E | ■ | 25,0 | 25,0 | 50,0 | 130,0 | 65,0 | 24,4 | 1,0 | 5 | ■ |

■ Lagerstandard. □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.
Anmerkung: bei Eckenradius >15% von DC → a_p=-30%, f_z=-20%
ICC = mit interner Kühlschmiermittelzufuhr

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NE-Metalle

Harter

Kunststoffe und Composite

Graphit

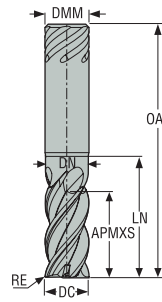
X-Heads

Minimaster Plus

Minimaster

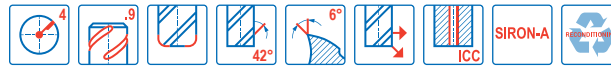
JHP770

Hochleistungsfräser – Titan – Eckfräser – 4-5 Schneiden – Safe-Lock – Eckenradius – ICC



E

- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Safe-Lock |
|---------------------------|--------------------|------------------|-------------------|-----|------|------|-------|-------|------|------|-----|-------|--------------------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JHP770060E2R030.9Z4A-SIRA | 02927936 | 2 | E | ■ | 6,0 | 6,0 | 12,0 | 60,0 | 18,0 | 6,0 | 0,3 | 4 | <input type="checkbox"/> |
| JHP770080E2R040.9Z4A-SIRA | 02927937 | 2 | E | ■ | 8,0 | 8,0 | 16,0 | 65,0 | 24,0 | 7,0 | 0,4 | 4 | <input type="checkbox"/> |
| JHP770080E2R050.9Z4A-SIRA | 02927938 | 2 | E | ■ | 8,0 | 8,0 | 16,0 | 65,0 | 24,0 | 7,0 | 0,5 | 4 | <input type="checkbox"/> |
| JHP770100E2R040.9Z4A-SIRA | 02927939 | 2 | E | ■ | 10,0 | 10,0 | 20,0 | 75,0 | 30,0 | 9,0 | 0,4 | 4 | <input type="checkbox"/> |
| JHP770100E2R050.9Z4A-SIRA | 02927940 | 2 | E | ■ | 10,0 | 10,0 | 20,0 | 75,0 | 30,0 | 9,0 | 0,5 | 4 | <input type="checkbox"/> |
| JHP770120E2R040.9Z4A-SIRA | 02927943 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,0 | 0,4 | 4 | <input type="checkbox"/> |
| JHP770120E2R050.9Z4A-SIRA | 02927944 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,0 | 0,5 | 4 | <input type="checkbox"/> |
| JHP770120E2R100.9Z4A-SIRA | 02927946 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,0 | 1,0 | 4 | <input type="checkbox"/> |
| JHP770120E2R250.9Z4A-SIRA | 02927947 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,0 | 2,5 | 4 | <input type="checkbox"/> |
| JHP770140E2R050.9Z4A-SIRA | 02927950 | 2 | E | ■ | 14,0 | 14,0 | 28,0 | 95,0 | 42,0 | 13,0 | 0,5 | 4 | <input type="checkbox"/> |
| JHP770160E2R040.9Z4A-SIRA | 02927948 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,0 | 0,4 | 4 | <input type="checkbox"/> |
| JHP770160E2R050.9Z4A-SIRA | 02927978 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,0 | 0,5 | 4 | <input type="checkbox"/> |
| JHP770160E2R080.9Z4A-SIRA | 02927951 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,0 | 0,8 | 4 | <input type="checkbox"/> |
| JHP770160E2R100.9Z4A-SIRA | 02927952 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,0 | 1,0 | 4 | <input type="checkbox"/> |
| JHP770160E2R250.9Z4A-SIRA | 02927954 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,0 | 2,5 | 4 | <input type="checkbox"/> |
| JHP770160E2R310.9Z4A-SIRA | 02927956 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,0 | 3,1 | 4 | <input type="checkbox"/> |
| JHP770160E2R400.9Z4A-SIRA | 02927958 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,0 | 4,0 | 4 | <input type="checkbox"/> |
| JHP770200E2R050.9Z4A-SIRA | 02927960 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,0 | 0,5 | 4 | <input type="checkbox"/> |
| JHP770200E2R100.9Z4A-SIRA | 02927962 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,0 | 1,0 | 4 | <input type="checkbox"/> |
| JHP770200E2R250.9Z4A-SIRA | 02927964 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,0 | 2,5 | 4 | <input type="checkbox"/> |
| JHP770200E2R310.9Z4A-SIRA | 02927966 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,0 | 3,1 | 4 | <input type="checkbox"/> |
| JHP770200E2R400.9Z4A-SIRA | 02927968 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,0 | 4,0 | 4 | <input type="checkbox"/> |

Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.

Anmerkung: bei Eckenradius >15% von DC → a_p=-30%, f_z=-20%

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Graphit

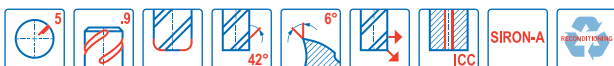
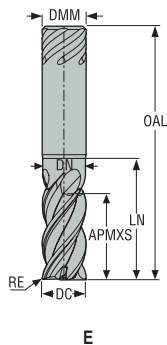
X-Heads

Minimaster Plus

Minimaster

JHP770

Hochleistungsfräser – Titan – Eckfräser – 4-5 Schneiden – Safe-Lock – Eckenradius – ICC



- Toleranzen:
- DMM = h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | ICC | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Safe-Lock |
|---------------------------|----------------|--------------|---------------|-----|------|------|-------|-------|------|------|-----|-------|--------------------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JHP770160E2R050.9Z5A-SIRA | 02927949 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,0 | 0,5 | 5 | <input type="checkbox"/> |
| JHP770160E2R100.9Z5A-SIRA | 02927953 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,0 | 1,0 | 5 | <input type="checkbox"/> |
| JHP770160E2R250.9Z5A-SIRA | 02927955 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,0 | 2,5 | 5 | <input type="checkbox"/> |
| JHP770160E2R310.9Z5A-SIRA | 02927957 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,0 | 3,1 | 5 | <input type="checkbox"/> |
| JHP770160E2R400.9Z5A-SIRA | 02927959 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,0 | 4,0 | 5 | <input type="checkbox"/> |
| JHP770200E2R050.9Z5A-SIRA | 02927961 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,0 | 0,5 | 5 | <input type="checkbox"/> |
| JHP770200E2R100.9Z5A-SIRA | 02927963 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,0 | 1,0 | 5 | <input type="checkbox"/> |
| JHP770200E2R250.9Z5A-SIRA | 02927965 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,0 | 2,5 | 5 | <input type="checkbox"/> |
| JHP770200E2R310.9Z5A-SIRA | 02927967 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,0 | 3,1 | 5 | <input type="checkbox"/> |
| JHP770200E2R400.9Z5A-SIRA | 02927969 | 2 | E | ■ | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,0 | 4,0 | 5 | <input type="checkbox"/> |
| JHP770250E2R050.9Z5A-SIRA | 02927971 | 2 | E | ■ | 25,0 | 25,0 | 50,0 | 130,0 | 65,0 | 24,0 | 0,5 | 5 | <input type="checkbox"/> |

Safelock verfügbar. Die Lieferzeit beträgt 6 Tage.
Anmerkung: bei Eckenradius >15% von DC → a_p=-30%, f_z=-20%

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Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JHP770 Eckfräsen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | | 6 | 8 | 10 | 12 | 14 | 16 | 20 | 25 | |
| S11 | E | 0.400 | 1.8 | 0.050 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.16 | 120 (110 – 130) |
| | | 0,400 | 1,6 | 0,0020 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0065 | 395 (370 – 420) |
| S12 | E | 0.400 | 1.8 | 0.050 | 0.065 | 0.080 | 0.095 | 0.11 | 0.12 | 0.14 | 0.16 | 90 (80 – 100) |
| | | 0,400 | 1,6 | 0,0020 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 0,0065 | 295 (270 – 320) |
| S13 | E | 0.400 | 1.8 | 0.042 | 0.055 | 0.070 | 0.085 | 0.095 | 0.11 | 0.12 | 0.14 | 75 (64 – 81) |
| | | 0,400 | 1,6 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0038 | 0,0044 | 0,0048 | 0,0055 | 245 (210 – 260) |

Schnittdaten – JHP770 Nutfräsen

| SMG | | a _p /DC | f _z | | | | | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | 6 | 8 | 10 | 12 | 14 | 16 | 20 | 25 | |
| S11 | E | 1.6 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.10 | 0.13 | 105 (94 – 120) |
| | | 1,6 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0040 | 0,0050 | 345 (310 – 390) |
| S12 | E | 1.6 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.10 | 0.13 | 80 (72 – 92) |
| | | 1,6 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0040 | 0,0050 | 260 (240 – 300) |
| S13 | E | 1.6 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.10 | 0.13 | 65 (56 – 71) |
| | | 1,6 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0040 | 0,0050 | 215 (190 – 230) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

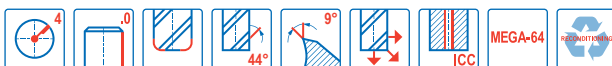
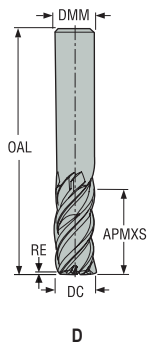
a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

JHP780

Hochleistungsfräser – Superlegierung – Eckfräser – 4-Schneiden – Zylindrisch – Eckenradius – ICC



- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DC | DMM | APMXS | OAL | RE | PCEDC | Zylindrisch |
|--------------------------|--------------------|------------------|-------------------|-----|------|------|-------|------|-----|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | | |
| JHP780060D1R030.0Z4A-M64 | 03134984 | 1 | D | ■ | 6,0 | 6,0 | 7,5 | 47,0 | 0,3 | 4 | ■ |
| JHP780060D1R080.0Z4A-M64 | 03134985 | 1 | D | ■ | 6,0 | 6,0 | 7,5 | 47,0 | 0,8 | 4 | ■ |
| JHP780080D1R040.0Z4A-M64 | 03134986 | 1 | D | ■ | 8,0 | 8,0 | 10,0 | 50,0 | 0,4 | 4 | ■ |
| JHP780080D1R080.0Z4A-M64 | 03134987 | 1 | D | ■ | 8,0 | 8,0 | 10,0 | 50,0 | 0,8 | 4 | ■ |
| JHP780100D1R040.0Z4A-M64 | 03134988 | 1 | D | ■ | 10,0 | 10,0 | 12,5 | 57,0 | 0,4 | 4 | ■ |
| JHP780100D1R080.0Z4A-M64 | 03134989 | 1 | D | ■ | 10,0 | 10,0 | 12,5 | 57,0 | 0,8 | 4 | ■ |

■ Lagerstandard.

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Composite

Graphit

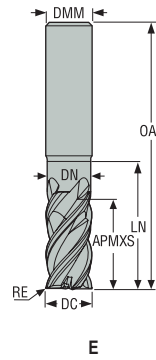
X-Heads

Minimaster Plus

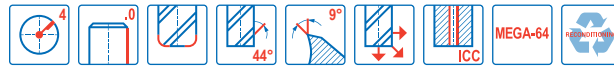
Minimaster

JHP780

Hochleistungsfräser – Superlegierung – Eckfräser – 4-Schneiden – Zylindrisch – Eckenradius – ICC



- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|--------------------------|--------------------|------------------|-------------------|-----|------|------|-------|-------|------|------|-----|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JHP780060E2R030.0Z4A-M64 | 03134992 | 2 | E | ■ | 6,0 | 6,0 | 12,0 | 60,0 | 18,0 | 5,6 | 0,3 | 4 | ■ |
| JHP780060E2R030.0Z4-M64 | 02760834 | 2 | E | - | 6,0 | 6,0 | 12,0 | 60,0 | 18,0 | 5,6 | 0,3 | 4 | ■ |
| JHP780080E2R040.0Z4A-M64 | 03134993 | 2 | E | ■ | 8,0 | 8,0 | 16,0 | 65,0 | 24,0 | 7,4 | 0,4 | 4 | ■ |
| JHP780080E2R040.0Z4-M64 | 02760842 | 2 | E | - | 8,0 | 8,0 | 16,0 | 65,0 | 24,0 | 7,4 | 0,4 | 4 | ■ |
| JHP780100E2R040.0Z4A-M64 | 03134994 | 2 | E | ■ | 10,0 | 10,0 | 20,0 | 75,0 | 30,0 | 9,4 | 0,4 | 4 | ■ |
| JHP780100E2R040.0Z4-M64 | 02760846 | 2 | E | - | 10,0 | 10,0 | 20,0 | 75,0 | 30,0 | 9,4 | 0,4 | 4 | ■ |
| JHP780100E2R080.0Z4A-M64 | 03134995 | 2 | E | ■ | 10,0 | 10,0 | 20,0 | 75,0 | 30,0 | 9,4 | 0,8 | 4 | ■ |
| JHP780100E2R080.0Z4-M64 | 02760847 | 2 | E | - | 10,0 | 10,0 | 20,0 | 75,0 | 30,0 | 9,4 | 0,8 | 4 | ■ |
| JHP780120E2R040.0Z4A-M64 | 03134996 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,4 | 0,4 | 4 | ■ |
| JHP780120E2R040.0Z4-M64 | 02760848 | 2 | E | - | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,4 | 0,4 | 4 | ■ |
| JHP780120E2R080.0Z4A-M64 | 03134997 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,4 | 0,8 | 4 | ■ |
| JHP780120E2R080.0Z4-M64 | 02760849 | 2 | E | - | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,4 | 0,8 | 4 | ■ |
| JHP780120E2R150.0Z4-M64 | 02760850 | 2 | E | - | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,4 | 1,5 | 4 | ■ |
| JHP780120E2R250.0Z4-M64 | 02760851 | 2 | E | - | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,4 | 2,5 | 4 | ■ |
| JHP780140E2R040.0Z4-M64 | 02760852 | 2 | E | - | 14,0 | 14,0 | 28,0 | 95,0 | 42,0 | 13,4 | 0,4 | 4 | ■ |
| JHP780160E2R040.0Z4A-M64 | 03135000 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 0,4 | 4 | ■ |
| JHP780160E2R040.0Z4-M64 | 02760853 | 2 | E | - | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 0,4 | 4 | ■ |
| JHP780160E2R080.0Z4A-M64 | 03135001 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 0,8 | 4 | ■ |
| JHP780160E2R080.0Z4-M64 | 02760861 | 2 | E | - | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 0,8 | 4 | ■ |
| JHP780160E2R310.0Z4-M64 | 02760862 | 2 | E | - | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 3,1 | 4 | ■ |
| JHP780160E2R400.0Z4-M64 | 02760863 | 2 | E | - | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 4,0 | 4 | ■ |
| JHP780200E2R040.0Z4-M64 | 02760865 | 2 | E | - | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 0,4 | 4 | ■ |
| JHP780200E2R080.0Z4-M64 | 02760866 | 2 | E | - | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 0,8 | 4 | ■ |
| JHP780200E2R310.0Z4-M64 | 02760867 | 2 | E | - | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 3,1 | 4 | ■ |
| JHP780200E2R400.0Z4-M64 | 02760868 | 2 | E | - | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 4,0 | 4 | ■ |
| JHP780250E2R080.0Z4-M64 | 02760870 | 2 | E | - | 25,0 | 25,0 | 50,0 | 130,0 | 65,0 | 24,4 | 0,8 | 4 | ■ |

■ Lagerstandard.

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Composite

Graphit

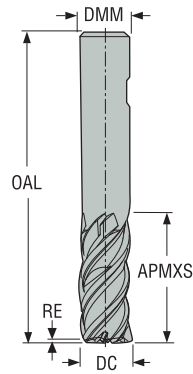
X-Heads

Minimaster Plus

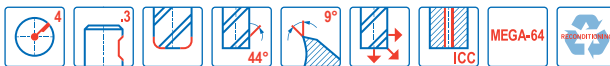
Minimaster

JHP780

Hochleistungsfräser – Superlegierung – Eckfräser – 4-Schneiden – Weldon – Eckenradius – ICC



D



- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | ICC | DC | DMM | APMXS | OAL | RE | PCEDC | Weldon |
|--------------------------|----------------|--------------|---------------|-----|------|------|-------|------|-----|-------|--------|
| | | | | | mm | mm | mm | mm | mm | | |
| JHP780060D1R030.3Z4A-M64 | 03135445 | 1 | D | ■ | 6,0 | 6,0 | 7,5 | 47,0 | 0,3 | 4 | ■ |
| JHP780060D1R080.3Z4A-M64 | 03135446 | 1 | D | ■ | 6,0 | 6,0 | 7,5 | 47,0 | 0,8 | 4 | ■ |
| JHP780080D1R040.3Z4A-M64 | 03135447 | 1 | D | ■ | 8,0 | 8,0 | 10,0 | 50,0 | 0,4 | 4 | ■ |
| JHP780080D1R080.3Z4A-M64 | 03135449 | 1 | D | ■ | 8,0 | 8,0 | 10,0 | 50,0 | 0,8 | 4 | ■ |
| JHP780100D1R040.3Z4A-M64 | 03135450 | 1 | D | ■ | 10,0 | 10,0 | 12,5 | 57,0 | 0,4 | 4 | ■ |
| JHP780100D1R080.3Z4A-M64 | 03135451 | 1 | D | ■ | 10,0 | 10,0 | 12,5 | 57,0 | 0,8 | 4 | ■ |

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Graphit

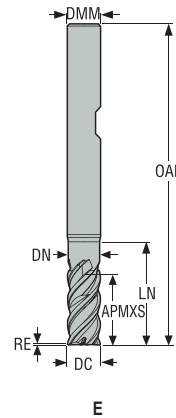
X-Heads

Minimaster Plus

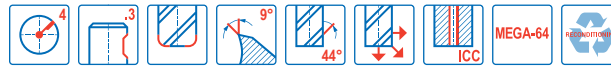
Minimaster

JHP780

Hochleistungsfräser – Superlegierung – Eckfräser – 4-Schneiden – Weldon – Eckenradius – ICC



- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Weldon |
|--------------------------|--------------------|------------------|-------------------|-----|------|------|-------|-------|------|------|-----|-------|--------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JHP780060E2R030.3Z4-M64 | 02760878 | 2 | E | – | 6,0 | 6,0 | 12,0 | 60,0 | 18,0 | 5,6 | 0,3 | 4 | ■ |
| JHP780060E2R030.3Z4A-M64 | 03135454 | 2 | E | ■ | 6,0 | 6,0 | 12,0 | 60,0 | 18,0 | 5,6 | 0,3 | 4 | ■ |
| JHP780080E2R040.3Z4-M64 | 02760879 | 2 | E | – | 8,0 | 8,0 | 16,0 | 65,0 | 24,0 | 7,4 | 0,4 | 4 | ■ |
| JHP780080E2R040.3Z4A-M64 | 03135455 | 2 | E | ■ | 8,0 | 8,0 | 16,0 | 65,0 | 24,0 | 7,4 | 0,4 | 4 | ■ |
| JHP780100E2R040.3Z4-M64 | 02760880 | 2 | E | – | 10,0 | 10,0 | 20,0 | 75,0 | 30,0 | 9,4 | 0,4 | 4 | ■ |
| JHP780100E2R040.3Z4A-M64 | 03135456 | 2 | E | ■ | 10,0 | 10,0 | 20,0 | 75,0 | 30,0 | 9,4 | 0,4 | 4 | ■ |
| JHP780100E2R080.3Z4-M64 | 02760881 | 2 | E | – | 10,0 | 10,0 | 20,0 | 75,0 | 30,0 | 9,4 | 0,8 | 4 | ■ |
| JHP780100E2R080.3Z4A-M64 | 03135457 | 2 | E | ■ | 10,0 | 10,0 | 20,0 | 75,0 | 30,0 | 9,4 | 0,8 | 4 | ■ |
| JHP780120E2R040.3Z4-M64 | 02760883 | 2 | E | – | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,4 | 0,4 | 4 | ■ |
| JHP780120E2R040.3Z4A-M64 | 03134998 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,4 | 0,4 | 4 | ■ |
| JHP780120E2R080.3Z4-M64 | 02760885 | 2 | E | – | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,4 | 0,8 | 4 | ■ |
| JHP780120E2R080.3Z4A-M64 | 03134999 | 2 | E | ■ | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,4 | 0,8 | 4 | ■ |
| JHP780120E2R150.3Z4-M64 | 02760887 | 2 | E | – | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,4 | 1,5 | 4 | ■ |
| JHP780120E2R250.3Z4-M64 | 02766989 | 2 | E | – | 12,0 | 12,0 | 24,0 | 90,0 | 36,0 | 11,4 | 2,5 | 4 | ■ |
| JHP780140E2R040.3Z4-M64 | 02760888 | 2 | E | – | 14,0 | 14,0 | 28,0 | 95,0 | 42,0 | 13,4 | 0,4 | 4 | ■ |
| JHP780160E2R040.3Z4-M64 | 02760889 | 2 | E | – | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 0,4 | 4 | ■ |
| JHP780160E2R040.3Z4A-M64 | 03135002 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 0,4 | 4 | ■ |
| JHP780160E2R080.3Z4-M64 | 02760890 | 2 | E | – | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 0,8 | 4 | ■ |
| JHP780160E2R080.3Z4A-M64 | 03135003 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 0,8 | 4 | ■ |
| JHP780160E2R400.3Z4-M64 | 02760893 | 2 | E | – | 16,0 | 16,0 | 32,0 | 100,0 | 45,0 | 15,4 | 4,0 | 4 | ■ |
| JHP780200E2R040.3Z4-M64 | 02760894 | 2 | E | – | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 0,4 | 4 | ■ |
| JHP780200E2R080.3Z4-M64 | 02760896 | 2 | E | – | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 0,8 | 4 | ■ |
| JHP780200E2R310.3Z4-M64 | 02760897 | 2 | E | – | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 3,1 | 4 | ■ |
| JHP780200E2R400.3Z4-M64 | 02760898 | 2 | E | – | 20,0 | 20,0 | 40,0 | 115,0 | 55,0 | 19,4 | 4,0 | 4 | ■ |
| JHP780250E2R080.3Z4-M64 | 02760901 | 2 | E | – | 25,0 | 25,0 | 50,0 | 130,0 | 65,0 | 24,4 | 0,8 | 4 | ■ |

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X-Heads

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Minimaster

Schnittdaten – JHP780 Eckfräsen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | | 6 | 8 | 10 | 12 | 14 | 16 | 20 | 25 | |
| S1 | E | 0.300 | 1.0 | 0.036 | 0.048 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.12 | 50 (45 – 59) |
| | | 0,300 | 1,0 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0048 | 165 (150 – 190) |
| S2 | E | 0.300 | 1.0 | 0.036 | 0.048 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.12 | 42 (36 – 47) |
| | | 0,300 | 1,0 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0048 | 140 (120 – 150) |
| S3 | E | 0.300 | 0.80 | 0.036 | 0.048 | 0.060 | 0.070 | 0.080 | 0.090 | 0.10 | 0.11 | 28 (23 – 33) |
| | | 0,300 | 0,80 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0032 | 0,0036 | 0,0040 | 0,0044 | 90 (76 – 100) |

Schnittdaten – JHP780 Nutfräsen

| SMG | | a _p /DC | f _z | | | | | | | | v _c |
|-----|---|--------------------|----------------|---------|---------|--------|--------|--------|--------|--------|-----------------|
| | | | 6 | 8 | 10 | 12 | 14 | 16 | 20 | 25 | |
| S1 | E | 0.80 | 0.020 | 0.028 | 0.034 | 0.042 | 0.048 | 0.055 | 0.070 | 0.085 | 43 (38 – 49) |
| | | 0,80 | 0,00080 | 0,0011 | 0,0013 | 0,0017 | 0,0019 | 0,0022 | 0,0028 | 0,0034 | 140 (130 – 160) |
| S2 | E | 0.80 | 0.020 | 0.028 | 0.034 | 0.042 | 0.048 | 0.055 | 0.070 | 0.085 | 35 (30 – 40) |
| | | 0,80 | 0,00080 | 0,0011 | 0,0013 | 0,0017 | 0,0019 | 0,0022 | 0,0028 | 0,0034 | 115 (99 – 130) |
| S3 | E | 0.60 | 0.012 | 0.016 | 0.020 | 0.025 | 0.028 | 0.032 | 0.040 | 0.050 | 26 (21 – 30) |
| | | 0,60 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0011 | 0,0013 | 0,0016 | 0,0020 | 85 (69 – 98) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

 v_c = m/min (sf/min)

 f_z = mm/Zahn (Zoll/Zahn)

 a_p = mm/DC (Zoll/DC) = Faktor

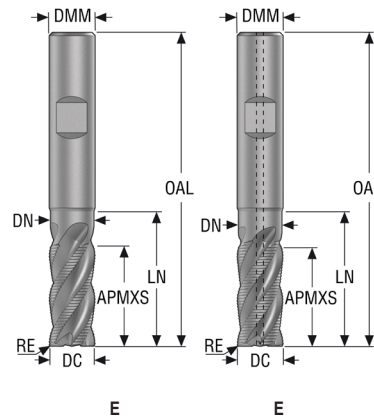
 a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

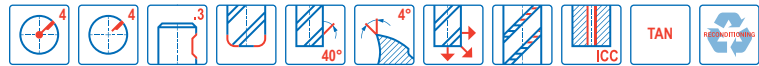
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 Harter
 Kunststoffe und Composite
 Graphit
 X-Heads
 Minmaster Plus
 Minmaster

JHP794

Hochleistungsfräser – ISO-M – Eckfräser – 4 Schneiden – Weldon – Eckenradius



- Toleranzen:
- DMM= h6
- DC= h12
- RE= ±0,05 mm
- Nachschleifen möglich, wenn DC ≥ Ø8 ist



| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | ICC | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Weldon |
|----------------------|--------------|----------------|--------------|---------------|-----|------|------|-------|-------|------|------|------|-------|--------|
| | | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JHP794060E2R020.3Z4 | TAN | 10072338 | 2 | E | – | 6,0 | 6,0 | 13,0 | 57,0 | 18,5 | 2,0 | 0,2 | 4 | ■ |
| JHP794060E2R020.3Z4A | TAN | 10072339 | 2 | E | ■ | 6,0 | 6,0 | 13,0 | 57,0 | 18,5 | 5,5 | 0,2 | 4 | ■ |
| JHP794080E2R020.3Z4 | TAN | 10072340 | 2 | E | – | 8,0 | 8,0 | 19,0 | 63,0 | 24,5 | 7,5 | 0,2 | 4 | ■ |
| JHP794080E2R020.3Z4A | TAN | 10072341 | 2 | E | ■ | 8,0 | 8,0 | 19,0 | 63,0 | 24,5 | 7,5 | 0,2 | 4 | ■ |
| JHP794100E2R035.3Z4 | TAN | 10072342 | 2 | E | – | 10,0 | 10,0 | 22,0 | 72,0 | 29,5 | 9,5 | 0,35 | 4 | ■ |
| JHP794100E2R035.3Z4A | TAN | 10072343 | 2 | E | ■ | 10,0 | 10,0 | 22,0 | 72,0 | 29,5 | 9,5 | 0,35 | 4 | ■ |
| JHP794120E2R035.3Z4 | TAN | 10072344 | 2 | E | – | 12,0 | 12,0 | 26,0 | 83,0 | 35,5 | 11,4 | 0,35 | 4 | ■ |
| JHP794120E2R035.3Z4A | TAN | 10072345 | 2 | E | ■ | 12,0 | 12,0 | 26,0 | 92,0 | 35,5 | 11,4 | 0,35 | 4 | ■ |
| JHP794160E2R040.3Z4 | TAN | 10072346 | 2 | E | – | 16,0 | 16,0 | 32,0 | 92,0 | 41,5 | 15,2 | 0,4 | 4 | ■ |
| JHP794160E2R040.3Z4A | TAN | 10072347 | 2 | E | ■ | 16,0 | 16,0 | 32,0 | 92,0 | 41,5 | 15,2 | 0,4 | 4 | ■ |
| JHP794200E2R040.3Z4 | TAN | 10072348 | 2 | E | – | 20,0 | 20,0 | 38,0 | 104,0 | 51,5 | 19,0 | 0,4 | 4 | ■ |
| JHP794200E2R040.3Z4A | TAN | 10072349 | 2 | E | ■ | 20,0 | 20,0 | 38,0 | 104,0 | 51,5 | 19,0 | 0,4 | 4 | ■ |
| JHP794250E2R040.3Z4 | TAN | 10072350 | 2 | E | – | 25,0 | 25,0 | 45,0 | 121,0 | 62,5 | 23,8 | 0,4 | 4 | ■ |
| JHP794250E2R040.3Z4A | TAN | 10072351 | 2 | E | ■ | 25,0 | 25,0 | 45,0 | 121,0 | 62,5 | 23,8 | 0,4 | 4 | ■ |

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Graphit

X-Heads


Minimaster Plus

Minimaster

Schnittdaten – JHP760 Eckfräsen

| SMG |  | a _p /DC | f _z | | | | | | v _c | |
|-----|---|--------------------|----------------|--------|--------|--------|--------|--------|----------------|-----------------|
| | | | 6 | 8 | 10 | 12 | 16 | 20 | | 25 |
| M1 | E | 1,3 | 0.032 | 0.044 | 0.055 | 0.065 | 0.080 | 0.090 | 0.10 | 90 (61 – 120) |
| | | 1,3 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 0,0040 | 295 (210 – 390) |
| M2 | E | 1,3 | 0.030 | 0.040 | 0.048 | 0.060 | 0.070 | 0.085 | 0.095 | 75 (50 – 99) |
| | | 1,3 | 0,0012 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 0,0034 | 0,0038 | 245 (170 – 320) |
| M3 | E | 1,3 | 0.024 | 0.032 | 0.040 | 0.046 | 0.055 | 0.065 | 0.075 | 60 (40 – 78) |
| | | 1,3 | 0,00095 | 0,0013 | 0,0016 | 0,0018 | 0,0022 | 0,0026 | 0,0030 | 195 (140 – 250) |
| M4 | E | 1,3 | 0.020 | 0.028 | 0.034 | 0.040 | 0.050 | 0.060 | 0.065 | 45 (31 – 60) |
| | | 1,3 | 0,00080 | 0,0011 | 0,0013 | 0,0016 | 0,0020 | 0,0024 | 0,0026 | 150 (110 – 190) |
| M5 | E | 1,3 | 0.020 | 0.028 | 0.034 | 0.040 | 0.050 | 0.060 | 0.065 | 38 (26 – 50) |
| | | 1,3 | 0,00080 | 0,0011 | 0,0013 | 0,0016 | 0,0020 | 0,0024 | 0,0026 | 125 (86 – 160) |

Schnittdaten – JHP760 Nutfräsen

| SMG |  | a _p /DC | f _z | | | | | | v _c | |
|-----|---|--------------------|----------------|--------|--------|--------|--------|--------|----------------|-----------------|
| | | | 6 | 8 | 10 | 12 | 16 | 20 | | 25 |
| M1 | E | 0.60 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 75 (50 – 99) |
| | | 0,60 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 245 (170 – 320) |
| M2 | E | 0.60 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.090 | 60 (40 – 79) |
| | | 0,60 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0036 | 195 (140 – 250) |
| M3 | E | 0.60 | 0.022 | 0.030 | 0.036 | 0.044 | 0.055 | 0.060 | 0.070 | 47 (32 – 62) |
| | | 0,60 | 0,00085 | 0,0012 | 0,0014 | 0,0017 | 0,0022 | 0,0024 | 0,0028 | 155 (110 – 200) |
| M4 | E | 0.60 | 0.019 | 0.026 | 0.032 | 0.038 | 0.048 | 0.055 | 0.060 | 36 (24 – 47) |
| | | 0,60 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0019 | 0,0022 | 0,0024 | 120 (79 – 150) |
| M5 | E | 0.60 | 0.019 | 0.026 | 0.032 | 0.038 | 0.048 | 0.055 | 0.060 | 30 (20 – 39) |
| | | 0,60 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0019 | 0,0022 | 0,0024 | 100 (66 – 120) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

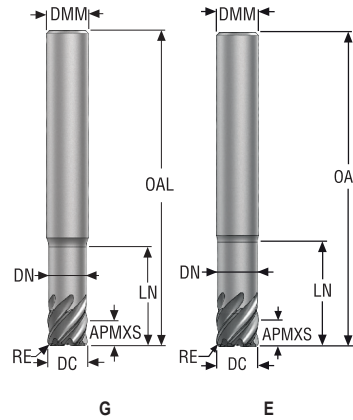
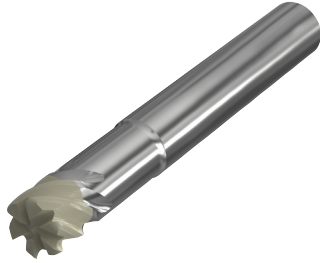
a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

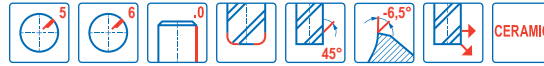
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JCG790

Hochleistungsfräser – Eckfräser – Superlegierung – 5-6 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM = h5
- DC = -0,02/-0,1 mm
- RE = ±0,05 mm



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | DN | LN | RE | PCEDC | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JCG790060E2R050.0Z5 | 10010512 | 2 | E | 6,0 | 6,0 | 6,0 | 59,0 | 5,7 | 15,0 | 0,5 | 5 | ■ |
| JCG790080E2R050.0Z5 | 10010513 | 2 | E | 8,0 | 8,0 | 6,0 | 67,0 | 7,6 | 20,0 | 0,5 | 5 | ■ |
| JCG790094G2R100.0Z6 | 10010514 | 2 | G | 9,4 | 10,0 | 6,0 | 75,0 | 9,0 | 23,5 | 1,0 | 6 | ■ |
| JCG790100E2R100.0Z6 | 10010515 | 2 | E | 10,0 | 10,0 | 6,0 | 75,0 | 9,5 | 25,0 | 1,0 | 6 | ■ |
| JCG790114G2R150.0Z6 | 10010516 | 2 | G | 11,4 | 12,0 | 6,0 | 82,0 | 10,9 | 28,5 | 1,5 | 6 | ■ |
| JCG790120E2R150.0Z6 | 10010517 | 2 | E | 12,0 | 12,0 | 6,0 | 82,0 | 11,4 | 30,0 | 1,5 | 6 | ■ |
| JCG790160E2R200.0Z6 | 10010518 | 2 | E | 16,0 | 16,0 | 8,0 | 93,0 | 15,2 | 40,0 | 2,0 | 6 | ■ |
| JCG790200E2R300.0Z6 | 10010519 | 2 | E | 20,0 | 20,0 | 8,0 | 103,0 | 19,0 | 50,0 | 3,0 | 6 | ■ |
| JCG790250E2R400.0Z6 | 10010520 | 2 | E | 25,0 | 25,0 | 8,0 | 108,0 | 23,8 | 50,0 | 4,0 | 6 | ■ |

■ Lagerstandard.

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Kunststoffe und
Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JCG790 Eckfräsen/Schruppen

| SMG | | a _p /DC | APMXS | f _z | | | | | | v _c | |
|-----|-----|--------------------|-------|----------------|---------|--------|--------|--------|--------|----------------|--------------------|
| | | | | 6 | 8 | 10 | 12 | 16 | 20 | | 25 |
| S1 | A/D | 0.0500 | 1 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.075 | 830 (420 – 1300) |
| | | 0,0500 | 1 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0030 | 2725 (1400 – 4200) |
| S2 | A/D | 0.0500 | 1 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.075 | 670 (340 – 1100) |
| | | 0,0500 | 1 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0030 | 2200 (1200 – 3600) |
| S3 | A/D | 0.0500 | 1 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.075 | 570 (290 – 950) |
| | | 0,0500 | 1 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0030 | 1875 (960 – 3100) |

Schnittdaten – JCG790 Nutfräsen

| SMG | | a _p /DC | f _z | | | | | | v _c | |
|-----|-----|--------------------|----------------|---------|--------|--------|--------|--------|----------------|--------------------|
| | | | 6 | 8 | 10 | 12 | 16 | 20 | | 25 |
| S1 | A/D | 0.05 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.075 | 830 (420 – 1300) |
| | | 0,05 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0030 | 2725 (1400 – 4200) |
| S2 | A/D | 0.05 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.075 | 670 (340 – 1100) |
| | | 0,05 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0030 | 2200 (1200 – 3600) |
| S3 | A/D | 0.05 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.075 | 570 (290 – 950) |
| | | 0,05 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0030 | 1875 (960 – 3100) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

 v_c = m/min (sf/min)

 f_z = mm/Zahn (Zoll/Zahn)

 a_p = mm/DC (Zoll/DC) = Faktor

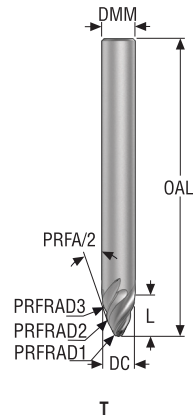
 a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

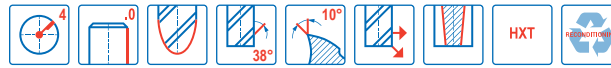
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JH724

Hochgeschwindigkeitsfräsen – ISO– M und ISO– S – Konische Form – 4 Schneiden – Zylindrisch



- Toleranzen:
- DMM=h5
- PRFRAD1= ±0.03 mm
- Formtoleranz PRFRAD2= 0.02 mm
- Nachschleifen möglich, wenn PRFRAD ≥1,5 ist



| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | L | OAL | PRFRAD1 | PRFRAD2 | PRFRAD3 | PRFA/2° | PCEDC | Zylindrisch |
|----------------------|--------------|----------------|--------------|---------------|------|------|------|------|---------|---------|---------|---------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | | |
| JH724100T2R2R030.0Z4 | HXT | 10106106 | 2 | T | 10,0 | 10,0 | 12,3 | 89,0 | 2,0 | 30,0 | 5,0 | 20,0 | 4 | ■ |
| JH724100T2R2R050.0Z4 | HXT | 10106107 | 2 | T | 10,0 | 10,0 | 12,5 | 89,0 | 2,0 | 50,0 | 5,0 | 20,0 | 4 | ■ |
| JH724100T2R3R100.0Z4 | HXT | 10106108 | 2 | T | 10,0 | 10,0 | 10,7 | 89,0 | 3,0 | 100,0 | 5,0 | 20,0 | 4 | ■ |
| JH724100T2R3R250.0Z4 | HXT | 10106109 | 2 | T | 10,0 | 10,0 | 10,8 | 89,0 | 3,0 | 250,0 | 5,0 | 20,0 | 4 | ■ |

■ Lagerstandard.

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X-Heads

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Schnittdaten – JH724 Kopierfräsen/ Feinbearbeitung

| SMG | | a_p/DC | f_z | v_c |
|-----|---|----------------|----------------|------------------------------------|
| | | | 10 | |
| P12 | E | 0,010 0,010 | 0,05 0,0022 | 120 (95 - 135) 400 (310 - 445) |
| M1 | E | 0,010 0,010 | 0,05 0,0022 | 150 (125 - 155) 490 (410 - 510) |
| M2 | E | 0,010 0,010 | 0,05 0,0022 | 145 (120 - 150) 475 (400 - 490) |
| M3 | E | 0,010 0,010 | 0,05 0,0022 | 130 (95 - 140) 425 (310 - 460) |
| S2 | E | 0,010 0,010 | 0,05 0,0022 | 65 (55 - 75) 215 (180 - 245) |
| S11 | E | 0,010 0,010 | 0,05 0,0022 | 130 (95 - 140) 425 (310 - 475) |
| S12 | E | 0,010 0,010 | 0,05 0,0022 | 120 (95 - 135) 400 (310 - 445) |
| S13 | E | 0,010 0,010 | 0,05 0,0022 | 95 (80 - 100) 310 (260 - 320) |

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 $v_c = m/min$ (sf/min)
 $f_z = mm/Zahn$ ($Zoll/Zahn$)
 $a_p = mm/DC$ ($Zoll/DC$) = Faktor
 $a_g = mm/DC$ ($Zoll/DC$) = Faktor
Alle Schnittdaten sind Richtwerte

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Graphit

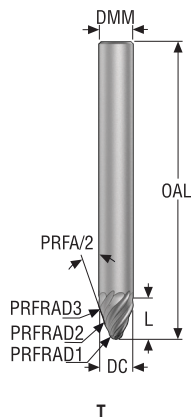
X-Heads

Minimaster Plus

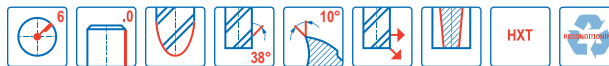
Minimaster

JH726

Hochgeschwindigkeitsfräsen – ISO– M und ISO– S – Konische Form – 6 Schneiden – Zylindrisch



- Toleranzen:
- DMM=h5
- PRFRAD1= ±0.03 mm
- Formtoleranz PRFRAD2= 0.02 mm
- Nachschleifen möglich, wenn PRFRAD ≥1,5 ist



| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | L | OAL | PRFRAD1 | PRFRAD2 | PRFRAD3 | PRFA/2° | PCEDC | Zylindrisch |
|----------------------|--------------|----------------|--------------|---------------|------|------|------|------|---------|---------|---------|---------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | | |
| JH726100T2R2R030.0Z6 | HXT | 10106110 | 2 | T | 10,0 | 10,0 | 10,8 | 89,0 | 2,0 | 30,0 | 5,0 | 20,0 | 6 | ■ |
| JH726100T2R2R050.0Z6 | HXT | 10106111 | 2 | T | 10,0 | 10,0 | 10,7 | 89,0 | 2,0 | 50,0 | 5,0 | 20,0 | 6 | ■ |
| JH726100T2R3R100.0Z6 | HXT | 10106112 | 2 | T | 10,0 | 10,0 | 12,3 | 89,0 | 3,0 | 100,0 | 5,0 | 20,0 | 6 | ■ |
| JH726100T2R3R250.0Z6 | HXT | 10106113 | 2 | T | 10,0 | 10,0 | 12,5 | 89,0 | 3,0 | 250,0 | 5,0 | 20,0 | 6 | ■ |

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Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JH726 Kopierfräsen/ Feinbearbeitung

| SMG | | a_e/DC | f_z | v_c |
|-----|---|----------------|----------------|------------------------------------|
| | | | 10 | |
| P12 | E | 0,010 0,010 | 0,05 0,0022 | 120 (95 - 135) 400 (310 - 445) |
| M1 | E | 0,010 0,010 | 0,05 0,0022 | 150 (125 - 155) 490 (410 - 510) |
| M2 | E | 0,010 0,010 | 0,05 0,0022 | 145 (120 - 150) 475 (400 - 490) |
| M3 | E | 0,010 0,010 | 0,05 0,0022 | 130 (95 - 140) 425 (310 - 460) |
| S2 | E | 0,010 0,010 | 0,05 0,0022 | 65 (55 - 75) 215 (180 - 245) |
| S11 | E | 0,010 0,010 | 0,05 0,0022 | 130 (95 - 140) 425 (310 - 475) |
| S12 | E | 0,010 0,010 | 0,05 0,0022 | 120 (95 - 135) 400 (310 - 445) |
| S13 | E | 0,010 0,010 | 0,05 0,0022 | 95 (80 - 100) 310 (260 - 320) |

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 $v_c = m/min (sf/min)$
 $f_z = mm/Zahn (Zoll/Zahn)$
 $a_p = mm/DC (Zoll/DC) = Faktor$
 $a_e = mm/DC (Zoll/DC) = Faktor$
Alle Schnittdaten sind Richtwerte

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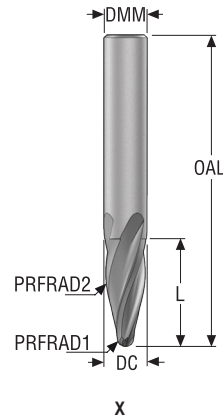
X-Heads

Minimaster Plus

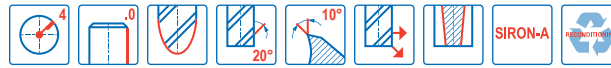
Minimaster

JH734

Hochgeschwindigkeitsfräsen – ISO– M und ISO– S – Tropfenform – 4 Schneiden – Zylindrisch



- Toleranzen:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | L | OAL | PRFRAD1 | PRFRAD2 | PCEDC | Zylindrisch |
|---------------------|--------------|----------------|--------------|---------------|------|------|------|------|---------|---------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | | |
| JH734060X2R1R95.0Z4 | SIRA | 10044783 | 2 | X | 6,0 | 6,0 | 20,8 | 62,0 | 1,0 | 95,0 | 4 | ■ |
| JH734080X2R1R90.0Z4 | SIRA | 10044784 | 2 | X | 8,0 | 8,0 | 24,5 | 68,0 | 1,0 | 90,0 | 4 | ■ |
| JH734100X2R2R85.0Z4 | SIRA | 10044785 | 2 | X | 10,0 | 10,0 | 24,7 | 72,0 | 2,0 | 85,0 | 4 | ■ |
| JH734120X2R2R80.0Z4 | SIRA | 10044786 | 2 | X | 12,0 | 12,0 | 27,3 | 83,0 | 2,0 | 80,0 | 4 | ■ |
| JH734160X2R3R75.0Z4 | SIRA | 10044787 | 2 | X | 16,0 | 16,0 | 30,1 | 92,0 | 3,0 | 75,0 | 4 | ■ |

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Schnittdaten – JH734 Kopierfräsen/ Feinbearbeitung

| SMG | | a _e /DC | f _z | | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------|-----------------|
| | | | 6 | 8 | 10 | 12 | 16 | |
| P8 | E | 0,010 | 0,03 | 0,04 | 0,05 | 0,06 | 0,08 | 170 (150 - 195) |
| | | 0,010 | 0,0012 | 0,0016 | 0,0022 | 0,0024 | 0,0032 | 560 (490 - 640) |
| P12 | E | 0,010 | 0,03 | 0,04 | 0,05 | 0,06 | 0,08 | 120 (95 - 135) |
| | | 0,010 | 0,0012 | 0,0016 | 0,0022 | 0,0024 | 0,0032 | 400 (310 - 445) |
| M1 | E | 0,010 | 0,03 | 0,04 | 0,05 | 0,06 | 0,08 | 150 (125 - 155) |
| | | 0,010 | 0,0012 | 0,0016 | 0,0022 | 0,0024 | 0,0032 | 490 (410 - 510) |
| M2 | E | 0,010 | 0,03 | 0,04 | 0,05 | 0,06 | 0,08 | 145 (120 - 150) |
| | | 0,010 | 0,0012 | 0,0016 | 0,0022 | 0,0024 | 0,0032 | 475 (400 - 490) |
| M3 | E | 0,010 | 0,03 | 0,04 | 0,05 | 0,06 | 0,08 | 130 (90 - 140) |
| | | 0,010 | 0,0012 | 0,0016 | 0,0022 | 0,0024 | 0,0032 | 425 (295 - 460) |
| S2 | E | 0,010 | 0,03 | 0,04 | 0,05 | 0,06 | 0,08 | 60 (50 - 70) |
| | | 0,010 | 0,0012 | 0,0016 | 0,0022 | 0,0024 | 0,0032 | 195 (165 - 230) |
| S11 | E | 0,010 | 0,03 | 0,04 | 0,05 | 0,06 | 0,08 | 100 (85 - 105) |
| | | 0,010 | 0,0012 | 0,0016 | 0,0022 | 0,0024 | 0,0032 | 320 (280 - 345) |
| S12 | E | 0,010 | 0,03 | 0,04 | 0,05 | 0,06 | 0,08 | 95 (80 - 100) |
| | | 0,010 | 0,0012 | 0,0016 | 0,0022 | 0,0024 | 0,0032 | 310 (260 - 320) |
| S13 | E | 0,010 | 0,03 | 0,04 | 0,05 | 0,06 | 0,08 | 90 (75 - 95) |
| | | 0,010 | 0,0012 | 0,0016 | 0,0022 | 0,0024 | 0,0032 | 295 (245 - 310) |

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

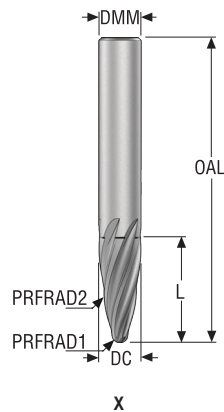
a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

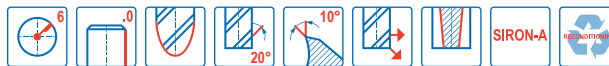
| |
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| Harter |
| Kunststoffe und Composite |
| Graphit |
| X-Heads |
| Minimaster Plus |
| Minimaster |

JH736

Hochgeschwindigkeitsfräsen – ISO– M und ISO– S – Tropfenform – 6 Schneiden – Zylindrisch



- Toleranzen:
- DMM= h5
- PRFRAD1= ±0.03mm
- Formtoleranz PRFRAD2= 0.02mm
- Nachschleifen möglich



| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | L | OAL | PRFRAD1 | PRFRAD2 | PCEDC | Zylindrisch |
|---------------------|--------------|----------------|--------------|---------------|------|------|------|------|---------|---------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | | |
| JH736100X2R2R85.0Z6 | SIRA | 10044834 | 2 | X | 10,0 | 10,0 | 24,7 | 72,0 | 2,0 | 85,0 | 6 | ■ |
| JH736120X2R2R80.0Z6 | SIRA | 10044835 | 2 | X | 12,0 | 12,0 | 27,3 | 83,0 | 2,0 | 80,0 | 6 | ■ |
| JH736160X2R3R75.0Z6 | SIRA | 10044836 | 2 | X | 16,0 | 16,0 | 30,1 | 92,0 | 3,0 | 75,0 | 6 | ■ |

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Schnittdaten – JH736 Kopierfräsen/ Feinbearbeitung

| SMG | | a _e /DC | f _z | | | v _c |
|-----|---|--------------------|----------------|--------|--------|-----------------|
| | | | 10 | 12 | 16 | |
| P8 | E | 0,010 | 0,05 | 0,06 | 0,08 | 170 (150 - 195) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 560 (490 - 640) |
| P12 | E | 0,010 | 0,05 | 0,06 | 0,08 | 120 (95 - 135) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 400 (310 - 445) |
| M1 | E | 0,010 | 0,05 | 0,06 | 0,08 | 150 (125 - 155) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 490 (410 - 510) |
| M2 | E | 0,010 | 0,05 | 0,06 | 0,08 | 145 (120 - 150) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 475 (400 - 490) |
| M3 | E | 0,010 | 0,05 | 0,06 | 0,08 | 130 (90 - 140) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 425 (295 - 460) |
| S2 | E | 0,010 | 0,05 | 0,06 | 0,08 | 60 (50 - 70) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 195 (165 - 230) |
| S11 | E | 0,010 | 0,05 | 0,06 | 0,08 | 100 (85 - 105) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 320 (280 - 345) |
| S12 | E | 0,010 | 0,05 | 0,06 | 0,08 | 95 (80 - 100) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 310 (260 - 320) |
| S13 | E | 0,010 | 0,05 | 0,06 | 0,08 | 90 (75 - 95) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 295 (245 - 310) |

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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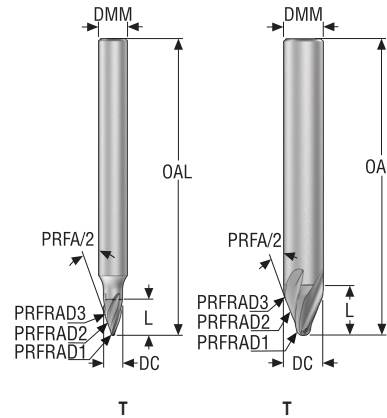
X-Heads

Minimaster Plus

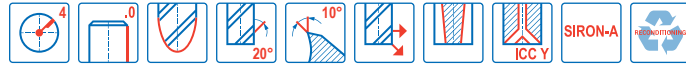
Minimaster

JH744

Hochgeschwindigkeitsfräsen – ISO– M und ISO– S – Konische Form – 4 Schneiden – Zylindrisch



- Toleranzen:
- DMM= h5
- PRFRAD1= ±0.03mm
- Formtoleranz PRFRAD2= 0.02mm
- Nachschleifen möglich, wenn PRFRAD1 ≥1,5 ist



| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | ICC | DC | DMM | L | OAL | PRFRAD1 | PRFRAD2 | PRFRAD3 | PRFA/2° | PCEDC | Zylindrisch |
|------------------------|--------------|----------------|--------------|---------------|-----|------|------|------|-------|---------|---------|---------|---------|-------|-------------|
| | | | | | | mm | mm | mm | mm | mm | mm | mm | | | |
| JH744100T1R1.5R250.0Z4 | SIRA | 10044920 | 1 | T | – | 10,0 | 10,0 | 5,4 | 72,0 | 1,5 | 250,0 | 2,0 | 65,0 | 4 | ■ |
| JH744120T1R3R250.0Z4 | SIRA | 10044921 | 1 | T | – | 12,0 | 12,0 | 10,5 | 89,0 | 3,0 | 250,0 | 6,0 | 32,5 | 4 | ■ |
| JH744160T1R4R500.0Z4 | SIRA | 10044922 | 1 | T | – | 16,0 | 16,0 | 14,6 | 108,0 | 4,0 | 500,0 | 8,0 | 27,5 | 4 | ■ |
| JH744040T2R0.5R250.0Z4 | SIRA | 10044923 | 2 | T | – | 4,0 | 6,0 | 7,6 | 62,0 | 0,5 | 250,0 | 3,0 | 17,5 | 4 | ■ |
| JH744060T2R1R250.0Z4 | SIRA | 10044924 | 2 | T | – | 6,0 | 6,0 | 9,6 | 62,0 | 1,0 | 250,0 | 3,0 | 17,5 | 4 | ■ |
| JH744080T2R1.5R250.0Z4 | SIRA | 10044925 | 2 | T | – | 8,0 | 8,0 | 10,7 | 68,0 | 1,5 | 250,0 | 4,0 | 20,0 | 4 | ■ |
| JH744100T2R2R250.0Z4 | SIRA | 10044926 | 2 | T | – | 10,0 | 10,0 | 12,7 | 75,0 | 2,0 | 250,0 | 5,0 | 20,0 | 4 | ■ |
| JH744120T2R3R250.0Z4 | SIRA | 10044927 | 2 | T | – | 12,0 | 12,0 | 13,7 | 89,0 | 3,0 | 250,0 | 6,0 | 20,0 | 4 | ■ |
| JH744160T2R4R500.0Z4 | SIRA | 10044928 | 2 | T | – | 16,0 | 16,0 | 17,6 | 108,0 | 4,0 | 500,0 | 8,0 | 20,0 | 4 | ■ |
| JH744160T2R2R1000.0Z4 | SIRA | 10044929 | 2 | T | – | 16,0 | 16,0 | 31,3 | 108,0 | 2,0 | 1000,0 | 5,0 | 12,5 | 4 | ■ |
| JH744160T2R4R1000.0Z4 | SIRA | 10044930 | 2 | T | – | 16,0 | 16,0 | 24,1 | 108,0 | 4,0 | 1000,0 | 5,0 | 12,5 | 4 | ■ |
| JH744160T4R4R1000.0Z4A | SIRA | 10044931 | 4 | T | ■ | 16,0 | 16,0 | 24,1 | 150,0 | 4,0 | 1000,0 | 5,0 | 12,5 | 4 | ■ |

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Schnittdaten – JH744 Kopierfräsen/ Feinbearbeitung

| SMG | | a _p /DC | f _z | | | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------|--------|-----------------|
| | | | 4 | 6 | 8 | 10 | 12 | 16 | |
| P8 | E | 0,010 | 0,02 | 0,03 | 0,04 | 0,05 | 0,06 | 0,08 | 170 (150 - 195) |
| | | 0,010 | 0,0008 | 0,0012 | 0,0016 | 0,0022 | 0,0024 | 0,0032 | 560 (490 - 640) |
| P12 | E | 0,010 | 0,02 | 0,03 | 0,04 | 0,05 | 0,06 | 0,08 | 120 (95 - 135) |
| | | 0,010 | 0,0008 | 0,0012 | 0,0016 | 0,0022 | 0,0024 | 0,0032 | 400 (310 - 445) |
| M1 | E | 0,010 | 0,02 | 0,03 | 0,04 | 0,05 | 0,06 | 0,08 | 150 (125 - 155) |
| | | 0,010 | 0,0008 | 0,0012 | 0,0016 | 0,0022 | 0,0024 | 0,0032 | 490 (410 - 510) |
| M2 | E | 0,010 | 0,02 | 0,03 | 0,04 | 0,05 | 0,06 | 0,08 | 145 (120 - 150) |
| | | 0,010 | 0,0008 | 0,0012 | 0,0016 | 0,0022 | 0,0024 | 0,0032 | 475 (400 - 490) |
| M3 | E | 0,010 | 0,02 | 0,03 | 0,04 | 0,05 | 0,06 | 0,08 | 130 (90 - 140) |
| | | 0,010 | 0,0008 | 0,0012 | 0,0016 | 0,0022 | 0,0024 | 0,0032 | 425 (295 - 460) |
| S2 | E | 0,010 | 0,02 | 0,03 | 0,04 | 0,05 | 0,06 | 0,08 | 60 (50 - 70) |
| | | 0,010 | 0,0008 | 0,0012 | 0,0016 | 0,0022 | 0,0024 | 0,0032 | 195 (165 - 230) |
| S11 | E | 0,010 | 0,02 | 0,03 | 0,04 | 0,05 | 0,06 | 0,08 | 100 (85 - 105) |
| | | 0,010 | 0,0008 | 0,0012 | 0,0016 | 0,0022 | 0,0024 | 0,0032 | 320 (280 - 345) |
| S12 | E | 0,010 | 0,02 | 0,03 | 0,04 | 0,05 | 0,06 | 0,08 | 95 (80 - 100) |
| | | 0,010 | 0,0008 | 0,0012 | 0,0016 | 0,0022 | 0,0024 | 0,0032 | 310 (260 - 320) |
| S13 | E | 0,010 | 0,02 | 0,03 | 0,04 | 0,05 | 0,06 | 0,08 | 90 (75 - 95) |
| | | 0,010 | 0,0008 | 0,0012 | 0,0016 | 0,0022 | 0,0024 | 0,0032 | 295 (245 - 310) |

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

 v_c = m/min (sf/min)

 f_z = mm/Zahn (Zoll/Zahn)

 a_p = mm/DC (Zoll/DC) = Faktor

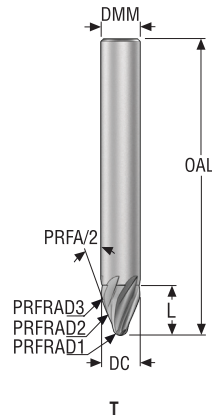
 a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

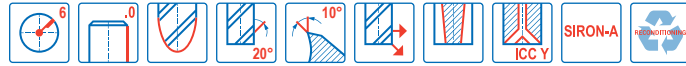
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| Minimaster |

JH746

Hochgeschwindigkeitsfräsen – ISO– M und ISO– S – Konische Form – 6 Schneiden – Zylindrisch



- Toleranzen:
- DMM= h5
- PRFRAD1= ±0.03mm
- Formtoleranz PRFRAD2= 0.02mm
- Nachschleifen möglich



| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | ICC | DC | DMM | L | OAL | PRFRAD1 | PRFRAD2 | PRFRAD3 | PRFA/2° | PCEDC | Zylindrisch |
|-----------------------|--------------|----------------|--------------|---------------|-----|------|------|------|-------|---------|---------|---------|---------|-------|-------------|
| | | | | | | mm | mm | mm | mm | mm | mm | mm | | | |
| JH746100T2R2R250.0Z6 | SIRA | 10044958 | 2 | T | – | 10,0 | 10,0 | 12,7 | 75,0 | 2,0 | 250,0 | 5,0 | 20,0 | 6 | ■ |
| JH746120T2R3R250.0Z6 | SIRA | 10044959 | 2 | T | – | 12,0 | 12,0 | 13,7 | 89,0 | 3,0 | 250,0 | 6,0 | 20,0 | 6 | ■ |
| JH746160T2R4R500.0Z6 | SIRA | 10044960 | 2 | T | – | 16,0 | 16,0 | 17,6 | 108,0 | 4,0 | 500,0 | 8,0 | 20,0 | 6 | ■ |
| JH746160T4R4R500.0Z6A | SIRA | 10044961 | 4 | T | ■ | 16,0 | 16,0 | 17,6 | 150,0 | 4,0 | 500,0 | 8,0 | 20,0 | 6 | ■ |

■ Lagerstandard.

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Schnittdaten – JH746 Kopierfräsen/ Feinbearbeitung

| SMG |  | a _e /DC | f _z | | | v _c |
|-----|---|--------------------|----------------|--------|--------|-----------------|
| | | | 10 | 12 | 16 | |
| P8 | E | 0,010 | 0,05 | 0,06 | 0,08 | 170 (150 - 195) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 560 (490 - 640) |
| P12 | E | 0,010 | 0,05 | 0,06 | 0,08 | 120 (95 - 135) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 400 (310 - 445) |
| M1 | E | 0,010 | 0,05 | 0,06 | 0,08 | 150 (125 - 155) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 490 (410 - 510) |
| M2 | E | 0,010 | 0,05 | 0,06 | 0,08 | 145 (120 - 150) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 475 (400 - 490) |
| M3 | E | 0,010 | 0,05 | 0,06 | 0,08 | 130 (90 - 140) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 425 (295 - 460) |
| S2 | E | 0,010 | 0,05 | 0,06 | 0,08 | 60 (50 - 70) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 195 (165 - 230) |
| S11 | E | 0,010 | 0,05 | 0,06 | 0,08 | 100 (85 - 105) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 320 (280 - 345) |
| S12 | E | 0,010 | 0,05 | 0,06 | 0,08 | 95 (80 - 100) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 310 (260 - 320) |
| S13 | E | 0,010 | 0,05 | 0,06 | 0,08 | 90 (75 - 95) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 295 (245 - 310) |

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – JH746 Kopierfräsen/Schruppen

| SMG |  | a _e /DC | f _z | | | v _c |
|-----|---|--------------------|----------------|--------|--------|-----------------|
| | | | 10 | 12 | 16 | |
| P12 | E | 0,025 | 0,03 | 0,036 | 0,048 | 120 (95 - 135) |
| | | 0,025 | 0,0012 | 0,0014 | 0,0019 | 400 (310 - 445) |
| M1 | E | 0,025 | 0,03 | 0,036 | 0,048 | 145 (120 - 150) |
| | | 0,025 | 0,0012 | 0,0014 | 0,0019 | 475 (400 - 490) |
| M2 | E | 0,025 | 0,03 | 0,036 | 0,048 | 145 (120 - 150) |
| | | 0,025 | 0,0012 | 0,0014 | 0,0019 | 475 (400 - 490) |
| S12 | E | 0,025 | 0,03 | 0,036 | 0,048 | 95 (80 - 100) |
| | | 0,025 | 0,0012 | 0,0014 | 0,0019 | 310 (270 - 320) |

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

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Graphit

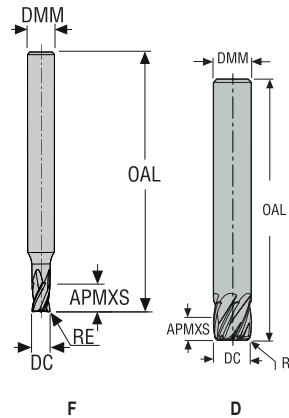
X-Heads

Minimaster Plus

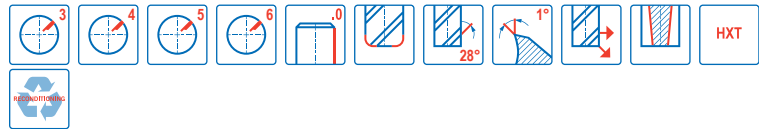
Minimaster

JH770

Hochgeschwindigkeitsfräsen – CoCr/Titan – Eckfräser – 3-4-5-6 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | RE | PCEDC | Zylindrisch |
|------------------------|----------------|--------------|---------------|------|------|-------|------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | | |
| JH770030F2R020.0Z3-HXT | 03320783 | 2 | F | 3,0 | 6,0 | 5,0 | 58,0 | 0,2 | 3 | ■ |
| JH770040F2R020.0Z4-HXT | 03320784 | 2 | F | 4,0 | 6,0 | 6,0 | 58,0 | 0,2 | 4 | ■ |
| JH770050F2R020.0Z4-HXT | 10000170 | 2 | F | 5,0 | 6,0 | 7,0 | 58,0 | 0,2 | 4 | ■ |
| JH770060D2R050.0Z4-HXT | 03127351 | 2 | D | 6,0 | 6,0 | 8,0 | 50,0 | 0,5 | 4 | ■ |
| JH770080D2R050.0Z4-HXT | 03127352 | 2 | D | 8,0 | 8,0 | 10,0 | 58,0 | 0,5 | 4 | ■ |
| JH770080D2R050.0Z5-HXT | 03127354 | 2 | D | 8,0 | 8,0 | 10,0 | 58,0 | 0,5 | 5 | ■ |
| JH770080D2R100.0Z4-HXT | 03127353 | 2 | D | 8,0 | 8,0 | 10,0 | 58,0 | 1,0 | 4 | ■ |
| JH770080D2R100.0Z5-HXT | 03127355 | 2 | D | 8,0 | 8,0 | 10,0 | 58,0 | 1,0 | 5 | ■ |
| JH770080D2R100.0Z6-HXT | 03127356 | 2 | D | 8,0 | 8,0 | 10,0 | 58,0 | 1,0 | 6 | ■ |
| JH770100D2R100.0Z5-HXT | 03127357 | 2 | D | 10,0 | 10,0 | 12,0 | 66,0 | 1,0 | 5 | ■ |
| JH770100D2R100.0Z6-HXT | 03127358 | 2 | D | 10,0 | 10,0 | 12,0 | 66,0 | 1,0 | 6 | ■ |

■ Lagerstandard.

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Schnittdaten – JH770 Eckfräsen/Schruppen PCEDC 3 und 4

| SMG | | a _e /DC | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|---------|-----------------|
| | | | | 3 | 4 | 6 | 8 | |
| S2 | E | 0,750 | 0,12 | 0,015 | 0,020 | 0,030 | 0,040 | 50 (42 – 62) |
| | | 0,750 | 0,12 | 0,00060 | 0,00080 | 0,0012 | 0,0016 | 165 (140 – 200) |
| S11 | E | 0,250 | 0,32 | 0,0075 | 0,010 | 0,015 | 0,020 | 65 (53 – 91) |
| | | 0,250 | 0,32 | 0,00030 | 0,00040 | 0,00060 | 0,00080 | 215 (180 – 290) |
| S12 | E | 0,250 | 0,32 | 0,0075 | 0,010 | 0,015 | 0,020 | 50 (41 – 70) |
| | | 0,250 | 0,32 | 0,00030 | 0,00040 | 0,00060 | 0,00080 | 165 (140 – 220) |

Schnittdaten – JH770 Eckfräsen/Schruppen PCEDC 6

| SMG | | a _e /DC | a _p /DC | f _z | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|-----------------|
| | | | | 8 | 10 | |
| S2 | E | 0,750 | 0,12 | 0,050 | 0,060 | 55 (43 – 64) |
| | | 0,750 | 0,12 | 0,0020 | 0,0024 | 180 (150 – 200) |
| S11 | E | 0,250 | 0,32 | 0,022 | 0,026 | 65 (54 – 93) |
| | | 0,250 | 0,32 | 0,00085 | 0,0010 | 215 (180 – 300) |
| S12 | E | 0,250 | 0,32 | 0,022 | 0,026 | 50 (42 – 71) |
| | | 0,250 | 0,32 | 0,00085 | 0,0010 | 165 (140 – 230) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

 v_c = m/min (sf/min)

 f_z = mm/Zahn (Zoll/Zahn)

 a_p = mm/DC (Zoll/DC) = Faktor

 a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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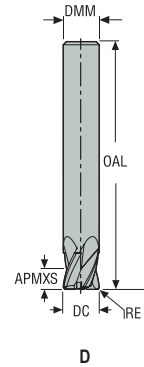
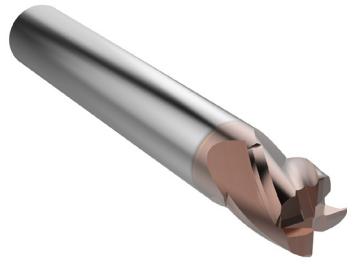
X-Heads

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Minimaster

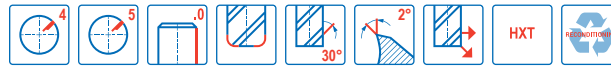
JH740

Hochgeschwindigkeitsfräsen – CoCr/Titan – Boden schlichten – 4-5 Schneiden – Zylindrisch – Eckenradius



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- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | RE | PCEDC | Zylindrisch |
|------------------------|----------------|--------------|---------------|------|------|-------|------|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | | |
| JH740060D2R025.0Z4-HXT | 03127359 | 2 | D | 6,0 | 6,0 | 6,0 | 50,0 | 0,25 | 4 | ■ |
| JH740060D2R050.0Z4-HXT | 03127360 | 2 | D | 6,0 | 6,0 | 6,0 | 50,0 | 0,5 | 4 | ■ |
| JH740080D2R025.0Z4-HXT | 03127361 | 2 | D | 8,0 | 8,0 | 8,0 | 58,0 | 0,25 | 4 | ■ |
| JH740080D2R050.0Z4-HXT | 03127362 | 2 | D | 8,0 | 8,0 | 8,0 | 58,0 | 0,5 | 4 | ■ |
| JH740100D2R025.0Z5-HXT | 03127363 | 2 | D | 10,0 | 10,0 | 10,0 | 66,0 | 0,25 | 5 | ■ |
| JH740100D2R050.0Z5-HXT | 03127364 | 2 | D | 10,0 | 10,0 | 10,0 | 66,0 | 0,5 | 5 | ■ |

■ Lagerstandard.

Schnittdaten – JH740 Planfräsen/Schlichten PCEDC 4

| SMG | | a _e /DC | a _p /DC | f _z | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|-----------------|
| | | | | 6 | 8 | |
| S2 | E | 0.500 | 0.0060 | 0.044 | 0.060 | 50 (40 – 59) |
| | | 0,500 | 0,0060 | 0,0017 | 0,0024 | 165 (140 – 190) |
| S11 | E | 0.500 | 0.0060 | 0.044 | 0.060 | 65 (52 – 77) |
| | | 0,500 | 0,0060 | 0,0017 | 0,0024 | 215 (180 – 250) |
| S12 | E | 0.500 | 0.0060 | 0.044 | 0.060 | 50 (40 – 59) |
| | | 0,500 | 0,0060 | 0,0017 | 0,0024 | 165 (140 – 190) |

Schnittdaten – JH740 Planfräsen/Schlichten PCEDC 5

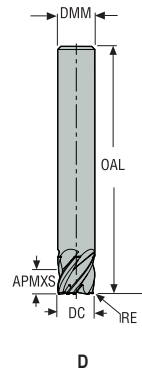
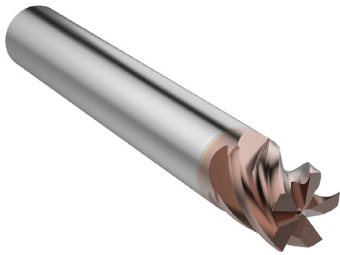
| SMG | | a _e /DC | a _p /DC | f _z | v _c |
|-----|---|--------------------|--------------------|----------------|-----------------|
| | | | | 10 | |
| S2 | E | 0.500 | 0.0065 | 0.046 | 48 (39 – 58) |
| | | 0,500 | 0,0065 | 0,0018 | 155 (130 – 190) |
| S11 | E | 0.500 | 0.0065 | 0.046 | 65 (51 – 75) |
| | | 0,500 | 0,0065 | 0,0018 | 215 (170 – 240) |
| S12 | E | 0.500 | 0.0065 | 0.046 | 48 (39 – 58) |
| | | 0,500 | 0,0065 | 0,0018 | 155 (130 – 190) |

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

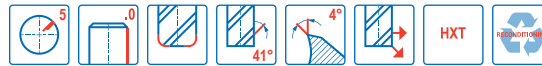
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JH710

Hochgeschwindigkeitsfräsen – CoCr/Titan – Eckfräser – 5 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | RE | PCEDC | Zylindrisch |
|------------------------|--------------------|------------------|-------------------|-----|-----|-------|------|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | | |
| JH710060D2R025.0Z5-HXT | 03127365 | 2 | D | 6,0 | 6,0 | 6,0 | 57,0 | 0,25 | 5 | ■ |
| JH710060D2R050.0Z5-HXT | 03127366 | 2 | D | 6,0 | 6,0 | 6,0 | 57,0 | 0,5 | 5 | ■ |
| JH710080D2R025.0Z5-HXT | 03127367 | 2 | D | 8,0 | 8,0 | 8,0 | 63,0 | 0,25 | 5 | ■ |
| JH710080D2R050.0Z5-HXT | 03127368 | 2 | D | 8,0 | 8,0 | 8,0 | 63,0 | 0,5 | 5 | ■ |
| JH710080D2R100.0Z5-HXT | 03127369 | 2 | D | 8,0 | 8,0 | 8,0 | 63,0 | 1,0 | 5 | ■ |

■ Lagerstandard.

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Schnittdaten – JH710 Eckfräsen/Schlichten

| SMG |  | a _e /DC | a _p /DC | f _z | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|-----------------|
| | | | | 6 | 8 | |
| S1 | E | 0.00800 | 0.65 | 0.034 | 0.044 | 100 (79 – 110) |
| | | 0,00800 | 0,65 | 0,0013 | 0,0017 | 330 (260 – 360) |
| S2 | E | 0.00800 | 0.65 | 0.034 | 0.044 | 100 (79 – 110) |
| | | 0,00800 | 0,65 | 0,0013 | 0,0017 | 330 (260 – 360) |
| S3 | E | 0.00800 | 0.65 | 0.034 | 0.044 | 100 (79 – 110) |
| | | 0,00800 | 0,65 | 0,0013 | 0,0017 | 330 (260 – 360) |
| S11 | E | 0.00800 | 0.65 | 0.036 | 0.046 | 180 (160 – 200) |
| | | 0,00800 | 0,65 | 0,0014 | 0,0018 | 590 (530 – 650) |
| S12 | E | 0.00800 | 0.65 | 0.036 | 0.046 | 135 (120 – 150) |
| | | 0,00800 | 0,65 | 0,0014 | 0,0018 | 445 (400 – 490) |
| S13 | E | 0.00800 | 0.65 | 0.032 | 0.040 | 105 (92 – 120) |
| | | 0,00800 | 0,65 | 0,0013 | 0,0016 | 345 (310 – 390) |

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

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Kunststoffe und Composite

Graphit

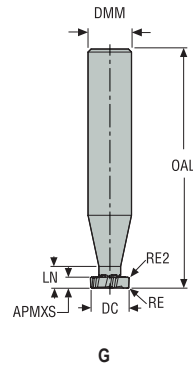
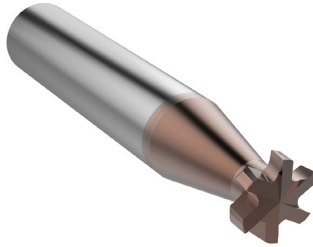
X-Heads

Minimaster Plus

Minimaster

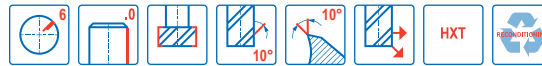
JH790

Hochgeschwindigkeitsfräsen – CoCr/Titan – T-Fräser – 6 Schneiden – Zylindrisch



G

- Toleranzen:
- DMM=h5
- DC= ±0,02 mm
- RE= ±0,02 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | RE | RE2 | PCEDC | Zylindrisch |
|------------------------|--------------------|------------------|-------------------|-----|------|-------|------|-----|------|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JH790095G2R025.0Z6-HXT | 03127370 | 2 | G | 9,5 | 10,0 | 2,0 | 66,0 | 5,0 | 0,25 | 0,25 | 6 | ■ |
| JH790095G2R050.0Z6-HXT | 03127371 | 2 | G | 9,5 | 10,0 | 2,0 | 66,0 | 5,0 | 0,5 | 0,5 | 6 | ■ |
| JH790095G3R025.0Z6-HXT | 03127372 | 3 | G | 9,5 | 10,0 | 2,54 | 66,0 | 5,0 | 0,25 | 0,25 | 6 | ■ |
| JH790095G3R050.0Z6-HXT | 03127373 | 3 | G | 9,5 | 10,0 | 2,54 | 66,0 | 5,0 | 0,5 | 0,5 | 6 | ■ |

■ Lagerstandard.

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Kunststoffe und Composite


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Schnittdaten – JH790 (T) Eckfräsen/Schruppen

| SMG |  | a_e/DC | a_p/DC | f_z | v_c |
|-----|---|-----------------------|---------------------|-------------------------|----------------------------------|
| | | | | 9.5 | |
| S2 | E | 0.189 <i>0,189</i> | 0.19 <i>0,19</i> | 0.030 <i>0,0012</i> | 39 (31 – 50) 130 (110 – 160) |
| S11 | E | 0.189 <i>0,189</i> | 0.19 <i>0,19</i> | 0.022 <i>0,00085</i> | 85 (66 – 100) 280 (220 – 320) |
| S12 | E | 0.189 <i>0,189</i> | 0.19 <i>0,19</i> | 0.022 <i>0,00085</i> | 65 (51 – 80) 215 (170 – 260) |

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (*sf/min*)

f_z = mm/Zahn (*Zoll/Zahn*)

a_p = mm/DC (*Zoll/DC*) = Faktor

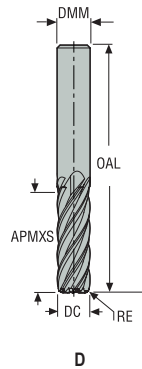
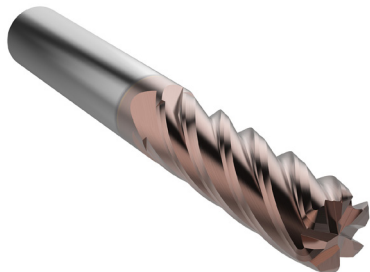
a_e = mm/DC (*Zoll/DC*) = Faktor

Alle Schnittdaten sind Richtwerte

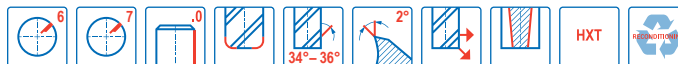
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JH730

Hochgeschwindigkeitsfräsen – CoCr/Titan – Eckfräser – 6-7 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | RE | PCEDC | Zylindrisch |
|------------------------|--------------------|------------------|-------------------|------|------|-------|------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | | |
| JH730080D2R050.0Z6-HXT | 03127375 | 2 | D | 8,0 | 8,0 | 25,0 | 63,0 | 0,5 | 6 | ■ |
| JH730080D2R100.0Z6-HXT | 03127377 | 2 | D | 8,0 | 8,0 | 25,0 | 63,0 | 1,0 | 6 | ■ |
| JH730080D2R150.0Z6-HXT | 03127378 | 2 | D | 8,0 | 8,0 | 25,0 | 63,0 | 1,5 | 6 | ■ |
| JH730080D2R200.0Z6-HXT | 03127379 | 2 | D | 8,0 | 8,0 | 25,0 | 63,0 | 2,0 | 6 | ■ |
| JH730100D2R100.0Z7-HXT | 03127380 | 2 | D | 10,0 | 10,0 | 31,0 | 72,0 | 1,0 | 7 | ■ |
| JH730100D2R250.0Z7-HXT | 03127381 | 2 | D | 10,0 | 10,0 | 31,0 | 72,0 | 2,5 | 7 | ■ |

■ Lagerstandard.

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Graphit

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Schnittdaten – JH730 Eckfräsen/Schlichten

| SMG | | a_e/DC | a_p/DC | f_z | | v_c |
|-----|---|----------|----------|---------|---------|-----------------|
| | | | | 8 | 10 | |
| S2 | E | 0,0625 | 1,8 | 0,020 | 0,025 | 80 (63 – 93) |
| | | 0,0625 | 1,8 | 0,00080 | 0,0010 | 260 (210 – 300) |
| S11 | E | 0,0625 | 1,8 | 0,016 | 0,020 | 135 (110 – 160) |
| | | 0,0625 | 1,8 | 0,00065 | 0,00080 | 445 (370 – 520) |
| S12 | E | 0,0625 | 1,8 | 0,016 | 0,020 | 105 (83 – 120) |
| | | 0,0625 | 1,8 | 0,00065 | 0,00080 | 345 (280 – 390) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

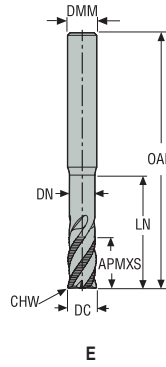
a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

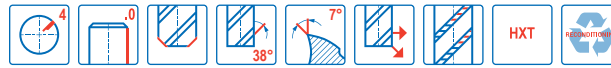
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JHP994

Hochleistungsfräser – CoCr/Titan – Eckfräser – 4 Schneiden – Zylindrisch – Fase



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,1 mm
- CHW=0/-0,1 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Zylindrisch |
|----------------------|--------------------|------------------|-------------------|------|------|-------|------|------|-----|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JHP994060E3C.0Z4-HXT | 03127382 | 3 | E | 6,0 | 6,0 | 14,0 | 63,0 | 24,0 | 5,6 | 0,2 | 4 | ■ |
| JHP994080E3C.0Z4-HXT | 03127383 | 3 | E | 8,0 | 8,0 | 18,0 | 69,0 | 32,0 | 7,4 | 0,2 | 4 | ■ |
| JHP994100E3C.0Z4-HXT | 03127384 | 3 | E | 10,0 | 10,0 | 22,0 | 88,0 | 40,0 | 9,4 | 0,2 | 4 | ■ |

■ Lagerstandard.

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Harter

Kunststoffe und
Composite


Graphit

X-Heads


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Schnittdaten – JHP994 Eckfräsen/Schruppen

| SMG |  | a _e /DC | a _p /DC | f _z | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|-----------------|
| | | | | 6 | 8 | 10 | |
| S2 | E | 0.0480 | 2.0 | 0.025 | 0.032 | 0.042 | 55 (40 – 69) |
| | | 0,0480 | 2,0 | 0,0010 | 0,0013 | 0,0017 | 180 (140 – 220) |
| S11 | E | 0.450 | 0.60 | 0.025 | 0.034 | 0.042 | 50 (39 – 77) |
| | | 0,450 | 0,60 | 0,0010 | 0,0013 | 0,0017 | 165 (130 – 250) |
| S12 | E | 0.450 | 0.60 | 0.025 | 0.034 | 0.042 | 40 (30 – 59) |
| | | 0,450 | 0,60 | 0,0010 | 0,0013 | 0,0017 | 130 (99 – 190) |

Schnittdaten – JHP994 Nutfräsen

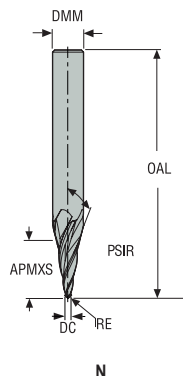
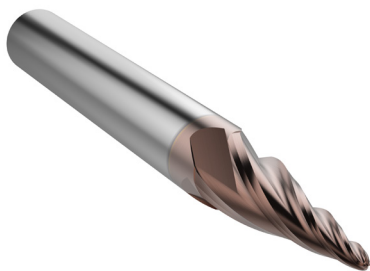
| SMG |  | a _p /DC | f _z | | | v _c |
|-----|---|--------------------|----------------|---------|---------|-----------------|
| | | | 6 | 8 | 10 | |
| S2 | E | 2.0 | 0.011 | 0.014 | 0.018 | 33 (24 – 41) |
| | | 2,0 | 0,00044 | 0,00055 | 0,00070 | 110 (79 – 130) |
| S11 | E | 0.60 | 0.025 | 0.034 | 0.042 | 42 (32 – 63) |
| | | 0,60 | 0,0010 | 0,0013 | 0,0017 | 140 (110 – 200) |
| S12 | E | 0.60 | 0.025 | 0.034 | 0.042 | 33 (25 – 48) |
| | | 0,60 | 0,0010 | 0,0013 | 0,0017 | 110 (83 – 150) |

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

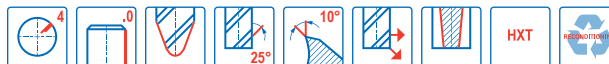
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Minimaster Plus
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JH780

Hochgeschwindigkeitsfräsen – CoCr/Titan – Konischer Kugelkopf – 4 Schneiden – Zylindrisch



- Toleranzen:
- DMM=h5
- DC= ±0,04 mm
- RE= ±0,01 mm
- Nachschleifen möglich



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | RE | PSIR | PCEDC | Zylindrisch |
|------------------------|----------------|--------------|---------------|-------|-----|-------|------|-----|--------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | | |
| JH780018N2R100.0Z4-HXT | 03127386 | 2 | N | 1,827 | 8,0 | 23,5 | 63,0 | 1,0 | 5,1838 | 4 | ■ |
| JH780028N2R150.0Z4-HXT | 03127387 | 2 | N | 2,803 | 8,0 | 23,5 | 63,0 | 1,5 | 3,8915 | 4 | ■ |
| JH780038N2R200.0Z4-HXT | 03127388 | 2 | N | 3,823 | 8,0 | 23,5 | 63,0 | 2,0 | 2,5972 | 4 | ■ |
| JH780049N2R250.0Z4-HXT | 03127389 | 2 | N | 4,888 | 8,0 | 23,5 | 63,0 | 2,5 | 1,3003 | 4 | ■ |

■ Lagerstandard.

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Schnittdaten – JH780 Eckfräsen

| SMG | | a _e /DC | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|---------|-----------------|
| | | | | 1.8 | 2.8 | 3.8 | 4.9 | |
| S2 | E | 0.0510 | 4.2 | 0.0080 | 0.012 | 0.017 | 0.022 | 70 (54 – 86) |
| | | 0,0510 | 4,2 | 0,00032 | 0,00048 | 0,00065 | 0,00085 | 230 (180 – 280) |
| S12 | E | 0.0510 | 4.2 | 0.0060 | 0.0090 | 0.013 | 0.016 | 95 (76 – 110) |
| | | 0,0510 | 4,2 | 0,00024 | 0,00036 | 0,00050 | 0,00065 | 310 (250 – 360) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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Graphit

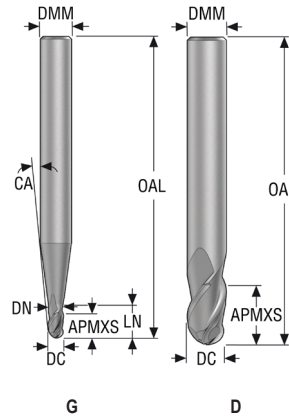
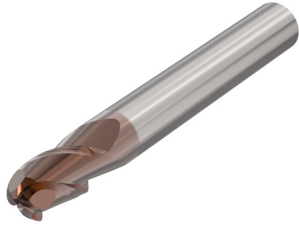
X-Heads

Minimaster Plus

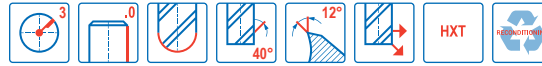
Minimaster

JHB720

Hochgeschwindigkeitsfräsen – Titan – Kugelkopf – 3 Schneiden – Zylindrisch



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | CA° | PCEDC | Zylindrisch |
|------------------|--------------|----------------|--------------|---------------|------|------|-------|-------|-----|-----|-----|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | | | |
| JHB720020G2B.0Z3 | HXT | 10072323 | 2 | G | 2,0 | 6,0 | 3,0 | 60,0 | 6,0 | 1,9 | 7,0 | 3 | ■ |
| JHB720030G2B.0Z3 | HXT | 10072324 | 2 | G | 3,0 | 6,0 | 4,5 | 60,0 | 6,5 | 2,8 | 5,0 | 3 | ■ |
| JHB720035G2B.0Z3 | HXT | 10072325 | 2 | G | 3,5 | 6,0 | 5,0 | 65,0 | 7,0 | 3,2 | 3,5 | 3 | ■ |
| JHB720040G2B.0Z3 | HXT | 10072326 | 2 | G | 4,0 | 6,0 | 6,0 | 65,0 | 8,0 | 3,7 | 3,0 | 3 | ■ |
| JHB720060D2B.0Z3 | HXT | 10072327 | 2 | D | 6,0 | 6,0 | 9,0 | 75,0 | - | - | - | 3 | ■ |
| JHB720080D2B.0Z3 | HXT | 10072328 | 2 | D | 8,0 | 8,0 | 12,0 | 75,0 | - | - | - | 3 | ■ |
| JHB720100D2B.0Z3 | HXT | 10072329 | 2 | D | 10,0 | 10,0 | 15,0 | 80,0 | - | - | - | 3 | ■ |
| JHB720120D2B.0Z3 | HXT | 10072330 | 2 | D | 12,0 | 12,0 | 18,0 | 90,0 | - | - | - | 3 | ■ |
| JHB720160D2B.0Z3 | HXT | 10072331 | 2 | D | 16,0 | 16,0 | 24,0 | 100,0 | - | - | - | 3 | ■ |

■ Lagerstandard.

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Schnittdaten – JHB720 Eckfräsen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|---------|---------|---------|--------|--------|--------|--------------------|
| | | | | 2 | 3 | 3.5 | 4 | 6 | 8 | 10 | 12 | 16 | |
| M1 | E | 0.200 | 1.2 | 0.0080 | 0.012 | 0.014 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 85 (62 – 110) |
| | | 0,200 | 1,2 | 0,00032 | 0,00048 | 0,00055 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 280 (210 – 360) |
| M2 | E | 0.200 | 1.2 | 0.0080 | 0.012 | 0.014 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 70 (51 – 90) |
| | | 0,200 | 1,2 | 0,00032 | 0,00048 | 0,00055 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 230 (170 – 290) |
| M3 | E | 0.200 | 1.2 | 0.0080 | 0.012 | 0.014 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 65 (46 – 84) |
| | | 0,200 | 1,2 | 0,00032 | 0,00048 | 0,00055 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 215 (160 – 270) |
| M4 | E | 0.200 | 1.2 | 0.0070 | 0.011 | 0.012 | 0.014 | 0.022 | 0.028 | 0.034 | 0.042 | 0.050 | 50 (35 – 65) |
| | | 0,200 | 1,2 | 0,00028 | 0,00044 | 0,00048 | 0,00055 | 0,00085 | 0,0011 | 0,0013 | 0,0017 | 0,0020 | 165 (120 – 210) |
| M5 | E | 0.200 | 1.2 | 0.0070 | 0.011 | 0.012 | 0.014 | 0.022 | 0.028 | 0.034 | 0.042 | 0.050 | 42 (29 – 54) |
| | | 0,200 | 1,2 | 0,00028 | 0,00044 | 0,00048 | 0,00055 | 0,00085 | 0,0011 | 0,0013 | 0,0017 | 0,0020 | 140 (96 – 170) |
| N1 | E/M/A | 0.400 | 1.2 | 0.020 | 0.030 | 0.036 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 600 (500 – 690) |
| | | 0,400 | 1,2 | 0,00080 | 0,0012 | 0,0014 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 1975 (1700 – 2200) |
| N2 | E/M/A | 0.400 | 1.2 | 0.016 | 0.024 | 0.028 | 0.032 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 500 (400 – 600) |
| | | 0,400 | 1,2 | 0,00065 | 0,00095 | 0,0011 | 0,0013 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 1650 (1400 – 1900) |
| N3 | E/M/A | 0.400 | 1.2 | 0.016 | 0.024 | 0.028 | 0.032 | 0.048 | 0.065 | 0.080 | 0.095 | 0.12 | 335 (270 – 400) |
| | | 0,400 | 1,2 | 0,00065 | 0,00095 | 0,0011 | 0,0013 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 1100 (890 – 1300) |
| N11 | E/M/A | 0.300 | 1.2 | 0.012 | 0.018 | 0.022 | 0.024 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 300 (260 – 340) |
| | | 0,300 | 1,2 | 0,00048 | 0,00070 | 0,00085 | 0,00095 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 980 (860 – 1100) |
| S1 | E | 0.100 | 1.2 | 0.0065 | 0.0095 | 0.011 | 0.013 | 0.019 | 0.026 | 0.032 | 0.038 | 0.048 | 43 (29 – 57) |
| | | 0,100 | 1,2 | 0,00026 | 0,00038 | 0,00044 | 0,00050 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0019 | 140 (96 – 180) |
| S2 | E | 0.100 | 1.2 | 0.0065 | 0.0095 | 0.011 | 0.013 | 0.019 | 0.026 | 0.032 | 0.038 | 0.048 | 35 (24 – 46) |
| | | 0,100 | 1,2 | 0,00026 | 0,00038 | 0,00044 | 0,00050 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 0,0019 | 115 (79 – 150) |
| S3 | E | 0.100 | 1.2 | 0.0060 | 0.0090 | 0.011 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.044 | 30 (21 – 39) |
| | | 0,100 | 1,2 | 0,00024 | 0,00036 | 0,00044 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0017 | 100 (69 – 120) |
| S11 | E | 0.300 | 1.2 | 0.010 | 0.015 | 0.018 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 90 (79 – 100) |
| | | 0,300 | 1,2 | 0,00040 | 0,00060 | 0,00070 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 295 (260 – 320) |
| S12 | E | 0.300 | 1.2 | 0.010 | 0.015 | 0.018 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 70 (61 – 80) |
| | | 0,300 | 1,2 | 0,00040 | 0,00060 | 0,00070 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 230 (210 – 260) |
| S13 | E | 0.300 | 1.2 | 0.0085 | 0.013 | 0.015 | 0.017 | 0.026 | 0.034 | 0.044 | 0.050 | 0.065 | 55 (48 – 63) |
| | | 0,300 | 1,2 | 0,00034 | 0,00050 | 0,00060 | 0,00065 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0026 | 180 (160 – 200) |
| TS1 | A | 0.400 | 1.2 | 0.020 | 0.030 | 0.036 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 500 (400 – 600) |
| | | 0,400 | 1,2 | 0,00080 | 0,0012 | 0,0014 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 1650 (1400 – 1900) |
| TP1 | M | 0.400 | 1.2 | 0.020 | 0.030 | 0.036 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 500 (400 – 600) |
| | | 0,400 | 1,2 | 0,00080 | 0,0012 | 0,0014 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 1650 (1400 – 1900) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

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Graphit

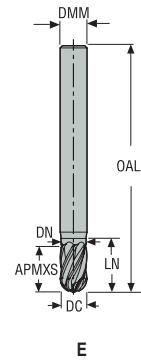
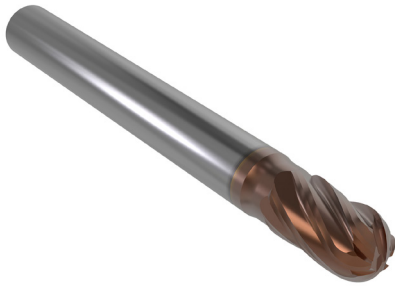
X-Heads

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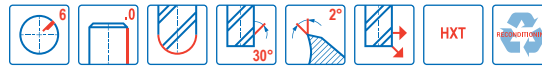
Minimaster

JH721

Hochgeschwindigkeitsfräsen – CoCr/Titan – Kugelkopf – 6 Schneiden – Zylindrisch



- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | PCEDC | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|-----|-----|-------|------|------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | | |
| JH721060E2B.0Z6-HXT | 03127390 | 2 | E | 6,0 | 6,0 | 10,0 | 57,0 | 12,0 | 5,6 | 6 | ■ |
| JH721080E2B.0Z6-HXT | 03127391 | 2 | E | 8,0 | 8,0 | 13,0 | 58,0 | 16,0 | 7,4 | 6 | ■ |

■ Lagerstandard.

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X-Heads

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Schnittdaten – JH721 Kopierfräsen/ Feinbearbeitung

| SMG | | a_e/DC | a_p/DC | f_z | | v_c |
|-----|---|----------|----------|--------|--------|-----------------|
| | | | | 6 | 8 | |
| S2 | E | 0,0424 | 0,040 | 0,032 | 0,042 | 120 (110 – 140) |
| | | 0,0424 | 0,040 | 0,0013 | 0,0017 | 395 (370 – 450) |
| S11 | E | 0,0424 | 0,040 | 0,032 | 0,042 | 210 (140 – 230) |
| | | 0,0424 | 0,040 | 0,0013 | 0,0017 | 690 (460 – 750) |
| S12 | E | 0,0424 | 0,040 | 0,032 | 0,042 | 160 (110 – 180) |
| | | 0,0424 | 0,040 | 0,0013 | 0,0017 | 520 (370 – 590) |

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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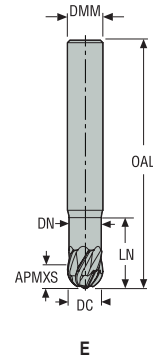
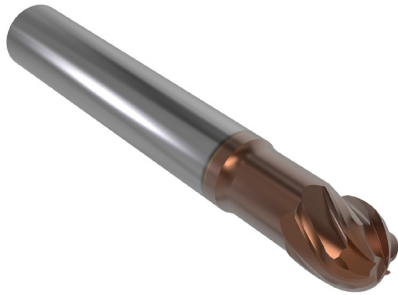
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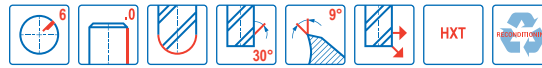
JH722

Hochgeschwindigkeitsfräsen – CoCr/Titan – Kugelkopf – 6 Schneiden – Zylindrisch



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- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,01 mm
- Nachschleifen möglich



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | PCEDC | Zylindrisch |
|---------------------|----------------|--------------|---------------|------|------|-------|------|------|-----|-------|-------------|
| JH722100E2B.0Z6-HXT | 03127392 | 2 | E | 10,0 | 10,0 | 10,0 | 72,0 | 20,0 | 9,4 | 6 | ■ |

■ Lagerstandard.

Schnittdaten – JH722 Kopierfräsen/ Feinbearbeitung

| SMG |  | a_e/DC | a_p/DC | f_z | | v_c |
|-----|---|----------|----------|--------|-----------------|-----------------|
| | | | | | 10 | |
| S2 | E | 0,0500 | 0,15 | 0,065 | 125 (110 – 150) | |
| | | 0,0500 | 0,15 | 0,0026 | | 410 (370 – 490) |
| S11 | E | 0,0500 | 0,15 | 0,048 | 210 (190 – 230) | |
| | | 0,0500 | 0,15 | 0,0019 | | 690 (630 – 750) |
| S12 | E | 0,0500 | 0,15 | 0,048 | 160 (150 – 180) | |
| | | 0,0500 | 0,15 | 0,0019 | | 520 (500 – 590) |

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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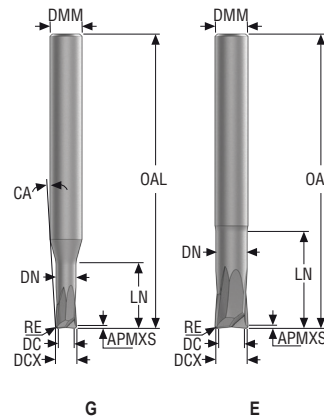
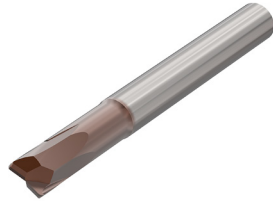
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Minimaster Plus

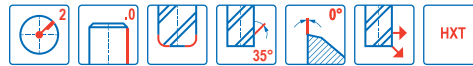
Minimaster

SHF712

Hochvorschubfräser – ISO- S – 2 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- Rundlaufabweichung = <math><0,005\text{ mm}</math>
- DMM = h5
- DC G- Form = 0/-0,01 mm
- DC E- Form = 0,005/-0,015 mm
- RE = $\pm 0,005\text{ mm}$



| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DCX | DMM | APMXS | OAL | LN | DN | RE | CA° | PCEDC | Zylindrisch |
|---------------------|--------------|----------------|--------------|---------------|-----|-----|-----|-------|------|------|------|-----|-------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| SHF712040G2R050.0Z2 | HXT | 10106493 | 2 | G | 3,0 | 4,0 | 6,0 | 0,5 | 55,0 | 12,0 | 3,8 | 0,5 | 3,9° | 2 | ■ |
| SHF712060E2R050.0Z2 | HXT | 10106494 | 2 | E | 5,0 | 6,0 | 6,0 | 0,5 | 55,0 | 18,0 | 5,7 | 0,5 | 0,0° | 2 | ■ |
| SHF712030G3R050.0Z2 | HXT | 10106495 | 3 | G | 2,0 | 3,0 | 6,0 | 0,5 | 55,0 | 12,0 | 2,85 | 0,5 | 5,65° | 2 | ■ |
| SHF712040G3R050.0Z2 | HXT | 10106496 | 3 | G | 3,0 | 4,0 | 6,0 | 0,5 | 55,0 | 16,0 | 3,8 | 0,5 | 3,07° | 2 | ■ |
| SHF712060E3R050.0Z2 | HXT | 10106497 | 3 | E | 5,0 | 6,0 | 6,0 | 0,5 | 55,0 | 25,0 | 5,7 | 0,5 | 0,0° | 2 | ■ |
| SHF712030G4R050.0Z2 | HXT | 10106498 | 4 | G | 2,0 | 3,0 | 6,0 | 0,5 | 55,0 | 16,0 | 2,85 | 0,5 | 4,47° | 2 | ■ |

■ Lagerstandard.

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X-Heads


Minimaster Plus

Minimaster

Schnittdaten – SHF712 Eckfräsen

| SMG |  | a _e /DCX | a _p /DCX | f _z | | | v _c |
|-----|---|---------------------|---------------------|----------------|--------|--------|-----------------|
| | | | | 3 | 4 | 6 | |
| S2 | E | 0,30 | 0,050 | 0,055 | 0,075 | 0,11 | 65 (51 – 76) |
| | | 0,30 | 0,050 | 0,0022 | 0,0030 | 0,0044 | 215 (170 – 240) |
| S12 | E | 0,30 | 0,050 | 0,085 | 0,12 | 0,17 | 170 (150 – 190) |
| | | 0,30 | 0,050 | 0,0034 | 0,0048 | 0,0065 | 560 (500 – 620) |

Schnittdaten – SHF712 Nutfräsen

| SMG |  | a _p /DCX | f _z | | | v _c |
|-----|---|---------------------|----------------|--------|--------|-----------------|
| | | | 3 | 4 | 6 | |
| S2 | E | 0,050 | 0,046 | 0,060 | 0,090 | 50 (41 – 60) |
| | | 0,050 | 0,0018 | 0,0024 | 0,0036 | 165 (140 – 190) |
| S12 | E | 0,050 | 0,046 | 0,060 | 0,090 | 145 (130 – 160) |
| | | 0,050 | 0,0018 | 0,0024 | 0,0036 | 475 (430 – 520) |

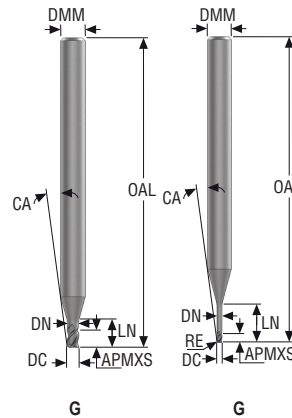
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

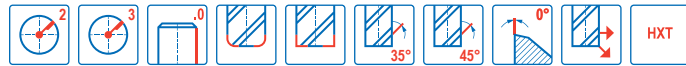
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SME714/716

Mini – ISO– S – Eckfräser – 2-3 Schneiden – Zylindrisch – scharf oder Eckenradius



- Toleranzen:
- Rundlaufabweichung = <math><0,005\text{ mm}</math>
- DMM = h5
- DC = 0/-0,01 mm
- RE = $\pm 0,005\text{ mm}$




| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | DN | LN | RE | CA° | PCEDC | Zylindrisch |
|---------------------|--------------|----------------|--------------|---------------|-----|-----|-------|-----|------|------|------|-------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | | |
| SME714020G1S.0Z3 | HXT | 10107349 | 1 | G | 2,0 | 4 | 2,0 | 50 | 1,9 | 4,0 | – | 6,86° | 3 | ■ |
| SME716020G1S.0Z3 | HXT | 10107360 | 1 | G | 2,0 | 6 | 2,0 | 50 | 1,9 | 4,0 | – | 9,42° | 3 | ■ |
| SME714020G3R010.0Z3 | HXT | 10107350 | 3 | G | 2,0 | 4 | 2,5 | 50 | 1,9 | 8,0 | 0,1 | 4,68° | 3 | ■ |
| SME716020G3R010.0Z3 | HXT | 10107361 | 3 | G | 2,0 | 6 | 2,5 | 50 | 1,9 | 8,0 | 0,1 | 7,14° | 3 | ■ |
| SME716010G4R010.0Z3 | HXT | 10107362 | 4 | G | 1,0 | 6 | 1,2 | 50 | 0,95 | 6,0 | 0,1 | 9,03° | 3 | ■ |
| SME716015G4R010.0Z3 | HXT | 10107363 | 4 | G | 1,5 | 6 | 1,8 | 50 | 1,4 | 10,0 | 0,1 | 6,79° | 3 | ■ |
| SME714010G4R010.0Z3 | HXT | 10107351 | 4 | G | 2,0 | 4 | 1,2 | 50 | 0,95 | 6,0 | 0,1 | 7,13° | 3 | ■ |
| SME714015G4R010.0Z3 | HXT | 10107352 | 4 | G | 2,0 | 4 | 1,8 | 50 | 1,4 | 10,0 | 0,1 | 4,72° | 3 | ■ |
| SME714020G4R010.0Z3 | HXT | 10107353 | 4 | G | 2,0 | 4 | 2,5 | 50 | 1,9 | 12,0 | 0,1 | 3,53° | 3 | ■ |
| SME716020G4R010.0Z3 | HXT | 10107364 | 4 | G | 2,0 | 6 | 2,5 | 50 | 1,9 | 12,0 | 0,1 | 5,72° | 3 | ■ |
| SME714015G5R010.0Z3 | HXT | 10107354 | 5 | G | 1,5 | 4 | 1,8 | 50 | 1,4 | 12,0 | 0,1 | 3,38° | 3 | ■ |
| SME716015G5R010.0Z3 | HXT | 10107365 | 5 | G | 1,5 | 6 | 1,8 | 50 | 1,4 | 12,0 | 0,1 | 6,15° | 3 | ■ |
| SME714020G5R010.0Z3 | HXT | 10107355 | 5 | G | 2,0 | 4 | 2,5 | 50 | 1,9 | 16,0 | 0,1 | 2,83° | 3 | ■ |
| SME716020G5R010.0Z3 | HXT | 10107366 | 5 | G | 2,0 | 6 | 2,5 | 50 | 1,9 | 16,0 | 0,1 | 4,77° | 3 | ■ |
| SME714005G6R005.0Z2 | HXT | 10107356 | 6 | G | 0,5 | 4 | 0,6 | 50 | 0,45 | 5,0 | 0,05 | 8,31° | 2 | ■ |
| SME716005G6R005.0Z2 | HXT | 10107367 | 6 | G | 0,5 | 6 | 0,6 | 50 | 0,45 | 5,0 | 0,05 | 9,93° | 2 | ■ |
| SME714010G6R010.0Z3 | HXT | 10107357 | 6 | G | 1,0 | 4 | 1,2 | 50 | 0,95 | 12,0 | 0,1 | 4,77° | 3 | ■ |
| SME716010G6R010.0Z3 | HXT | 10107368 | 6 | G | 1,0 | 6 | 1,6 | 50 | 0,95 | 12,0 | 0,1 | 6,56° | 3 | ■ |
| SME714015G6R010.0Z3 | HXT | 10107358 | 6 | G | 1,5 | 4 | 1,8 | 50 | 1,4 | 16,0 | 0,1 | 3,38° | 3 | ■ |
| SME716015G6R010.0Z3 | HXT | 10107369 | 6 | G | 1,5 | 6 | 1,8 | 50 | 1,4 | 16,0 | 0,1 | 5,16° | 3 | ■ |
| SME714010G7R010.0Z3 | HXT | 10107359 | 7 | G | 1,0 | 4 | 1,2 | 50 | 0,95 | 16,0 | 0,1 | 3,9° | 3 | ■ |
| SME716010G7R010.0Z3 | HXT | 10107370 | 7 | G | 1,0 | 6 | 1,2 | 50 | 0,95 | 16,0 | 0,1 | 5,55° | 3 | ■ |


■ Lagerstandard.

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Schnittdaten – SME714 Eckfräsen/Schruppen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|---------|-----------------|
| | | | | 0.5 | 1 | 1.5 | 2 | |
| S2 | E | 0,0800 | 0,070 | 0,0036 | 0,0070 | 0,010 | 0,014 | 60 (31 – 120) |
| | | 0,0800 | 0,070 | 0,00014 | 0,00028 | 0,00040 | 0,00055 | 195 (110 – 390) |
| S12 | E | 0,0800 | 0,070 | 0,0036 | 0,0070 | 0,010 | 0,014 | 65 (33 – 130) |
| | | 0,0800 | 0,070 | 0,00014 | 0,00028 | 0,00040 | 0,00055 | 215 (110 – 420) |


Schnittdaten – SME714 Nutfräsen

| SMG |  | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|----------------|---------|---------|---------|----------------|
| | | | 0.5 | 1 | 1.5 | 2 | |
| S2 | E | 0,070 | 0,0036 | 0,0070 | 0,010 | 0,014 | 41 (21 – 82) |
| | | 0,070 | 0,00014 | 0,00028 | 0,00040 | 0,00055 | 135 (69 – 260) |
| S12 | E | 0,070 | 0,0036 | 0,0070 | 0,010 | 0,014 | 45 (23 – 89) |
| | | 0,070 | 0,00014 | 0,00028 | 0,00040 | 0,00055 | 150 (76 – 290) |


Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c = m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

Schnittdaten – SME716 Eckfräsen/Schruppen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|---------|-----------------|
| | | | | 0.5 | 1 | 1.5 | 2 | |
| S2 | E | 0,0800 | 0,070 | 0,0036 | 0,0070 | 0,010 | 0,014 | 60 (31 – 120) |
| | | 0,0800 | 0,070 | 0,00014 | 0,00028 | 0,00040 | 0,00055 | 195 (110 – 390) |
| S12 | E | 0,0800 | 0,070 | 0,0036 | 0,0070 | 0,010 | 0,014 | 65 (33 – 130) |
| | | 0,0800 | 0,070 | 0,00014 | 0,00028 | 0,00040 | 0,00055 | 215 (110 – 420) |

Schnittdaten – SME716 Nutfräsen

| SMG |  | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|----------------|---------|---------|---------|----------------|
| | | | 0.5 | 1 | 1.5 | 2 | |
| S2 | E | 0,070 | 0,0036 | 0,0070 | 0,010 | 0,014 | 41 (21 – 82) |
| | | 0,070 | 0,00014 | 0,00028 | 0,00040 | 0,00055 | 135 (69 – 260) |
| S12 | E | 0,070 | 0,0036 | 0,0070 | 0,010 | 0,014 | 45 (23 – 89) |
| | | 0,070 | 0,00014 | 0,00028 | 0,00040 | 0,00055 | 150 (76 – 290) |

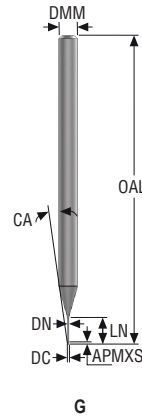
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c = m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

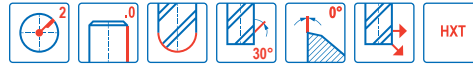
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SMB713/714/716

Mini – ISO- S – Kugelkopf – 2 Schneiden – Zylindrisch



- Toleranzen:
- Rundlaufabweichung = <math><0,005\text{ mm}</math>
- DMM = h5
- DC = 0/+0,01 mm
- RE = $\pm 0,005\text{ mm}$



| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | DN | LN | CA° | PCEDC | Zylindrisch |
|------------------|--------------|----------------|--------------|---------------|-----|-----|-------|-----|------|------|--------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | | | |
| SMB714020G2B.0Z2 | HXT | 10109582 | 2 | G | 2,0 | 4 | 2,0 | 50 | 1,9 | 6,0 | 6,13° | 2 | ■ |
| SMB716020G2B.0Z2 | HXT | 10109596 | 2 | G | 2,0 | 6 | 2,0 | 50 | 1,9 | 6,0 | 8,72° | 2 | ■ |
| SMB714030G2B.0Z2 | HXT | 10109583 | 2 | G | 3,0 | 4 | 3,0 | 50 | 2,85 | 9,0 | 2,85° | 2 | ■ |
| SMB716030G2B.0Z2 | HXT | 10109597 | 2 | G | 3,0 | 6 | 3,0 | 50 | 2,85 | 9,0 | 6,22° | 2 | ■ |
| SMB714030G3B.0Z2 | HXT | 10109584 | 3 | G | 3,0 | 4 | 3,0 | 50 | 2,85 | 12,0 | 2,2° | 2 | ■ |
| SMB716030G3B.0Z2 | HXT | 10109598 | 3 | G | 3,0 | 6 | 3,0 | 50 | 2,85 | 12,0 | 5,11° | 2 | ■ |
| SMB714015G4B.0Z2 | HXT | 10109585 | 4 | G | 1,5 | 4 | 1,5 | 50 | 1,4 | 9,0 | 5,29° | 2 | ■ |
| SMB716015G4B.0Z2 | HXT | 10109599 | 4 | G | 1,5 | 6 | 1,5 | 50 | 1,4 | 9,0 | 7,44° | 2 | ■ |
| SMB714020G4B.0Z2 | HXT | 10109586 | 4 | G | 2,0 | 4 | 2,0 | 50 | 1,9 | 10,0 | 4,3° | 2 | ■ |
| SMB716020G4B.0Z2 | HXT | 10109600 | 4 | G | 2,0 | 6 | 2,0 | 50 | 1,9 | 10,0 | 6,69° | 2 | ■ |
| SMB714005G5B.0Z2 | HXT | 10109587 | 5 | G | 0,5 | 4 | 0,5 | 50 | 0,45 | 4,0 | 9,23° | 2 | ■ |
| SMB716005G5B.0Z2 | HXT | 10109601 | 5 | G | 0,5 | 6 | 0,5 | 50 | 0,45 | 4,0 | 10,73° | 2 | ■ |
| SMB714010G5B.0Z2 | HXT | 10109588 | 5 | G | 1,0 | 4 | 1,0 | 50 | 0,95 | 10,0 | 5,5° | 2 | ■ |
| SMB716010G5B.0Z2 | HXT | 10109602 | 5 | G | 1,0 | 6 | 1,0 | 50 | 0,95 | 10,0 | 7,37° | 2 | ■ |
| SMB714015G5B.0Z2 | HXT | 10109589 | 5 | G | 1,5 | 4 | 1,5 | 50 | 1,4 | 12,0 | 4,41° | 2 | ■ |
| SMB716015G5B.0Z2 | HXT | 10109603 | 5 | G | 1,5 | 6 | 1,5 | 50 | 1,4 | 12,0 | 6,35° | 2 | ■ |
| SMB714020G5B.0Z2 | HXT | 10109590 | 5 | G | 2,0 | 4 | 2,0 | 50 | 1,9 | 16,0 | 2,96° | 2 | ■ |
| SMB716020G5B.0Z2 | HXT | 10109604 | 5 | G | 2,0 | 6 | 2,0 | 50 | 1,9 | 16,0 | 4,96° | 2 | ■ |
| SMB713003G6B.0Z2 | HXT | 10109581 | 6 | G | 0,3 | 3 | 0,3 | 50 | 0,28 | 4,0 | 8,24° | 2 | ■ |
| SMB714005G6B.0Z2 | HXT | 10109591 | 6 | G | 0,5 | 4 | 0,5 | 50 | 0,45 | 6,0 | 7,8° | 2 | ■ |
| SMB716005G6B.0Z2 | HXT | 10109605 | 6 | G | 0,5 | 6 | 0,5 | 50 | 0,45 | 6,0 | 9,46° | 2 | ■ |
| SMB714010G6B.0Z2 | HXT | 10109592 | 6 | G | 1,0 | 4 | 1,0 | 50 | 0,95 | 12,0 | 4,97° | 2 | ■ |
| SMB716010G6B.0Z2 | HXT | 10109606 | 6 | G | 1,0 | 6 | 1,0 | 50 | 0,95 | 12,0 | 6,69° | 2 | ■ |
| SMB714015G6B.0Z2 | HXT | 10109593 | 6 | G | 1,5 | 4 | 1,5 | 50 | 1,4 | 16,0 | 3,49° | 2 | ■ |
| SMB716015G6B.0Z2 | HXT | 10109607 | 6 | G | 1,5 | 6 | 1,5 | 55 | 1,4 | 16,0 | 5,31° | 2 | ■ |
| SMB714005G7B.0Z2 | HXT | 10109594 | 7 | G | 0,5 | 4 | 0,5 | 50 | 0,45 | 9,0 | 6,33° | 2 | ■ |
| SMB716005G7B.0Z2 | HXT | 10109608 | 7 | G | 0,5 | 6 | 0,5 | 50 | 0,45 | 9,0 | 8,03° | 2 | ■ |
| SMB714010G7B.0Z2 | HXT | 10109595 | 7 | G | 1,0 | 4 | 1,0 | 50 | 0,95 | 16,0 | 3,98° | 2 | ■ |
| SMB716010G7B.0Z2 | HXT | 10109609 | 7 | G | 1,0 | 6 | 1,0 | 55 | 0,95 | 16,0 | 5,64° | 2 | ■ |

■ Lagerstandard.

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Schnittdaten – SMB713 Kopierfräsen/Schruppen

| SMG |  | a_e/DC | a_p/DC | f_z | | v_c |
|-----|---|----------|----------|----------|--|----------------|
| | | | | 0.3 | | |
| S2 | E | 0,0600 | 0,050 | 0,0020 | | 47 (26 – 64) |
| | | 0.0600 | 0.050 | 0.000080 | | 155 (86 – 200) |
| S12 | E | 0,0600 | 0,050 | 0,0020 | | 47 (26 – 64) |
| | | 0.0600 | 0.050 | 0.000080 | | 155 (86 – 200) |

Schnittdaten – SMB714 Kopierfräsen/Schruppen

| SMG |  | a_e/DC | a_p/DC | f_z | | | | | v_c |
|-----|---|----------|----------|---------|---------|---------|---------|---------|-----------------|
| | | | | 0.5 | 1 | 1.5 | 2 | 3 | |
| S2 | E | 0,0600 | 0,050 | 0,0036 | 0,0070 | 0,010 | 0,014 | 0,020 | 60 (33 – 81) |
| | | 0.0600 | 0.050 | 0.00014 | 0.00028 | 0.00040 | 0.00055 | 0.00080 | 195 (110 – 260) |
| S12 | E | 0,0600 | 0,050 | 0,0036 | 0,0070 | 0,010 | 0,014 | 0,020 | 60 (33 – 81) |
| | | 0.0600 | 0.050 | 0.00014 | 0.00028 | 0.00040 | 0.00055 | 0.00080 | 195 (110 – 260) |

Schnittdaten – SMB716 Kopierfräsen/Schruppen

| SMG |  | a_e/DC | a_p/DC | f_z | | | | | v_c |
|-----|---|----------|----------|---------|---------|---------|---------|---------|-----------------|
| | | | | 0.5 | 1 | 1.5 | 2 | 3 | |
| S2 | E | 0,0600 | 0,050 | 0,0036 | 0,0070 | 0,010 | 0,014 | 0,020 | 60 (33 – 81) |
| | | 0.0600 | 0.050 | 0.00014 | 0.00028 | 0.00040 | 0.00055 | 0.00080 | 195 (110 – 260) |
| S12 | E | 0,0600 | 0,050 | 0,0036 | 0,0070 | 0,010 | 0,014 | 0,020 | 60 (33 – 81) |
| | | 0.0600 | 0.050 | 0.00014 | 0.00028 | 0.00040 | 0.00055 | 0.00080 | 195 (110 – 260) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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| Kunststoffe und Composite |
| Graphit |
| X-Heads |
| Minimaster Plus |
| Minimaster |



NICHT-EISEN-METALLE

Das vollständige Programm an Hochleistungsvollhartmetallfräsern für hohe Produktivität in Nicht-Eisen-Metallen besteht aus Schafffräsern und Kugelkopffräsern.

- JS412 und JS413 Schafffräser mit scharfer Ecke
- JS452, JS453, JHP490, JH40, JH421, JM403, JM404, JM406, JH410 und JH440 mit Eckenradius
- JH450, JH460, SMB413, SMB414, SMB416, JM413 und JM416 Kugelkopffräser.

Werkzeugauswahl NE-Metall

| | |  |  |  |  |  |
|---------------------|-------------|---|---|---|---|---|
| Werkzeugbezeichnung | | JS412 | JS413 | JS452 | JS453 | JHP490 |
| Seite(n) | | 330 | 333 | 336 | 341 | 346 |
| Produktfamilie | | SOLID ² | SOLID ² | SOLID ² | SOLID ² | HPM |
| Fräserausführung | |  |  |  |  |  |
| Aufnahmen | Zylindrisch | ■ | ■ | ■ | ■ | ■ |
| | Weldon | ■ | ■ | □ | □ | ■ |
| | Safe-Lock | | | | | □ |
| Schneidenzahl | | 2 | 3 | 2 | 3 | 2-3 |
| ICC | | | | | | ■ |
| | Metrisch | 2-20 | 2-20 | 2-20 | 2-20 | 10-25 |
| | Zoll | | | | | |
| Verfügbare Längen | | 2 | 2,3 | 2,3 | 2,3 | 2,3,4 |
| Bearbeitung | |  |  |  |  |  |
| | |  |  |  |  |  |
| SMG | | | | | | |
| N1 | | ● | ● | ● | ● | ● |
| N2 | | ● | ● | ● | ● | ● |
| N3 | | | ● | ● | ● | ● |
| N11 | | | | | | |
| TS1 | | ● | ● | ● | ● | |
| TP1 | | ● | ● | ● | ● | |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

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








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Werkzeugauswahl NE-Metall

| | | | | | |
|----------------------------|-------------|-------------|-------------|-------------|-------------|
| | | | | | |
| Werkzeugbezeichnung | | JH40 | JH421 | JH410 | JH440 |
| Seite(n) | | 350 | 353 | 357 | 359 |
| Produktfamilie | | HSM/TORNADO | HSM/TORNADO | HSM/TORNADO | HSM/TORNADO |
| Fräserausführung | | | | | |
| Aufnahmen | Zylindrisch | ■ | ■ | ■ | ■ |
| | Weldon | | | | |
| | Safe-Lock | | | | |
| Schneidenzahl | | 2 | 2-3 | 1 | 2 |
| ICC | | | ■ | | |
| | Metrisch | 2-20 | 2-25 | 2-17 | 6-8 |
| | Zoll | | | | |
| | | | | | |
| Bearbeitung | | | | | |
| | | | | | |
| SMG | | | | | |
| N1 | | ● | ● | ● | ● |
| N2 | | | | | ● |
| N3 | | | | | ● |
| N11 | | ● | ● | ● | ● |
| TS1 | | ● | ● | ● | ● |
| TP1 | | | ● | | ● |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
 ● Erste Wahl ○ Alternative

Werkzeugauswahl NE-Metall

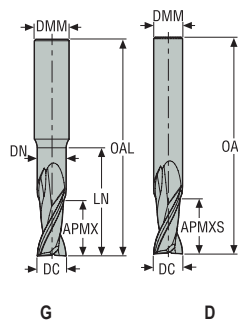
| | |  |  |  |  |  |
|---------------------|-------------|---|---|---|---|---|
| Werkzeugbezeichnung | | JH450 | JH460 | SMB413/414/416 | JM403/404/406 | JM413/416 |
| Seite(n) | | 361 | 363 | 369 | 367 | 369 |
| Produktfamilie | | HSM/TORNADO | HSM/TORNADO | MINI | MINI | MINI |
| Fräserausführung | |  |  |  |  |  |
| Aufnahmen | Zylindrisch | ■ | ■ | ■ | ■ | ■ |
| | Weldon | | | | | |
| | Safe-Lock | | | | | |
| Schneidenzahl | | 2 | 2 | 2 | 1 | 2 |
| ICC | | | | | | |
| | Metrisch | 2-20 | 3-12 | 0,5-2 | 0,5-2 | 0,5-2 |
| | Zoll | | | | | |
| Verfügbare Längen | | 2,3 | 2 | 2,3,5 | 1,2,5 | 2,3,5 |
| Bearbeitung | | | |  |  | |
| | | | |  |  | |
| | |  |  |  | |  |
| SMG | | | | | | |
| N1 | | ● | ● | ● | ● | ● |
| N2 | | ● | | ● | ● | ● |
| N3 | | ● | | ● | ● | ● |
| N11 | | ● | ● | | | ● |
| TS1 | | ● | ● | ● | | ● |
| TP1 | | ● | ● | ● | | ● |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

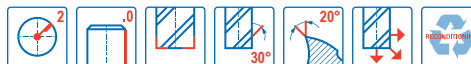
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JS412

Allgemeine Anwendung – Aluminium – Eckfräser – 2 Schneiden – Zylindrisch – Scharfe Schneide



- Toleranzen:
- DMM= h5
- DC= e8
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | DN | LN | PCEDC | Zylindrisch |
|-----------------|--------------------|------------------|-------------------|------|------|-------|-------|-----|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | | |
| JS412020G2SZ2.0 | 02881760 | 2 | G | 2,0 | 6,0 | 4,0 | 57,0 | 1,9 | 7,0 | 2 | ■ |
| JS412030G2SZ2.0 | 02881761 | 2 | G | 3,0 | 6,0 | 6,0 | 57,0 | 2,8 | 10,0 | 2 | ■ |
| JS412040G2SZ2.0 | 02881762 | 2 | G | 4,0 | 6,0 | 8,0 | 57,0 | 3,8 | 14,0 | 2 | ■ |
| JS412050G2SZ2.0 | 02881763 | 2 | G | 5,0 | 6,0 | 10,0 | 57,0 | 4,7 | 17,0 | 2 | ■ |
| JS412060D2SZ2.0 | 02881764 | 2 | D | 6,0 | 6,0 | 12,0 | 57,0 | – | – | 2 | ■ |
| JS412080D2SZ2.0 | 02881765 | 2 | D | 8,0 | 8,0 | 16,0 | 63,0 | – | – | 2 | ■ |
| JS412100D2SZ2.0 | 02881766 | 2 | D | 10,0 | 10,0 | 20,0 | 75,0 | – | – | 2 | ■ |
| JS412120D2SZ2.0 | 02881767 | 2 | D | 12,0 | 12,0 | 24,0 | 88,0 | – | – | 2 | ■ |
| JS412160D2SZ2.0 | 02881769 | 2 | D | 16,0 | 16,0 | 32,0 | 100,0 | – | – | 2 | ■ |
| JS412200D2SZ2.0 | 02881770 | 2 | D | 20,0 | 20,0 | 40,0 | 124,0 | – | – | 2 | ■ |

■ Lagerstandard.

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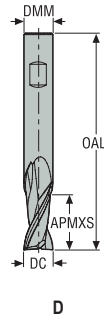
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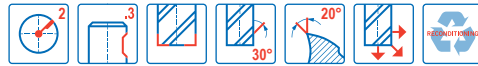
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JS412

Allgemeine Anwendung – Aluminium – Eckfräser – 2 Schneiden – Weldon – Scharfe Schneide



D



- Toleranzen:
- DMM= h5
- DC= e8
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | PCEDC | Weldon |
|-----------------|--------------------|------------------|-------------------|------|------|-------|-------|-------|--------|
| | | | | mm | mm | mm | mm | | |
| JS412060D2SZ2.3 | 02881771 | 2 | D | 6,0 | 6,0 | 12,0 | 57,0 | 2 | ■ |
| JS412080D2SZ2.3 | 02881772 | 2 | D | 8,0 | 8,0 | 16,0 | 63,0 | 2 | ■ |
| JS412100D2SZ2.3 | 02881773 | 2 | D | 10,0 | 10,0 | 20,0 | 75,0 | 2 | ■ |
| JS412120D2SZ2.3 | 02881774 | 2 | D | 12,0 | 12,0 | 24,0 | 88,0 | 2 | ■ |
| JS412160D2SZ2.3 | 02881776 | 2 | D | 16,0 | 16,0 | 32,0 | 100,0 | 2 | ■ |
| JS412200D2SZ2.3 | 02881777 | 2 | D | 20,0 | 20,0 | 40,0 | 124,0 | 2 | ■ |

■ Lagerstandard.

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Schnittdaten – JS412 Eckfräsen

| SMG | | a _p /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| N1 | E/MA | 0.400 | 1.5 | 0.026 | 0.038 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.15 | 0.19 | 0.22 | 590 (470 – 700) |
| | | 0,400 | 1,5 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0060 | 0,0075 | 0,0085 | 1925 (1600 – 2200) |
| N2 | E/MA | 0.300 | 1.4 | 0.026 | 0.040 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 0.19 | 0.22 | 475 (360 – 590) |
| | | 0,300 | 1,4 | 0,0010 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 0,0075 | 0,0085 | 1550 (1200 – 1900) |
| TS1 | A/D | 0.400 | 1.5 | 0.024 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.18 | 0.20 | 600 (480 – 710) |
| | | 0,400 | 1,5 | 0,00095 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 1975 (1600 – 2300) |
| TP1 | A/D | 0.400 | 1.5 | 0.024 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.18 | 0.20 | 500 (380 – 630) |
| | | 0,400 | 1,5 | 0,00095 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 1650 (1300 – 2000) |

Schnittdaten – JS412 Nutfräsen

| SMG | | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|----------------|---------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| N1 | E | 1.2 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.16 | 0.20 | 500 (410 – 590) |
| | | 1,2 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 1650 (1400 – 1900) |
| N2 | E | 1.0 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.13 | 0.16 | 400 (310 – 500) |
| | | 1,0 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 1300 (1100 – 1600) |
| TS1 | A | 1.2 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.16 | 0.20 | 500 (410 – 590) |
| | | 1,2 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 1650 (1400 – 1900) |
| TP1 | A | 1.2 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.16 | 0.20 | 420 (320 – 520) |
| | | 1,2 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 1375 (1100 – 1700) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_s = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

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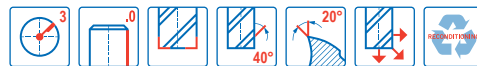
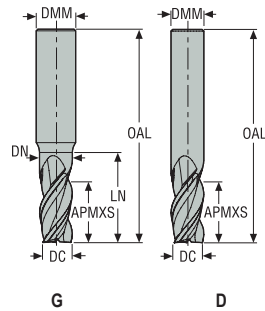
X-Heads

Minimaster Plus

Minimaster

JS413

Allgemeine Anwendung – Aluminium – Eckfräser – 3 Schneiden – Zylindrisch – Scharfe Schneide



- Toleranzen:
- DMM= h5
- DC= e8
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | DN | LN | PCEDC | Zylindrisch |
|-----------------|--------------------|------------------|-------------------|------|------|-------|-------|-----|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | | |
| JS413020G2SZ3.0 | 02881797 | 2 | G | 2,0 | 6,0 | 4,0 | 57,0 | 1,9 | 7,0 | 3 | ■ |
| JS413030G2SZ3.0 | 02881798 | 2 | G | 3,0 | 6,0 | 6,0 | 57,0 | 2,8 | 10,0 | 3 | ■ |
| JS413040G2SZ3.0 | 02881799 | 2 | G | 4,0 | 6,0 | 8,0 | 57,0 | 3,8 | 14,0 | 3 | ■ |
| JS413050G2SZ3.0 | 02881800 | 2 | G | 5,0 | 6,0 | 10,0 | 57,0 | 4,7 | 17,0 | 3 | ■ |
| JS413060D2SZ3.0 | 02881801 | 2 | D | 6,0 | 6,0 | 12,0 | 57,0 | - | - | 3 | ■ |
| JS413080D2SZ3.0 | 02881802 | 2 | D | 8,0 | 8,0 | 16,0 | 63,0 | - | - | 3 | ■ |
| JS413100D2SZ3.0 | 02881803 | 2 | D | 10,0 | 10,0 | 20,0 | 72,0 | - | - | 3 | ■ |
| JS413120D2SZ3.0 | 02881804 | 2 | D | 12,0 | 12,0 | 24,0 | 88,0 | - | - | 3 | ■ |
| JS413160D2SZ3.0 | 02881806 | 2 | D | 16,0 | 16,0 | 32,0 | 100,0 | - | - | 3 | ■ |
| JS413200D2SZ3.0 | 02881807 | 2 | D | 20,0 | 20,0 | 40,0 | 124,0 | - | - | 3 | ■ |
| JS413060D3SZ3.0 | 02881815 | 3 | D | 6,0 | 6,0 | 24,0 | 70,0 | - | - | 3 | ■ |
| JS413080D3SZ3.0 | 02881816 | 3 | D | 8,0 | 8,0 | 32,0 | 85,0 | - | - | 3 | ■ |
| JS413100D3SZ3.0 | 02881817 | 3 | D | 10,0 | 10,0 | 40,0 | 100,0 | - | - | 3 | ■ |
| JS413120D3SZ3.0 | 02881818 | 3 | D | 12,0 | 12,0 | 50,0 | 115,0 | - | - | 3 | ■ |
| JS413160D3SZ3.0 | 02881820 | 3 | D | 16,0 | 16,0 | 55,0 | 125,0 | - | - | 3 | ■ |
| JS413200D3SZ3.0 | 02881821 | 3 | D | 20,0 | 20,0 | 75,0 | 150,0 | - | - | 3 | ■ |

■ Lagerstandard.

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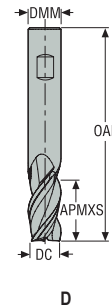
X-Heads

Minimaster Plus

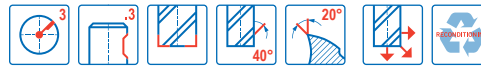
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JS413

Allgemeine Anwendung – Aluminium – Eckfräser – 3 Schneiden – Weldon – Scharfe Schneide



- Toleranzen:
- DMM= h5
- DC= e8
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | PCEDC | Weldon |
|-----------------|--------------------|------------------|-------------------|------|------|-------|-------|-------|--------|
| | | | | mm | mm | mm | mm | | |
| JS413060D2SZ3.3 | 02881808 | 2 | D | 6,0 | 6,0 | 12,0 | 57,0 | 3 | ■ |
| JS413080D2SZ3.3 | 02881809 | 2 | D | 8,0 | 8,0 | 16,0 | 63,0 | 3 | ■ |
| JS413100D2SZ3.3 | 02881810 | 2 | D | 10,0 | 10,0 | 20,0 | 72,0 | 3 | ■ |
| JS413120D2SZ3.3 | 02881811 | 2 | D | 12,0 | 12,0 | 24,0 | 88,0 | 3 | ■ |
| JS413160D2SZ3.3 | 02881813 | 2 | D | 16,0 | 16,0 | 32,0 | 100,0 | 3 | ■ |
| JS413200D2SZ3.3 | 02881814 | 2 | D | 20,0 | 20,0 | 40,0 | 124,0 | 3 | ■ |
| JS413060D3SZ3.3 | 02881955 | 3 | D | 6,0 | 6,0 | 24,0 | 70,0 | 3 | □ |
| JS413080D3SZ3.3 | 02881956 | 3 | D | 8,0 | 8,0 | 32,0 | 85,0 | 3 | □ |
| JS413100D3SZ3.3 | 02881957 | 3 | D | 10,0 | 10,0 | 40,0 | 100,0 | 3 | □ |
| JS413120D3SZ3.3 | 02881958 | 3 | D | 12,0 | 12,0 | 50,0 | 115,0 | 3 | □ |
| JS413160D3SZ3.3 | 02881960 | 3 | D | 16,0 | 16,0 | 55,0 | 125,0 | 3 | □ |
| JS413200D3SZ3.3 | 02881961 | 3 | D | 20,0 | 20,0 | 75,0 | 150,0 | 3 | □ |

□ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

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X-Heads


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Minimaster

Schnittdaten – JS413 Eckfräsen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| N1 | E/M/A | 0.400 | 1.5 | 0.024 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.18 | 0.20 | 600 (480 – 710) |
| | | 0,400 | 1,5 | 0,00095 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 1975 (1600 – 2300) |
| N2 | E/M/A | 0.300 | 1.5 | 0.024 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.18 | 0.20 | 470 (360 – 580) |
| | | 0,300 | 1,5 | 0,00095 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 1550 (1200 – 1900) |
| N3 | E/M/A | 0.300 | 1.5 | 0.024 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.18 | 0.20 | 315 (240 – 390) |
| | | 0,300 | 1,5 | 0,00095 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 1025 (790 – 1200) |
| TS1 | A/D | 0.400 | 1.5 | 0.022 | 0.034 | 0.044 | 0.055 | 0.065 | 0.090 | 0.11 | 0.13 | 0.17 | 0.19 | 610 (500 – 730) |
| | | 0,400 | 1,5 | 0,00085 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0036 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 2000 (1700 – 2300) |
| TP1 | A/D | 0.400 | 1.5 | 0.022 | 0.034 | 0.044 | 0.055 | 0.065 | 0.090 | 0.11 | 0.13 | 0.17 | 0.19 | 330 (250 – 410) |
| | | 0,400 | 1,5 | 0,00085 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0036 | 0,0044 | 0,0050 | 0,0065 | 0,0075 | 1075 (830 – 1300) |

Schnittdaten – JS413 Nutfräsen

| SMG |  | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|----------------|---------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| N1 | E | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.16 | 0.20 | 500 (400 – 600) |
| | | 1,0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 1650 (1400 – 1900) |
| N2 | E | 1.0 | 0.014 | 0.022 | 0.028 | 0.036 | 0.042 | 0.055 | 0.070 | 0.085 | 0.11 | 0.14 | 400 (300 – 490) |
| | | 1,0 | 0,00055 | 0,00085 | 0,0011 | 0,0014 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0044 | 0,0055 | 1300 (990 – 1600) |
| N3 | E | 1.0 | 0.014 | 0.022 | 0.028 | 0.036 | 0.042 | 0.055 | 0.070 | 0.085 | 0.11 | 0.14 | 265 (200 – 330) |
| | | 1,0 | 0,00055 | 0,00085 | 0,0011 | 0,0014 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0044 | 0,0055 | 870 (660 – 1000) |
| TS1 | A | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.16 | 0.19 | 500 (400 – 600) |
| | | 1,0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0075 | 1650 (1400 – 1900) |
| TP1 | A | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.16 | 0.19 | 270 (210 – 330) |
| | | 1,0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0075 | 890 (690 – 1000) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

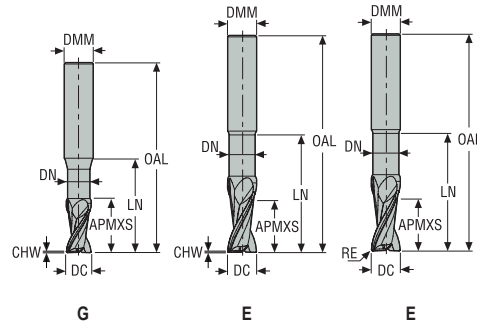
a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

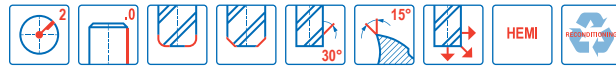
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Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

JS452

Hochleistungsfräser – Aluminium – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius oder Fase



- Toleranzen:
- DMM= h5
- DC= e7
- RE= ±0,02
- CHW= +0,04 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | CHW | RE | PCEDC | Zylindrisch |
|-------------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | | |
| JS452020G2CZ2.0-HEMI | 02881848 | 2 | G | 2,0 | 6,0 | 4,0 | 57,0 | 8,0 | 1,9 | 0,1 | – | 2 | ■ |
| JS452030G2CZ2.0-HEMI | 02881849 | 2 | G | 3,0 | 6,0 | 6,0 | 57,0 | 10,0 | 2,8 | 0,1 | – | 2 | ■ |
| JS452040G2CZ2.0-HEMI | 02881850 | 2 | G | 4,0 | 6,0 | 8,0 | 57,0 | 14,0 | 3,8 | 0,1 | – | 2 | ■ |
| JS452050G2CZ2.0-HEMI | 02881851 | 2 | G | 5,0 | 6,0 | 8,0 | 57,0 | 17,0 | 4,7 | 0,1 | – | 2 | ■ |
| JS452060E2CZ2.0-HEMI | 02881852 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 19,0 | 5,7 | 0,1 | – | 2 | ■ |
| JS452060E2R050Z2.0-HEMI | 02881853 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 19,0 | 5,7 | – | 0,5 | 2 | ■ |
| JS452060E2R100Z2.0-HEMI | 02881854 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 19,0 | 5,7 | – | 1,0 | 2 | ■ |
| JS452080E2CZ2.0-HEMI | 02881778 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 24,0 | 7,6 | 0,1 | – | 2 | ■ |
| JS452080E2R050Z2.0-HEMI | 02881855 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 24,0 | 7,6 | – | 0,5 | 2 | ■ |
| JS452080E2R100Z2.0-HEMI | 02881779 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 24,0 | 7,6 | – | 1,0 | 2 | ■ |
| JS452100E2CZ2.0-HEMI | 02881856 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,1 | – | 2 | ■ |
| JS452100E2R050Z2.0-HEMI | 02881857 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | – | 0,5 | 2 | ■ |
| JS452100E2R100Z2.0-HEMI | 02881858 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | – | 1,0 | 2 | ■ |
| JS452120E2CZ2.0-HEMI | 02881859 | 2 | E | 12,0 | 12,0 | 24,0 | 88,0 | 37,0 | 11,4 | 0,1 | – | 2 | ■ |
| JS452120E2R050Z2.0-HEMI | 02881860 | 2 | E | 12,0 | 12,0 | 24,0 | 88,0 | 37,0 | 11,4 | – | 0,5 | 2 | ■ |
| JS452120E2R100Z2.0-HEMI | 02881861 | 2 | E | 12,0 | 12,0 | 24,0 | 88,0 | 37,0 | 11,4 | – | 1,0 | 2 | ■ |
| JS452120E2R200Z2.0-HEMI | 02881780 | 2 | E | 12,0 | 12,0 | 24,0 | 88,0 | 37,0 | 11,4 | – | 2,0 | 2 | ■ |
| JS452140E2CZ2.0-HEMI | 02881862 | 2 | E | 14,0 | 14,0 | 28,0 | 88,0 | 41,0 | 13,3 | 0,1 | – | 2 | ■ |
| JS452160E2CZ2.0-HEMI | 02881863 | 2 | E | 16,0 | 16,0 | 32,0 | 100,0 | 48,0 | 15,2 | 0,1 | – | 2 | ■ |
| JS452160E2R050Z2.0-HEMI | 02881864 | 2 | E | 16,0 | 16,0 | 32,0 | 100,0 | 48,0 | 15,2 | – | 0,5 | 2 | ■ |
| JS452160E2R100Z2.0-HEMI | 02881782 | 2 | E | 16,0 | 16,0 | 32,0 | 100,0 | 48,0 | 15,2 | – | 1,0 | 2 | ■ |
| JS452160E2R200Z2.0-HEMI | 02881783 | 2 | E | 16,0 | 16,0 | 32,0 | 100,0 | 48,0 | 15,2 | – | 2,0 | 2 | ■ |
| JS452200E2CZ2.0-HEMI | 02881865 | 2 | E | 20,0 | 20,0 | 36,0 | 110,0 | 57,0 | 19,0 | 0,1 | – | 2 | ■ |
| JS452200E2R050Z2.0-HEMI | 02881866 | 2 | E | 20,0 | 20,0 | 36,0 | 110,0 | 57,0 | 19,0 | – | 0,5 | 2 | ■ |
| JS452200E2R100Z2.0-HEMI | 02881768 | 2 | E | 20,0 | 20,0 | 36,0 | 110,0 | 57,0 | 19,0 | – | 1,0 | 2 | ■ |

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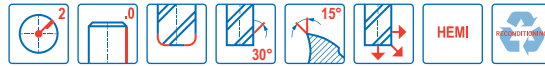
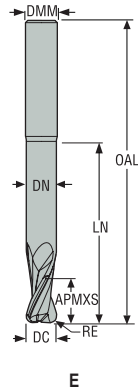
X-Heads

Minimaster Plus

Minimaster

JS452

Hochleistungsfräser – Aluminium – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM= h5
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|-------------------------|--------------------|------------------|-------------------|------|------|-------|-------|-------|------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS452080E3R020.0Z2-HEMI | 03003413 | 3 | E | 8,0 | 8,0 | 12,0 | 79,0 | 41,0 | 7,6 | 0,2 | 2 | ■ |
| JS452100E3R050.0Z2-HEMI | 03003415 | 3 | E | 10,0 | 10,0 | 15,0 | 99,0 | 57,0 | 9,5 | 0,5 | 2 | ■ |
| JS452120E3R050.0Z2-HEMI | 03003419 | 3 | E | 12,0 | 12,0 | 18,0 | 119,0 | 72,0 | 11,4 | 0,5 | 2 | ■ |
| JS452160E3R050.0Z2-HEMI | 03003426 | 3 | E | 16,0 | 16,0 | 24,0 | 129,0 | 79,0 | 15,2 | 0,5 | 2 | ■ |
| JS452200E3R050.0Z2-HEMI | 03003433 | 3 | E | 20,0 | 20,0 | 30,0 | 164,0 | 111,0 | 19,0 | 0,5 | 2 | ■ |

■ Lagerstandard.

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Graphit

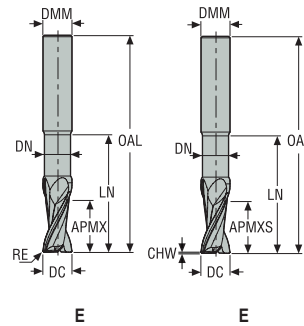
X-Heads

Minimaster Plus

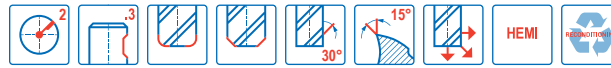
Minimaster

JS452

Hochleistungsfräser – Aluminium – Eckfräser – 2 Schneiden – Weldon – Eckenradius oder Fase



- Toleranzen:
- DMM= h5
- DC= e7
- RE= ±0,02
- CHW= +0,04 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | CHW | RE | PCEDC | Weldon |
|-------------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-----|-------|--------------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | | |
| JS452060E2CZ2.3-HEMI | 02881867 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 19,0 | 5,7 | 0,1 | – | 2 | <input type="checkbox"/> |
| JS452060E2R050Z2.3-HEMI | 02881868 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 19,0 | 5,7 | – | 0,5 | 2 | <input type="checkbox"/> |
| JS452060E2R100Z2.3-HEMI | 02881869 | 2 | E | 6,0 | 6,0 | 12,0 | 57,0 | 19,0 | 5,7 | – | 1,0 | 2 | <input type="checkbox"/> |
| JS452080E2CZ2.3-HEMI | 02881947 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 24,0 | 7,6 | 0,1 | – | 2 | <input type="checkbox"/> |
| JS452080E2R050Z2.3-HEMI | 02881870 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 24,0 | 7,6 | – | 0,5 | 2 | <input type="checkbox"/> |
| JS452080E2R100Z2.3-HEMI | 02922247 | 2 | E | 8,0 | 8,0 | 16,0 | 63,0 | 24,0 | 7,6 | – | 1,0 | 2 | <input type="checkbox"/> |
| JS452100E2CZ2.3-HEMI | 02881871 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | 0,1 | – | 2 | <input type="checkbox"/> |
| JS452100E2R050Z2.3-HEMI | 02881872 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | – | 0,5 | 2 | <input type="checkbox"/> |
| JS452100E2R100Z2.3-HEMI | 02881873 | 2 | E | 10,0 | 10,0 | 20,0 | 72,0 | 29,0 | 9,5 | – | 1,0 | 2 | <input type="checkbox"/> |
| JS452120E2CZ2.3-HEMI | 02881874 | 2 | E | 12,0 | 12,0 | 24,0 | 88,0 | 37,0 | 11,4 | 0,1 | – | 2 | <input type="checkbox"/> |
| JS452120E2R050Z2.3-HEMI | 02881875 | 2 | E | 12,0 | 12,0 | 24,0 | 88,0 | 37,0 | 11,4 | – | 0,5 | 2 | <input type="checkbox"/> |
| JS452120E2R100Z2.3-HEMI | 02881876 | 2 | E | 12,0 | 12,0 | 24,0 | 88,0 | 37,0 | 11,4 | – | 1,0 | 2 | <input type="checkbox"/> |
| JS452120E2R200Z2.3-HEMI | 02881948 | 2 | E | 12,0 | 12,0 | 24,0 | 88,0 | 37,0 | 11,4 | – | 2,0 | 2 | <input type="checkbox"/> |
| JS452140E2CZ2.3-HEMI | 02881877 | 2 | E | 14,0 | 14,0 | 28,0 | 88,0 | 41,0 | 13,3 | 0,1 | – | 2 | <input type="checkbox"/> |
| JS452160E2CZ2.3-HEMI | 02881878 | 2 | E | 16,0 | 16,0 | 32,0 | 100,0 | 48,0 | 15,2 | 0,1 | – | 2 | <input type="checkbox"/> |
| JS452160E2R050Z2.3-HEMI | 02881879 | 2 | E | 16,0 | 16,0 | 32,0 | 100,0 | 48,0 | 15,2 | – | 0,5 | 2 | <input type="checkbox"/> |
| JS452160E2R100Z2.3-HEMI | 02881949 | 2 | E | 16,0 | 16,0 | 32,0 | 100,0 | 48,0 | 15,2 | – | 1,0 | 2 | <input type="checkbox"/> |
| JS452160E2R200Z2.3-HEMI | 02881950 | 2 | E | 16,0 | 16,0 | 32,0 | 100,0 | 48,0 | 15,2 | – | 2,0 | 2 | <input type="checkbox"/> |
| JS452200E2CZ2.3-HEMI | 02881880 | 2 | E | 20,0 | 20,0 | 36,0 | 110,0 | 57,0 | 19,0 | 0,1 | – | 2 | <input type="checkbox"/> |
| JS452200E2R050Z2.3-HEMI | 02881881 | 2 | E | 20,0 | 20,0 | 36,0 | 110,0 | 57,0 | 19,0 | – | 0,5 | 2 | <input type="checkbox"/> |
| JS452200E2R100Z2.3-HEMI | 02881953 | 2 | E | 20,0 | 20,0 | 36,0 | 110,0 | 57,0 | 19,0 | – | 1,0 | 2 | <input type="checkbox"/> |

Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

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Graphit

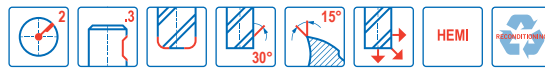
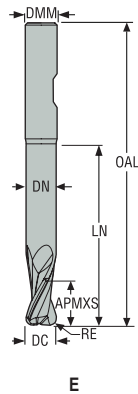
X-Heads

Minimaster Plus

Minimaster

JS452

Hochleistungsfräser – Aluminium – Eckfräser – 2 Schneiden – Weldon – Eckenradius



- Toleranzen:
- DMM= h5
- DC= e7
- RE= ±0,02
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Weldon |
|-------------------------|--------------------|------------------|-------------------|------|------|-------|-------|-------|------|-----|-------|--------------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JS452080E3R020.3Z2-HEMI | 03003447 | 3 | E | 8,0 | 8,0 | 12,0 | 79,0 | 41,0 | 7,6 | 0,2 | 2 | <input type="checkbox"/> |
| JS452100E3R050.3Z2-HEMI | 03003449 | 3 | E | 10,0 | 10,0 | 15,0 | 99,0 | 57,0 | 9,5 | 0,5 | 2 | <input type="checkbox"/> |
| JS452120E3R050.3Z2-HEMI | 03003453 | 3 | E | 12,0 | 12,0 | 18,0 | 119,0 | 72,0 | 11,4 | 0,5 | 2 | <input type="checkbox"/> |
| JS452160E3R050.3Z2-HEMI | 03003460 | 3 | E | 16,0 | 16,0 | 24,0 | 129,0 | 79,0 | 15,2 | 0,5 | 2 | <input type="checkbox"/> |
| JS452200E3R050.3Z2-HEMI | 03003467 | 3 | E | 20,0 | 20,0 | 30,0 | 164,0 | 111,0 | 19,0 | 0,5 | 2 | <input type="checkbox"/> |

Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

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Harter

Kunststoffe und
Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JS452 Eckfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 14 | 16 | 20 | |
| N1 | E/M/A | 0.400 | 1.5 | 0.030 | 0.046 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 0.20 | 0.22 | 0.25 | 560 (450 – 670) |
| | | 0,400 | 1,5 | 0,0012 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0080 | 0,0085 | 0,010 | 1825 (1500 – 2100) |
| N2 | E/M/A | 0.300 | 1.5 | 0.024 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.16 | 0.18 | 0.20 | 485 (370 – 600) |
| | | 0,300 | 1,5 | 0,00095 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0065 | 0,0070 | 0,0080 | 1600 (1300 – 1900) |
| N3 | E/M/A | 0.300 | 1.5 | 0.024 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.16 | 0.18 | 0.20 | 325 (250 – 400) |
| | | 0,300 | 1,5 | 0,00095 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0065 | 0,0070 | 0,0080 | 1075 (830 – 1300) |
| TS1 | A/D | 0.400 | 1.5 | 0.030 | 0.046 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 0.20 | 0.22 | 0.25 | 560 (450 – 670) |
| | | 0,400 | 1,5 | 0,0012 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0080 | 0,0085 | 0,010 | 1825 (1500 – 2100) |
| TP1 | A/D | 0.400 | 1.5 | 0.030 | 0.046 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 0.20 | 0.22 | 0.25 | 450 (340 – 560) |
| | | 0,400 | 1,5 | 0,0012 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0080 | 0,0085 | 0,010 | 1475 (1200 – 1800) |

Schnittdaten – JS452 Nutfräsen

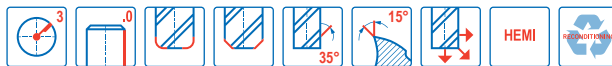
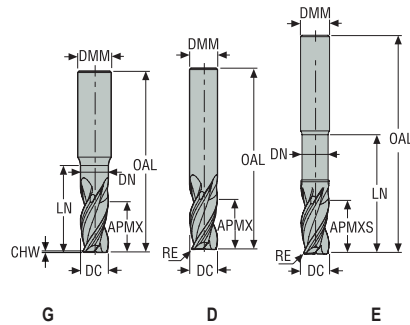
| SMG | | a _p /DC | f _z | | | | | | | | | | | v _c |
|-----|---|--------------------|----------------|---------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 14 | 16 | 20 | |
| N1 | E | 1.5 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.14 | 0.16 | 0.20 | 500 (410 – 590) |
| | | 1,5 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0055 | 0,0065 | 0,0080 | 1650 (1400 – 1900) |
| N2 | E | 1.2 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.13 | 0.16 | 400 (310 – 500) |
| | | 1,2 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 0,0065 | 1300 (1100 – 1600) |
| N3 | E | 1.2 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.13 | 0.16 | 265 (210 – 330) |
| | | 1,2 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 0,0065 | 870 (690 – 1000) |
| TS1 | A | 1.5 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.14 | 0.16 | 0.20 | 500 (410 – 590) |
| | | 1,5 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0055 | 0,0065 | 0,0080 | 1650 (1400 – 1900) |
| TP1 | A | 1.5 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.14 | 0.16 | 0.20 | 400 (310 – 500) |
| | | 1,5 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0055 | 0,0065 | 0,0080 | 1300 (1100 – 1600) |

Anmerkung: bei Eckenradius >15% DC dann a_p= -30%, f_z= -20%
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
v_c = m/min (sf/min)
f_z = mm/Zahn (Zoll/Zahn)
a_p = mm/DC (Zoll/DC) = Faktor
a_e = mm/DC (Zoll/DC) = Faktor
Alle Schnittdaten sind Richtwerte

JS453

Hochleistungsfräser – Aluminium – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius oder Fase



- Toleranzen:
- DMM=h5
- DC=e7
- RE= ±0,02 mm
- CHW= +0,04 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

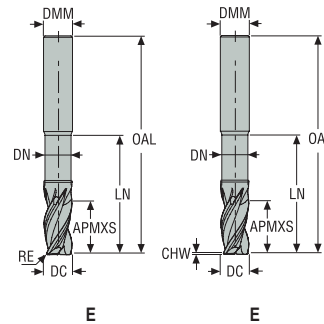
| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | CHW | RE | PCEDC | Zylindrisch |
|-------------------------|----------------|--------------|---------------|------|------|-------|-------|------|------|-----|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | | |
| JS453020G2CZ3.0-HEMI | 02881896 | 2 | G | 2,0 | 6,0 | 4,0 | 57,0 | 7,0 | 1,9 | 0,1 | - | 3 | ■ |
| JS453030G2CZ3.0-HEMI | 02881897 | 2 | G | 3,0 | 6,0 | 6,0 | 57,0 | 10,0 | 2,85 | 0,1 | - | 3 | ■ |
| JS453040G2CZ3.0-HEMI | 02881898 | 2 | G | 4,0 | 6,0 | 8,0 | 57,0 | 13,0 | 3,8 | 0,1 | - | 3 | ■ |
| JS453050G2CZ3.0-HEMI | 02881899 | 2 | G | 5,0 | 6,0 | 10,0 | 57,0 | 14,0 | 4,75 | 0,1 | - | 3 | ■ |
| JS453060D2CZ3.0-HEMI | 02881900 | 2 | D | 6,0 | 6,0 | 12,0 | 57,0 | - | - | 0,1 | - | 3 | ■ |
| JS453060D2R050Z3.0-HEMI | 02881901 | 2 | D | 6,0 | 6,0 | 12,0 | 57,0 | - | - | - | 0,5 | 3 | ■ |
| JS453080D2CZ3.0-HEMI | 02881812 | 2 | D | 8,0 | 8,0 | 16,0 | 63,0 | - | - | 0,1 | - | 3 | ■ |
| JS453080D2R050Z3.0-HEMI | 02881902 | 2 | D | 8,0 | 8,0 | 16,0 | 63,0 | - | - | - | 0,5 | 3 | ■ |
| JS453100D2CZ3.0-HEMI | 02881903 | 2 | D | 10,0 | 10,0 | 20,0 | 72,0 | - | - | 0,1 | - | 3 | ■ |
| JS453100D2R050Z3.0-HEMI | 02881904 | 2 | D | 10,0 | 10,0 | 20,0 | 72,0 | - | - | - | 0,5 | 3 | ■ |
| JS453120D2CZ3.0-HEMI | 02881905 | 2 | D | 12,0 | 12,0 | 24,0 | 88,0 | - | - | 0,1 | - | 3 | ■ |
| JS453120D2R050Z3.0-HEMI | 02881906 | 2 | D | 12,0 | 12,0 | 24,0 | 88,0 | - | - | - | 0,5 | 3 | ■ |
| JS453120E2R300.0Z3-HEMI | 02905280 | 2 | E | 12,0 | 12,0 | 24,0 | 88,0 | 37,0 | 11,4 | - | 3,0 | 3 | ■ |
| JS453140D2CZ3.0-HEMI | 02881907 | 2 | D | 14,0 | 14,0 | 28,0 | 88,0 | - | - | 0,1 | - | 3 | ■ |
| JS453160D2CZ3.0-HEMI | 02881908 | 2 | D | 16,0 | 16,0 | 32,0 | 100,0 | - | - | 0,1 | - | 3 | ■ |
| JS453160D2R050Z3.0-HEMI | 02881909 | 2 | D | 16,0 | 16,0 | 32,0 | 100,0 | - | - | - | 0,5 | 3 | ■ |
| JS453160E2R100.0Z3-HEMI | 02905281 | 2 | E | 16,0 | 16,0 | 32,0 | 100,0 | 48,0 | 15,2 | - | 1,0 | 3 | ■ |
| JS453160E2R200.0Z3-HEMI | 02905282 | 2 | E | 16,0 | 16,0 | 32,0 | 100,0 | 48,0 | 15,2 | - | 2,0 | 3 | ■ |
| JS453160E2R250.0Z3-HEMI | 02905283 | 2 | E | 16,0 | 16,0 | 32,0 | 100,0 | 48,0 | 15,2 | - | 2,5 | 3 | ■ |
| JS453160E2R300.0Z3-HEMI | 02905284 | 2 | E | 16,0 | 16,0 | 32,0 | 100,0 | 48,0 | 15,2 | - | 3,0 | 3 | ■ |
| JS453160E2R400.0Z3-HEMI | 02905285 | 2 | E | 16,0 | 16,0 | 32,0 | 100,0 | 48,0 | 15,2 | - | 4,0 | 3 | ■ |
| JS453200E2C.0Z3-HEMI | 02905286 | 2 | E | 20,0 | 20,0 | 36,0 | 110,0 | 57,0 | 19,0 | 0,1 | - | 3 | ■ |
| JS453200E2R050.0Z3-HEMI | 02905287 | 2 | E | 20,0 | 20,0 | 36,0 | 110,0 | 57,0 | 19,0 | - | 0,5 | 3 | ■ |
| JS453200E2R100.0Z3-HEMI | 02905288 | 2 | E | 20,0 | 20,0 | 36,0 | 110,0 | 57,0 | 19,0 | - | 1,0 | 3 | ■ |
| JS453200E2R200.0Z3-HEMI | 02905289 | 2 | E | 20,0 | 20,0 | 36,0 | 110,0 | 57,0 | 19,0 | - | 2,0 | 3 | ■ |
| JS453200E2R300.0Z3-HEMI | 02905291 | 2 | E | 20,0 | 20,0 | 36,0 | 110,0 | 57,0 | 19,0 | - | 3,0 | 3 | ■ |

■ Lagerstandard.

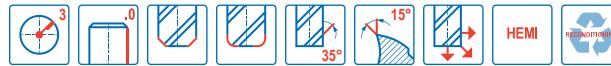
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 X-Heads
 Minimax Plus
 Minimaxter

JS453

Hochleistungsfräser – Aluminium – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius oder Fase



- Toleranzen:
- DMM= h5
- DC = e7
- RE= ±0,02 mm
- CHW= +0,04 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | CHW | RE | PCEDC | Zylindrisch |
|-------------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | | |
| JS453120E3R300.0Z3-HEMI | 02905294 | 3 | E | 12,0 | 12,0 | 24,0 | 110,0 | 54,0 | 11,4 | – | 3,0 | 3 | ■ |
| JS453160E3R100.0Z3-HEMI | 02905295 | 3 | E | 16,0 | 16,0 | 32,0 | 125,0 | 77,0 | 15,2 | – | 1,0 | 3 | ■ |
| JS453160E3R200.0Z3-HEMI | 02905296 | 3 | E | 16,0 | 16,0 | 32,0 | 125,0 | 77,0 | 15,2 | – | 2,0 | 3 | ■ |
| JS453160E3R300.0Z3-HEMI | 02905298 | 3 | E | 16,0 | 16,0 | 32,0 | 125,0 | 77,0 | 15,2 | – | 3,0 | 3 | ■ |
| JS453160E3R400.0Z3-HEMI | 02905299 | 3 | E | 16,0 | 16,0 | 32,0 | 125,0 | 77,0 | 15,2 | – | 4,0 | 3 | ■ |
| JS453200E3C.0Z3-HEMI | 02905300 | 3 | E | 20,0 | 20,0 | 36,0 | 150,0 | 90,0 | 19,0 | 0,1 | – | 3 | ■ |
| JS453200E3R050.0Z3-HEMI | 02905301 | 3 | E | 20,0 | 20,0 | 36,0 | 150,0 | 90,0 | 19,0 | – | 0,5 | 3 | ■ |
| JS453200E3R100.0Z3-HEMI | 02905302 | 3 | E | 20,0 | 20,0 | 36,0 | 150,0 | 90,0 | 19,0 | – | 1,0 | 3 | ■ |
| JS453200E3R200.0Z3-HEMI | 02905303 | 3 | E | 20,0 | 20,0 | 36,0 | 150,0 | 90,0 | 19,0 | – | 2,0 | 3 | ■ |
| JS453200E3R300.0Z3-HEMI | 02905305 | 3 | E | 20,0 | 20,0 | 36,0 | 150,0 | 90,0 | 19,0 | – | 3,0 | 3 | ■ |

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NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

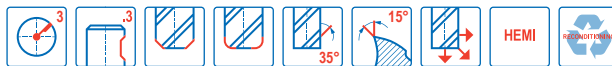
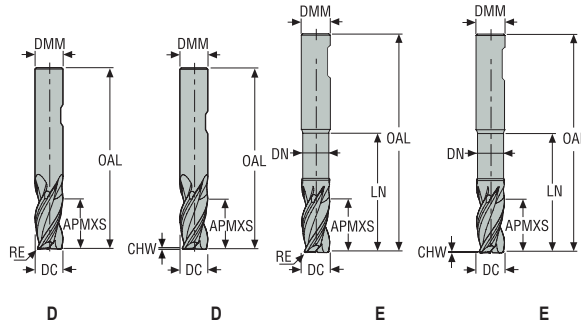
X-Heads

Minimaster Plus

Minimaster

JS453

Hochleistungsfräser – Aluminium – Eckfräser – 3 Schneiden – Weldon – Eckenradius oder Fase



- Toleranzen:
- DMM=h5
- DC=e7
- RE=±0,02 mm
- CHW= ±0,02 mm
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | CHW | RE | PCEDC | Weldon |
|-------------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-----|-------|--------------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | | |
| JS453060D2CZ3.3-HEMI | 02881910 | 2 | D | 6,0 | 6,0 | 12,0 | 57,0 | - | - | 0,1 | - | 3 | <input type="checkbox"/> |
| JS453060D2R050Z3.3-HEMI | 02881911 | 2 | D | 6,0 | 6,0 | 12,0 | 57,0 | - | - | - | 0,5 | 3 | <input type="checkbox"/> |
| JS453080D2CZ3.3-HEMI | 02881964 | 2 | D | 8,0 | 8,0 | 16,0 | 63,0 | - | - | 0,1 | - | 3 | <input type="checkbox"/> |
| JS453080D2R050Z3.3-HEMI | 02881954 | 2 | D | 8,0 | 8,0 | 16,0 | 63,0 | - | - | - | 0,5 | 3 | <input type="checkbox"/> |
| JS453100D2CZ3.3-HEMI | 02881913 | 2 | D | 10,0 | 10,0 | 20,0 | 72,0 | - | - | 0,1 | - | 3 | <input type="checkbox"/> |
| JS453100D2R050Z3.3-HEMI | 02881914 | 2 | D | 10,0 | 10,0 | 20,0 | 72,0 | - | - | - | 0,5 | 3 | <input type="checkbox"/> |
| JS453120D2CZ3.3-HEMI | 02881915 | 2 | D | 12,0 | 12,0 | 24,0 | 88,0 | - | - | 0,1 | - | 3 | <input type="checkbox"/> |
| JS453120D2R050Z3.3-HEMI | 02881916 | 2 | D | 12,0 | 12,0 | 24,0 | 88,0 | - | - | - | 0,5 | 3 | <input type="checkbox"/> |
| JS453120E2R300.3Z3-HEMI | 02905308 | 2 | E | 12,0 | 12,0 | 24,0 | 88,0 | 37,0 | 11,4 | - | 3,0 | 3 | <input type="checkbox"/> |
| JS453140D2CZ3.3-HEMI | 02881917 | 2 | D | 14,0 | 14,0 | 28,0 | 88,0 | - | - | 0,1 | - | 3 | <input type="checkbox"/> |
| JS453160D2CZ3.3-HEMI | 02881918 | 2 | D | 16,0 | 16,0 | 32,0 | 100,0 | - | - | 0,1 | - | 3 | <input type="checkbox"/> |
| JS453160D2R050Z3.3-HEMI | 02881919 | 2 | D | 16,0 | 16,0 | 32,0 | 100,0 | - | - | - | 0,5 | 3 | <input type="checkbox"/> |
| JS453160E2R100.3Z3-HEMI | 02905309 | 2 | E | 16,0 | 16,0 | 32,0 | 100,0 | 48,0 | 15,2 | - | 1,0 | 3 | <input type="checkbox"/> |
| JS453160E2R200.3Z3-HEMI | 02905310 | 2 | E | 16,0 | 16,0 | 32,0 | 100,0 | 48,0 | 15,2 | - | 2,0 | 3 | <input type="checkbox"/> |
| JS453160E2R250.3Z3-HEMI | 02905311 | 2 | E | 16,0 | 16,0 | 32,0 | 100,0 | 48,0 | 15,2 | - | 2,5 | 3 | <input type="checkbox"/> |
| JS453160E2R300.3Z3-HEMI | 02905312 | 2 | E | 16,0 | 16,0 | 32,0 | 100,0 | 48,0 | 15,2 | - | 3,0 | 3 | <input type="checkbox"/> |
| JS453160E2R400.3Z3-HEMI | 02905313 | 2 | E | 16,0 | 16,0 | 32,0 | 100,0 | 48,0 | 15,2 | - | 4,0 | 3 | <input type="checkbox"/> |
| JS453200E2C.3Z3-HEMI | 02905314 | 2 | E | 20,0 | 20,0 | 36,0 | 110,0 | 57,0 | 19,0 | 0,1 | - | 3 | <input type="checkbox"/> |
| JS453200E2R050.3Z3-HEMI | 02905315 | 2 | E | 20,0 | 20,0 | 36,0 | 110,0 | 57,0 | 19,0 | - | 0,5 | 3 | <input type="checkbox"/> |
| JS453200E2R100.3Z3-HEMI | 02905316 | 2 | E | 20,0 | 20,0 | 36,0 | 110,0 | 57,0 | 19,0 | - | 1,0 | 3 | <input type="checkbox"/> |
| JS453200E2R200.3Z3-HEMI | 02905317 | 2 | E | 20,0 | 20,0 | 36,0 | 110,0 | 57,0 | 19,0 | - | 2,0 | 3 | <input type="checkbox"/> |
| JS453200E2R300.3Z3-HEMI | 02905319 | 2 | E | 20,0 | 20,0 | 36,0 | 110,0 | 57,0 | 19,0 | - | 3,0 | 3 | <input type="checkbox"/> |

Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

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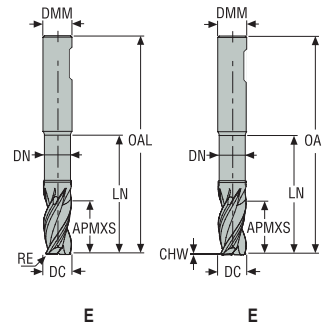
X-Heads

Minimaster Plus

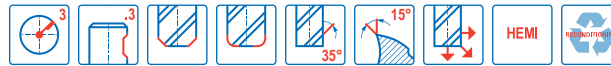
Minimaster

JS453

Hochleistungsfräser – Aluminium – Eckfräser – 3 Schneiden – Weldon – Eckenradius oder Fase



- Toleranzen:
- DMM= h5
- DC = e7
- RE= ±0,02 mm
- CHW= +0,04 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | CHW | RE | PCEDC | Weldon |
|-------------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-----|-------|--------------------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | | |
| JS453120E3R300.3Z3-HEMI | 02905322 | 3 | E | 12,0 | 12,0 | 24,0 | 110,0 | 54,0 | 11,4 | – | 3,0 | 3 | <input type="checkbox"/> |
| JS453160E3R100.3Z3-HEMI | 02905323 | 3 | E | 16,0 | 16,0 | 32,0 | 125,0 | 77,0 | 15,2 | – | 1,0 | 3 | <input type="checkbox"/> |
| JS453160E3R200.3Z3-HEMI | 02905324 | 3 | E | 16,0 | 16,0 | 32,0 | 125,0 | 77,0 | 15,2 | – | 2,0 | 3 | <input type="checkbox"/> |
| JS453160E3R300.3Z3-HEMI | 02905326 | 3 | E | 16,0 | 16,0 | 32,0 | 125,0 | 77,0 | 15,2 | – | 3,0 | 3 | <input type="checkbox"/> |
| JS453160E3R400.3Z3-HEMI | 02905327 | 3 | E | 16,0 | 16,0 | 32,0 | 125,0 | 77,0 | 15,2 | – | 4,0 | 3 | <input type="checkbox"/> |
| JS453200E3C.3Z3-HEMI | 02905328 | 3 | E | 20,0 | 20,0 | 36,0 | 150,0 | 90,0 | 19,0 | 0,1 | – | 3 | <input type="checkbox"/> |
| JS453200E3R050.3Z3-HEMI | 02905329 | 3 | E | 20,0 | 20,0 | 36,0 | 150,0 | 90,0 | 19,0 | – | 0,5 | 3 | <input type="checkbox"/> |
| JS453200E3R100.3Z3-HEMI | 02905330 | 3 | E | 20,0 | 20,0 | 36,0 | 150,0 | 90,0 | 19,0 | – | 1,0 | 3 | <input type="checkbox"/> |
| JS453200E3R200.3Z3-HEMI | 02905331 | 3 | E | 20,0 | 20,0 | 36,0 | 150,0 | 90,0 | 19,0 | – | 2,0 | 3 | <input type="checkbox"/> |
| JS453200E3R300.3Z3-HEMI | 02905333 | 3 | E | 20,0 | 20,0 | 36,0 | 150,0 | 90,0 | 19,0 | – | 3,0 | 3 | <input type="checkbox"/> |

Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

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Composite


Graphit

X-Heads


Minimaster Plus

Minimaster

Schnittdaten – JS453 Eckfräsen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 14 | 16 | 20 | |
| N1 | E/M/A | 0.400 | 1.5 | 0.030 | 0.046 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 0.20 | 0.22 | 0.25 | 560 (450 – 660) |
| | | 0.400 | 1,5 | 0,0012 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0080 | 0,0085 | 0,010 | 1825 (1500 – 2100) |
| N2 | E/M/A | 0.300 | 1.5 | 0.024 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.16 | 0.18 | 0.20 | 480 (370 – 600) |
| | | 0.300 | 1,5 | 0,00095 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0065 | 0,0070 | 0,0080 | 1575 (1300 – 1900) |
| N3 | E/M/A | 0.300 | 1.5 | 0.024 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.16 | 0.18 | 0.20 | 320 (250 – 400) |
| | | 0.300 | 1,5 | 0,00095 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0065 | 0,0070 | 0,0080 | 1050 (830 – 1300) |
| TS1 | A/D | 0.400 | 1.5 | 0.030 | 0.046 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 0.20 | 0.22 | 0.25 | 560 (450 – 660) |
| TP1 | A/D | 0.400 | 1.5 | 0.030 | 0.046 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 0.20 | 0.22 | 0.25 | 445 (340 – 550) |
| | | 0.400 | 1,5 | 0,0012 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0080 | 0,0085 | 0,010 | 1450 (1200 – 1800) |

Schnittdaten – JS453 Nutfräsen

| SMG |  | a _p /DC | f _z | | | | | | | | | | | v _c |
|-----|---|--------------------|----------------|---------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 14 | 16 | 20 | |
| N1 | E | 1.5 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.14 | 0.16 | 0.20 | 500 (410 – 590) |
| | | 1,5 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0055 | 0,0065 | 0,0080 | 1650 (1400 – 1900) |
| N2 | E | 1.2 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.13 | 0.16 | 400 (300 – 490) |
| | | 1,2 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 0,0065 | 1300 (990 – 1600) |
| N3 | E | 1.2 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.11 | 0.13 | 0.16 | 265 (200 – 330) |
| | | 1,2 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0044 | 0,0050 | 0,0065 | 870 (660 – 1000) |
| TS1 | A | 1.5 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.14 | 0.16 | 0.20 | 500 (410 – 590) |
| | | 1,5 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0055 | 0,0065 | 0,0080 | 1650 (1400 – 1900) |
| TP1 | A | 1.5 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.14 | 0.16 | 0.20 | 400 (300 – 500) |
| | | 1,5 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0055 | 0,0065 | 0,0080 | 1300 (990 – 1600) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

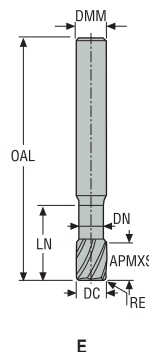
a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

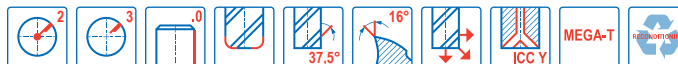
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Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

JHP490

Hochleistungsfräser – Aluminium – Eckfräser – 2-3 Schneiden – Zylindrisch – Eckenradius – ICC



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,1 mm
- RE= ±0,05 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|---------------------------|--------------------|------------------|-------------------|-----|------|------|-------|-------|------|------|-----|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| 490V100R050Z2.0A-MEGA-T | 02623870 | 2 | E | ■ | 10,0 | 10,0 | 12,0 | 65,0 | 20,0 | 9,0 | 0,5 | 2 | ■ |
| 490V120R200Z2.0A-MEGA-T | 02623883 | 2 | E | ■ | 12,0 | 12,0 | 14,0 | 75,0 | 24,0 | 11,0 | 2,0 | 2 | ■ |
| 490V160R050Z3.0A-MEGA-T | 02623889 | 2 | E | ■ | 16,0 | 16,0 | 18,0 | 85,0 | 32,0 | 14,5 | 0,5 | 3 | ■ |
| 490V200R050Z3.0A-MEGA-T | 02623908 | 2 | E | ■ | 20,0 | 20,0 | 22,0 | 100,0 | 40,0 | 18,0 | 0,5 | 3 | ■ |
| 490V250R050Z3.0A-MEGA-T | 02623926 | 2 | E | ■ | 25,0 | 25,0 | 27,0 | 125,0 | 50,0 | 23,0 | 0,5 | 3 | ■ |
| 490VL100R100Z2.0A-MEGA-T | 02623876 | 3 | E | ■ | 10,0 | 10,0 | 22,0 | 85,0 | 42,0 | 9,0 | 1,0 | 2 | ■ |
| 490VL120R050Z3.0A-MEGA-T | 02623880 | 3 | E | ■ | 12,0 | 12,0 | 14,0 | 95,0 | 40,0 | 11,0 | 0,5 | 3 | ■ |
| 490VL120R100Z2.0A-MEGA-T | 02623886 | 3 | E | ■ | 12,0 | 12,0 | 26,0 | 95,0 | 50,0 | 11,0 | 1,0 | 2 | ■ |
| 490VL160R050Z3.0A-MEGA-T | 02623891 | 3 | E | ■ | 16,0 | 16,0 | 18,0 | 95,0 | 45,0 | 14,5 | 0,5 | 3 | ■ |
| 490VL200R200Z3.0A-MEGA-T | 02623916 | 3 | E | ■ | 20,0 | 20,0 | 42,0 | 125,0 | 65,0 | 18,0 | 2,0 | 3 | ■ |
| 490VXL250R050Z3.0A-MEGA-T | 02623927 | 4 | E | ■ | 25,0 | 25,0 | 50,0 | 125,0 | 75,0 | 23,0 | 0,5 | 3 | ■ |

■ Lagerstandard.

ICC = mit interner Kühlschmiermittelzufuhr

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Kunststoffe und
Composite

Graphit

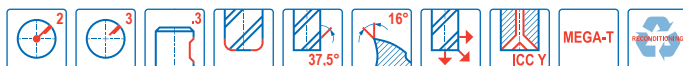
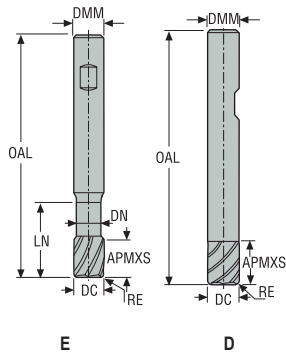
X-Heads

Minimaster Plus

Minimaster

JHP490

Hochleistungsfräser – Aluminium – Eckfräser – 2-3 Schneiden – Weldon – Eckenradius – ICC



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,1 mm
- RE= ±0,05 mm
- Nachschleifen möglich

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | ICC | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Weldon |
|----------------------------|----------------|--------------|---------------|-----|------|------|-------|-------|------|------|-----|-------|--------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| 490V120R200Z2.0A-MEGA-TW | 02669371 | 2 | E | ■ | 12,0 | 12,0 | 14,0 | 75,0 | 24,0 | 11,0 | 2,0 | 2 | □ |
| 490V160R050Z3A-MEGA-T | 02623888 | 2 | E | ■ | 16,0 | 16,0 | 18,0 | 85,0 | 32,0 | 14,5 | 0,5 | 3 | ■ |
| 490160R200Z3A-MEGA-T | 02623898 | 2 | D | ■ | 16,0 | 16,0 | 34,0 | 95,0 | - | - | 2,0 | 3 | ■ |
| 490V200R050Z3A-MEGA-T | 02623907 | 2 | E | ■ | 20,0 | 20,0 | 22,0 | 100,0 | 40,0 | 18,0 | 0,5 | 3 | ■ |
| 490V250R050Z3A-MEGA-T | 02623925 | 2 | E | ■ | 25,0 | 25,0 | 27,0 | 125,0 | 50,0 | 23,0 | 0,5 | 3 | ■ |
| 490VL100R100Z2.0A-MEGA-TW | 02669368 | 3 | E | ■ | 10,0 | 10,0 | 22,0 | 85,0 | 42,0 | 9,0 | 1,0 | 2 | □ |
| 490VL120R050Z3.0A-MEGA-TW | 02669374 | 3 | E | ■ | 12,0 | 12,0 | 14,0 | 95,0 | 40,0 | 11,0 | 0,5 | 3 | □ |
| 490VL120R100Z2.0A-MEGA-TW | 02669375 | 3 | E | ■ | 12,0 | 12,0 | 26,0 | 95,0 | 50,0 | 11,0 | 1,0 | 2 | □ |
| 490VL160R050Z3.0A-MEGA-TW | 02669382 | 3 | E | ■ | 16,0 | 16,0 | 18,0 | 95,0 | 45,0 | 14,5 | 0,5 | 3 | □ |
| 490VL200R200Z3.0A-MEGA-TW | 02669388 | 3 | E | ■ | 20,0 | 20,0 | 42,0 | 125,0 | 65,0 | 18,0 | 2,0 | 3 | □ |
| 490VXL250R050Z3.0A-MEGA-TW | 02669397 | 4 | E | ■ | 25,0 | 25,0 | 50,0 | 125,0 | 75,0 | 23,0 | 0,5 | 3 | □ |

■ Lagerstandard. □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.
ICC = mit interner Kühlschmiermittelzufuhr

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Graphit

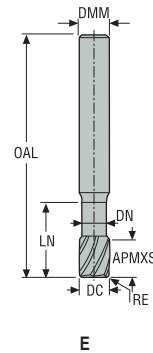
X-Heads

Minimaster Plus

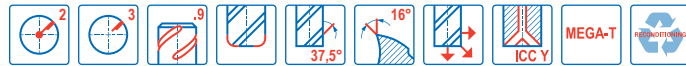
Minimaster

JHP490

Hochleistungsfräser – Aluminium – Eckfräser – 2-3 Schneiden – Safe-Lock – Eckenradius – ICC



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,1 mm
- RE= ±0,05 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Safe-Lock |
|---------------------------|--------------------|------------------|-------------------|-----|------|------|-------|-------|------|------|-----|-------|--------------------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| 490V100R050Z2.9A-MEGA-T | 02927984 | 2 | E | ■ | 10,0 | 10,0 | 12,0 | 65,0 | 20,0 | 9,0 | 0,5 | 2 | <input type="checkbox"/> |
| 490V120R200Z2.9A-MEGA-T | 02927988 | 2 | E | ■ | 12,0 | 12,0 | 14,0 | 75,0 | 24,0 | 11,0 | 2,0 | 2 | <input type="checkbox"/> |
| 490V160R050Z3.9A-MEGA-T | 02927990 | 2 | E | ■ | 16,0 | 16,0 | 18,0 | 85,0 | 32,0 | 14,0 | 0,5 | 3 | <input type="checkbox"/> |
| 490V200R050Z3.9A-MEGA-T | 02927992 | 2 | E | ■ | 20,0 | 20,0 | 22,0 | 100,0 | 40,0 | 18,0 | 0,5 | 3 | <input type="checkbox"/> |
| 490V250R050Z3.9A-MEGA-T | 02927993 | 2 | E | ■ | 25,0 | 25,0 | 27,0 | 125,0 | 50,0 | 23,0 | 0,5 | 3 | <input type="checkbox"/> |
| 490VL100R100Z2.9A-MEGA-T | 02927994 | 3 | E | ■ | 10,0 | 10,0 | 22,0 | 85,0 | 42,0 | 9,0 | 1,0 | 2 | <input type="checkbox"/> |
| 490VL120R050Z3.9A-MEGA-T | 02927995 | 3 | E | ■ | 12,0 | 12,0 | 14,0 | 95,0 | 40,0 | 11,0 | 0,5 | 3 | <input type="checkbox"/> |
| 490VL120R100Z2.9A-MEGA-T | 02927996 | 3 | E | ■ | 12,0 | 12,0 | 26,0 | 95,0 | 50,0 | 11,0 | 1,0 | 2 | <input type="checkbox"/> |
| 490VL160R050Z3.9A-MEGA-T | 02927997 | 3 | E | ■ | 16,0 | 16,0 | 18,0 | 95,0 | 32,0 | 14,0 | 0,5 | 3 | <input type="checkbox"/> |
| 490VL200R200Z3.9A-MEGA-T | 02927998 | 3 | E | ■ | 20,0 | 20,0 | 42,0 | 125,0 | 65,0 | 18,0 | 2,0 | 3 | <input type="checkbox"/> |
| 490VXL250R050Z3.9A-MEGA-T | 02927999 | 4 | E | ■ | 25,0 | 25,0 | 50,0 | 125,0 | 75,0 | 23,0 | 0,5 | 3 | <input type="checkbox"/> |

Safelock verfügbar. Verfügbarkeit, siehe gültige Preis- und Lagerliste und jederzeit aktuell auf www.secotools.com.
ICC = mit interner Kühlschmiermittelzufuhr

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Composite


Graphit

X-Heads


Minimaster Plus

Minimaster

Schnittdaten – JHP490 Eckfräsen/Schruppen

| SMG |  | a _p /DC | a _p /DC | f _z | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|-------|-------|-------|--------------------|
| | | | | 10 | 12 | 16 | 20 | 25 | |
| N1 | E/M/A | 0.500 | 1.1 | 0.20 | 0.24 | 0.30 | 0.34 | 0.38 | 700 (550 — 860) |
| | | 0.500 | 1,0 | 0,0080 | 0,0095 | 0,012 | 0,013 | 0,015 | 2325 (1900 — 2800) |
| N2 | E/M/A | 0.500 | 1.1 | 0.20 | 0.24 | 0.30 | 0.34 | 0.38 | 455 (350 — 550) |
| | | 0.500 | 1,0 | 0,0080 | 0,0095 | 0,012 | 0,013 | 0,015 | 1500 (1200 — 1800) |
| N3 | E/M/A | 0.500 | 1.1 | 0.20 | 0.24 | 0.30 | 0.34 | 0.38 | 540 (440 — 650) |
| | | 0.500 | 1,0 | 0,0080 | 0,0095 | 0,012 | 0,013 | 0,015 | 1775 (1500 — 2100) |

Schnittdaten – JHP490 Nutfräsen

| SMG |  | a _p /DC | a _p /DC | f _z | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|-------|-------|--------------------|-----------------|
| | | | | 10 | 12 | 16 | 20 | 25 | |
| N1 | E/M/A | 1.0 | 0.15 | 0.15 | 0.18 | 0.24 | 0.30 | 0.38 | 650 (500 — 790) |
| | | 1,0 | 0,0060 | 0,0070 | 0,0095 | 0,012 | 0,015 | 2125 (1700 — 2500) | |
| N2 | E/M/A | 1.0 | 0.15 | 0.15 | 0.18 | 0.24 | 0.30 | 0.38 | 420 (330 — 510) |
| | | 1,0 | 0,0060 | 0,0070 | 0,0095 | 0,012 | 0,015 | 1375 (1100 — 1600) | |
| N3 | E/M/A | 1.0 | 0.15 | 0.15 | 0.18 | 0.24 | 0.30 | 0.38 | 500 (400 — 590) |
| | | 1,0 | 0,0060 | 0,0070 | 0,0095 | 0,012 | 0,015 | 1650 (1400 — 1900) | |

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Kunststoffe und Composite

Graphit

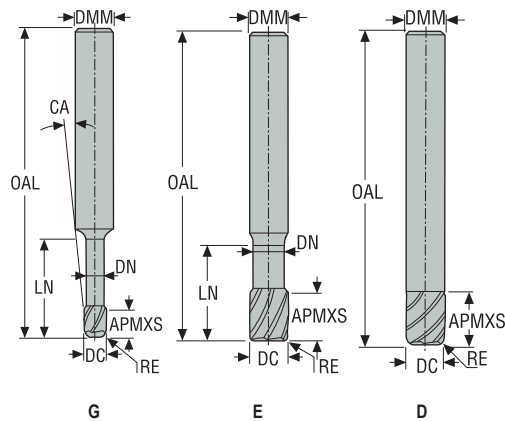
X-Heads

Minimaster Plus

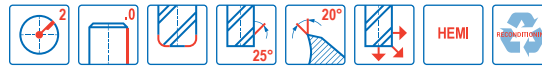
Minimaster

JH40

Hochleistungsfräser – Aluminium – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,1 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | CA° | PCEDC | Zylindrisch |
|-------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | | |
| 40K060-HEMI | 00022089 | 1 | D | 6,0 | 6,0 | 13,0 | 50,0 | – | – | 0,1 | – | 2 | ■ |
| 40K080-HEMI | 00022090 | 1 | D | 8,0 | 8,0 | 13,0 | 50,0 | – | – | 0,1 | – | 2 | ■ |
| 40K100-HEMI | 00022091 | 1 | D | 10,0 | 10,0 | 16,0 | 50,0 | – | – | 0,1 | – | 2 | ■ |
| 40K120-HEMI | 00022092 | 1 | D | 12,0 | 12,0 | 16,0 | 65,0 | – | – | 0,1 | – | 2 | ■ |
| 40020-HEMI | 00022093 | 2 | G | 2,0 | 3,0 | 3,0 | 40,0 | 6,0 | 1,9 | 0,1 | 3,5 | 2 | ■ |
| 40030-HEMI | 00022094 | 2 | E | 3,0 | 3,0 | 4,0 | 40,0 | 8,0 | 2,9 | 0,1 | – | 2 | ■ |
| 40040-HEMI | 00022095 | 2 | E | 4,0 | 4,0 | 5,0 | 50,0 | 12,0 | 3,8 | 0,1 | – | 2 | ■ |
| 40050-HEMI | 00022120 | 2 | E | 5,0 | 5,0 | 8,0 | 50,0 | 14,0 | 4,8 | 0,1 | – | 2 | ■ |
| 40060-HEMI | 00022250 | 2 | E | 6,0 | 6,0 | 8,0 | 65,0 | 18,0 | 5,7 | 0,1 | – | 2 | ■ |
| 40080-HEMI | 00022580 | 2 | E | 8,0 | 8,0 | 10,0 | 70,0 | 22,0 | 7,7 | 0,1 | – | 2 | ■ |
| 40100-HEMI | 00022663 | 2 | E | 10,0 | 10,0 | 14,0 | 80,0 | 28,0 | 9,7 | 0,1 | – | 2 | ■ |
| 40120-HEMI | 00022667 | 2 | E | 12,0 | 12,0 | 16,0 | 90,0 | 35,0 | 11,5 | 0,1 | – | 2 | ■ |
| 40160-HEMI | 00022668 | 2 | E | 16,0 | 16,0 | 20,0 | 90,0 | 40,0 | 15,5 | 0,1 | – | 2 | ■ |
| 40200-HEMI | 00022701 | 2 | E | 20,0 | 20,0 | 25,0 | 100,0 | 50,0 | 19,5 | 0,1 | – | 2 | ■ |

■ Lagerstandard.

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NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

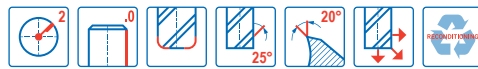
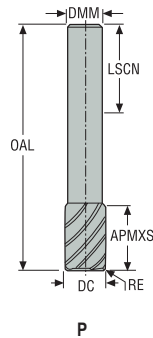
X-Heads

Minimaster Plus

Minimaster

JH40

Hochleistungsfräser – Aluminium – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,1 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LSCN | RE | PCEDC | Zylindrisch |
|-------------|----------------|--------------|---------------|------|------|-------|-------|------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | | |
| 40020-RS | 02479642 | 2 | P | 2,0 | 1,9 | 3,0 | 40,0 | 28,0 | 0,1 | 2 | ■ |
| 40030-RS | 02479643 | 2 | P | 3,0 | 2,9 | 4,0 | 60,0 | 28,0 | 0,1 | 2 | ■ |
| 40040-RS | 02479644 | 2 | P | 4,0 | 3,8 | 5,0 | 60,0 | 28,0 | 0,1 | 2 | ■ |
| 40050-RS | 02479645 | 2 | P | 5,0 | 4,8 | 8,0 | 70,0 | 28,0 | 0,1 | 2 | ■ |
| 40060-RS | 02479646 | 2 | P | 6,0 | 5,8 | 8,0 | 65,0 | 36,0 | 0,1 | 2 | ■ |
| 40080-RS | 02479647 | 2 | P | 8,0 | 7,8 | 10,0 | 70,0 | 36,0 | 0,1 | 2 | ■ |
| 40100-RS | 02479648 | 2 | P | 10,0 | 9,7 | 14,0 | 100,0 | 40,0 | 0,1 | 2 | ■ |
| 40120-RS | 02479649 | 2 | P | 12,0 | 11,7 | 16,0 | 90,0 | 45,0 | 0,1 | 2 | ■ |
| 40L060-RS | 02479650 | 3 | P | 6,0 | 5,8 | 8,0 | 100,0 | 36,0 | 0,1 | 2 | ■ |
| 40L080-RS | 02479651 | 3 | P | 8,0 | 7,8 | 10,0 | 100,0 | 36,0 | 0,1 | 2 | ■ |
| 40L120-RS | 02479652 | 3 | P | 12,0 | 11,7 | 16,0 | 125,0 | 45,0 | 0,1 | 2 | ■ |
| 40L160-RS | 02479653 | 3 | P | 16,0 | 15,7 | 20,0 | 125,0 | 48,0 | 0,1 | 2 | ■ |
| 40L200-RS | 02479654 | 3 | P | 20,0 | 19,7 | 25,0 | 125,0 | 50,0 | 0,1 | 2 | ■ |

■ Lagerstandard.

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Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JH40 Eckfräsen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|-------|--------------------|
| | | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| N1 | E/M/A | 0.400 | 1.2 | 0.030 | 0.046 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 0.22 | 0.25 | 730 (610 – 840) |
| | | 0,400 | 1,2 | 0,0012 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0085 | 0,010 | 2400 (2100 – 2700) |
| N11 | E/M/A | 0.400 | 1.0 | 0.030 | 0.046 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 0.22 | 0.26 | 425 (320 – 520) |
| | | 0,400 | 1,0 | 0,0012 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0085 | 0,010 | 1400 (1100 – 1700) |
| TS1 | A | 0.400 | 1.2 | 0.030 | 0.046 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 0.22 | 0.25 | 730 (610 – 840) |
| | | 0,400 | 1,2 | 0,0012 | 0,0018 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0085 | 0,010 | 2400 (2100 – 2700) |

Schnittdaten – JH40 Nutfräsen

| SMG | | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|-------|--------------------|----------------|---------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| N1 | E/M/A | 0.60 | 0.026 | 0.040 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 0.20 | 0.25 | 600 (510 – 700) |
| | | 0,60 | 0,0010 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 0,0080 | 0,010 | 1975 (1700 – 2200) |
| N11 | E/M/A | 0.40 | 0.016 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 0.080 | 0.095 | 0.13 | 0.16 | 400 (310 – 500) |
| | | 0,40 | 0,00065 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 1300 (1100 – 1600) |
| TS1 | A | 1.0 | 0.026 | 0.040 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 0.20 | 0.25 | 600 (510 – 700) |
| | | 1,0 | 0,0010 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 0,0080 | 0,010 | 1975 (1700 – 2200) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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Kunststoffe und Composite

Graphit

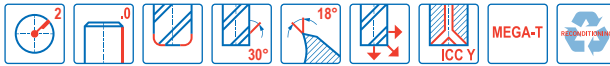
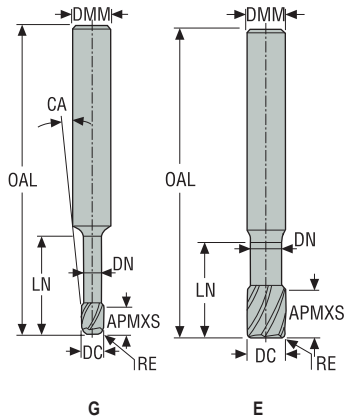
X-Heads

Minimaster Plus

Minimaster

JH421

Hochleistungsfräser – Aluminium – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius – ICC



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DC | DMM | APMXS | OAL | LN | DN | RE | CA° | PCEDC | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|-----|------|------|-------|------|------|------|------|-----|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | | |
| 421020R020Z2-MEGA-T | 02434927 | 2 | G | – | 2,0 | 3,0 | 3,0 | 40,0 | 8,0 | 1,8 | 0,2 | 3,0 | 2 | ■ |
| 421030R020Z2-MEGA-T | 02434939 | 2 | E | – | 3,0 | 3,0 | 4,0 | 40,0 | 12,0 | 2,7 | 0,2 | – | 2 | ■ |
| 421040R020Z2-MEGA-T | 02434940 | 2 | G | – | 4,0 | 6,0 | 5,0 | 50,0 | 16,0 | 3,6 | 0,2 | 3,0 | 2 | ■ |
| 421040R030Z2-MEGA-T | 02434941 | 2 | G | – | 4,0 | 6,0 | 5,0 | 50,0 | 16,0 | 3,6 | 0,3 | 3,0 | 2 | ■ |
| 421050R100Z2-MEGA-T | 02434942 | 2 | G | – | 5,0 | 6,0 | 6,0 | 50,0 | 18,0 | 4,5 | 1,0 | 1,5 | 2 | ■ |
| 421060R025Z2-MEGA-T | 02434946 | 2 | E | – | 6,0 | 6,0 | 8,0 | 50,0 | 20,0 | 5,4 | 0,25 | – | 2 | ■ |
| 421060R050Z2-MEGA-T | 02434947 | 2 | E | – | 6,0 | 6,0 | 8,0 | 50,0 | 20,0 | 5,4 | 0,5 | – | 2 | ■ |
| 421060R100Z2-MEGA-T | 02434958 | 2 | E | – | 6,0 | 6,0 | 8,0 | 50,0 | 20,0 | 5,4 | 1,0 | – | 2 | ■ |
| 421080R030Z2-MEGA-T | 02434960 | 2 | E | – | 8,0 | 8,0 | 10,0 | 65,0 | 30,0 | 7,2 | 0,3 | – | 2 | ■ |
| 421080R060Z2-MEGA-T | 02434964 | 2 | E | – | 8,0 | 8,0 | 10,0 | 65,0 | 30,0 | 7,2 | 0,6 | – | 2 | ■ |
| 421080R100Z2-MEGA-T | 02434967 | 2 | E | – | 8,0 | 8,0 | 10,0 | 65,0 | 30,0 | 7,2 | 1,0 | – | 2 | ■ |
| 421100R030Z2-MEGA-T | 02434968 | 2 | E | – | 10,0 | 10,0 | 12,0 | 80,0 | 36,0 | 9,0 | 0,3 | – | 2 | ■ |
| 421100R080Z2-MEGA-T | 02434970 | 2 | E | – | 10,0 | 10,0 | 12,0 | 80,0 | 36,0 | 9,0 | 0,8 | – | 2 | ■ |
| 421100R150Z2-MEGA-T | 02434971 | 2 | E | – | 10,0 | 10,0 | 12,0 | 80,0 | 36,0 | 9,0 | 1,5 | – | 2 | ■ |
| 421100R250Z2-MEGA-T | 02438614 | 2 | E | – | 10,0 | 10,0 | 12,0 | 80,0 | 36,0 | 9,0 | 2,5 | – | 2 | ■ |
| 421100R310Z2-MEGA-T | 02438683 | 2 | E | – | 10,0 | 10,0 | 12,0 | 80,0 | 36,0 | 9,0 | 3,1 | – | 2 | ■ |
| 421120R030Z2-MEGA-T | 02434983 | 2 | E | – | 12,0 | 12,0 | 14,0 | 90,0 | 40,0 | 11,0 | 0,3 | – | 2 | ■ |
| 421120R050Z2-MEGA-T | 02434986 | 2 | E | – | 12,0 | 12,0 | 14,0 | 90,0 | 40,0 | 11,0 | 0,5 | – | 2 | ■ |
| 421120R100Z2-MEGA-T | 02434988 | 2 | E | – | 12,0 | 12,0 | 14,0 | 90,0 | 40,0 | 11,0 | 1,0 | – | 2 | ■ |
| 421120R150Z2-MEGA-T | 02434989 | 2 | E | – | 12,0 | 12,0 | 14,0 | 90,0 | 40,0 | 11,0 | 1,5 | – | 2 | ■ |
| 421120R200Z2-MEGA-T | 02434990 | 2 | E | – | 12,0 | 12,0 | 14,0 | 90,0 | 40,0 | 11,0 | 2,0 | – | 2 | ■ |
| 421120R250Z2AMEGA-T | 02435008 | 2 | E | ■ | 12,0 | 12,0 | 14,0 | 90,0 | 40,0 | 11,0 | 2,5 | – | 2 | ■ |
| 421120R250Z2-MEGA-T | 02435007 | 2 | E | – | 12,0 | 12,0 | 14,0 | 90,0 | 40,0 | 11,0 | 2,5 | – | 2 | ■ |
| 421120R310Z2-MEGA-T | 02435009 | 2 | E | – | 12,0 | 12,0 | 14,0 | 90,0 | 40,0 | 11,0 | 3,1 | – | 2 | ■ |

■ Lagerstandard.
ICC = mit interner Kühlschmiermittelzufuhr

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Composite

Graphit

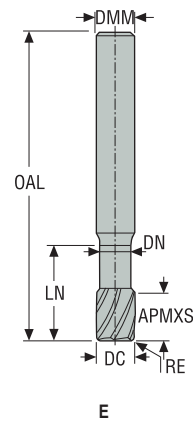
X-Heads

Minimaster Plus

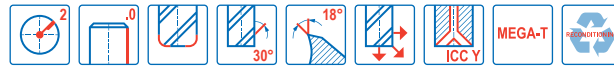
Minimaster

JH421

Hochleistungsfräser – Aluminium – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius – ICC



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Nachschleifen möglich



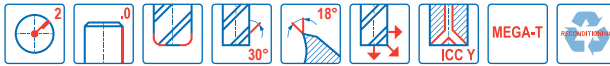
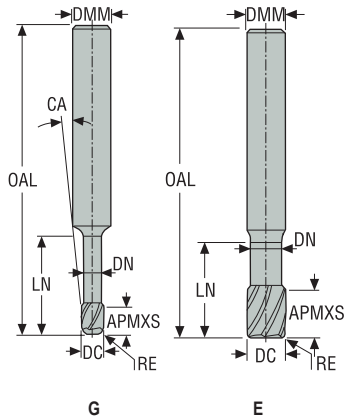
| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|-----|------|------|-------|-------|------|------|-----|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| 421160R050Z2-MEGA-T | 02435010 | 2 | E | - | 16,0 | 16,0 | 18,0 | 100,0 | 45,0 | 14,5 | 0,5 | 2 | ■ |
| 421160R200Z2-MEGA-T | 02435014 | 2 | E | - | 16,0 | 16,0 | 18,0 | 100,0 | 45,0 | 14,5 | 2,0 | 2 | ■ |
| 421160R250Z2-MEGA-T | 02435020 | 2 | E | ■ | 16,0 | 16,0 | 18,0 | 100,0 | 45,0 | 14,5 | 2,5 | 2 | ■ |
| 421160R310Z2-MEGA-T | 02435036 | 2 | E | - | 16,0 | 16,0 | 18,0 | 100,0 | 45,0 | 14,5 | 3,1 | 2 | ■ |
| 421160R400Z2-MEGA-T | 02438684 | 2 | E | ■ | 16,0 | 16,0 | 18,0 | 100,0 | 45,0 | 14,5 | 4,0 | 2 | ■ |
| 421160R400Z2-MEGA-T | 02435039 | 2 | E | - | 16,0 | 16,0 | 18,0 | 100,0 | 45,0 | 14,5 | 4,0 | 2 | ■ |
| 421200R160Z2-MEGA-T | 02435042 | 2 | E | - | 20,0 | 20,0 | 24,0 | 100,0 | 45,0 | 18,0 | 1,6 | 2 | ■ |
| 421200R200Z2-MEGA-T | 02435044 | 2 | E | - | 20,0 | 20,0 | 24,0 | 100,0 | 45,0 | 18,0 | 2,0 | 2 | ■ |
| 421200R250Z2-MEGA-T | 02438685 | 2 | E | ■ | 20,0 | 20,0 | 24,0 | 100,0 | 45,0 | 18,0 | 2,5 | 2 | ■ |
| 421200R250Z2-MEGA-T | 02435046 | 2 | E | - | 20,0 | 20,0 | 24,0 | 100,0 | 45,0 | 18,0 | 2,5 | 2 | ■ |
| 421200R310Z2-MEGA-T | 02435049 | 2 | E | - | 20,0 | 20,0 | 24,0 | 100,0 | 45,0 | 18,0 | 3,1 | 2 | ■ |
| 421200R400Z2-MEGA-T | 02435051 | 2 | E | - | 20,0 | 20,0 | 24,0 | 100,0 | 45,0 | 18,0 | 4,0 | 2 | ■ |
| 421200R500Z2-MEGA-T | 02435055 | 2 | E | - | 20,0 | 20,0 | 24,0 | 100,0 | 45,0 | 18,0 | 5,0 | 2 | ■ |

■ Lagerstandard.
ICC = mit interner Kühlschmiermittelzufuhr

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JH421

Hochleistungsfräser – Aluminium – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius – ICC



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Nachschleifen möglich

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | ICC | DC | DMM | APMXS | OAL | LN | DN | RE | CA° | PCEDC | Zylindrisch |
|----------------------|----------------|--------------|---------------|-----|------|------|-------|-------|-------|------|-----|-----|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | | |
| 421L080R020Z2-MEGA-T | 02435068 | 3 | E | – | 8,0 | 8,0 | 6,0 | 75,0 | 40,0 | 7,2 | 0,2 | – | 2 | ■ |
| 421L100R050Z2-MEGA-T | 02435070 | 3 | E | – | 10,0 | 10,0 | 8,0 | 90,0 | 50,0 | 9,0 | 0,5 | – | 2 | ■ |
| 421L100R250Z2-MEGA-T | 02435074 | 3 | E | – | 10,0 | 10,0 | 8,0 | 90,0 | 50,0 | 9,0 | 2,5 | – | 2 | ■ |
| 421L100R310Z2-MEGA-T | 02438690 | 3 | E | – | 10,0 | 10,0 | 8,0 | 90,0 | 50,0 | 9,0 | 3,1 | – | 2 | ■ |
| 421L120R050Z2-MEGA-T | 02435340 | 3 | E | – | 12,0 | 12,0 | 10,0 | 110,0 | 70,0 | 11,0 | 0,5 | – | 2 | ■ |
| 421L120R100Z2-MEGA-T | 02435343 | 3 | E | – | 12,0 | 12,0 | 10,0 | 110,0 | 70,0 | 11,0 | 1,0 | – | 2 | ■ |
| 421L120R200Z2-MEGA-T | 02435373 | 3 | E | – | 12,0 | 12,0 | 10,0 | 110,0 | 70,0 | 11,0 | 2,0 | – | 2 | ■ |
| 421L120R250Z2-MEGA-T | 02435374 | 3 | E | – | 12,0 | 12,0 | 10,0 | 110,0 | 70,0 | 11,0 | 2,5 | – | 2 | ■ |
| 421L120R310Z2-MEGA-T | 02438692 | 3 | E | – | 12,0 | 12,0 | 10,0 | 110,0 | 70,0 | 11,0 | 3,1 | – | 2 | ■ |
| 421L160R050Z2-MEGA-T | 02435375 | 3 | E | – | 16,0 | 16,0 | 13,0 | 125,0 | 80,0 | 14,5 | 0,5 | – | 2 | ■ |
| 421L160R100Z2-MEGA-T | 02435380 | 3 | E | – | 16,0 | 16,0 | 13,0 | 125,0 | 80,0 | 14,5 | 1,0 | – | 2 | ■ |
| 421L160R200Z2-MEGA-T | 02435381 | 3 | E | – | 16,0 | 16,0 | 13,0 | 125,0 | 80,0 | 14,5 | 2,0 | – | 2 | ■ |
| 421L160R250Z2AMEGA-T | 02435383 | 3 | E | ■ | 16,0 | 16,0 | 13,0 | 125,0 | 80,0 | 14,5 | 2,5 | – | 2 | ■ |
| 421L160R250Z2-MEGA-T | 02435382 | 3 | E | – | 16,0 | 16,0 | 13,0 | 125,0 | 80,0 | 14,5 | 2,5 | – | 2 | ■ |
| 421L160R310Z2-MEGA-T | 02435384 | 3 | E | – | 16,0 | 16,0 | 13,0 | 125,0 | 80,0 | 14,5 | 3,1 | – | 2 | ■ |
| 421L160R400Z2AMEGA-T | 02435386 | 3 | E | ■ | 16,0 | 16,0 | 13,0 | 125,0 | 80,0 | 14,5 | 4,0 | – | 2 | ■ |
| 421L200R050Z2-MEGA-T | 02435387 | 3 | E | – | 20,0 | 20,0 | 16,0 | 150,0 | 100,0 | 18,0 | 0,5 | – | 2 | ■ |
| 421L200R200Z2-MEGA-T | 02435391 | 3 | E | – | 20,0 | 20,0 | 16,0 | 150,0 | 100,0 | 18,0 | 2,0 | – | 2 | ■ |
| 421L200R310Z2-MEGA-T | 02435398 | 3 | E | – | 20,0 | 20,0 | 16,0 | 150,0 | 100,0 | 18,0 | 3,1 | – | 2 | ■ |
| 421L200R500Z2-MEGA-T | 02435401 | 3 | E | – | 20,0 | 20,0 | 16,0 | 150,0 | 100,0 | 18,0 | 5,0 | – | 2 | ■ |

■ Lagerstandard.
ICC = mit interner Kühlschmiermittelzufuhr

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Schnittdaten – JH421 Eckfräsen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 14 | 16 | 20 | 25 | |
| N1 | E/M/A | 0.400 | 1.0 | 0.030 | 0.044 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 0.20 | 0.22 | 0.25 | 0.28 | 620 (520 – 720) |
| | | 0,400 | 1,0 | 0,0012 | 0,0017 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0080 | 0,0085 | 0,010 | 0,011 | 2025 (1800 – 2300) |
| N11 | E/M/A | 0.400 | 1.0 | 0.020 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 0.10 | 0.12 | 0.13 | 0.15 | 0.17 | 0.19 | 410 (310 – 510) |
| | | 0,400 | 1,0 | 0,00080 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0050 | 0,0060 | 0,0065 | 0,0075 | 1350 (1100 – 1600) |
| TS1 | A | 0.400 | 1.0 | 0.030 | 0.044 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 0.20 | 0.22 | 0.25 | 0.28 | 620 (520 – 720) |
| | | 0,400 | 1,0 | 0,0012 | 0,0017 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0080 | 0,0085 | 0,010 | 0,011 | 2025 (1800 – 2300) |
| TP1 | M | 0.400 | 1.0 | 0.024 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 0.12 | 0.14 | 0.16 | 0.18 | 0.20 | 0.24 | 410 (310 – 500) |
| | | 0,400 | 1,0 | 0,00095 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0065 | 0,0070 | 0,0080 | 0,0095 | 1350 (1100 – 1600) |

Schnittdaten – JH421 Nutfräsen

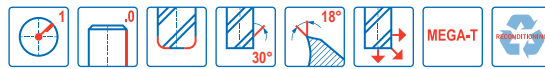
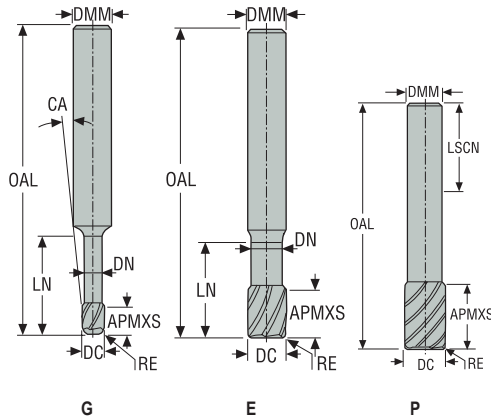
| SMG | | a _p /DC | f _z | | | | | | | | | | | | v _c |
|-----|-------|--------------------|----------------|---------|---------|---------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 14 | 16 | 20 | 25 | |
| N1 | E/M/A | 0.50 | 0.014 | 0.022 | 0.028 | 0.036 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.11 | 0.14 | 0.18 | 610 (510 – 700) |
| | | 0,50 | 0,00055 | 0,00085 | 0,0011 | 0,0014 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 0,0055 | 0,0070 | 2000 (1700 – 2200) |
| N11 | E/M/A | 0.50 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.040 | 0.050 | 0.055 | 0.065 | 0.080 | 0.10 | 405 (310 – 500) |
| | | 0,50 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 0,0022 | 0,0026 | 0,0032 | 0,0040 | 1325 (1100 – 1600) |
| TS1 | A | 0.50 | 0.014 | 0.022 | 0.028 | 0.036 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 0.11 | 0.14 | 0.18 | 610 (510 – 700) |
| | | 0,50 | 0,00055 | 0,00085 | 0,0011 | 0,0014 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 0,0055 | 0,0070 | 2000 (1700 – 2200) |
| TP1 | M | 0.50 | 0.010 | 0.015 | 0.020 | 0.025 | 0.030 | 0.040 | 0.050 | 0.060 | 0.070 | 0.080 | 0.10 | 0.13 | 405 (310 – 500) |
| | | 0,50 | 0,00040 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 0,0040 | 0,0050 | 1325 (1100 – 1600) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

JH410

Hochleistungsfräser – Aluminium – Eckfräser – 1 Schneide – Zylindrisch – Eckenradius



- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | LSCN | DN | RE | CA° | PCEDC | Zylindrisch |
|----------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-----|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | | | |
| 410020R050-MEGA-T | 02451548 | 2 | G | 2,0 | 6,0 | 3,0 | 50,0 | 6,0 | 36,0 | 1,7 | 0,5 | 12,0 | 1 | ■ |
| 410030R050-MEGA-T | 02451578 | 2 | G | 3,0 | 6,0 | 4,0 | 50,0 | 8,0 | 36,0 | 2,7 | 0,5 | 7,5 | 1 | ■ |
| 410ML030R050-MEGA-T | 02451580 | 2 | G | 3,0 | 6,0 | 4,0 | 60,0 | 15,0 | 36,0 | 2,7 | 0,5 | 5,0 | 1 | ■ |
| 410040R050-MEGA-T | 02451581 | 2 | G | 4,0 | 6,0 | 5,0 | 60,0 | 8,0 | 36,0 | 3,6 | 0,5 | 5,5 | 1 | ■ |
| 410ML040R050-MEGA-T | 02451585 | 2 | G | 4,0 | 6,0 | 5,0 | 60,0 | 15,0 | 36,0 | 3,6 | 0,5 | 3,5 | 1 | ■ |
| 410050R050-MEGA-T | 02451586 | 2 | G | 5,0 | 6,0 | 7,0 | 65,0 | 11,0 | 36,0 | 4,5 | 0,5 | 2,5 | 1 | ■ |
| 410ML050R050-MEGA-T | 02451589 | 2 | G | 5,0 | 6,0 | 7,0 | 65,0 | 18,0 | 36,0 | 4,5 | 0,5 | 1,5 | 1 | ■ |
| 410TL050R050-MEGA-T | 02451587 | 2 | G | 5,0 | 6,0 | 7,0 | 65,0 | 26,0 | 36,0 | 4,5 | 0,5 | 1,5 | 1 | ■ |
| 410060R050-MEGA-T | 02451591 | 2 | E | 6,0 | 6,0 | 8,0 | 70,0 | 11,0 | 36,0 | 5,3 | 0,5 | - | 1 | ■ |
| 410ML060R050-MEGA-T | 02451593 | 2 | E | 6,0 | 6,0 | 8,0 | 70,0 | 18,0 | 36,0 | 5,3 | 0,5 | - | 1 | ■ |
| 410TL060R050-MEGA-T | 02451592 | 2 | E | 6,0 | 6,0 | 8,0 | 70,0 | 31,0 | 36,0 | 5,3 | 0,5 | - | 1 | ■ |
| 410070RSR050-MEGA-T | 02451594 | 2 | P | 7,0 | 6,0 | 9,0 | 65,0 | - | 36,0 | - | 0,5 | - | 1 | ■ |
| 410090RSR050-MEGA-T | 02451596 | 2 | P | 9,0 | 8,0 | 11,0 | 65,0 | - | 36,0 | - | 0,5 | - | 1 | ■ |
| 410110RSR050-MEGA-T | 02451598 | 2 | P | 11,0 | 10,0 | 13,0 | 70,0 | - | 40,0 | - | 0,5 | - | 1 | ■ |
| 410130RSR100-MEGA-T | 02451600 | 2 | P | 13,0 | 12,0 | 15,0 | 70,0 | - | 45,0 | - | 1,0 | - | 1 | ■ |
| 410150RSR100-MEGA-T | 02451603 | 2 | P | 15,0 | 14,0 | 17,0 | 80,0 | - | 45,0 | - | 1,0 | - | 1 | ■ |
| 410170RSR100-MEGA-T | 02451605 | 2 | P | 17,0 | 16,0 | 19,0 | 80,0 | - | 48,0 | - | 1,0 | - | 1 | ■ |
| 410L070RSR200-MEGA-T | 02451595 | 3 | P | 7,0 | 6,0 | 9,0 | 85,0 | - | 36,0 | - | 2,0 | - | 1 | ■ |
| 410L090RSR200-MEGA-T | 02451597 | 3 | P | 9,0 | 8,0 | 11,0 | 85,0 | - | 36,0 | - | 2,0 | - | 1 | ■ |
| 410L110RSR200-MEGA-T | 02451599 | 3 | P | 11,0 | 10,0 | 13,0 | 90,0 | - | 40,0 | - | 2,0 | - | 1 | ■ |
| 410L130RSR200-MEGA-T | 02451601 | 3 | P | 13,0 | 12,0 | 15,0 | 90,0 | - | 45,0 | - | 2,0 | - | 1 | ■ |
| 410L150RSR200-MEGA-T | 02451604 | 3 | P | 15,0 | 14,0 | 17,0 | 110,0 | - | 45,0 | - | 2,0 | - | 1 | ■ |
| 410L170RSR200-MEGA-T | 02451606 | 3 | P | 17,0 | 16,0 | 19,0 | 110,0 | - | 48,0 | - | 2,0 | - | 1 | ■ |

■ Lagerstandard.

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Kunststoffe und
Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JH410 Eckfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 2 | 3 | 4 | 5 | 6 | 7 | 9 | 11 | 13 | 15 | 17 | |
| N1 | E/M/A | 0.410 | 1.0 | 0.070 | 0.11 | 0.14 | 0.18 | 0.22 | 0.25 | 0.32 | 0.40 | 0.46 | 0.50 | 0.55 | 710 (600 – 820) |
| | | 0,410 | 1,0 | 0,0028 | 0,0044 | 0,0055 | 0,0070 | 0,0085 | 0,010 | 0,013 | 0,016 | 0,018 | 0,020 | 0,022 | 2325 (2000 – 2600) |
| N11 | E/M/A | 0.318 | 0.65 | 0.026 | 0.040 | 0.055 | 0.065 | 0.080 | 0.095 | 0.12 | 0.15 | 0.17 | 0.19 | 0.22 | 495 (380 – 610) |
| | | 0,318 | 0,65 | 0,0010 | 0,0016 | 0,0022 | 0,0026 | 0,0032 | 0,0038 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 0,0085 | 1625 (1300 – 2000) |
| TS1 | A | 0.410 | 1.0 | 0.070 | 0.11 | 0.14 | 0.18 | 0.22 | 0.25 | 0.32 | 0.40 | 0.46 | 0.50 | 0.55 | 710 (600 – 820) |
| | | 0,410 | 1,0 | 0,0028 | 0,0044 | 0,0055 | 0,0070 | 0,0085 | 0,010 | 0,013 | 0,016 | 0,018 | 0,020 | 0,022 | 2325 (2000 – 2600) |

Schnittdaten – JH410 Nutfräsen

| SMG | | a _p /DC | f _z | | | | | | | | | | | v _c |
|-----|-------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | 2 | 3 | 4 | 5 | 6 | 7 | 9 | 11 | 13 | 15 | 17 | |
| N1 | E/M/A | 0.75 | 0.055 | 0.080 | 0.11 | 0.14 | 0.16 | 0.19 | 0.25 | 0.30 | 0.36 | 0.40 | 0.46 | 630 (530 – 730) |
| | | 0,75 | 0,0022 | 0,0032 | 0,0044 | 0,0055 | 0,0065 | 0,0075 | 0,010 | 0,012 | 0,014 | 0,016 | 0,018 | 2075 (1800 – 2300) |
| N11 | E/M/A | 0.36 | 0.018 | 0.028 | 0.036 | 0.046 | 0.055 | 0.065 | 0.080 | 0.10 | 0.12 | 0.14 | 0.15 | 420 (320 – 520) |
| | | 0,36 | 0,00070 | 0,0011 | 0,0014 | 0,0018 | 0,0022 | 0,0026 | 0,0032 | 0,0040 | 0,0048 | 0,0055 | 0,0060 | 1375 (1100 – 1700) |
| TS1 | A | 1.0 | 0.055 | 0.080 | 0.11 | 0.14 | 0.16 | 0.19 | 0.25 | 0.30 | 0.36 | 0.40 | 0.46 | 630 (530 – 730) |
| | | 1,0 | 0,0022 | 0,0032 | 0,0044 | 0,0055 | 0,0065 | 0,0075 | 0,010 | 0,012 | 0,014 | 0,016 | 0,018 | 2075 (1800 – 2300) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

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Graphit

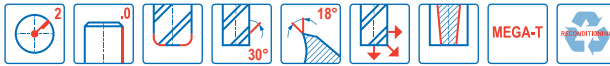
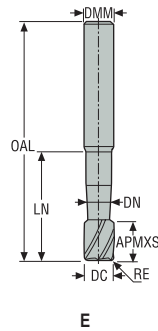
X-Heads

Minimaster Plus

Minimaster

JH440

Hochgeschwindigkeitsfräsen – Aluminium – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|---------------|--------------------|------------------|-------------------|-----|-----|-------|------|------|-----|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| 440060-MEGA-T | 00022702 | 2 | E | 6,0 | 6,0 | 8,0 | 60,0 | 30,0 | 5,4 | 1,5 | 2 | ■ |
| 440080-MEGA-T | 00022865 | 2 | E | 8,0 | 8,0 | 10,0 | 60,0 | 30,0 | 7,2 | 2,0 | 2 | ■ |

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Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JH440 Kopierfräsen/Schruppen

| SMG | | a_e/DC | a_p/DC | f_z | | v_c |
|-----|-------|----------|----------|--------|--------|--------------------|
| | | | | 6 | 8 | |
| N1 | E/M/A | 0.300 | 0.50 | 0.080 | 0.10 | 780 (650 – 900) |
| | | 0,300 | 0,50 | 0,0032 | 0,0040 | 2550 (2200 – 2900) |
| N2 | E/M/A | 0.300 | 0.50 | 0.060 | 0.080 | 510 (390 – 640) |
| | | 0,300 | 0,50 | 0,0024 | 0,0032 | 1675 (1300 – 2000) |
| N3 | E/M/A | 0.300 | 0.50 | 0.060 | 0.080 | 340 (260 – 420) |
| | | 0,300 | 0,50 | 0,0024 | 0,0032 | 1125 (860 – 1300) |
| N11 | E/M/A | 0.300 | 0.50 | 0.060 | 0.080 | 255 (130 – 370) |
| | | 0,300 | 0,50 | 0,0024 | 0,0032 | 840 (430 – 1200) |
| TS1 | A | 0.300 | 0.50 | 0.080 | 0.10 | 780 (650 – 900) |
| | | 0,300 | 0,50 | 0,0032 | 0,0040 | 2550 (2200 – 2900) |
| TP1 | A | 0.300 | 0.60 | 0.060 | 0.080 | 510 (380 – 630) |
| | | 0,300 | 0,60 | 0,0024 | 0,0032 | 1675 (1300 – 2000) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

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Kunststoffe und Composite

Graphit

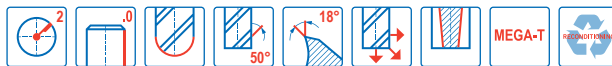
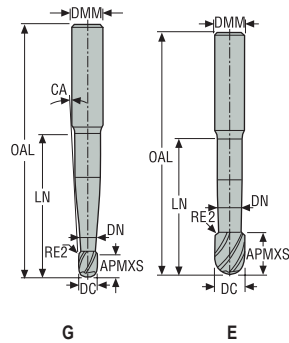
X-Heads

Minimaster Plus

Minimaster

JH450

Hochgeschwindigkeitsfräsen – Aluminium – Kugelkopf – 2 Schneiden – Zylindrisch



- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE2 | CA° | PCEDC | Zylindrisch |
|----------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | | |
| 450020-MEGA-T | 00022977 | 2 | G | 2,0 | 3,0 | 1,75 | 40,0 | 10,0 | 1,8 | 1,0 | 3,0 | 2 | ■ |
| 450030-MEGA-T | 00022978 | 2 | E | 3,0 | 3,0 | 2,5 | 40,0 | 12,0 | 2,7 | 2,0 | - | 2 | ■ |
| 450040-MEGA-T | 00022979 | 2 | G | 4,0 | 6,0 | 3,5 | 50,0 | 21,0 | 3,6 | 2,0 | 3,0 | 2 | ■ |
| 450050-MEGA-T | 00022980 | 2 | G | 5,0 | 6,0 | 4,5 | 50,0 | 22,5 | 4,5 | 2,0 | 2,0 | 2 | ■ |
| 450060-MEGA-T | 00023020 | 2 | E | 6,0 | 6,0 | 5,5 | 55,0 | 25,0 | 5,4 | 2,0 | - | 2 | ■ |
| 450080-MEGA-T | 00023032 | 2 | E | 8,0 | 8,0 | 7,0 | 65,0 | 30,0 | 7,2 | 2,0 | - | 2 | ■ |
| 450100-MEGA-T | 00023040 | 2 | E | 10,0 | 10,0 | 8,5 | 75,0 | 35,0 | 9,0 | 3,0 | - | 2 | ■ |
| 450120-MEGA-T | 00029842 | 2 | E | 12,0 | 12,0 | 10,5 | 75,0 | 40,0 | 11,0 | 3,0 | - | 2 | ■ |
| 450160-MEGA-T | 00023050 | 2 | E | 16,0 | 16,0 | 14,0 | 90,0 | 50,0 | 14,5 | 4,0 | - | 2 | ■ |
| 450200-MEGA-T | 00023053 | 2 | E | 20,0 | 20,0 | 17,0 | 100,0 | 50,0 | 18,0 | 4,0 | - | 2 | ■ |
| 450L100-MEGA-T | 00023056 | 3 | G | 10,0 | 12,0 | 8,5 | 125,0 | 50,0 | 9,0 | 3,0 | 1,5 | 2 | ■ |
| 450L120-MEGA-T | 00023091 | 3 | E | 12,0 | 12,0 | 10,5 | 150,0 | 60,0 | 11,0 | 3,0 | - | 2 | ■ |
| 450L160-MEGA-T | 00023095 | 3 | E | 16,0 | 16,0 | 14,0 | 150,0 | 70,0 | 14,5 | 4,0 | - | 2 | ■ |

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Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JH450 Kopierfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|-------|-------|--------------------|
| | | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| N1 | E/M/A | 0.400 | 0.24 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 690 (670 – 930) |
| | | 0,400 | 0,24 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,013 | 0,016 | 2275 (2200 – 3000) |
| N2 | E/M/A | 0.300 | 0.24 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 470 (410 – 680) |
| | | 0,300 | 0,24 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,013 | 0,016 | 1550 (1400 – 2200) |
| N3 | E/M/A | 0.300 | 0.24 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.40 | 315 (280 – 450) |
| | | 0,300 | 0,24 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,013 | 0,016 | 1025 (920 – 1400) |
| N11 | E/M/A | 0.300 | 0.24 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.38 | 470 (420 – 680) |
| | | 0,300 | 0,24 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,013 | 0,015 | 1550 (1400 – 2200) |
| TS1 | A | 0.500 | 0.50 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 0.16 | 0.20 | 0.24 | 0.30 | 0.34 | 700 (630 – 860) |
| | | 0,500 | 0,50 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,012 | 0,013 | 2300 (2100 – 2800) |
| TP1 | M | 0.300 | 0.24 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 0.16 | 0.20 | 0.24 | 0.32 | 0.38 | 470 (410 – 680) |
| | | 0,300 | 0,24 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 0,013 | 0,015 | 1550 (1400 – 2200) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

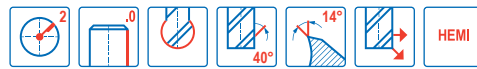
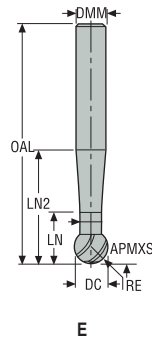
a_e = mm/DC (Zoll/DC) = Faktor

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JH460

Hochgeschwindigkeitsfräsen – Aluminium – Kugelkopf – 2 Schneiden – Zylindrisch



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,06 mm
- RE= ±0.02 mm
- SA=250°

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | LN2 | DN | RE | PCEDC | Zylindrisch |
|-------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | | |
| 460030-HEMI | 00040372 | 2 | E | 3,0 | 3,0 | 2,3 | 60,0 | 4,8 | 9,9 | 1,5 | 1,5 | 2 | ■ |
| 460040-HEMI | 00040373 | 2 | E | 4,0 | 4,0 | 3,1 | 60,0 | 5,6 | 12,1 | 2,0 | 2,0 | 2 | ■ |
| 460050-HEMI | 00040376 | 2 | E | 5,0 | 5,0 | 3,9 | 70,0 | 6,4 | 14,4 | 2,5 | 2,5 | 2 | ■ |
| 460060-HEMI | 00040377 | 2 | E | 6,0 | 6,0 | 4,7 | 80,0 | 9,7 | 19,1 | 3,0 | 3,0 | 2 | ■ |
| 460080-HEMI | 00040378 | 2 | E | 8,0 | 8,0 | 6,2 | 85,0 | 11,2 | 23,6 | 4,0 | 4,0 | 2 | ■ |
| 460100-HEMI | 00040379 | 2 | E | 10,0 | 10,0 | 7,8 | 100,0 | 15,6 | 30,8 | 5,0 | 5,0 | 2 | ■ |
| 460120-HEMI | 00040380 | 2 | E | 12,0 | 12,0 | 9,4 | 125,0 | 17,2 | 35,3 | 6,0 | 6,0 | 2 | ■ |

■ Lagerstandard.

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Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JH460 Kopierfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 3 | 4 | 5 | 6 | 8 | 10 | 12 | |
| N1 | E/M/A | 0.500 | 0.20 | 0.055 | 0.075 | 0.095 | 0.11 | 0.15 | 0.19 | 0.22 | 590 (500 – 680) |
| | | 0,500 | 0,20 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0060 | 0,0075 | 0,0085 | 1925 (1700 – 2200) |
| N11 | E/M/A | 0.300 | 0.20 | 0.046 | 0.065 | 0.080 | 0.095 | 0.13 | 0.16 | 0.18 | 610 (510 – 700) |
| | | 0,300 | 0,20 | 0,0018 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 0,0070 | 2000 (1700 – 2200) |
| S11 | E/M/A | 0.300 | 0.20 | 0.034 | 0.044 | 0.055 | 0.065 | 0.090 | 0.11 | 0.13 | 120 (110 – 130) |
| | | 0,300 | 0,20 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0036 | 0,0044 | 0,0050 | 395 (370 – 420) |
| S12 | E/M/A | 0.300 | 0.20 | 0.034 | 0.044 | 0.055 | 0.065 | 0.090 | 0.11 | 0.13 | 90 (82 – 100) |
| | | 0,300 | 0,20 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0036 | 0,0044 | 0,0050 | 295 (270 – 320) |
| S13 | E/M/A | 0.300 | 0.20 | 0.030 | 0.038 | 0.048 | 0.060 | 0.075 | 0.095 | 0.11 | 75 (65 – 81) |
| | | 0,300 | 0,20 | 0,0012 | 0,0015 | 0,0019 | 0,0024 | 0,0030 | 0,0038 | 0,0044 | 245 (220 – 260) |
| TS1 | A | 0.500 | 0.50 | 0.055 | 0.070 | 0.13 | 0.15 | 0.20 | 0.25 | 0.30 | 620 (520 – 720) |
| | | 0,500 | 0,50 | 0,0022 | 0,0028 | 0,0050 | 0,0060 | 0,0080 | 0,010 | 0,012 | 2025 (1800 – 2300) |
| TP1 | M | 0.300 | 0.20 | 0.046 | 0.065 | 0.080 | 0.095 | 0.13 | 0.16 | 0.18 | 405 (360 – 450) |
| | | 0,300 | 0,20 | 0,0018 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 0,0070 | 1325 (1200 – 1400) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

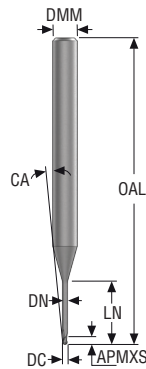
a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

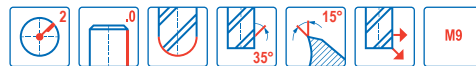
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SMB413/414/416

Mini – Aluminium – Kugelkopf – 2 Schneiden – Zylindrisch



G



- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC = 0/-0,01 mm
- RE = ±0,005 mm

| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | G | DC | DMM | APMXS | OAL | DN | LN | CA° | PCEDC | Zylindrisch |
|------------------|--------------|----------------|--------------|---|-----|-----|-------|-----|------|------|--------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | | | |
| SMB414020G4B.0Z2 | - | 10109385 | 4 | G | 2,0 | 4 | 2,0 | 50 | 1,9 | 12,0 | 3,75 ° | 2 | ■ |
| SMB414020G4B.0Z2 | M9 | 10109139 | 4 | G | 2,0 | 4 | 2,0 | 50 | 1,9 | 12,0 | 3,75 ° | 2 | ■ |
| SMB414030G4B.0Z2 | - | 10109386 | 4 | G | 3,0 | 4 | 3,0 | 50 | 2,85 | 16,0 | 1,68 ° | 2 | ■ |
| SMB414030G4B.0Z2 | M9 | 10109140 | 4 | G | 3,0 | 4 | 3,0 | 50 | 2,85 | 16,0 | 1,68 ° | 2 | ■ |
| SMB413025G5B.0Z2 | - | 10109133 | 5 | G | 2,5 | 3 | 2,5 | 50 | 2,4 | 20,0 | 0,71 ° | 2 | ■ |
| SMB413025G5B.0Z2 | M9 | 10109136 | 5 | G | 2,5 | 3 | 2,5 | 50 | 2,4 | 20,0 | 0,71 ° | 2 | ■ |
| SMB414025G5B.0Z2 | - | 10109387 | 5 | G | 2,5 | 4 | 2,5 | 50 | 2,4 | 20,0 | 1,94 ° | 2 | ■ |
| SMB414025G5B.0Z2 | M9 | 10109141 | 5 | G | 2,5 | 4 | 2,5 | 50 | 2,4 | 20,0 | 1,94 ° | 2 | ■ |
| SMB416025G5B.0Z2 | - | 10109390 | 5 | G | 2,5 | 6 | 2,5 | 55 | 2,4 | 20,0 | 3,87 ° | 2 | ■ |
| SMB416025G5B.0Z2 | M9 | 10109145 | 5 | G | 2,5 | 6 | 1,0 | 55 | 0,95 | 20,0 | 3,87 ° | 2 | ■ |
| SMB414010G6B.0Z2 | - | 10109381 | 6 | G | 1,0 | 4 | 1,0 | 50 | 0,95 | 10,0 | 5,5 ° | 2 | ■ |
| SMB414010G6B.0Z2 | M9 | 10109142 | 6 | G | 1,0 | 4 | 1,0 | 50 | 0,95 | 10,0 | 5,5 ° | 2 | ■ |
| SMB413015G6B.0Z2 | - | 10109134 | 6 | G | 1,5 | 3 | 1,5 | 50 | 1,4 | 20,0 | 1,9 ° | 2 | ■ |
| SMB413015G6B.0Z2 | M9 | 10109137 | 6 | G | 1,5 | 3 | 1,5 | 50 | 1,4 | 20,0 | 1,9 ° | 2 | ■ |
| SMB414015G6B.0Z2 | - | 10109388 | 6 | G | 1,5 | 4 | 2,5 | 55 | 2,4 | 20,0 | 2,92 ° | 2 | ■ |
| SMB414015G6B.0Z2 | M9 | 10109143 | 6 | G | 1,5 | 4 | 1,5 | 55 | 1,4 | 20,0 | 2,92 ° | 2 | ■ |
| SMB416015G6B.0Z2 | - | 10109391 | 6 | G | 1,5 | 6 | 1,5 | 55 | 1,4 | 20,0 | 4,56 ° | 2 | ■ |
| SMB416015G6B.0Z2 | M9 | 10109146 | 6 | G | 1,5 | 6 | 1,5 | 55 | 1,4 | 20,0 | 4,56 ° | 2 | ■ |
| SMB413010G7B.0Z2 | - | 10109135 | 7 | G | 1,0 | 3 | 1,0 | 50 | 0,95 | 18,0 | 2,63 ° | 2 | ■ |
| SMB413010G7B.0Z2 | M9 | 10109138 | 7 | G | 1,0 | 3 | 1,0 | 50 | 0,95 | 18,0 | 2,63 ° | 2 | ■ |
| SMB414010G7B.0Z2 | - | 10109389 | 7 | G | 1,0 | 4 | 1,0 | 50 | 0,95 | 18,0 | 3,64 ° | 2 | ■ |
| SMB414010G7B.0Z2 | M9 | 10109144 | 7 | G | 1,0 | 4 | 1,0 | 50 | 0,95 | 18,0 | 3,64 ° | 2 | ■ |
| SMB416010G7B.0Z2 | - | 10109392 | 7 | G | 1,0 | 6 | 1,0 | 55 | 0,95 | 18,0 | 5,23 ° | 2 | ■ |
| SMB416010G7B.0Z2 | M9 | 10109147 | 7 | G | 1,0 | 6 | 1,0 | 55 | 0,95 | 18,0 | 5,23 ° | 2 | ■ |

■ Lagerstandard.

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Minimaster

Schnittdaten – SMB413 Kopierfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|--------|-----------------|
| | | | | 1 | 1.5 | 2.5 | |
| N1 | E | 0,0500 | 0,080 | 0,013 | 0,020 | 0,032 | 135 (86 – 170) |
| | | 0,0500 | 0,080 | 0,00050 | 0,00080 | 0,0013 | 445 (290 – 550) |
| N2 | E | 0,0500 | 0,080 | 0,013 | 0,020 | 0,032 | 85 (55 – 100) |
| | | 0,0500 | 0,080 | 0,00050 | 0,00080 | 0,0013 | 280 (190 – 320) |
| N3 | E | 0,0500 | 0,080 | 0,013 | 0,020 | 0,032 | 55 (37 – 73) |
| | | 0,0500 | 0,080 | 0,00050 | 0,00080 | 0,0013 | 180 (130 – 230) |
| TS1 | A | 0,0500 | 0,080 | 0,013 | 0,020 | 0,032 | 135 (86 – 170) |
| | | 0,0500 | 0,080 | 0,00050 | 0,00080 | 0,0013 | 445 (290 – 550) |
| TP1 | A | 0,0500 | 0,080 | 0,013 | 0,020 | 0,032 | 135 (86 – 170) |
| | | 0,0500 | 0,080 | 0,00050 | 0,00080 | 0,0013 | 445 (290 – 550) |

Schnittdaten – SMB414 Kopierfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|--------|--------|--------|-----------------|
| | | | | 1 | 1.5 | 2 | 2.5 | 3 | |
| N1 | E | 0,0500 | 0,080 | 0,013 | 0,020 | 0,026 | 0,032 | 0,040 | 135 (86 – 170) |
| | | 0,0500 | 0,080 | 0,00050 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 445 (290 – 550) |
| N2 | E | 0,0500 | 0,080 | 0,013 | 0,020 | 0,026 | 0,032 | 0,040 | 85 (55 – 100) |
| | | 0,0500 | 0,080 | 0,00050 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 280 (190 – 320) |
| N3 | E | 0,0500 | 0,080 | 0,013 | 0,020 | 0,026 | 0,032 | 0,040 | 55 (37 – 73) |
| | | 0,0500 | 0,080 | 0,00050 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 180 (130 – 230) |
| TS1 | A | 0,0500 | 0,080 | 0,013 | 0,020 | 0,026 | 0,032 | 0,040 | 135 (86 – 170) |
| | | 0,0500 | 0,080 | 0,00050 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 445 (290 – 550) |
| TP1 | A | 0,0500 | 0,080 | 0,013 | 0,020 | 0,026 | 0,032 | 0,040 | 135 (86 – 170) |
| | | 0,0500 | 0,080 | 0,00050 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 445 (290 – 550) |

Schnittdaten – SMB416 Kopierfräsen/Schruppen

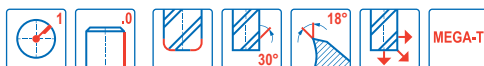
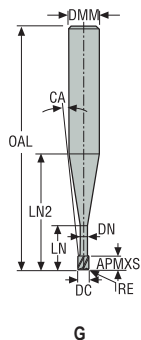
| SMG | | a _e /DC | a _p /DC | f _z | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|--------|-----------------|
| | | | | 1 | 1.5 | 2.5 | |
| N1 | E | 0,0500 | 0,080 | 0,013 | 0,020 | 0,032 | 135 (86 – 170) |
| | | 0,0500 | 0,080 | 0,00050 | 0,00080 | 0,0013 | 445 (290 – 550) |
| N2 | E | 0,0500 | 0,080 | 0,013 | 0,020 | 0,032 | 85 (55 – 100) |
| | | 0,0500 | 0,080 | 0,00050 | 0,00080 | 0,0013 | 280 (190 – 320) |
| N3 | E | 0,0500 | 0,080 | 0,013 | 0,020 | 0,032 | 55 (37 – 73) |
| | | 0,0500 | 0,080 | 0,00050 | 0,00080 | 0,0013 | 180 (130 – 230) |
| TS1 | A | 0,0500 | 0,080 | 0,013 | 0,020 | 0,032 | 135 (86 – 170) |
| | | 0,0500 | 0,080 | 0,00050 | 0,00080 | 0,0013 | 445 (290 – 550) |
| TP1 | A | 0,0500 | 0,080 | 0,013 | 0,020 | 0,032 | 135 (86 – 170) |
| | | 0,0500 | 0,080 | 0,00050 | 0,00080 | 0,0013 | 445 (290 – 550) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

JM403/JM404/JM406

Mini – Aluminium – Eckfräser – 1 Schneide – Zylindrisch – Eckenradius



- Toleranzen:
- Rundlaufabweichung = $\leq 0,005\text{ mm}$
- DMM = h5
- DC = <math>< \varnothing 0,6 = -0,005/-0,013\text{ mm}</math>
- DC = $\geq \varnothing 0,6 = -0,005/-0,015\text{ mm}$
- RE = $\pm 0,01\text{ mm}$

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | LN2 | DN | RE | CA° | PCEDC | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|-----|-----|-------|------|-----|------|------|------|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | | | |
| 403ML005R005-MEGA-T | 02568434 | 2 | G | 0,5 | 3,0 | 0,5 | 40,0 | 1,5 | 6,7 | 0,45 | 0,05 | 11,0 | 1 | ■ |
| 403ML008R005-MEGA-T | 02568450 | 2 | G | 0,8 | 3,0 | 0,8 | 40,0 | 2,5 | 7,1 | 0,75 | 0,05 | 9,0 | 1 | ■ |
| 403ML010R010-MEGA-T | 02568456 | 2 | G | 1,0 | 3,0 | 1,0 | 40,0 | 4,0 | 8,3 | 0,95 | 0,1 | 7,5 | 1 | ■ |
| 406ML015R010-MEGA-T | 02568478 | 5 | G | 1,5 | 6,0 | 1,5 | 50,0 | 5,0 | 14,0 | 1,4 | 0,1 | 9,5 | 1 | ■ |
| 404ML020R010-MEGA-T | 02577246 | 5 | G | 2,0 | 4,0 | 2,0 | 40,0 | 6,0 | 10,4 | 1,9 | 0,1 | 6,0 | 1 | ■ |

■ Lagerstandard.

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Minimaster

Schnittdaten – JM403/JM404/406 Eckfräsen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|--------|--------|--------|--------------------|
| | | | | 0.5 | 0.8 | 1 | 1.5 | 2 | |
| N1 | E | 0.500 | 0.70 | 0.015 | 0.024 | 0.030 | 0.042 | 0.050 | 365 (310 – 420) |
| | | 0,500 | 0,70 | 0,00060 | 0,00095 | 0,0012 | 0,0017 | 0,0020 | 1200 (1100 – 1300) |
| N2 | E | 0.500 | 0.70 | 0.015 | 0.024 | 0.030 | 0.042 | 0.050 | 235 (200 – 270) |
| | | 0,500 | 0,70 | 0,00060 | 0,00095 | 0,0012 | 0,0017 | 0,0020 | 770 (660 – 880) |
| N3 | E | 0.500 | 0.70 | 0.015 | 0.024 | 0.030 | 0.042 | 0.050 | 155 (140 – 180) |
| | | 0,500 | 0,70 | 0,00060 | 0,00095 | 0,0012 | 0,0017 | 0,0020 | 510 (460 – 590) |

Schnittdaten – JM403/JM404/406 Nutfräsen

| SMG | | a _p /DC | f _z | | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------|-------------------|
| | | | 0.5 | 0.8 | 1 | 1.5 | 2 | |
| N1 | E | 0.40 | 0.015 | 0.025 | 0.030 | 0.044 | 0.050 | 315 (270 – 360) |
| | | 0,40 | 0,00060 | 0,0010 | 0,0012 | 0,0017 | 0,0020 | 1025 (890 – 1100) |
| N2 | E | 0.40 | 0.015 | 0.025 | 0.030 | 0.044 | 0.050 | 200 (170 – 230) |
| | | 0,40 | 0,00060 | 0,0010 | 0,0012 | 0,0017 | 0,0020 | 660 (560 – 750) |
| N3 | E | 0.40 | 0.015 | 0.025 | 0.030 | 0.044 | 0.050 | 135 (120 – 150) |
| | | 0,40 | 0,00060 | 0,0010 | 0,0012 | 0,0017 | 0,0020 | 445 (400 – 490) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

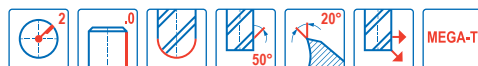
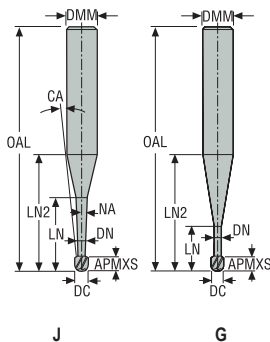
a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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JM413/JM416

Mini – Aluminium – Kugelkopf – 2 Schneide – Zylindrisch



- Toleranzen:
- Rundlaufabweichung = $\le 0,005\text{ mm}$
- DMM=h5
- DC = $\le \varnothing 0,6 = -0,005/-0,013\text{ mm}$
- DC = $\ge \varnothing 0,6 = -0,005/-0,015\text{ mm}$
- RE = $\pm 0,005\text{ mm}$

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | LN2 | DN | RE | NA° | CA° | PCEDC | Zylindrisch |
|-------------------|----------------|--------------|---------------|-----|-----|-------|------|------|------|------|------|-----|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | | | | |
| 413ML005TN-MEGA-T | 02568709 | 2 | J | 0,5 | 3,0 | 0,375 | 40,0 | 1,5 | 6,6 | 0,45 | 0,25 | 0,9 | 11,5 | 2 | ■ |
| 413L005-MEGA-T | 02568711 | 3 | G | 0,5 | 3,0 | 0,375 | 40,0 | 2,5 | 7,7 | 0,45 | 0,25 | 0,0 | 10,0 | 2 | ■ |
| 413L008-MEGA-T | 02568727 | 3 | G | 0,8 | 3,0 | 0,6 | 40,0 | 4,0 | 8,6 | 0,75 | 0,4 | 0,0 | 8,0 | 2 | ■ |
| 413L010-MEGA-T | 02568736 | 3 | G | 1,0 | 3,0 | 0,75 | 40,0 | 5,0 | 9,3 | 0,95 | 0,5 | 0,0 | 7,0 | 2 | ■ |
| 416L015-MEGA-T | 02568772 | 3 | G | 1,5 | 6,0 | 1,125 | 50,0 | 7,5 | 16,5 | 1,4 | 0,75 | 0,0 | 8,5 | 2 | ■ |
| 416L020-MEGA-T | 02568779 | 3 | G | 2,0 | 6,0 | 1,5 | 50,0 | 10,0 | 18,1 | 1,9 | 1,0 | 0,0 | 7,0 | 2 | ■ |

■ Lagerstandard.

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Minimaster

Schnittdaten – JM413/416 Kopierfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------|--------------------|
| | | | | 0,5 | 0,8 | 1 | 1,5 | 2 | |
| N1 | E | 0,300 | 0,30 | 0,030 | 0,048 | 0,060 | 0,085 | 0,10 | 385 (370 – 510) |
| | | 0,300 | 0,30 | 0,0012 | 0,0019 | 0,0024 | 0,0034 | 0,0040 | 1275 (1300 – 1600) |
| N2 | E | 0,300 | 0,30 | 0,030 | 0,048 | 0,060 | 0,085 | 0,10 | 245 (240 – 320) |
| | | 0,300 | 0,30 | 0,0012 | 0,0019 | 0,0024 | 0,0034 | 0,0040 | 800 (790 – 1000) |
| N3 | E | 0,300 | 0,30 | 0,030 | 0,048 | 0,060 | 0,085 | 0,10 | 165 (160 – 210) |
| | | 0,300 | 0,30 | 0,0012 | 0,0019 | 0,0024 | 0,0034 | 0,0040 | 540 (530 – 680) |
| N11 | E | 0,300 | 0,30 | 0,030 | 0,048 | 0,060 | 0,085 | 0,10 | 320 (300 – 430) |
| | | 0,300 | 0,30 | 0,0012 | 0,0019 | 0,0024 | 0,0034 | 0,0040 | 1050 (990 – 1400) |
| TS1 | A | 0,300 | 0,30 | 0,030 | 0,048 | 0,060 | 0,085 | 0,10 | 385 (370 – 510) |
| | | 0,300 | 0,30 | 0,0012 | 0,0019 | 0,0024 | 0,0034 | 0,0040 | 1275 (1300 – 1600) |
| TP1 | A | 0,300 | 0,30 | 0,030 | 0,048 | 0,060 | 0,085 | 0,10 | 385 (370 – 510) |
| | | 0,300 | 0,30 | 0,0012 | 0,0019 | 0,0024 | 0,0034 | 0,0040 | 1275 (1300 – 1600) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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Minimaster



HART

Das vollständige Programm an Hochleistungsvollhartmetallfräsern für hohe Produktivität in harten Werkstoffen besteht aus Schaft- und Kugelkopffräsern.

- JHP170, JHF181, JH120, JH130, JH930, JH142, JME142 und JME144 mit Eckenradius
- JH112, JH150, JH160 und JMB112 Kugelkopffräser

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ISO-S-Werkstoffe

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Composite

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





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Werkzeugauswahl Hart

| Werkzeugbezeichnung | | JHP170 | JHF181 | JH120 | JH130 | JH930 | JH142 |
|----------------------------|-------------|--------|---------|-------------|-------------|-------------|-------------|
| Seite(n) | | 374 | 377 | 380 | 382 | 142, 384 | 202, 387 |
| Produktfamilie | | HPM | HFM | HSM/TORNADO | HSM/TORNADO | HSM/TORNADO | HSM/TORNADO |
| Fräserausführung | | | | | | | |
| Aufnahmen | Zylindrisch | ■ | ■ | ■ | ■ | ■ | ■ |
| | Weldon | ■ | | | | | |
| Schneidenzahl | | 3-4 | 3-4-5 | 4 | 5-6, 8 | 5-6, 8 | 2-4-5-6 |
| ICC | | | ■ | | | | |
| | Metrisch | 2-20 | 1-10 | 2-16 | 6-20 | 6-20 | 2-12 |
| | Zoll | | | | | | |
| Verfügbare Längen | | 2 | 1,2,3,4 | 2 | 2 | 2 | 2,3,6 |
| Bearbeitung | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| SMG | | | | | | | |
| H3 | | ● | ● | ● | ● | ● | ● |
| H5 | | ● | ● | ● | ● | ● | ● |
| H7 | | ● | ● | ● | ● | ● | ● |
| H8 | | ● | ● | ● | ● | ● | ● |
| H11 | | ● | ● | ● | ● | ● | |
| H12 | | ● | ● | ● | ● | ● | |
| H21 | | ● | ● | ● | ● | ● | ● |
| H31 | | ● | ● | ● | ● | ● | ● |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
 ● Erste Wahl ○ Alternative

Werkzeugauswahl Hart

| | | | | | | | |
|---------------------|---|---|---|---|---|---|---------|
| |  |  |  |  |  |  | |
| Werkzeugbezeichnung | JH112 | JH150 | JH160 | JME142 | JME144 | JMB112 | |
| Seite(n) | 207, 390 | 393 | 395 | 397 | 402 | 404 | |
| Produktfamilie | HSM/TORNADO | HSM/TORNADO | HSM/TORNADO | MINI | MINI | MINI | |
| Fräserausführung |  |  |  |  |  |  | |
| Aufnahmen | Zylindrisch | ■ | ■ | ■ | ■ | ■ | |
| | Weldon | | | | | | |
| Schneidenzahl | 2 | 4 | 4 | 2 | 4 | 2 | |
| ICC | | | | | | | |
| | Metrisch | 2-12 | 6-12 | 3-12 | 0,2-3,0 | 1,0-3,0 | 0,2-3,0 |
| | Zoll | | | | | | |
| Verfügbare Längen | 1,2,3,4,5,6 | 2 | 2 | 1,2,3,4,5,6 | 2,3,4 | 1,2,3,4,5,6 | |
| Bearbeitung | | | |  |  | | |
| | | | |  |  | | |
| |  |  |  | | |  | |
| SMG | | | | | | | |
| H3 | ● | ● | ● | ● | ● | ● | |
| H5 | ● | ● | ● | ● | ● | ● | |
| H7 | ● | ● | ● | ● | ● | ● | |
| H8 | ● | ● | ● | ● | ● | ● | |
| H11 | | ● | ● | ● | ● | ● | |
| H12 | | ● | ● | ● | ● | ● | |
| H21 | ● | ● | ● | ● | ● | ● | |
| H31 | ● | ● | ● | ● | ● | ● | |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

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Graphit

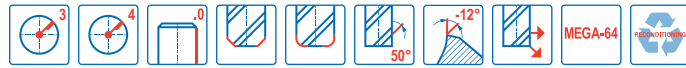
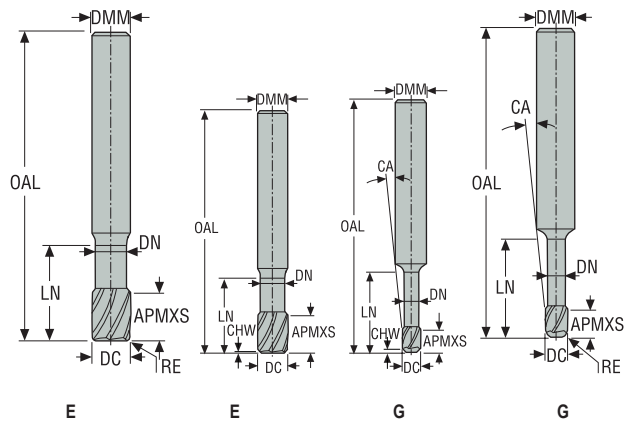
X-Heads

Minimaster Plus

Minimaster

JHP170

Hochleistungsfräser – Gehärteter Stahl – Eckfräser – 3-4 Schneiden – Zylindrisch – Eckenradius oder Fase



- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- CHW= Ø2- Ø4=+0,05 mm
- CHW= Ø5-Ø16=+0,1 mm
- RE= ±0,05 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | CHW | RE | CA° | PCEDC | Zylindrisch |
|----------------------|--------------------|------------------|-------------------|------|------|-------|------|------|------|------|-----|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | mm | | |
| 170020.0-MEGA-64 | 02462685 | 2 | G | 2,0 | 6,0 | 2,0 | 50,0 | 4,0 | 1,9 | 0,08 | - | 14,5 | 3 | ■ |
| 170020R020.0-MEGA-64 | 02587615 | 2 | G | 2,0 | 6,0 | 2,0 | 50,0 | 4,0 | 1,9 | - | 0,2 | 14,5 | 3 | ■ |
| 170020R050.0-MEGA-64 | 02587617 | 2 | G | 2,0 | 6,0 | 2,0 | 50,0 | 4,0 | 1,9 | - | 0,5 | 15,0 | 3 | ■ |
| 170030.0-MEGA-64 | 02462686 | 2 | G | 3,0 | 6,0 | 3,0 | 50,0 | 6,0 | 2,8 | 0,08 | - | 9,0 | 3 | ■ |
| 170030R020.0-MEGA-64 | 02587618 | 2 | G | 3,0 | 6,0 | 3,0 | 50,0 | 6,0 | 2,8 | - | 0,2 | 9,5 | 3 | ■ |
| 170030R050.0-MEGA-64 | 02587619 | 2 | G | 3,0 | 6,0 | 3,0 | 50,0 | 6,0 | 2,8 | - | 0,5 | 9,5 | 3 | ■ |
| 170040.0-MEGA-64 | 02462687 | 2 | G | 4,0 | 6,0 | 4,0 | 50,0 | 8,0 | 3,7 | 0,1 | - | 5,5 | 4 | ■ |
| 170040R020.0-MEGA-64 | 02587620 | 2 | G | 4,0 | 6,0 | 4,0 | 50,0 | 8,0 | 3,7 | - | 0,2 | 5,5 | 4 | ■ |
| 170040R050.0-MEGA-64 | 02587621 | 2 | G | 4,0 | 6,0 | 4,0 | 50,0 | 8,0 | 3,7 | - | 0,5 | 5,5 | 4 | ■ |
| 170050.0-MEGA-64 | 02462688 | 2 | G | 5,0 | 6,0 | 5,0 | 50,0 | 10,0 | 4,6 | 0,12 | - | 2,5 | 4 | ■ |
| 170050R020.0-MEGA-64 | 02587622 | 2 | G | 5,0 | 6,0 | 5,0 | 50,0 | 10,0 | 4,6 | - | 0,2 | 2,5 | 4 | ■ |
| 170050R050.0-MEGA-64 | 02587623 | 2 | G | 5,0 | 6,0 | 5,0 | 50,0 | 10,0 | 4,6 | - | 0,5 | 2,5 | 4 | ■ |
| 170060.0-MEGA-64 | 02462689 | 2 | E | 6,0 | 6,0 | 6,0 | 50,0 | 11,5 | 5,6 | 0,14 | - | - | 4 | ■ |
| 170060R020.0-MEGA-64 | 02587624 | 2 | E | 6,0 | 6,0 | 6,0 | 50,0 | 11,5 | 5,6 | - | 0,2 | - | 4 | ■ |
| 170060R050.0-MEGA-64 | 02587625 | 2 | E | 6,0 | 6,0 | 6,0 | 50,0 | 11,5 | 5,6 | - | 0,5 | - | 4 | ■ |
| 170080.0-MEGA-64 | 02462690 | 2 | E | 8,0 | 8,0 | 8,0 | 55,0 | 16,0 | 7,4 | 0,16 | - | - | 4 | ■ |
| 170080R020.0-MEGA-64 | 02587626 | 2 | E | 8,0 | 8,0 | 8,0 | 55,0 | 16,0 | 7,4 | - | 0,2 | - | 4 | ■ |
| 170080R050.0-MEGA-64 | 02587627 | 2 | E | 8,0 | 8,0 | 8,0 | 55,0 | 16,0 | 7,4 | - | 0,5 | - | 4 | ■ |
| 170080R100.0-MEGA-64 | 02587628 | 2 | E | 8,0 | 8,0 | 8,0 | 55,0 | 16,0 | 7,4 | - | 1,0 | - | 4 | ■ |
| 170100.0-MEGA-64 | 02462691 | 2 | E | 10,0 | 10,0 | 10,0 | 65,0 | 22,0 | 9,4 | 0,18 | - | - | 4 | ■ |
| 170100R050.0-MEGA-64 | 02587629 | 2 | E | 10,0 | 10,0 | 10,0 | 65,0 | 22,0 | 9,4 | - | 0,5 | - | 4 | ■ |
| 170100R100.0-MEGA-64 | 02587630 | 2 | E | 10,0 | 10,0 | 10,0 | 65,0 | 22,0 | 9,4 | - | 1,0 | - | 4 | ■ |
| 170120.0-MEGA-64 | 02462692 | 2 | E | 12,0 | 12,0 | 12,0 | 75,0 | 27,0 | 11,4 | 0,2 | - | - | 4 | ■ |
| 170120R050.0-MEGA-64 | 02587631 | 2 | E | 12,0 | 12,0 | 12,0 | 75,0 | 27,0 | 11,4 | - | 0,5 | - | 4 | ■ |
| 170120R100.0-MEGA-64 | 02587632 | 2 | E | 12,0 | 12,0 | 12,0 | 75,0 | 27,0 | 11,4 | - | 1,0 | - | 4 | ■ |
| 170160.0-MEGA-64 | 02462693 | 2 | E | 16,0 | 16,0 | 16,0 | 80,0 | 29,0 | 15,4 | 0,3 | - | - | 4 | ■ |
| 170160R050.0-MEGA-64 | 02587633 | 2 | E | 16,0 | 16,0 | 16,0 | 80,0 | 29,0 | 15,4 | - | 0,5 | - | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und Composite

Graphit

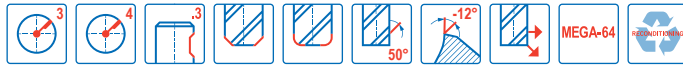
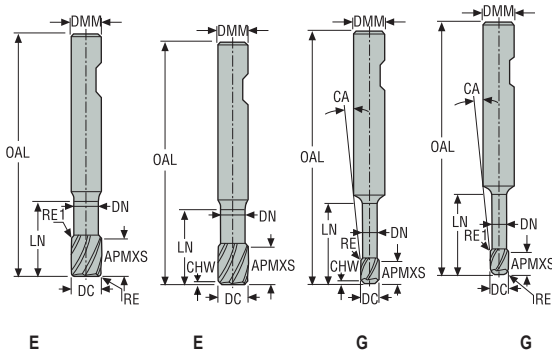
X-Heads

Minimaster Plus

Minimaster

JHP170

Hochleistungsfräser – Gehärteter Stahl – Eckfräser – 3-4 Schneiden – Weldon – Eckenradius oder Fase



- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- CHW= Ø2-Ø4=+0,05 mm
- CHW= Ø5-Ø16= +0,1 mm
- RE= ±0,05 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | CHW | RE | CA° | PCEDC | Weldon |
|-----------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|------|-----|------|-------|--------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | | | |
| 170020-MEGA-64 | 02452924 | 2 | G | 2,0 | 6,0 | 2,0 | 50,0 | 4,0 | 1,9 | 0,08 | - | 14,5 | 3 | ■ |
| 170020R020.0-MEGA-64W | 02669319 | 2 | G | 2,0 | 6,0 | 2,0 | 50,0 | 4,0 | 1,9 | - | 0,2 | - | 3 | □ |
| 170020R050.0-MEGA-64W | 02669320 | 2 | G | 2,0 | 6,0 | 2,0 | 50,0 | 4,0 | 1,9 | - | 0,5 | - | 3 | □ |
| 170030-MEGA-64 | 02452925 | 2 | G | 3,0 | 6,0 | 3,0 | 50,0 | 6,0 | 2,8 | 0,08 | - | 9,0 | 3 | ■ |
| 170030R020.0-MEGA-64W | 02669321 | 2 | G | 3,0 | 6,0 | 3,0 | 50,0 | 6,0 | 2,8 | - | 0,2 | - | 3 | □ |
| 170030R050.0-MEGA-64W | 02669322 | 2 | G | 3,0 | 6,0 | 3,0 | 50,0 | 6,0 | 2,8 | - | 0,5 | - | 3 | □ |
| 170040-MEGA-64 | 02452927 | 2 | G | 4,0 | 6,0 | 4,0 | 50,0 | 8,0 | 3,7 | 0,1 | - | 5,5 | 4 | ■ |
| 170040R020.0-MEGA-64W | 02669323 | 2 | G | 4,0 | 6,0 | 4,0 | 50,0 | 8,0 | 3,7 | - | 0,2 | - | 4 | □ |
| 170040R050.0-MEGA-64W | 02669324 | 2 | G | 4,0 | 6,0 | 4,0 | 50,0 | 8,0 | 3,7 | - | 0,5 | - | 4 | □ |
| 170050-MEGA-64 | 02452928 | 2 | G | 5,0 | 6,0 | 5,0 | 50,0 | 10,0 | 4,6 | 0,12 | - | 2,5 | 4 | ■ |
| 170050R020.0-MEGA-64W | 02669325 | 2 | G | 5,0 | 6,0 | 5,0 | 50,0 | 10,0 | 4,6 | - | 0,2 | - | 4 | □ |
| 170050R050.0-MEGA-64W | 02669326 | 2 | G | 5,0 | 6,0 | 5,0 | 50,0 | 10,0 | 4,6 | - | 0,5 | - | 4 | □ |
| 170060-MEGA-64 | 02452929 | 2 | E | 6,0 | 6,0 | 6,0 | 50,0 | 11,5 | 5,6 | 0,14 | - | - | 4 | ■ |
| 170060R020.0-MEGA-64W | 02669327 | 2 | E | 6,0 | 6,0 | 6,0 | 50,0 | 11,5 | 5,6 | - | 0,2 | - | 4 | □ |
| 170060R050.0-MEGA-64W | 02669328 | 2 | E | 6,0 | 6,0 | 6,0 | 50,0 | 11,5 | 5,6 | - | 0,5 | - | 4 | □ |
| 170080-MEGA-64 | 02452930 | 2 | E | 8,0 | 8,0 | 8,0 | 55,0 | 16,0 | 7,4 | 0,16 | - | - | 4 | ■ |
| 170080R020.0-MEGA-64W | 02669329 | 2 | E | 8,0 | 8,0 | 8,0 | 55,0 | 16,0 | 7,4 | - | 0,2 | - | 4 | □ |
| 170080R050.0-MEGA-64W | 02669331 | 2 | E | 8,0 | 8,0 | 8,0 | 55,0 | 16,0 | 7,4 | - | 0,5 | - | 4 | □ |
| 170080R100.0-MEGA-64W | 02669332 | 2 | E | 8,0 | 8,0 | 8,0 | 55,0 | 16,0 | 7,4 | - | 1,0 | - | 4 | □ |
| 170100-MEGA-64 | 02452931 | 2 | E | 10,0 | 10,0 | 10,0 | 65,0 | 22,0 | 9,4 | 0,18 | - | - | 4 | ■ |
| 170100R050.0-MEGA-64W | 02669333 | 2 | E | 10,0 | 10,0 | 10,0 | 65,0 | 22,0 | 9,4 | - | 0,5 | - | 4 | □ |
| 170100R100.0-MEGA-64W | 02669334 | 2 | E | 10,0 | 10,0 | 10,0 | 65,0 | 22,0 | 9,4 | - | 1,0 | - | 4 | □ |
| 170120-MEGA-64 | 02452932 | 2 | E | 12,0 | 12,0 | 12,0 | 75,0 | 27,0 | 11,4 | 0,2 | - | - | 4 | ■ |
| 170120R050.0-MEGA-64W | 02669335 | 2 | E | 12,0 | 12,0 | 12,0 | 75,0 | 27,0 | 11,4 | - | 0,5 | - | 4 | □ |
| 170120R100.0-MEGA-64W | 02669336 | 2 | E | 12,0 | 12,0 | 12,0 | 75,0 | 27,0 | 11,4 | - | 1,0 | - | 4 | □ |
| 170160-MEGA-64 | 02452933 | 2 | E | 16,0 | 16,0 | 16,0 | 80,0 | 29,0 | 15,4 | 0,3 | - | - | 4 | ■ |
| 170160R050.0-MEGA-64W | 02669337 | 2 | E | 16,0 | 16,0 | 16,0 | 80,0 | 29,0 | 15,4 | - | 0,5 | - | 4 | □ |
| 170200R050-MEGA-64 | 02611637 | 2 | E | 20,0 | 20,0 | 20,0 | 100,0 | 40,0 | 19,2 | - | 0,5 | - | 4 | ■ |

■ Lagerstandard. □ Weldon verfügbar. Die Lieferzeit beträgt 3 Tage.

Unversell
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

Schnittdaten – JHP170 Eckfräsen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|---------|---------|---------|--------|--------|--------|--------|-----------------|
| | | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| H3 | M | 0.150 | 0.60 | 0.0055 | 0.0085 | 0.011 | 0.014 | 0.017 | 0.022 | 0.028 | 0.034 | 0.042 | 0.048 | 29 (22 – 35) |
| | | 0,150 | 0,60 | 0,00022 | 0,00034 | 0,00044 | 0,00055 | 0,00065 | 0,00085 | 0,0011 | 0,0013 | 0,0017 | 0,0019 | 95 (73 – 110) |
| H5 | M | 0.300 | 0.80 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 60 (56 – 68) |
| | | 0,300 | 0,80 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 195 (190 – 220) |
| H7 | M | 0.150 | 0.60 | 0.0055 | 0.0085 | 0.011 | 0.014 | 0.017 | 0.022 | 0.028 | 0.034 | 0.042 | 0.048 | 29 (22 – 35) |
| | | 0,150 | 0,60 | 0,00022 | 0,00034 | 0,00044 | 0,00055 | 0,00065 | 0,00085 | 0,0011 | 0,0013 | 0,0017 | 0,0019 | 95 (73 – 110) |
| H8 | M | 0.300 | 0.80 | 0.0090 | 0.014 | 0.018 | 0.022 | 0.028 | 0.036 | 0.046 | 0.055 | 0.065 | 0.080 | 65 (59 – 71) |
| | | 0,300 | 0,80 | 0,00036 | 0,00055 | 0,00070 | 0,00085 | 0,0011 | 0,0014 | 0,0018 | 0,0022 | 0,0026 | 0,0032 | 215 (200 – 230) |
| H11 | M | 0.300 | 0.80 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 80 (71 – 86) |
| | | 0,300 | 0,80 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 260 (240 – 280) |
| H12 | M | 0.300 | 0.80 | 0.0090 | 0.014 | 0.018 | 0.022 | 0.028 | 0.036 | 0.046 | 0.055 | 0.065 | 0.080 | 75 (69 – 83) |
| | | 0,300 | 0,80 | 0,00036 | 0,00055 | 0,00070 | 0,00085 | 0,0011 | 0,0014 | 0,0018 | 0,0022 | 0,0026 | 0,0032 | 245 (230 – 270) |
| H21 | M | 0.300 | 0.80 | 0.0090 | 0.014 | 0.018 | 0.022 | 0.028 | 0.036 | 0.046 | 0.055 | 0.065 | 0.080 | 65 (59 – 71) |
| | | 0,300 | 0,80 | 0,00036 | 0,00055 | 0,00070 | 0,00085 | 0,0011 | 0,0014 | 0,0018 | 0,0022 | 0,0026 | 0,0032 | 215 (200 – 230) |
| H31 | M | 0.300 | 0.80 | 0.012 | 0.018 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 60 (56 – 68) |
| | | 0,300 | 0,80 | 0,00048 | 0,00070 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 195 (190 – 220) |

Schnittdaten – JHP170 Nutfräsen

| SMG | | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|----------------|---------|---------|---------|---------|---------|---------|---------|--------|--------|-----------------|
| | | | 2 | 3 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| H3 | M | 0.40 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.034 | 20 (16 – 25) |
| | | 0,40 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0013 | 65 (53 – 82) |
| H5 | M | 0.60 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.040 | 0.050 | 0.065 | 0.080 | 50 (46 – 55) |
| | | 0,60 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 165 (160 – 180) |
| H7 | M | 0.40 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.034 | 20 (16 – 25) |
| | | 0,40 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0013 | 65 (53 – 82) |
| H8 | M | 0.60 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.040 | 0.050 | 0.060 | 0.070 | 50 (46 – 55) |
| | | 0,60 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 165 (160 – 180) |
| H11 | M | 0.60 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.040 | 0.050 | 0.065 | 0.080 | 65 (58 – 70) |
| | | 0,60 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 215 (200 – 220) |
| H12 | M | 0.60 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.040 | 0.050 | 0.060 | 0.070 | 60 (53 – 64) |
| | | 0,60 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 195 (180 – 200) |
| H21 | M | 0.60 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.040 | 0.050 | 0.060 | 0.070 | 50 (46 – 55) |
| | | 0,60 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 0,0024 | 0,0028 | 165 (160 – 180) |
| H31 | M | 0.60 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.025 | 0.032 | 0.040 | 0.050 | 0.065 | 0.080 | 50 (46 – 55) |
| | | 0,60 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 165 (160 – 180) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

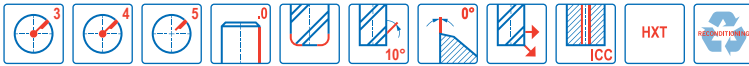
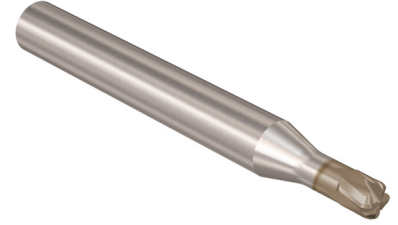
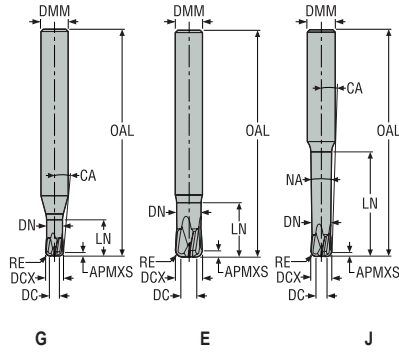
a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

JHF181

Hochvorschubfräser – Gehärteter Stahl – Eckfräser – 3-5 Schneiden – Zylindrisch – Eckenradius – ICC



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DCX | DC | DMM | APMXS | OAL | LN | DN | NA | RE | CA° | PCEDC | Zylindrisch |
|--------------------------|--------------------|------------------|-------------------|-----|------|------|------|-------|-------|------|------|-----|------|------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | mm | mm | | | |
| JHF181020G1R050.0Z4-HXT | 03067297 | 1 | G | – | 2,0 | 1,0 | 6,0 | 0,5 | 50,0 | 4,0 | 1,8 | 0,0 | 0,5 | 10,0 | 4 | ■ |
| JHF181030G1R075.0Z4-HXT | 03067298 | 1 | G | – | 3,0 | 1,5 | 6,0 | 0,75 | 50,0 | 6,0 | 2,7 | 0,0 | 0,75 | 7,5 | 4 | ■ |
| JHF181040G1R100.0Z4-HXT | 03067299 | 1 | G | – | 4,0 | 2,0 | 6,0 | 1,0 | 50,0 | 8,0 | 3,6 | 0,0 | 1,0 | 5,0 | 4 | ■ |
| JHF181060E1R150.0Z4-HXT | 03067300 | 1 | E | – | 6,0 | 3,0 | 6,0 | 1,5 | 50,0 | 12,0 | 5,4 | 0,0 | 1,5 | – | 4 | ■ |
| JHF181080E1R200.0Z4-HXT | 03067301 | 1 | E | – | 8,0 | 4,0 | 8,0 | 2,0 | 55,0 | 16,0 | 7,3 | 0,0 | 2,0 | – | 4 | ■ |
| JHF181100E1R200.0Z4-HXT | 03067302 | 1 | E | – | 10,0 | 6,0 | 10,0 | 2,0 | 65,0 | 20,0 | 9,2 | 0,0 | 2,0 | – | 4 | ■ |
| JHF181100E1R200.0Z5-HXT | 03067303 | 1 | E | – | 10,0 | 6,0 | 10,0 | 2,0 | 65,0 | 20,0 | 9,2 | 0,0 | 2,0 | – | 5 | ■ |
| JHF181120E1R300.0Z4-HXT | 03067304 | 1 | E | – | 12,0 | 6,0 | 12,0 | 3,0 | 75,0 | 24,0 | 11,0 | 0,0 | 3,0 | – | 4 | ■ |
| JHF181120E1R300.0Z5-HXT | 03067305 | 1 | E | – | 12,0 | 6,0 | 12,0 | 3,0 | 75,0 | 24,0 | 11,0 | 0,0 | 3,0 | – | 5 | ■ |
| JHF181160E1R300.0Z4-HXT | 03067306 | 1 | E | – | 16,0 | 10,0 | 16,0 | 3,0 | 80,0 | 32,0 | 14,8 | 0,0 | 3,0 | – | 4 | ■ |
| JHF181020G2R050.0Z4-HXT | 03067307 | 2 | G | – | 2,0 | 1,0 | 6,0 | 0,5 | 50,0 | 8,0 | 1,8 | 0,0 | 0,5 | 7,5 | 4 | ■ |
| JHF181030G2R075.0Z4-HXT | 03067308 | 2 | G | – | 3,0 | 1,5 | 6,0 | 0,75 | 50,0 | 12,0 | 2,7 | 0,0 | 0,75 | 5,0 | 4 | ■ |
| JHF181040G2R100.0Z4-HXT | 03067309 | 2 | G | – | 4,0 | 2,0 | 6,0 | 1,0 | 50,0 | 16,0 | 3,6 | 0,0 | 1,0 | 3,0 | 4 | ■ |
| JHF181060E2R150.0Z4A-HXT | 03067311 | 2 | E | ■ | 6,0 | 3,0 | 6,0 | 1,5 | 65,0 | 24,0 | 5,4 | 0,0 | 1,5 | – | 4 | ■ |
| JHF181060E2R150.0Z4-HXT | 03067310 | 2 | E | – | 6,0 | 3,0 | 6,0 | 1,5 | 65,0 | 24,0 | 5,4 | 0,0 | 1,5 | – | 4 | ■ |
| JHF181080E2R200.0Z4A-HXT | 03067313 | 2 | E | ■ | 8,0 | 4,0 | 8,0 | 2,0 | 70,0 | 32,0 | 7,3 | 0,0 | 2,0 | – | 4 | ■ |
| JHF181080E2R200.0Z4-HXT | 03067312 | 2 | E | – | 8,0 | 4,0 | 8,0 | 2,0 | 70,0 | 32,0 | 7,3 | 0,0 | 2,0 | – | 4 | ■ |
| JHF181100E2R200.0Z4A-HXT | 03067315 | 2 | E | ■ | 10,0 | 6,0 | 10,0 | 2,0 | 85,0 | 40,0 | 9,2 | 0,0 | 2,0 | – | 4 | ■ |
| JHF181100E2R200.0Z4-HXT | 03067314 | 2 | E | – | 10,0 | 6,0 | 10,0 | 2,0 | 85,0 | 40,0 | 9,2 | 0,0 | 2,0 | – | 4 | ■ |
| JHF181120E2R300.0Z4A-HXT | 03067317 | 2 | E | ■ | 12,0 | 6,0 | 12,0 | 3,0 | 100,0 | 48,0 | 11,0 | 0,0 | 3,0 | – | 4 | ■ |
| JHF181120E2R300.0Z4-HXT | 03067316 | 2 | E | – | 12,0 | 6,0 | 12,0 | 3,0 | 100,0 | 48,0 | 11,0 | 0,0 | 3,0 | – | 4 | ■ |
| JHF181020J3R050.0Z4-HXT | 03067318 | 3 | J | – | 2,0 | 1,0 | 6,0 | 0,5 | 50,0 | 10,0 | 1,8 | 0,9 | 0,5 | 6,8 | 4 | ■ |
| JHF181030J3R075.0Z4-HXT | 03067319 | 3 | J | – | 3,0 | 1,5 | 6,0 | 0,75 | 50,0 | 15,0 | 2,7 | 0,9 | 0,75 | 4,4 | 4 | ■ |
| JHF181040J3R100.0Z4-HXT | 03067320 | 3 | J | – | 4,0 | 2,0 | 6,0 | 1,0 | 60,0 | 20,0 | 3,6 | 0,9 | 1,0 | 2,6 | 4 | ■ |
| JHF181060J3R150.0Z4-HXT | 03067321 | 3 | J | – | 6,0 | 3,0 | 8,0 | 1,5 | 65,0 | 30,0 | 5,4 | 0,9 | 1,5 | 1,9 | 4 | ■ |
| JHF181080J3R200.0Z4-HXT | 03067325 | 3 | J | – | 8,0 | 4,0 | 10,0 | 2,0 | 85,0 | 40,0 | 7,3 | 0,9 | 2,0 | 1,5 | 4 | ■ |
| JHF181100J3R200.0Z4-HXT | 03067327 | 3 | J | – | 10,0 | 6,0 | 12,0 | 2,0 | 100,0 | 50,0 | 9,2 | 0,9 | 2,0 | 1,2 | 4 | ■ |
| JHF181020J4R050.0Z3-HXT | 03067329 | 4 | J | – | 2,0 | 1,0 | 6,0 | 0,5 | 50,0 | 14,0 | 1,8 | 0,9 | 0,5 | 5,6 | 3 | ■ |
| JHF181030J4R075.0Z3-HXT | 03067330 | 4 | J | – | 3,0 | 1,5 | 6,0 | 0,75 | 60,0 | 21,0 | 2,7 | 0,9 | 0,75 | 3,4 | 3 | ■ |
| JHF181040J4R100.0Z3-HXT | 03067331 | 4 | J | – | 4,0 | 2,0 | 6,0 | 1,0 | 65,0 | 28,0 | 3,6 | 0,9 | 1,0 | 2,0 | 3 | ■ |
| JHF181060J4R150.0Z3-HXT | 03067332 | 4 | J | – | 6,0 | 3,0 | 8,0 | 1,5 | 80,0 | 42,0 | 5,4 | 0,9 | 1,5 | 1,4 | 3 | ■ |
| JHF181080J4R200.0Z3-HXT | 03067333 | 4 | J | – | 8,0 | 4,0 | 10,0 | 2,0 | 100,0 | 56,0 | 7,3 | 0,9 | 2,0 | 1,1 | 3 | ■ |
| JHF181100J4R200.0Z3-HXT | 03067334 | 4 | J | – | 10,0 | 6,0 | 12,0 | 2,0 | 125,0 | 70,0 | 9,2 | 0,9 | 2,0 | 0,9 | 3 | ■ |

■ Lagerstandard.

Unversell
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster


Schnittdaten – JHF181 Eckfräsen/Schruppen

| SMG | | a _e /DCX | a _p /DCX | f _z | | | | | | | | v _c |
|-----|-------|---------------------|---------------------|----------------|--------|--------|--------|--------|--------|--------|--------|-------------------|
| | | | | 2 | 3 | 4 | 6 | 8 | 10 | 12 | 16 | |
| P6 | E/M/A | 0.30 | 0.040 | 0.070 | 0.10 | 0.14 | 0.20 | 0.28 | 0.34 | 0.40 | 0.55 | 305 (290 – 320) |
| | | 0,30 | 0,040 | 0,0028 | 0,0040 | 0,0055 | 0,0080 | 0,011 | 0,013 | 0,016 | 0,022 | 1000 (960 – 1000) |
| P7 | E/M/A | 0.30 | 0.040 | 0.070 | 0.10 | 0.14 | 0.20 | 0.28 | 0.34 | 0.40 | 0.55 | 290 (270 – 300) |
| | | 0,30 | 0,040 | 0,0028 | 0,0040 | 0,0055 | 0,0080 | 0,011 | 0,013 | 0,016 | 0,022 | 950 (890 – 980) |
| P8 | E/M/A | 0.30 | 0.040 | 0.070 | 0.10 | 0.14 | 0.20 | 0.28 | 0.34 | 0.40 | 0.55 | 270 (260 – 290) |
| | | 0,30 | 0,040 | 0,0028 | 0,0040 | 0,0055 | 0,0080 | 0,011 | 0,013 | 0,016 | 0,022 | 890 (860 – 950) |
| P11 | E/M/A | 0.30 | 0.040 | 0.070 | 0.10 | 0.14 | 0.20 | 0.28 | 0.34 | 0.40 | 0.55 | 280 (270 – 290) |
| | | 0,30 | 0,040 | 0,0028 | 0,0040 | 0,0055 | 0,0080 | 0,011 | 0,013 | 0,016 | 0,022 | 920 (890 – 950) |
| K1 | E/M/A | 0.30 | 0.040 | 0.070 | 0.10 | 0.14 | 0.20 | 0.28 | 0.34 | 0.40 | 0.55 | 210 (190 – 240) |
| | | 0,30 | 0,040 | 0,0028 | 0,0040 | 0,0055 | 0,0080 | 0,011 | 0,013 | 0,016 | 0,022 | 690 (630 – 780) |
| K2 | E/M/A | 0.30 | 0.040 | 0.070 | 0.10 | 0.14 | 0.20 | 0.28 | 0.34 | 0.40 | 0.55 | 185 (160 – 200) |
| | | 0,30 | 0,040 | 0,0028 | 0,0040 | 0,0055 | 0,0080 | 0,011 | 0,013 | 0,016 | 0,022 | 610 (530 – 650) |
| K3 | E/M/A | 0.30 | 0.040 | 0.070 | 0.10 | 0.14 | 0.20 | 0.28 | 0.34 | 0.40 | 0.55 | 155 (140 – 170) |
| | | 0,30 | 0,040 | 0,0028 | 0,0040 | 0,0055 | 0,0080 | 0,011 | 0,013 | 0,016 | 0,022 | 510 (460 – 550) |
| K4 | E/M/A | 0.30 | 0.040 | 0.070 | 0.10 | 0.14 | 0.20 | 0.28 | 0.34 | 0.40 | 0.55 | 150 (130 – 160) |
| | | 0,30 | 0,040 | 0,0028 | 0,0040 | 0,0055 | 0,0080 | 0,011 | 0,013 | 0,016 | 0,022 | 490 (430 – 520) |
| K5 | E/M/A | 0.30 | 0.040 | 0.050 | 0.080 | 0.10 | 0.16 | 0.20 | 0.26 | 0.32 | 0.42 | 150 (120 – 170) |
| | | 0,30 | 0,040 | 0,0020 | 0,0032 | 0,0040 | 0,0065 | 0,0080 | 0,010 | 0,013 | 0,017 | 490 (400 – 550) |
| K6 | E/M/A | 0.30 | 0.040 | 0.050 | 0.080 | 0.10 | 0.16 | 0.20 | 0.26 | 0.32 | 0.42 | 220 (180 – 260) |
| | | 0,30 | 0,040 | 0,0020 | 0,0032 | 0,0040 | 0,0065 | 0,0080 | 0,010 | 0,013 | 0,017 | 720 (600 – 850) |
| K7 | E/M/A | 0.30 | 0.040 | 0.050 | 0.080 | 0.10 | 0.16 | 0.20 | 0.26 | 0.32 | 0.42 | 190 (160 – 220) |
| | | 0,30 | 0,040 | 0,0020 | 0,0032 | 0,0040 | 0,0065 | 0,0080 | 0,010 | 0,013 | 0,017 | 620 (530 – 720) |
| S1 | E | 0.18 | 0.014 | 0.025 | 0.038 | 0.050 | 0.075 | 0.10 | 0.13 | 0.15 | 0.19 | 60 (40 – 79) |
| | | 0,18 | 0,014 | 0,0010 | 0,0015 | 0,0020 | 0,0030 | 0,0040 | 0,0050 | 0,0060 | 0,0075 | 195 (140 – 250) |
| S2 | E | 0.18 | 0.014 | 0.025 | 0.038 | 0.050 | 0.075 | 0.10 | 0.13 | 0.15 | 0.19 | 48 (33 – 64) |
| | | 0,18 | 0,014 | 0,0010 | 0,0015 | 0,0020 | 0,0030 | 0,0040 | 0,0050 | 0,0060 | 0,0075 | 155 (110 – 200) |
| S3 | E | 0.18 | 0.014 | 0.024 | 0.036 | 0.048 | 0.070 | 0.095 | 0.12 | 0.14 | 0.17 | 42 (28 – 55) |
| | | 0,18 | 0,014 | 0,00095 | 0,0014 | 0,0019 | 0,0028 | 0,0038 | 0,0048 | 0,0055 | 0,0065 | 140 (92 – 180) |
| S11 | E | 0.18 | 0.034 | 0.036 | 0.055 | 0.070 | 0.11 | 0.14 | 0.18 | 0.22 | 0.26 | 200 (180 – 220) |
| | | 0,18 | 0,034 | 0,0014 | 0,0022 | 0,0028 | 0,0044 | 0,0055 | 0,0070 | 0,0085 | 0,010 | 660 (600 – 720) |
| S12 | E | 0.18 | 0.034 | 0.036 | 0.055 | 0.070 | 0.11 | 0.14 | 0.18 | 0.22 | 0.26 | 155 (140 – 170) |
| | | 0,18 | 0,034 | 0,0014 | 0,0022 | 0,0028 | 0,0044 | 0,0055 | 0,0070 | 0,0085 | 0,010 | 510 (460 – 550) |
| S13 | E | 0.18 | 0.034 | 0.032 | 0.046 | 0.065 | 0.095 | 0.13 | 0.16 | 0.18 | 0.24 | 125 (110 – 130) |
| | | 0,18 | 0,034 | 0,0013 | 0,0018 | 0,0026 | 0,0038 | 0,0050 | 0,0065 | 0,0070 | 0,0095 | 410 (370 – 420) |
| H3 | M/A/D | 0.30 | 0.020 | 0.050 | 0.080 | 0.10 | 0.16 | 0.20 | 0.26 | 0.32 | 0.42 | 85 (73 – 96) |
| | | 0,30 | 0,020 | 0,0020 | 0,0032 | 0,0040 | 0,0065 | 0,0080 | 0,010 | 0,013 | 0,017 | 280 (240 – 310) |
| H5 | M/A/D | 0.30 | 0.040 | 0.070 | 0.10 | 0.14 | 0.20 | 0.28 | 0.34 | 0.40 | 0.55 | 165 (150 – 180) |
| | | 0,30 | 0,040 | 0,0028 | 0,0040 | 0,0055 | 0,0080 | 0,011 | 0,013 | 0,016 | 0,022 | 540 (500 – 590) |
| H7 | M/A/D | 0.30 | 0.020 | 0.050 | 0.080 | 0.10 | 0.16 | 0.20 | 0.26 | 0.32 | 0.42 | 85 (73 – 96) |
| | | 0,30 | 0,020 | 0,0020 | 0,0032 | 0,0040 | 0,0065 | 0,0080 | 0,010 | 0,013 | 0,017 | 280 (240 – 310) |
| H8 | M/A/D | 0.30 | 0.040 | 0.070 | 0.10 | 0.14 | 0.20 | 0.28 | 0.34 | 0.40 | 0.55 | 165 (150 – 180) |
| | | 0,30 | 0,040 | 0,0028 | 0,0040 | 0,0055 | 0,0080 | 0,011 | 0,013 | 0,016 | 0,022 | 540 (500 – 590) |
| H11 | M/A/D | 0.30 | 0.040 | 0.070 | 0.10 | 0.14 | 0.20 | 0.28 | 0.34 | 0.40 | 0.55 | 210 (190 – 230) |
| | | 0,30 | 0,040 | 0,0028 | 0,0040 | 0,0055 | 0,0080 | 0,011 | 0,013 | 0,016 | 0,022 | 690 (630 – 750) |
| H12 | M/A/D | 0.30 | 0.040 | 0.070 | 0.10 | 0.14 | 0.20 | 0.28 | 0.34 | 0.40 | 0.55 | 190 (180 – 210) |
| | | 0,30 | 0,040 | 0,0028 | 0,0040 | 0,0055 | 0,0080 | 0,011 | 0,013 | 0,016 | 0,022 | 620 (600 – 680) |
| H21 | M/A/D | 0.30 | 0.040 | 0.070 | 0.10 | 0.14 | 0.20 | 0.28 | 0.34 | 0.40 | 0.55 | 165 (150 – 180) |
| | | 0,30 | 0,040 | 0,0028 | 0,0040 | 0,0055 | 0,0080 | 0,011 | 0,013 | 0,016 | 0,022 | 540 (500 – 590) |
| H31 | M/A/D | 0.30 | 0.040 | 0.070 | 0.10 | 0.14 | 0.20 | 0.28 | 0.34 | 0.40 | 0.55 | 125 (120 – 130) |
| | | 0,30 | 0,040 | 0,0028 | 0,0040 | 0,0055 | 0,0080 | 0,011 | 0,013 | 0,016 | 0,022 | 410 (400 – 420) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – JHF181 Nutfräsen

| SMG |  | a _p /DCX | f _z | | | | | | | | v _c | |
|-----|---|---------------------|----------------|---------|---------|--------|--------|--------|--------|--------|-----------------|-------------------------------|
| | | | 2 | 3 | 4 | 6 | 8 | 10 | 12 | 16 | | |
| P6 | E/M/A | 0.040 | 0.042 | 0.065 | 0.085 | 0.13 | 0.17 | 0.20 | 0.25 | 0.34 | 270 (260 – 280) | Unversell |
| | | 0,040 | 0,0017 | 0,0026 | 0,0034 | 0,0050 | 0,0065 | 0,0080 | 0,010 | 0,013 | 890 (860 – 910) | |
| P7 | E/M/A | 0.040 | 0.042 | 0.065 | 0.085 | 0.13 | 0.17 | 0.20 | 0.25 | 0.34 | 255 (240 – 270) | Stahl und Guss |
| | | 0,040 | 0,0017 | 0,0026 | 0,0034 | 0,0050 | 0,0065 | 0,0080 | 0,010 | 0,013 | 840 (790 – 880) | |
| P8 | E/M/A | 0.040 | 0.042 | 0.065 | 0.085 | 0.13 | 0.17 | 0.20 | 0.25 | 0.34 | 240 (230 – 250) | Stahl und Guss |
| | | 0,040 | 0,0017 | 0,0026 | 0,0034 | 0,0050 | 0,0065 | 0,0080 | 0,010 | 0,013 | 790 (760 – 820) | |
| P11 | E/M/A | 0.040 | 0.042 | 0.065 | 0.085 | 0.13 | 0.17 | 0.20 | 0.25 | 0.34 | 250 (240 – 260) | Stahl und Guss |
| | | 0,040 | 0,0017 | 0,0026 | 0,0034 | 0,0050 | 0,0065 | 0,0080 | 0,010 | 0,013 | 820 (790 – 850) | |
| K1 | E/M/A | 0.040 | 0.042 | 0.065 | 0.085 | 0.13 | 0.17 | 0.20 | 0.25 | 0.34 | 185 (170 – 210) | Stahl und Guss |
| | | 0,040 | 0,0017 | 0,0026 | 0,0034 | 0,0050 | 0,0065 | 0,0080 | 0,010 | 0,013 | 610 (560 – 680) | |
| K2 | E/M/A | 0.040 | 0.042 | 0.065 | 0.085 | 0.13 | 0.17 | 0.20 | 0.25 | 0.34 | 160 (140 – 180) | Stahl und Guss |
| | | 0,040 | 0,0017 | 0,0026 | 0,0034 | 0,0050 | 0,0065 | 0,0080 | 0,010 | 0,013 | 520 (460 – 590) | |
| K3 | E/M/A | 0.040 | 0.042 | 0.065 | 0.085 | 0.13 | 0.17 | 0.20 | 0.25 | 0.34 | 135 (120 – 150) | Rostfrei und ISO-S-Werkstoffe |
| | | 0,040 | 0,0017 | 0,0026 | 0,0034 | 0,0050 | 0,0065 | 0,0080 | 0,010 | 0,013 | 445 (400 – 490) | |
| K4 | E/M/A | 0.040 | 0.042 | 0.065 | 0.085 | 0.13 | 0.17 | 0.20 | 0.25 | 0.34 | 130 (120 – 140) | Rostfrei und ISO-S-Werkstoffe |
| | | 0,040 | 0,0017 | 0,0026 | 0,0034 | 0,0050 | 0,0065 | 0,0080 | 0,010 | 0,013 | 425 (400 – 450) | |
| K5 | E/M/A | 0.040 | 0.030 | 0.046 | 0.060 | 0.090 | 0.12 | 0.15 | 0.18 | 0.24 | 130 (110 – 150) | Rostfrei und ISO-S-Werkstoffe |
| | | 0,040 | 0,0012 | 0,0018 | 0,0024 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0095 | 425 (370 – 490) | |
| K6 | E/M/A | 0.040 | 0.030 | 0.046 | 0.060 | 0.090 | 0.12 | 0.15 | 0.18 | 0.24 | 195 (160 – 230) | Rostfrei und ISO-S-Werkstoffe |
| | | 0,040 | 0,0012 | 0,0018 | 0,0024 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0095 | 640 (530 – 750) | |
| K7 | E/M/A | 0.040 | 0.030 | 0.046 | 0.060 | 0.090 | 0.12 | 0.15 | 0.18 | 0.24 | 170 (140 – 200) | NE-Metalle |
| | | 0,040 | 0,0012 | 0,0018 | 0,0024 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 0,0095 | 560 (460 – 650) | |
| S1 | E | 0.014 | 0.0090 | 0.014 | 0.018 | 0.028 | 0.036 | 0.046 | 0.055 | 0.070 | 48 (33 – 64) | NE-Metalle |
| | | 0,014 | 0,00036 | 0,00055 | 0,00070 | 0,0011 | 0,0014 | 0,0018 | 0,0022 | 0,0028 | 155 (110 – 200) | |
| S2 | E | 0.014 | 0.0090 | 0.014 | 0.018 | 0.028 | 0.036 | 0.046 | 0.055 | 0.070 | 39 (26 – 51) | NE-Metalle |
| | | 0,014 | 0,00036 | 0,00055 | 0,00070 | 0,0011 | 0,0014 | 0,0018 | 0,0022 | 0,0028 | 130 (86 – 160) | |
| S3 | E | 0.014 | 0.0090 | 0.014 | 0.018 | 0.028 | 0.036 | 0.046 | 0.055 | 0.070 | 33 (23 – 44) | NE-Metalle |
| | | 0,014 | 0,00036 | 0,00055 | 0,00070 | 0,0011 | 0,0014 | 0,0018 | 0,0022 | 0,0028 | 110 (76 – 140) | |
| S11 | E | 0.034 | 0.011 | 0.017 | 0.022 | 0.034 | 0.046 | 0.055 | 0.070 | 0.090 | 170 (150 – 190) | Harter |
| | | 0,034 | 0,00044 | 0,00065 | 0,00085 | 0,0013 | 0,0018 | 0,0022 | 0,0028 | 0,0036 | 560 (500 – 620) | |
| S12 | E | 0.034 | 0.011 | 0.017 | 0.022 | 0.034 | 0.046 | 0.055 | 0.070 | 0.090 | 130 (120 – 140) | Harter |
| | | 0,034 | 0,00044 | 0,00065 | 0,00085 | 0,0013 | 0,0018 | 0,0022 | 0,0028 | 0,0036 | 425 (400 – 450) | |
| S13 | E | 0.034 | 0.011 | 0.017 | 0.022 | 0.034 | 0.046 | 0.055 | 0.070 | 0.090 | 100 (89 – 110) | Harter |
| | | 0,034 | 0,00044 | 0,00065 | 0,00085 | 0,0013 | 0,0018 | 0,0022 | 0,0028 | 0,0036 | 330 (300 – 360) | |
| H3 | M/A/D | 0.020 | 0.034 | 0.050 | 0.070 | 0.10 | 0.14 | 0.17 | 0.20 | 0.28 | 75 (63 – 83) | Kunststoffe und Composite |
| | | 0,020 | 0,0013 | 0,0020 | 0,0028 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 0,011 | 245 (210 – 270) | |
| H5 | M/A/D | 0.040 | 0.042 | 0.065 | 0.085 | 0.13 | 0.17 | 0.20 | 0.25 | 0.34 | 145 (130 – 160) | Kunststoffe und Composite |
| | | 0,040 | 0,0017 | 0,0026 | 0,0034 | 0,0050 | 0,0065 | 0,0080 | 0,010 | 0,013 | 475 (430 – 520) | |
| H7 | M/A/D | 0.020 | 0.034 | 0.050 | 0.070 | 0.10 | 0.14 | 0.17 | 0.20 | 0.28 | 75 (63 – 83) | Kunststoffe und Composite |
| | | 0,020 | 0,0013 | 0,0020 | 0,0028 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 0,011 | 245 (210 – 270) | |
| H8 | M/A/D | 0.040 | 0.042 | 0.065 | 0.085 | 0.13 | 0.17 | 0.20 | 0.25 | 0.34 | 145 (130 – 160) | Kunststoffe und Composite |
| | | 0,040 | 0,0017 | 0,0026 | 0,0034 | 0,0050 | 0,0065 | 0,0080 | 0,010 | 0,013 | 475 (430 – 520) | |
| H11 | M/A/D | 0.040 | 0.042 | 0.065 | 0.085 | 0.13 | 0.17 | 0.20 | 0.25 | 0.34 | 185 (170 – 200) | Kunststoffe und Composite |
| | | 0,040 | 0,0017 | 0,0026 | 0,0034 | 0,0050 | 0,0065 | 0,0080 | 0,010 | 0,013 | 610 (560 – 650) | |
| H12 | M/A/D | 0.040 | 0.042 | 0.065 | 0.085 | 0.13 | 0.17 | 0.20 | 0.25 | 0.34 | 170 (160 – 180) | Graphit |
| | | 0,040 | 0,0017 | 0,0026 | 0,0034 | 0,0050 | 0,0065 | 0,0080 | 0,010 | 0,013 | 560 (530 – 590) | |
| H21 | M/A/D | 0.040 | 0.042 | 0.065 | 0.085 | 0.13 | 0.17 | 0.20 | 0.25 | 0.34 | 145 (130 – 160) | Graphit |
| | | 0,040 | 0,0017 | 0,0026 | 0,0034 | 0,0050 | 0,0065 | 0,0080 | 0,010 | 0,013 | 475 (430 – 520) | |
| H31 | M/A/D | 0.040 | 0.042 | 0.065 | 0.085 | 0.13 | 0.17 | 0.20 | 0.25 | 0.34 | 110 (98 – 120) | Graphit |
| | | 0,040 | 0,0017 | 0,0026 | 0,0034 | 0,0050 | 0,0065 | 0,0080 | 0,010 | 0,013 | 360 (330 – 390) | |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

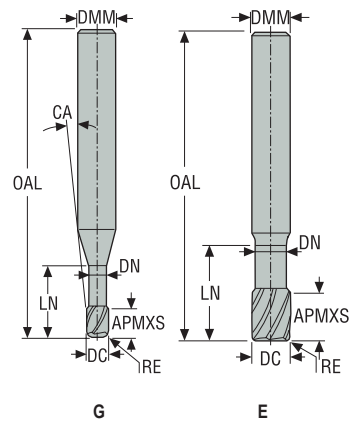
a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

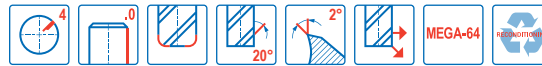
Unversell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
NE-Metalle
Harter
Harter
Kunststoffe und Composite
Kunststoffe und Composite
Graphit
Graphit
X-Heads
X-Heads
Minimaster Plus
Minimaster Plus
Minimaster
Minimaster

JH120

Hochgeschwindigkeitsfräsen – Gehärteter Stahl – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,03 mm
- RE= ±0,01 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | CA° | PCEDC | Zylindrisch |
|----------------|--------------------|------------------|-------------------|------|------|-------|------|------|------|------|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | | |
| 120020-MEGA-64 | 00019437 | 2 | G | 2,0 | 6,0 | 2,5 | 50,0 | 5,0 | 1,9 | 0,2 | 10,5 | 4 | ■ |
| 120025-MEGA-64 | 00019448 | 2 | G | 2,5 | 6,0 | 3,0 | 50,0 | 6,0 | 2,4 | 0,25 | 8,5 | 4 | ■ |
| 120030-MEGA-64 | 00019450 | 2 | G | 3,0 | 6,0 | 4,0 | 50,0 | 7,0 | 2,8 | 0,3 | 7,0 | 4 | ■ |
| 120035-MEGA-64 | 00019460 | 2 | G | 3,5 | 6,0 | 4,5 | 50,0 | 8,0 | 3,2 | 0,35 | 5,5 | 4 | ■ |
| 120040-MEGA-64 | 00019462 | 2 | G | 4,0 | 6,0 | 5,0 | 50,0 | 9,0 | 3,7 | 0,4 | 4,5 | 4 | ■ |
| 120050-MEGA-64 | 00019476 | 2 | G | 5,0 | 6,0 | 6,0 | 50,0 | 12,0 | 4,6 | 0,5 | 2,5 | 4 | ■ |
| 120060-MEGA-64 | 00019479 | 2 | E | 6,0 | 6,0 | 7,0 | 55,0 | 14,0 | 5,6 | 0,6 | - | 4 | ■ |
| 120080-MEGA-64 | 00019481 | 2 | E | 8,0 | 8,0 | 10,0 | 60,0 | 18,0 | 7,4 | 0,8 | - | 4 | ■ |
| 120100-MEGA-64 | 00019494 | 2 | E | 10,0 | 10,0 | 12,0 | 70,0 | 25,0 | 9,4 | 1,0 | - | 4 | ■ |
| 120120-MEGA-64 | 00019501 | 2 | E | 12,0 | 12,0 | 15,0 | 80,0 | 30,0 | 11,4 | 1,2 | - | 4 | ■ |
| 120160-MEGA-64 | 00019503 | 2 | E | 16,0 | 16,0 | 18,0 | 90,0 | 35,0 | 15,4 | 1,6 | - | 4 | ■ |

■ Lagerstandard.

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NE-Metalle

Harter

Kunststoffe und
Composite


Graphit

X-Heads


Minimaster Plus

Minimaster

Schnittdaten – JH120 Eckfräsen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|---------|---------|---------|--------|--------|--------|--------|--------|------------------|
| | | | | 2 | 2.5 | 3 | 3.5 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | |
| H3 | M | 0.0150 | 0.50 | 0.0095 | 0.012 | 0.014 | 0.016 | 0.019 | 0.024 | 0.028 | 0.038 | 0.048 | 0.055 | 0.070 | 90 (57 – 130) |
| | | 0,0150 | 0,50 | 0,00038 | 0,00048 | 0,00055 | 0,00065 | 0,00075 | 0,00095 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 0,0028 | 295 (190 – 420) |
| H5 | M | 0.0300 | 1.0 | 0.012 | 0.015 | 0.018 | 0.020 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 215 (180 – 250) |
| | | 0,0300 | 1,0 | 0,00048 | 0,00060 | 0,00070 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 710 (600 – 820) |
| H7 | M | 0.0150 | 0.50 | 0.0095 | 0.012 | 0.014 | 0.016 | 0.019 | 0.024 | 0.028 | 0.038 | 0.048 | 0.055 | 0.070 | 90 (57 – 130) |
| | | 0,0150 | 0,50 | 0,00038 | 0,00048 | 0,00055 | 0,00065 | 0,00075 | 0,00095 | 0,0011 | 0,0015 | 0,0019 | 0,0022 | 0,0028 | 295 (190 – 420) |
| H8 | M | 0.0300 | 1.0 | 0.012 | 0.015 | 0.018 | 0.020 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 215 (180 – 250) |
| | | 0,0300 | 1,0 | 0,00048 | 0,00060 | 0,00070 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 710 (600 – 820) |
| H11 | M | 0.0300 | 1.0 | 0.012 | 0.015 | 0.018 | 0.020 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 275 (230 – 320) |
| | | 0,0300 | 1,0 | 0,00048 | 0,00060 | 0,00070 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 900 (760 – 1000) |
| H12 | M | 0.0300 | 1.0 | 0.012 | 0.015 | 0.018 | 0.020 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 250 (210 – 290) |
| | | 0,0300 | 1,0 | 0,00048 | 0,00060 | 0,00070 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 820 (690 – 950) |
| H21 | M | 0.0300 | 1.0 | 0.012 | 0.015 | 0.018 | 0.020 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 215 (180 – 250) |
| | | 0,0300 | 1,0 | 0,00048 | 0,00060 | 0,00070 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 710 (600 – 820) |
| H31 | M | 0.0300 | 1.0 | 0.012 | 0.015 | 0.018 | 0.020 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.095 | 135 (120 – 150) |
| | | 0,0300 | 1,0 | 0,00048 | 0,00060 | 0,00070 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0038 | 445 (400 – 490) |

Schnittdaten – JH120 Nutfräsen

| SMG |  | a _p /DC | f _z | | | | | | | | | | | v _c |
|-----|---|--------------------|----------------|---------|---------|---------|---------|---------|---------|---------|--------|--------|--------|-----------------|
| | | | 2 | 2.5 | 3 | 3.5 | 4 | 5 | 6 | 8 | 10 | 12 | 16 | |
| H3 | M | 0.050 | 0.0050 | 0.0065 | 0.0075 | 0.0090 | 0.010 | 0.013 | 0.015 | 0.020 | 0.025 | 0.030 | 0.038 | 55 (34 – 78) |
| | | 0,050 | 0,00020 | 0,00026 | 0,00030 | 0,00036 | 0,00040 | 0,00050 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0015 | 180 (120 – 250) |
| H5 | M | 0.18 | 0.0080 | 0.010 | 0.012 | 0.014 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 120 (98 – 140) |
| | | 0,18 | 0,00032 | 0,00040 | 0,00048 | 0,00055 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 395 (330 – 450) |
| H7 | M | 0.050 | 0.0050 | 0.0065 | 0.0075 | 0.0090 | 0.010 | 0.013 | 0.015 | 0.020 | 0.025 | 0.030 | 0.038 | 55 (34 – 78) |
| | | 0,050 | 0,00020 | 0,00026 | 0,00030 | 0,00036 | 0,00040 | 0,00050 | 0,00060 | 0,00080 | 0,0010 | 0,0012 | 0,0015 | 180 (120 – 250) |
| H8 | M | 0.18 | 0.0060 | 0.0075 | 0.0090 | 0.011 | 0.012 | 0.015 | 0.018 | 0.025 | 0.030 | 0.036 | 0.044 | 125 (110 – 140) |
| | | 0,18 | 0,00024 | 0,00030 | 0,00036 | 0,00044 | 0,00048 | 0,00060 | 0,00070 | 0,0010 | 0,0012 | 0,0014 | 0,0017 | 410 (370 – 450) |
| H11 | M | 0.18 | 0.0080 | 0.010 | 0.012 | 0.014 | 0.016 | 0.020 | 0.024 | 0.032 | 0.040 | 0.048 | 0.060 | 150 (130 – 170) |
| | | 0,18 | 0,00032 | 0,00040 | 0,00048 | 0,00055 | 0,00065 | 0,00080 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0024 | 490 (430 – 550) |
| H12 | M | 0.18 | 0.0060 | 0.0075 | 0.0090 | 0.011 | 0.012 | 0.015 | 0.018 | 0.025 | 0.030 | 0.036 | 0.044 | 145 (120 – 170) |
| | | 0,18 | 0,00024 | 0,00030 | 0,00036 | 0,00044 | 0,00048 | 0,00060 | 0,00070 | 0,0010 | 0,0012 | 0,0014 | 0,0017 | 475 (400 – 550) |
| H21 | M | 0.18 | 0.0060 | 0.0075 | 0.0090 | 0.011 | 0.012 | 0.015 | 0.018 | 0.025 | 0.030 | 0.036 | 0.044 | 125 (110 – 140) |
| | | 0,18 | 0,00024 | 0,00030 | 0,00036 | 0,00044 | 0,00048 | 0,00060 | 0,00070 | 0,0010 | 0,0012 | 0,0014 | 0,0017 | 410 (370 – 450) |
| H31 | M | 0.18 | 0.0055 | 0.0065 | 0.0080 | 0.0090 | 0.011 | 0.013 | 0.016 | 0.022 | 0.026 | 0.032 | 0.038 | 80 (70 – 92) |
| | | 0,18 | 0,00022 | 0,00026 | 0,00032 | 0,00036 | 0,00044 | 0,00050 | 0,00065 | 0,00085 | 0,0010 | 0,0013 | 0,0015 | 260 (230 – 300) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

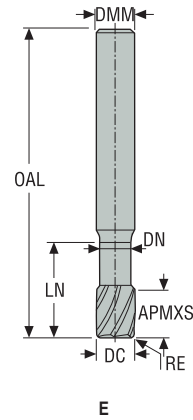
a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

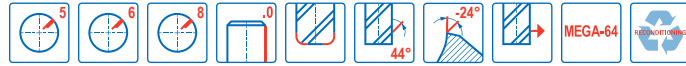
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ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

JH130

Hochgeschwindigkeitsfräsen – Gehärteter Stahl – Eckfräser – 5-8 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|----------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| 130060-MEGA-64 | 00019504 | 2 | E | 6,0 | 6,0 | 6,0 | 55,0 | 12,0 | 5,6 | 0,2 | 5 | ■ |
| 130080-MEGA-64 | 00019507 | 2 | E | 8,0 | 8,0 | 8,0 | 60,0 | 16,0 | 7,4 | 0,2 | 5 | ■ |
| 130100-MEGA-64 | 00019511 | 2 | E | 10,0 | 10,0 | 10,0 | 70,0 | 20,0 | 9,4 | 0,3 | 6 | ■ |
| 130120-MEGA-64 | 00019512 | 2 | E | 12,0 | 12,0 | 12,0 | 80,0 | 24,0 | 11,4 | 0,5 | 6 | ■ |
| 130160-MEGA-64 | 00019514 | 2 | E | 16,0 | 16,0 | 16,0 | 90,0 | 30,0 | 15,4 | 0,5 | 8 | ■ |
| 130200-MEGA-64 | 00019542 | 2 | E | 20,0 | 20,0 | 20,0 | 100,0 | 35,0 | 19,2 | 0,5 | 8 | ■ |

■ Lagerstandard.

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Stahl und Guss

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NE-Metalle

Harter

Kunststoffe und
Composite


Graphit

X-Heads


Minimaster Plus

Minimaster

Schnittdaten – JH130 Eckfräsen/Schlichten

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|--------|--------|--------|-------------------|
| | | | | 6 | 8 | 10 | 12 | 16 | 20 | |
| H3 | M | 0.0300 | 0.50 | 0.013 | 0.018 | 0.022 | 0.026 | 0.032 | 0.038 | 85 (73 – 93) |
| | | 0.0300 | 0.50 | 0,00050 | 0,00070 | 0,00085 | 0,0010 | 0,0013 | 0,0015 | 280 (240 – 300) |
| H5 | M | 0.0300 | 1.0 | 0.032 | 0.042 | 0.050 | 0.060 | 0.075 | 0.090 | 255 (240 – 270) |
| | | 0.0300 | 1,0 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 840 (790 – 880) |
| H7 | M | 0.0300 | 0.50 | 0.013 | 0.018 | 0.022 | 0.026 | 0.032 | 0.038 | 85 (73 – 93) |
| | | 0.0300 | 0,50 | 0,00050 | 0,00070 | 0,00085 | 0,0010 | 0,0013 | 0,0015 | 280 (240 – 300) |
| H8 | M | 0.0300 | 1.0 | 0.024 | 0.032 | 0.040 | 0.046 | 0.060 | 0.065 | 260 (240 – 270) |
| | | 0.0300 | 1,0 | 0,00095 | 0,0013 | 0,0016 | 0,0018 | 0,0024 | 0,0026 | 850 (790 – 880) |
| H11 | M | 0.0300 | 1.0 | 0.032 | 0.042 | 0.050 | 0.060 | 0.075 | 0.090 | 320 (300 – 340) |
| | | 0.0300 | 1,0 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 1050 (990 – 1100) |
| H12 | M | 0.0300 | 1.0 | 0.024 | 0.032 | 0.040 | 0.046 | 0.060 | 0.065 | 300 (280 – 320) |
| | | 0.0300 | 1,0 | 0,00095 | 0,0013 | 0,0016 | 0,0018 | 0,0024 | 0,0026 | 980 (920 – 1000) |
| H21 | M | 0.0300 | 1.0 | 0.024 | 0.032 | 0.040 | 0.046 | 0.060 | 0.065 | 260 (240 – 270) |
| | | 0.0300 | 1,0 | 0,00095 | 0,0013 | 0,0016 | 0,0018 | 0,0024 | 0,0026 | 850 (790 – 880) |
| H31 | M | 0.0300 | 1.0 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 155 (140 – 170) |
| | | 0.0300 | 1,0 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 510 (460 – 550) |

Schnittdaten – JH130 Eckfräsen/Schuppen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|--------|--------|--------|-------------------|
| | | | | 6 | 8 | 10 | 12 | 16 | 20 | |
| H3 | M | 0.0300 | 0.50 | 0.013 | 0.018 | 0.022 | 0.026 | 0.032 | 0.038 | 85 (73 – 93) |
| | | 0.0300 | 0,50 | 0,00050 | 0,00070 | 0,00085 | 0,0010 | 0,0013 | 0,0015 | 280 (240 – 300) |
| H5 | M | 0.0300 | 1.0 | 0.032 | 0.042 | 0.050 | 0.060 | 0.075 | 0.090 | 255 (240 – 270) |
| | | 0.0300 | 1,0 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 840 (790 – 880) |
| H7 | M | 0.0300 | 0.50 | 0.013 | 0.018 | 0.022 | 0.026 | 0.032 | 0.038 | 85 (73 – 93) |
| | | 0.0300 | 0,50 | 0,00050 | 0,00070 | 0,00085 | 0,0010 | 0,0013 | 0,0015 | 280 (240 – 300) |
| H8 | M | 0.0300 | 1.0 | 0.024 | 0.032 | 0.040 | 0.046 | 0.060 | 0.065 | 260 (240 – 270) |
| | | 0.0300 | 1,0 | 0,00095 | 0,0013 | 0,0016 | 0,0018 | 0,0024 | 0,0026 | 850 (790 – 880) |
| H11 | M | 0.0300 | 1.0 | 0.032 | 0.042 | 0.050 | 0.060 | 0.075 | 0.090 | 320 (300 – 340) |
| | | 0.0300 | 1,0 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 1050 (990 – 1100) |
| H12 | M | 0.0300 | 1.0 | 0.024 | 0.032 | 0.040 | 0.046 | 0.060 | 0.065 | 300 (280 – 320) |
| | | 0.0300 | 1,0 | 0,00095 | 0,0013 | 0,0016 | 0,0018 | 0,0024 | 0,0026 | 980 (920 – 1000) |
| H21 | M | 0.0300 | 1.0 | 0.024 | 0.032 | 0.040 | 0.046 | 0.060 | 0.065 | 260 (240 – 270) |
| | | 0.0300 | 1,0 | 0,00095 | 0,0013 | 0,0016 | 0,0018 | 0,0024 | 0,0026 | 850 (790 – 880) |
| H31 | M | 0.0300 | 1.0 | 0.030 | 0.040 | 0.050 | 0.060 | 0.075 | 0.085 | 155 (140 – 170) |
| | | 0.0300 | 1,0 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 510 (460 – 550) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

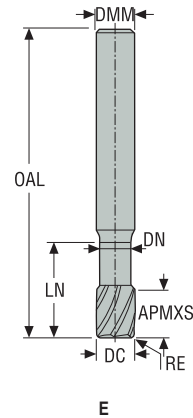
X-Heads

Minimaster Plus

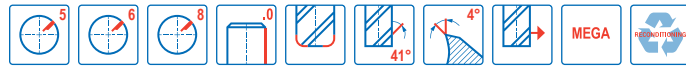
Minimaster

JH930

Hochgeschwindigkeitsfräsen – Universell – Eckfräser – 5-8 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,05 mm
- Nachschleifen möglich



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|-----------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| 930060R020-MEGA | 00022026 | 2 | E | 6,0 | 6,0 | 9,0 | 55,0 | 15,0 | 5,6 | 0,2 | 5 | ■ |
| 930060R050-MEGA | 00022027 | 2 | E | 6,0 | 6,0 | 9,0 | 55,0 | 15,0 | 5,6 | 0,5 | 5 | ■ |
| 930080R020-MEGA | 00022028 | 2 | E | 8,0 | 8,0 | 12,0 | 60,0 | 18,0 | 7,4 | 0,2 | 5 | ■ |
| 930080R050-MEGA | 00022029 | 2 | E | 8,0 | 8,0 | 12,0 | 60,0 | 18,0 | 7,4 | 0,5 | 5 | ■ |
| 930100R030-MEGA | 00022030 | 2 | E | 10,0 | 10,0 | 15,0 | 70,0 | 25,0 | 9,4 | 0,3 | 6 | ■ |
| 930100R100-MEGA | 00022031 | 2 | E | 10,0 | 10,0 | 15,0 | 70,0 | 25,0 | 9,4 | 1,0 | 6 | ■ |
| 930120R050-MEGA | 00022033 | 2 | E | 12,0 | 12,0 | 18,0 | 80,0 | 30,0 | 11,4 | 0,5 | 6 | ■ |
| 930120R100-MEGA | 00022034 | 2 | E | 12,0 | 12,0 | 18,0 | 80,0 | 30,0 | 11,4 | 1,0 | 6 | ■ |
| 930160R050-MEGA | 00022035 | 2 | E | 16,0 | 16,0 | 24,0 | 90,0 | 35,0 | 15,4 | 0,5 | 8 | ■ |
| 930160R100-MEGA | 00022040 | 2 | E | 16,0 | 16,0 | 24,0 | 90,0 | 35,0 | 15,4 | 1,0 | 8 | ■ |
| 930200R050-MEGA | 00022044 | 2 | E | 20,0 | 20,0 | 30,0 | 100,0 | 38,0 | 19,2 | 0,5 | 8 | ■ |

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Composite


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X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JH930 Eckfräsen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | v _c |
|-----|---|--------------------|--------------------|------------------|------------------|-----------------|-----------------|-----------------|-----------------|---------------------------------------|
| | | | | 6 | 8 | 10 | 12 | 16 | 20 | |
| P1 | M/E/A | 0,0400 0,0400 | 0,70 0,70 | 0,065 0,0026 | 0,085 0,0034 | 0,11 0,0044 | 0,13 0,0050 | 0,16 0,0065 | 0,18 0,0070 | 440 (370 – 490) 1450 (1300 – 1600) |
| P2 | M/E/A | 0,0400 0,0400 | 0,70 0,70 | 0,065 0,0026 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,16 0,0065 | 0,19 0,0075 | 430 (360 – 480) 1400 (1200 – 1500) |
| P3 | M/E/A | 0,0400 0,0400 | 0,70 0,70 | 0,060 0,0024 | 0,085 0,0034 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,18 0,0070 | 375 (320 – 420) 1225 (1100 – 1300) |
| P4 | M/E/A | 0,0400 0,0400 | 0,70 0,70 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 330 (280 – 370) 1075 (920 – 1200) |
| P5 | M/E/A | 0,0400 0,0400 | 0,70 0,70 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 315 (270 – 350) 1025 (890 – 1100) |
| P6 | M/E/A | 0,0400 0,0400 | 0,70 0,70 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 355 (300 – 390) 1175 (990 – 1200) |
| P7 | M/E/A | 0,0400 0,0400 | 0,70 0,70 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 335 (280 – 370) 1100 (920 – 1200) |
| P8 | M/E/A | 0,0400 0,0400 | 0,70 0,70 | 0,060 0,0024 | 0,085 0,0034 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,18 0,0070 | 315 (270 – 350) 1025 (890 – 1100) |
| P11 | M/E/A | 0,0400 0,0400 | 0,70 0,70 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 325 (280 – 360) 1075 (920 – 1100) |
| P12 | M/E/A | 0,0400 0,0400 | 0,70 0,70 | 0,040 0,0016 | 0,055 0,0022 | 0,070 0,0028 | 0,080 0,0032 | 0,10 0,0040 | 0,11 0,0044 | 200 (170 – 220) 660 (560 – 720) |
| K1 | E/M/A | 0,0400 0,0400 | 0,70 0,70 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 255 (210 – 300) 840 (690 – 980) |
| K2 | E/M/A | 0,0400 0,0400 | 0,70 0,70 | 0,055 0,0022 | 0,075 0,0030 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,15 0,0060 | 225 (180 – 260) 740 (600 – 850) |
| K3 | E/M/A | 0,0400 0,0400 | 0,70 0,70 | 0,055 0,0022 | 0,075 0,0030 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,15 0,0060 | 190 (160 – 220) 620 (530 – 720) |
| K4 | E/M/A | 0,0400 0,0400 | 0,70 0,70 | 0,055 0,0022 | 0,075 0,0030 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,15 0,0060 | 180 (150 – 210) 590 (500 – 680) |
| K5 | E/M/A | 0,0300 0,0300 | 0,50 0,50 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 205 (160 – 250) 670 (530 – 820) |
| K6 | E/M/A | 0,0300 0,0300 | 0,50 0,50 | 0,065 0,0026 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,16 0,0065 | 0,19 0,0075 | 300 (230 – 370) 980 (760 – 1200) |
| K7 | E/M/A | 0,0300 0,0300 | 0,50 0,50 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 260 (200 – 320) 850 (660 – 1000) |
| S1 | E/M/A | 0,0300 0,0300 | 0,44 0,44 | 0,055 0,0022 | 0,070 0,0028 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,15 0,0060 | 80 (62 – 100) 260 (210 – 320) |
| S2 | E/M/A | 0,0300 0,0300 | 0,44 0,44 | 0,055 0,0022 | 0,070 0,0028 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,15 0,0060 | 65 (50 – 82) 215 (170 – 260) |
| S3 | E/M/A | 0,0200 0,0200 | 0,70 0,70 | 0,055 0,0022 | 0,070 0,0028 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,15 0,0060 | 41 (31 – 50) 135 (110 – 160) |
| S11 | E/M/A | 0,0400 0,0400 | 0,70 0,70 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 160 (140 – 180) 520 (460 – 590) |
| S12 | E/M/A | 0,0400 0,0400 | 0,70 0,70 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 120 (110 – 140) 395 (370 – 450) |
| S13 | E/M/A | 0,0400 0,0400 | 0,70 0,70 | 0,050 0,0020 | 0,070 0,0028 | 0,085 0,0034 | 0,10 0,0040 | 0,13 0,0050 | 0,15 0,0060 | 95 (81 – 110) 310 (270 – 360) |
| H3 | M/A | 0,0200 0,0200 | 0,50 0,50 | 0,018 0,00070 | 0,024 0,00095 | 0,030 0,0012 | 0,036 0,0014 | 0,044 0,0017 | 0,050 0,0020 | 55 (41 – 71) 180 (140 – 230) |
| H5 | M/A | 0,0300 0,0300 | 0,50 0,50 | 0,024 0,00095 | 0,032 0,0013 | 0,040 0,0016 | 0,048 0,0019 | 0,060 0,0024 | 0,070 0,0028 | 250 (210 – 300) 820 (690 – 980) |
| H7 | M/A | 0,0200 0,0200 | 0,50 0,50 | 0,018 0,00070 | 0,024 0,00095 | 0,030 0,0012 | 0,036 0,0014 | 0,044 0,0017 | 0,050 0,0020 | 55 (41 – 71) 180 (140 – 230) |
| H8 | M/A | 0,0300 0,0300 | 0,50 0,50 | 0,018 0,00070 | 0,024 0,00095 | 0,030 0,0012 | 0,036 0,0014 | 0,044 0,0017 | 0,050 0,0020 | 255 (210 – 300) 840 (690 – 980) |
| H11 | M/A | 0,0300 0,0300 | 0,50 0,50 | 0,024 0,00095 | 0,032 0,0013 | 0,040 0,0016 | 0,048 0,0019 | 0,060 0,0024 | 0,070 0,0028 | 320 (260 – 380) 1050 (860 – 1200) |
| H12 | M/A | 0,0400 0,0400 | 0,70 0,70 | 0,030 0,0012 | 0,042 0,0017 | 0,050 0,0020 | 0,060 0,0024 | 0,075 0,0030 | 0,085 0,0034 | 270 (220 – 320) 890 (730 – 1000) |
| H21 | M/A | 0,0300 0,0300 | 0,50 0,50 | 0,018 0,00070 | 0,024 0,00095 | 0,030 0,0012 | 0,036 0,0014 | 0,044 0,0017 | 0,050 0,0020 | 255 (210 – 300) 840 (690 – 980) |
| H31 | M/A | 0,0300 0,0300 | 0,50 0,50 | 0,024 0,00095 | 0,032 0,0013 | 0,040 0,0016 | 0,048 0,0019 | 0,060 0,0024 | 0,070 0,0028 | 155 (130 – 180) 510 (430 – 590) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

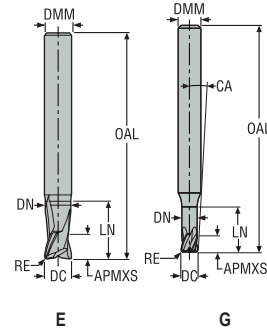
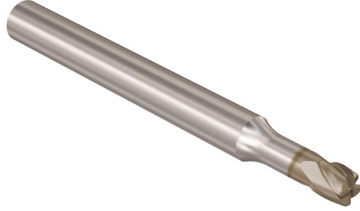
a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Universell
Stahl und Guss
Stahl und Guss
Rohtrenn- und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

JH142

Hochgeschwindigkeitsfräsen – Hochpräzise – Torisch – Gehärteter Stahl – 2-6 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- Rundlaufabweichung = <math><0,005\text{ mm}</math>
- DMM = h5
- DC= 0-0,01 mm
- RE= $\pm 0,005\text{ mm}$
- Nachschleifen möglich, wenn DC $\geq \varnothing 6$ ist



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | CA° | PCEDC | Zylindrisch |
|------------------------|----------------|--------------|---------------|------|------|-------|------|------|------|-----|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | | |
| JH142020G2R030.0Z2-HXT | 02968223 | 2 | G | 2,0 | 4,0 | 2,0 | 40,0 | 6,0 | 1,9 | 0,3 | 6,64 | 2 | ■ |
| JH142020G2R030.0Z4-HXT | 02968224 | 2 | G | 2,0 | 4,0 | 2,0 | 40,0 | 6,0 | 1,9 | 0,3 | 6,64 | 4 | ■ |
| JH142020G2R050.0Z2-HXT | 02968225 | 2 | G | 2,0 | 4,0 | 2,0 | 40,0 | 6,0 | 1,9 | 0,5 | 6,79 | 2 | ■ |
| JH142020G2R050.0Z4-HXT | 02968226 | 2 | G | 2,0 | 4,0 | 2,0 | 40,0 | 6,0 | 1,9 | 0,5 | 6,79 | 4 | ■ |
| JH142030G2R050.0Z2-HXT | 02968227 | 2 | G | 3,0 | 4,0 | 3,0 | 40,0 | 8,0 | 2,8 | 0,5 | 2,95 | 2 | ■ |
| JH142030G2R050.0Z4-HXT | 02968228 | 2 | G | 3,0 | 4,0 | 3,0 | 40,0 | 8,0 | 2,8 | 0,5 | 2,95 | 4 | ■ |
| JH142030G2R100.0Z2-HXT | 02968229 | 2 | G | 3,0 | 4,0 | 3,0 | 40,0 | 8,0 | 2,8 | 1,0 | 3,1 | 2 | ■ |
| JH142030G2R100.0Z4-HXT | 02968230 | 2 | G | 3,0 | 4,0 | 3,0 | 40,0 | 8,0 | 2,8 | 1,0 | 3,1 | 4 | ■ |
| JH142040G2R030.0Z2-HXT | 02968231 | 2 | G | 4,0 | 6,0 | 4,0 | 50,0 | 8,0 | 3,7 | 0,3 | 5,34 | 2 | ■ |
| JH142040G2R030.0Z4-HXT | 02970110 | 2 | G | 4,0 | 6,0 | 4,0 | 50,0 | 8,0 | 3,7 | 0,3 | 5,34 | 4 | ■ |
| JH142040G2R050.0Z4-HXT | 02968232 | 2 | G | 4,0 | 6,0 | 4,0 | 50,0 | 8,0 | 3,7 | 0,5 | 5,44 | 4 | ■ |
| JH142040G2R100.0Z4-HXT | 02968233 | 2 | G | 4,0 | 6,0 | 4,0 | 50,0 | 8,0 | 3,7 | 1,0 | 5,69 | 4 | ■ |
| JH142060E2R050.0Z4-HXT | 02968235 | 2 | E | 6,0 | 6,0 | 6,0 | 50,0 | 12,0 | 5,6 | 0,5 | - | 4 | ■ |
| JH142060E2R100.0Z4-HXT | 02968237 | 2 | E | 6,0 | 6,0 | 6,0 | 50,0 | 12,0 | 5,6 | 1,0 | - | 4 | ■ |
| JH142060E2R100.0Z5-HXT | 02968238 | 2 | E | 6,0 | 6,0 | 6,0 | 50,0 | 12,0 | 5,6 | 1,0 | - | 5 | ■ |
| JH142060E2R150.0Z5-HXT | 02968240 | 2 | E | 6,0 | 6,0 | 6,0 | 50,0 | 12,0 | 5,6 | 1,5 | - | 5 | ■ |
| JH142060E2R200.0Z5-HXT | 02968241 | 2 | E | 6,0 | 6,0 | 6,0 | 50,0 | 12,0 | 5,6 | 2,0 | - | 5 | ■ |
| JH142080E2R050.0Z5-HXT | 02968242 | 2 | E | 8,0 | 8,0 | 8,0 | 60,0 | 16,0 | 7,4 | 0,5 | - | 5 | ■ |
| JH142080E2R100.0Z5-HXT | 02968243 | 2 | E | 8,0 | 8,0 | 8,0 | 60,0 | 16,0 | 7,4 | 1,0 | - | 5 | ■ |
| JH142080E2R150.0Z5-HXT | 02968244 | 2 | E | 8,0 | 8,0 | 8,0 | 60,0 | 16,0 | 7,4 | 1,5 | - | 5 | ■ |
| JH142080E2R200.0Z5-HXT | 02968245 | 2 | E | 8,0 | 8,0 | 8,0 | 60,0 | 16,0 | 7,4 | 2,0 | - | 5 | ■ |
| JH142080E2R300.0Z5-HXT | 02968246 | 2 | E | 8,0 | 8,0 | 8,0 | 60,0 | 16,0 | 7,4 | 3,0 | - | 5 | ■ |
| JH142100E2R050.0Z5-HXT | 02968247 | 2 | E | 10,0 | 10,0 | 10,0 | 70,0 | 20,0 | 9,4 | 0,5 | - | 5 | ■ |
| JH142100E2R100.0Z5-HXT | 02968248 | 2 | E | 10,0 | 10,0 | 10,0 | 70,0 | 20,0 | 9,4 | 1,0 | - | 5 | ■ |
| JH142100E2R200.0Z5-HXT | 02968249 | 2 | E | 10,0 | 10,0 | 10,0 | 70,0 | 20,0 | 9,4 | 2,0 | - | 5 | ■ |
| JH142100E2R250.0Z5-HXT | 02968250 | 2 | E | 10,0 | 10,0 | 10,0 | 70,0 | 20,0 | 9,4 | 2,5 | - | 5 | ■ |
| JH142120E2R100.0Z6-HXT | 02968251 | 2 | E | 12,0 | 12,0 | 12,0 | 75,0 | 24,0 | 11,4 | 1,0 | - | 6 | ■ |
| JH142120E2R200.0Z6-HXT | 02968252 | 2 | E | 12,0 | 12,0 | 12,0 | 75,0 | 24,0 | 11,4 | 2,0 | - | 6 | ■ |
| JH142120E2R300.0Z6-HXT | 02968253 | 2 | E | 12,0 | 12,0 | 12,0 | 75,0 | 24,0 | 11,4 | 3,0 | - | 6 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

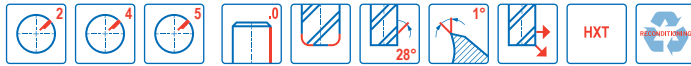
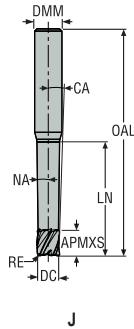
X-Heads

Minimaster Plus

Minimaster

JH142

Hochgeschwindigkeitsfräsen – Hochpräzise – Torisch – Gehärteter Stahl – 2-5 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | CA° | PCEDC | Zylindrisch |
|------------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|-----|-----|------|-------|-------------|
| | | | | | | | | | | | | | |
| JH142020J3R030.0Z2-HXT | 02968255 | 3 | J | 2,0 | 6,0 | 2,0 | 60,0 | 10,0 | 1,9 | 0,3 | 6,72 | 2 | ■ |
| JH142020J3R030.0Z4-HXT | 02968256 | 3 | J | 2,0 | 6,0 | 2,0 | 60,0 | 10,0 | 1,9 | 0,3 | 6,72 | 4 | ■ |
| JH142020J3R050.0Z2-HXT | 02968257 | 3 | J | 2,0 | 6,0 | 2,0 | 60,0 | 10,0 | 1,9 | 0,5 | 6,79 | 2 | ■ |
| JH142020J3R050.0Z4-HXT | 02968258 | 3 | J | 2,0 | 6,0 | 2,0 | 60,0 | 10,0 | 1,9 | 0,5 | 6,79 | 4 | ■ |
| JH142030J3R050.0Z2-HXT | 02968259 | 3 | J | 3,0 | 6,0 | 3,0 | 60,0 | 15,0 | 2,8 | 0,5 | 4,3 | 2 | ■ |
| JH142030J3R050.0Z4-HXT | 02968260 | 3 | J | 3,0 | 6,0 | 3,0 | 60,0 | 15,0 | 2,8 | 0,5 | 4,3 | 4 | ■ |
| JH142030J3R100.0Z2-HXT | 02968261 | 3 | J | 3,0 | 6,0 | 3,0 | 60,0 | 15,0 | 2,8 | 1,0 | 4,4 | 2 | ■ |
| JH142030J3R100.0Z4-HXT | 02968262 | 3 | J | 3,0 | 6,0 | 3,0 | 60,0 | 15,0 | 2,8 | 1,0 | 4,4 | 4 | ■ |
| JH142040J3R030.0Z2-HXT | 02968263 | 3 | J | 4,0 | 6,0 | 4,0 | 60,0 | 20,0 | 3,7 | 0,3 | 2,45 | 2 | ■ |
| JH142040J3R030.0Z4-HXT | 02970111 | 3 | J | 4,0 | 6,0 | 4,0 | 60,0 | 20,0 | 3,7 | 0,3 | 2,45 | 4 | ■ |
| JH142040J3R050.0Z2-HXT | 02968265 | 3 | J | 4,0 | 6,0 | 4,0 | 60,0 | 20,0 | 3,7 | 0,5 | 2,48 | 2 | ■ |
| JH142040J3R050.0Z4-HXT | 02968264 | 3 | J | 4,0 | 6,0 | 4,0 | 60,0 | 20,0 | 3,7 | 0,5 | 2,48 | 4 | ■ |
| JH142040J3R100.0Z2-HXT | 02968266 | 3 | J | 4,0 | 6,0 | 4,0 | 60,0 | 20,0 | 3,7 | 1,0 | 2,53 | 2 | ■ |
| JH142040J3R100.0Z4-HXT | 02968267 | 3 | J | 4,0 | 6,0 | 4,0 | 60,0 | 20,0 | 3,7 | 1,0 | 2,53 | 4 | ■ |
| JH142060J3R050.0Z4-HXT | 02968268 | 3 | J | 6,0 | 8,0 | 6,0 | 75,0 | 30,0 | 5,6 | 0,5 | 1,75 | 4 | ■ |
| JH142060J3R050.0Z5-HXT | 02968269 | 3 | J | 6,0 | 8,0 | 6,0 | 75,0 | 30,0 | 5,6 | 0,5 | 1,75 | 5 | ■ |
| JH142060J3R100.0Z4-HXT | 02968270 | 3 | J | 6,0 | 8,0 | 6,0 | 75,0 | 30,0 | 5,6 | 1,0 | 1,77 | 4 | ■ |
| JH142060J3R100.0Z5-HXT | 02968271 | 3 | J | 6,0 | 8,0 | 6,0 | 75,0 | 30,0 | 5,6 | 1,0 | 1,77 | 5 | ■ |
| JH142060J3R150.0Z5-HXT | 02968272 | 3 | J | 6,0 | 8,0 | 6,0 | 75,0 | 30,0 | 5,6 | 1,5 | 1,8 | 5 | ■ |
| JH142060J3R200.0Z5-HXT | 02968273 | 3 | J | 6,0 | 8,0 | 6,0 | 75,0 | 30,0 | 5,6 | 2,0 | 1,83 | 5 | ■ |
| JH142080J3R050.0Z5-HXT | 02968274 | 3 | J | 8,0 | 10,0 | 8,0 | 85,0 | 40,0 | 7,4 | 0,5 | 1,34 | 5 | ■ |
| JH142080J3R100.0Z5-HXT | 02968275 | 3 | J | 8,0 | 10,0 | 8,0 | 85,0 | 40,0 | 7,4 | 1,0 | 1,36 | 5 | ■ |
| JH142080J3R150.0Z5-HXT | 02968276 | 3 | J | 8,0 | 10,0 | 8,0 | 85,0 | 40,0 | 7,4 | 1,5 | 1,37 | 5 | ■ |
| JH142080J3R200.0Z5-HXT | 02968277 | 3 | J | 8,0 | 10,0 | 8,0 | 85,0 | 40,0 | 7,4 | 2,0 | 1,39 | 5 | ■ |
| JH142100J3R050.0Z5-HXT | 02968278 | 3 | J | 10,0 | 12,0 | 10,0 | 100,0 | 50,0 | 9,4 | 0,5 | 1,1 | 5 | ■ |
| JH142100J3R100.0Z5-HXT | 02968279 | 3 | J | 10,0 | 12,0 | 10,0 | 100,0 | 50,0 | 9,4 | 1,0 | 1,11 | 5 | ■ |
| JH142100J3R200.0Z5-HXT | 02968280 | 3 | J | 10,0 | 12,0 | 10,0 | 100,0 | 50,0 | 9,4 | 2,0 | 1,13 | 5 | ■ |
| JH142020J6R030.0Z4-HXT | 02968282 | 6 | J | 2,0 | 6,0 | 2,0 | 75,0 | 20,0 | 1,9 | 0,3 | 4,33 | 4 | ■ |
| JH142020J6R050.0Z4-HXT | 02968283 | 6 | J | 2,0 | 6,0 | 2,0 | 75,0 | 20,0 | 1,9 | 0,5 | 4,36 | 4 | ■ |
| JH142030J6R050.0Z4-HXT | 02968284 | 6 | J | 3,0 | 6,0 | 3,0 | 75,0 | 30,0 | 2,8 | 0,5 | 2,52 | 4 | ■ |
| JH142030J6R100.0Z4-HXT | 02968285 | 6 | J | 3,0 | 6,0 | 3,0 | 75,0 | 30,0 | 2,8 | 1,0 | 2,56 | 4 | ■ |
| JH142040J6R030.0Z4-HXT | 02968286 | 6 | J | 4,0 | 6,0 | 4,0 | 80,0 | 40,0 | 3,7 | 0,3 | 1,36 | 4 | ■ |
| JH142040J6R050.0Z4-HXT | 02968287 | 6 | J | 4,0 | 6,0 | 4,0 | 80,0 | 40,0 | 3,7 | 0,5 | 1,37 | 4 | ■ |
| JH142040J6R100.0Z4-HXT | 02968288 | 6 | J | 4,0 | 6,0 | 4,0 | 80,0 | 40,0 | 3,7 | 1,0 | 1,38 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JH142 Kopierfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | v _c |
|-----|-----|--------------------|--------------------|----------------|---------|---------|--------|--------|--------|--------|--------|--------------------|
| | | | | 2 | 3 | 4 | 6 | 8 | 10 | 12 | 16 | |
| P1 | M/E | 0.0500 | 0.050 | 0.020 | 0.030 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 0.14 | 485 (460 – 530) |
| | | 0,0500 | 0,050 | 0,00080 | 0,0012 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0055 | 1600 (1600 – 1700) |
| P2 | M/E | 0.0500 | 0.050 | 0.020 | 0.030 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 470 (450 – 520) |
| | | 0,0500 | 0,050 | 0,00080 | 0,0012 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 1550 (1500 – 1700) |
| P3 | M/E | 0.0500 | 0.050 | 0.019 | 0.028 | 0.038 | 0.055 | 0.075 | 0.095 | 0.11 | 0.14 | 405 (390 – 450) |
| | | 0,0500 | 0,050 | 0,00075 | 0,0011 | 0,0015 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0055 | 1325 (1300 – 1400) |
| P4 | M/E | 0.0500 | 0.050 | 0.019 | 0.028 | 0.038 | 0.055 | 0.075 | 0.095 | 0.11 | 0.14 | 360 (340 – 390) |
| | | 0,0500 | 0,050 | 0,00075 | 0,0011 | 0,0015 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0055 | 1175 (1200 – 1200) |
| P5 | M/E | 0.0500 | 0.050 | 0.018 | 0.028 | 0.036 | 0.055 | 0.075 | 0.090 | 0.11 | 0.13 | 345 (330 – 380) |
| | | 0,0500 | 0,050 | 0,00070 | 0,0011 | 0,0014 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 1125 (1100 – 1200) |
| P6 | M/E | 0.0500 | 0.050 | 0.018 | 0.028 | 0.036 | 0.055 | 0.070 | 0.090 | 0.11 | 0.13 | 385 (370 – 420) |
| | | 0,0500 | 0,050 | 0,00070 | 0,0011 | 0,0014 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0050 | 1275 (1300 – 1300) |
| P7 | M/E | 0.0500 | 0.050 | 0.018 | 0.028 | 0.036 | 0.055 | 0.070 | 0.090 | 0.11 | 0.13 | 365 (350 – 400) |
| | | 0,0500 | 0,050 | 0,00070 | 0,0011 | 0,0014 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0050 | 1200 (1200 – 1300) |
| P8 | M/E | 0.0500 | 0.050 | 0.019 | 0.028 | 0.038 | 0.055 | 0.075 | 0.095 | 0.11 | 0.14 | 340 (330 – 380) |
| | | 0,0500 | 0,050 | 0,00075 | 0,0011 | 0,0015 | 0,0022 | 0,0030 | 0,0038 | 0,0044 | 0,0055 | 1125 (1100 – 1200) |
| P11 | M/E | 0.0500 | 0.050 | 0.018 | 0.028 | 0.036 | 0.055 | 0.070 | 0.090 | 0.11 | 0.13 | 355 (340 – 390) |
| | | 0,0500 | 0,050 | 0,00070 | 0,0011 | 0,0014 | 0,0022 | 0,0028 | 0,0036 | 0,0044 | 0,0050 | 1175 (1200 – 1200) |
| K1 | A/E | 0.0500 | 0.050 | 0.018 | 0.028 | 0.036 | 0.055 | 0.075 | 0.090 | 0.11 | 0.13 | 345 (330 – 380) |
| | | 0,0500 | 0,050 | 0,00070 | 0,0011 | 0,0014 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 1125 (1100 – 1200) |
| K2 | A/E | 0.0500 | 0.050 | 0.017 | 0.025 | 0.034 | 0.050 | 0.065 | 0.085 | 0.10 | 0.12 | 300 (290 – 330) |
| | | 0,0500 | 0,050 | 0,00065 | 0,0010 | 0,0013 | 0,0020 | 0,0026 | 0,0034 | 0,0040 | 0,0048 | 980 (960 – 1000) |
| K3 | A/E | 0.0500 | 0.050 | 0.017 | 0.025 | 0.034 | 0.050 | 0.065 | 0.085 | 0.10 | 0.12 | 255 (240 – 280) |
| | | 0,0500 | 0,050 | 0,00065 | 0,0010 | 0,0013 | 0,0020 | 0,0026 | 0,0034 | 0,0040 | 0,0048 | 840 (790 – 910) |
| K4 | A/E | 0.0500 | 0.050 | 0.017 | 0.025 | 0.034 | 0.050 | 0.065 | 0.085 | 0.10 | 0.12 | 245 (230 – 260) |
| | | 0,0500 | 0,050 | 0,00065 | 0,0010 | 0,0013 | 0,0020 | 0,0026 | 0,0034 | 0,0040 | 0,0048 | 800 (760 – 850) |
| K5 | A/E | 0.0500 | 0.050 | 0.018 | 0.028 | 0.036 | 0.055 | 0.075 | 0.090 | 0.11 | 0.13 | 345 (330 – 380) |
| | | 0,0500 | 0,050 | 0,00070 | 0,0011 | 0,0014 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 1125 (1100 – 1200) |
| K6 | A/E | 0.0500 | 0.050 | 0.020 | 0.030 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 500 (480 – 550) |
| | | 0,0500 | 0,050 | 0,00080 | 0,0012 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 1650 (1600 – 1800) |
| K7 | A/E | 0.0500 | 0.050 | 0.018 | 0.028 | 0.036 | 0.055 | 0.075 | 0.090 | 0.11 | 0.13 | 440 (420 – 490) |
| | | 0,0500 | 0,050 | 0,00070 | 0,0011 | 0,0014 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 1450 (1400 – 1600) |
| H3 | M/A | 0.0200 | 0.020 | 0.014 | 0.020 | 0.028 | 0.042 | 0.055 | 0.070 | 0.080 | 0.10 | 95 (72 – 110) |
| | | 0,0200 | 0,020 | 0,00055 | 0,00080 | 0,0011 | 0,0017 | 0,0022 | 0,0028 | 0,0032 | 0,0040 | 310 (240 – 360) |
| H5 | M/A | 0.0400 | 0.040 | 0.014 | 0.022 | 0.028 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 305 (290 – 330) |
| | | 0,0400 | 0,040 | 0,00055 | 0,00085 | 0,0011 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 1000 (960 – 1000) |
| H7 | M/A | 0.0200 | 0.020 | 0.014 | 0.020 | 0.028 | 0.042 | 0.055 | 0.070 | 0.080 | 0.10 | 95 (72 – 110) |
| | | 0,0200 | 0,020 | 0,00055 | 0,00080 | 0,0011 | 0,0017 | 0,0022 | 0,0028 | 0,0032 | 0,0040 | 310 (240 – 360) |
| H8 | M/A | 0.0400 | 0.040 | 0.011 | 0.016 | 0.022 | 0.032 | 0.042 | 0.055 | 0.065 | 0.080 | 310 (290 – 330) |
| | | 0,0400 | 0,040 | 0,00044 | 0,00065 | 0,00085 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 1025 (960 – 1000) |
| H11 | M/A | 0.0400 | 0.040 | 0.014 | 0.022 | 0.028 | 0.042 | 0.055 | 0.070 | 0.085 | 0.10 | 390 (360 – 420) |
| | | 0,0400 | 0,040 | 0,00055 | 0,00085 | 0,0011 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 0,0040 | 1275 (1200 – 1300) |
| H12 | M/A | 0.0500 | 0.050 | 0.0095 | 0.014 | 0.019 | 0.028 | 0.038 | 0.046 | 0.055 | 0.070 | 345 (320 – 370) |
| | | 0,0500 | 0,050 | 0,00038 | 0,00055 | 0,00075 | 0,0011 | 0,0015 | 0,0018 | 0,0022 | 0,0028 | 1125 (1100 – 1200) |
| H21 | M/A | 0.0400 | 0.040 | 0.011 | 0.016 | 0.022 | 0.032 | 0.042 | 0.055 | 0.065 | 0.080 | 310 (290 – 330) |
| | | 0,0400 | 0,040 | 0,00044 | 0,00065 | 0,00085 | 0,0013 | 0,0017 | 0,0022 | 0,0026 | 0,0032 | 1025 (960 – 1000) |
| H31 | M/A | 0.0300 | 0.030 | 0.013 | 0.019 | 0.025 | 0.038 | 0.050 | 0.065 | 0.075 | 0.090 | 140 (120 – 160) |
| | | 0,0300 | 0,030 | 0,00050 | 0,00075 | 0,0010 | 0,0015 | 0,0020 | 0,0026 | 0,0030 | 0,0036 | 460 (400 – 520) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

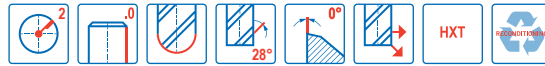
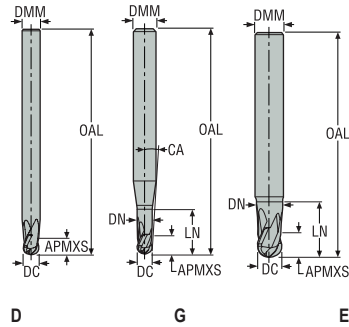
a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

JH112

Hochgeschwindigkeitsfräsen – Hochpräzise – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch



- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC= 0-0,01 mm
- RE= ±0,005 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | CA° | PCEDC | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | | | |
| JH112020G1B.0Z2-HXT | 02970112 | 1 | G | 2,0 | 4,0 | 2,0 | 40,0 | 4,0 | 1,9 | 6,45 | 2 | ■ |
| JH112030G1B.0Z2-HXT | 02970113 | 1 | G | 3,0 | 4,0 | 3,0 | 40,0 | 6,0 | 2,8 | 3,3 | 2 | ■ |
| JH112040D1B.0Z2-HXT | 02970114 | 1 | D | 4,0 | 4,0 | 4,0 | 40,0 | - | - | - | 2 | ■ |
| JH112050G1B.0Z2-HXT | 02970115 | 1 | G | 5,0 | 6,0 | 5,0 | 50,0 | 10,0 | 4,6 | 2,0 | 2 | ■ |
| JH112060D1B.0Z2-HXT | 02970116 | 1 | D | 6,0 | 6,0 | 6,0 | 50,0 | - | - | - | 2 | ■ |
| JH112080D1B.0Z2-HXT | 02970117 | 1 | D | 8,0 | 8,0 | 8,0 | 65,0 | - | - | - | 2 | ■ |
| JH112100D1B.0Z2-HXT | 02970118 | 1 | D | 10,0 | 10,0 | 10,0 | 65,0 | - | - | - | 2 | ■ |
| JH112020G2B.0Z2-HXT | 02970119 | 2 | G | 2,0 | 3,0 | 2,0 | 50,0 | 10,0 | 1,9 | 2,5 | 2 | ■ |
| JH112030D2B.0Z2-HXT | 02970120 | 2 | D | 3,0 | 3,0 | 3,0 | 50,0 | - | - | - | 2 | ■ |
| JH112040D2B.0Z2-HXT | 02970121 | 2 | D | 4,0 | 4,0 | 4,0 | 60,0 | - | - | - | 2 | ■ |
| JH112050D2B.0Z2-HXT | 02970122 | 2 | D | 5,0 | 5,0 | 5,0 | 60,0 | - | - | - | 2 | ■ |
| JH112060D2B.0Z2-HXT | 02970123 | 2 | D | 6,0 | 6,0 | 6,0 | 75,0 | - | - | - | 2 | ■ |
| JH112020G3B.0Z2-HXT | 02970124 | 3 | G | 2,0 | 6,0 | 2,0 | 60,0 | 4,0 | 1,9 | 8,12 | 2 | ■ |
| JH112025G3B.0Z2-HXT | 02970125 | 3 | G | 2,5 | 6,0 | 2,5 | 60,0 | 5,0 | 2,4 | 7,39 | 2 | ■ |
| JH112030G3B.0Z2-HXT | 02970126 | 3 | G | 3,0 | 6,0 | 3,0 | 60,0 | 6,0 | 2,8 | 5,5 | 2 | ■ |
| JH112035G3B.0Z2-HXT | 02968289 | 3 | G | 3,5 | 6,0 | 3,5 | 65,0 | 7,0 | 3,2 | 3,81 | 2 | ■ |
| JH112040G3B.0Z2-HXT | 02970127 | 3 | G | 4,0 | 6,0 | 4,0 | 65,0 | 8,0 | 3,7 | 3,34 | 2 | ■ |
| JH112050G3B.0Z2-HXT | 02970128 | 3 | G | 5,0 | 6,0 | 5,0 | 65,0 | 10,0 | 4,6 | 2,0 | 2 | ■ |
| JH112060G3B.0Z2-HXT | 02970129 | 3 | G | 6,0 | 8,0 | 6,0 | 75,0 | 12,0 | 5,6 | 2,78 | 2 | ■ |
| JH112080E3B.0Z2-HXT | 02968290 | 3 | E | 8,0 | 8,0 | 8,0 | 75,0 | 16,0 | 7,4 | - | 2 | ■ |
| JH112100E3B.0Z2-HXT | 02968291 | 3 | E | 10,0 | 10,0 | 10,0 | 80,0 | 20,0 | 9,4 | - | 2 | ■ |
| JH112120E3B.0Z2-HXT | 02968292 | 3 | E | 12,0 | 12,0 | 12,0 | 90,0 | 24,0 | 11,4 | - | 2 | ■ |
| JH112020G4B.0Z2-HXT | 02970130 | 4 | G | 2,0 | 6,0 | 2,0 | 80,0 | 20,0 | 1,9 | 3,82 | 2 | ■ |
| JH112030G4B.0Z2-HXT | 02970131 | 4 | G | 3,0 | 6,0 | 3,0 | 80,0 | 20,0 | 2,8 | 2,91 | 2 | ■ |
| JH112040G4B.0Z2-HXT | 02970132 | 4 | G | 4,0 | 6,0 | 4,0 | 80,0 | 20,0 | 3,7 | 1,97 | 2 | ■ |
| JH112050G4B.0Z2-HXT | 02970133 | 4 | G | 5,0 | 6,0 | 5,0 | 100,0 | 50,0 | 4,6 | 0,53 | 2 | ■ |
| JH112060D4B.0Z2-HXT | 02968293 | 4 | D | 6,0 | 6,0 | 6,0 | 100,0 | - | - | - | 2 | ■ |
| JH112080D4B.0Z2-HXT | 02968294 | 4 | D | 8,0 | 8,0 | 8,0 | 110,0 | - | - | - | 2 | ■ |
| JH112100D4B.0Z2-HXT | 02968295 | 4 | D | 10,0 | 10,0 | 10,0 | 125,0 | - | - | - | 2 | ■ |
| JH112120D4B.0Z2-HXT | 02968296 | 4 | D | 12,0 | 12,0 | 12,0 | 125,0 | - | - | - | 2 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und Composite

Graphit

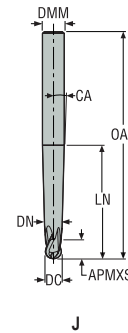
X-Heads

Minimaster Plus

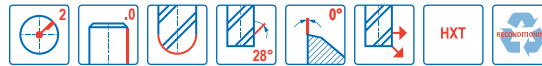
Minimaster

JH112

Hochgeschwindigkeitsfräsen – Hochpräzise – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch



- Toleranzen:
- Rundlaufabweichung = <math><0,005\text{ mm}</math>
- DMM = h5
- DC= 0-0,01 mm
- RE= $\pm 0,005\text{ mm}$
- Nachschleifen möglich, wenn DC $\geq \varnothing 6$ ist



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | DN | NA° | CA° | PCEDC | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|------|------|-------|-------|-----|------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | | | | |
| JH112020J5B.0Z2-HXT | 02970134 | 5 | J | 2,0 | 6,0 | 2,0 | 80,0 | 1,9 | 3,55 | 3,3 | 2 | ■ |
| JH112030J5B.0Z2-HXT | 02970135 | 5 | J | 3,0 | 6,0 | 3,0 | 80,0 | 2,8 | 2,5 | 2,2 | 2 | ■ |
| JH112040J5B.0Z2-HXT | 02970136 | 5 | J | 4,0 | 6,0 | 4,0 | 80,0 | 3,7 | 1,4 | 1,2 | 2 | ■ |
| JH112050J5B.0Z2-HXT | 02970137 | 5 | J | 5,0 | 8,0 | 5,0 | 100,0 | 4,6 | 1,95 | 1,6 | 2 | ■ |
| JH112060J5B.0Z2-HXT | 02970138 | 5 | J | 6,0 | 8,0 | 6,0 | 100,0 | 5,6 | 1,4 | 1,1 | 2 | ■ |
| JH112080J5B.0Z2-HXT | 02970139 | 5 | J | 8,0 | 10,0 | 8,0 | 125,0 | 7,4 | 1,43 | 1,0 | 2 | ■ |
| JH112100J5B.0Z2-HXT | 02970140 | 5 | J | 10,0 | 12,0 | 10,0 | 125,0 | 9,4 | 1,5 | 1,0 | 2 | ■ |
| JH112060J6B.0Z2-HXT | 02970141 | 6 | J | 6,0 | 10,0 | 6,0 | 125,0 | 5,6 | 2,3 | 2,0 | 2 | ■ |
| JH112080J6B.0Z2-HXT | 02970142 | 6 | J | 8,0 | 12,0 | 8,0 | 150,0 | 7,4 | 2,3 | 1,8 | 2 | ■ |
| JH112100J6B.0Z2-HXT | 02970143 | 6 | J | 10,0 | 12,0 | 10,0 | 150,0 | 9,4 | 1,1 | 0,8 | 2 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite


Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JH112 Kopierfräsen/ Feinbearbeitung

| SMG |  | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | 2 | 2.5 | 3 | 3.5 | 4 | 5 | 6 | 8 | 10 | 12 | |
| K1 | E | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 520 (500 – 730) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 1700 (1700 – 2300) |
| K2 | E | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 445 (430 – 630) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 1450 (1500 – 2000) |
| K3 | E | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 380 (360 – 530) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 1250 (1200 – 1700) |
| K4 | E | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 360 (350 – 510) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 1175 (1200 – 1600) |
| K5 | E | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 415 (370 – 610) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 1350 (1300 – 2000) |
| K6 | E | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 610 (550 – 900) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 2000 (1900 – 2900) |
| K7 | E | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 680 (560 – 790) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 2225 (1900 – 2500) |
| H3 | M | 0.16 | 0.028 | 0.036 | 0.042 | 0.048 | 0.055 | 0.070 | 0.085 | 0.11 | 0.14 | 0.17 | 155 (150 – 230) |
| | | 0,16 | 0,0011 | 0,0014 | 0,0017 | 0,0019 | 0,0022 | 0,0028 | 0,0034 | 0,0044 | 0,0055 | 0,0065 | 510 (500 – 750) |
| H5 | M | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 285 (240 – 330) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 940 (790 – 1000) |
| H7 | M | 0.16 | 0.028 | 0.036 | 0.042 | 0.048 | 0.055 | 0.070 | 0.085 | 0.11 | 0.14 | 0.17 | 155 (150 – 230) |
| | | 0,16 | 0,0011 | 0,0014 | 0,0017 | 0,0019 | 0,0022 | 0,0028 | 0,0034 | 0,0044 | 0,0055 | 0,0065 | 510 (500 – 750) |
| H8 | M | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 285 (240 – 330) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 940 (790 – 1000) |
| H11 | M | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 360 (300 – 420) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 1175 (990 – 1300) |
| H12 | M | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 330 (280 – 380) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 1075 (920 – 1200) |
| H21 | M | 0.30 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 285 (240 – 330) |
| | | 0,30 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 940 (790 – 1000) |
| H31 | M | 0.30 | 0.026 | 0.032 | 0.040 | 0.046 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 300 (290 – 430) |
| | | 0,30 | 0,0010 | 0,0013 | 0,0016 | 0,0018 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 980 (960 – 1400) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Universell

Stahl und Guss

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JH112 Kopierfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 2 | 2.5 | 3 | 3.5 | 4 | 5 | 6 | 8 | 10 | 12 | |
| K1 | E | 0.250 | 0.15 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 315 (310 – 450) |
| | | 0,250 | 0,15 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 1025 (1100 – 1400) |
| K2 | E | 0.250 | 0.15 | 0.028 | 0.036 | 0.044 | 0.050 | 0.060 | 0.070 | 0.085 | 0.12 | 0.14 | 0.17 | 280 (270 – 390) |
| | | 0,250 | 0,15 | 0,0011 | 0,0014 | 0,0017 | 0,0020 | 0,0024 | 0,0028 | 0,0034 | 0,0048 | 0,0055 | 0,0065 | 920 (890 – 1200) |
| K3 | E | 0.250 | 0.15 | 0.028 | 0.036 | 0.044 | 0.050 | 0.060 | 0.070 | 0.085 | 0.12 | 0.14 | 0.17 | 235 (230 – 330) |
| | | 0,250 | 0,15 | 0,0011 | 0,0014 | 0,0017 | 0,0020 | 0,0024 | 0,0028 | 0,0034 | 0,0048 | 0,0055 | 0,0065 | 770 (760 – 1000) |
| K4 | E | 0.250 | 0.15 | 0.028 | 0.036 | 0.044 | 0.050 | 0.060 | 0.070 | 0.085 | 0.12 | 0.14 | 0.17 | 225 (220 – 320) |
| | | 0,250 | 0,15 | 0,0011 | 0,0014 | 0,0017 | 0,0020 | 0,0024 | 0,0028 | 0,0034 | 0,0048 | 0,0055 | 0,0065 | 740 (730 – 1000) |
| K5 | E | 0.160 | 0.15 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 280 (250 – 410) |
| | | 0,160 | 0,15 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 920 (830 – 1300) |
| K6 | E | 0.160 | 0.15 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 415 (370 – 610) |
| | | 0,160 | 0,15 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 1350 (1300 – 2000) |
| K7 | E | 0.250 | 0.10 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 420 (350 – 490) |
| | | 0,250 | 0,10 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 1375 (1200 – 1600) |
| H3 | M | 0.120 | 0.040 | 0.028 | 0.036 | 0.042 | 0.048 | 0.055 | 0.070 | 0.085 | 0.11 | 0.14 | 0.17 | 110 (100 – 160) |
| | | 0,120 | 0,040 | 0,0011 | 0,0014 | 0,0017 | 0,0019 | 0,0022 | 0,0028 | 0,0034 | 0,0044 | 0,0055 | 0,0065 | 360 (330 – 520) |
| H5 | M | 0.250 | 0.10 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 175 (150 – 200) |
| | | 0,250 | 0,10 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 570 (500 – 650) |
| H7 | M | 0.120 | 0.040 | 0.028 | 0.036 | 0.042 | 0.048 | 0.055 | 0.070 | 0.085 | 0.11 | 0.14 | 0.17 | 110 (100 – 160) |
| | | 0,120 | 0,040 | 0,0011 | 0,0014 | 0,0017 | 0,0019 | 0,0022 | 0,0028 | 0,0034 | 0,0044 | 0,0055 | 0,0065 | 360 (330 – 520) |
| H8 | M | 0.250 | 0.10 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 175 (150 – 200) |
| | | 0,250 | 0,10 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 570 (500 – 650) |
| H11 | M | 0.250 | 0.10 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 225 (190 – 260) |
| | | 0,250 | 0,10 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 740 (630 – 850) |
| H12 | M | 0.250 | 0.10 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 205 (170 – 240) |
| | | 0,250 | 0,10 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 670 (560 – 780) |
| H21 | M | 0.250 | 0.10 | 0.030 | 0.038 | 0.044 | 0.050 | 0.060 | 0.075 | 0.090 | 0.12 | 0.15 | 0.18 | 175 (150 – 200) |
| | | 0,250 | 0,10 | 0,0012 | 0,0015 | 0,0017 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 570 (500 – 650) |
| H31 | M | 0.200 | 0.10 | 0.026 | 0.032 | 0.040 | 0.046 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 200 (200 – 280) |
| | | 0,200 | 0,10 | 0,0010 | 0,0013 | 0,0016 | 0,0018 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 660 (660 – 910) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

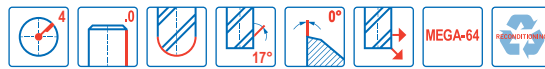
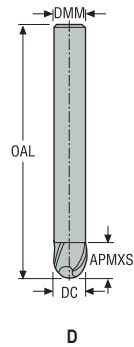
a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

JH150

Hochgeschwindigkeitsfräsen – Gehärteter Stahl – Kugelkopf – 4 Schneiden – Zylindrisch



- Toleranzen:
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= ±0,01 mm
- Nachschleifen möglich

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | PCEDC | Zylindrisch |
|----------------|--------------------|------------------|-------------------|------|------|-------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | | |
| 150060-MEGA-64 | 00019198 | 2 | D | 6,0 | 6,0 | 6,0 | 80,0 | 4 | ■ |
| 150080-MEGA-64 | 00019208 | 2 | D | 8,0 | 8,0 | 8,0 | 85,0 | 4 | ■ |
| 150100-MEGA-64 | 00019219 | 2 | D | 10,0 | 10,0 | 10,0 | 100,0 | 4 | ■ |
| 150120-MEGA-64 | 00019254 | 2 | D | 12,0 | 12,0 | 12,0 | 100,0 | 4 | ■ |

■ Lagerstandard.

Unversell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JH150 Kopierfräsen/Schruppen

| SMG | | a _p /DC | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------------------|
| | | | | 6 | 8 | 10 | 12 | |
| K1 | A | 0.300 | 0.15 | 0.10 | 0.14 | 0.17 | 0.20 | 290 (310 – 370) |
| | | 0,300 | 0,15 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 950 (1100 – 1200) |
| K2 | A | 0.300 | 0.15 | 0.10 | 0.14 | 0.17 | 0.20 | 250 (270 – 320) |
| | | 0,300 | 0,15 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 820 (890 – 1000) |
| K3 | A | 0.300 | 0.15 | 0.10 | 0.14 | 0.17 | 0.20 | 210 (230 – 270) |
| | | 0,300 | 0,15 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 690 (760 – 880) |
| K5 | A | 0.200 | 0.15 | 0.10 | 0.14 | 0.17 | 0.20 | 255 (270 – 330) |
| | | 0,200 | 0,15 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 840 (890 – 1000) |
| K6 | A | 0.200 | 0.15 | 0.10 | 0.14 | 0.17 | 0.20 | 375 (390 – 500) |
| | | 0,200 | 0,15 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1225 (1300 – 1600) |
| K7 | A | 0.200 | 0.15 | 0.10 | 0.14 | 0.17 | 0.20 | 325 (340 – 430) |
| | | 0,200 | 0,15 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1075 (1200 – 1400) |
| H3 | M | 0.0500 | 0.020 | 0.085 | 0.11 | 0.14 | 0.17 | 85 (88 – 120) |
| | | 0,0500 | 0,020 | 0,0034 | 0,0044 | 0,0055 | 0,0065 | 280 (290 – 390) |
| H5 | M | 0.200 | 0.060 | 0.10 | 0.14 | 0.17 | 0.20 | 180 (160 – 200) |
| | | 0,200 | 0,060 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 590 (530 – 650) |
| H7 | M | 0.0500 | 0.020 | 0.085 | 0.11 | 0.14 | 0.17 | 85 (88 – 120) |
| | | 0,0500 | 0,020 | 0,0034 | 0,0044 | 0,0055 | 0,0065 | 280 (290 – 390) |
| H8 | M | 0.200 | 0.060 | 0.10 | 0.14 | 0.17 | 0.20 | 180 (160 – 200) |
| | | 0,200 | 0,060 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 590 (530 – 650) |
| H11 | M | 0.200 | 0.060 | 0.10 | 0.14 | 0.17 | 0.20 | 230 (210 – 250) |
| | | 0,200 | 0,060 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 750 (690 – 820) |
| H12 | M | 0.200 | 0.060 | 0.10 | 0.14 | 0.17 | 0.20 | 210 (190 – 230) |
| | | 0,200 | 0,060 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 690 (630 – 750) |
| H21 | M | 0.200 | 0.060 | 0.10 | 0.14 | 0.17 | 0.20 | 180 (160 – 200) |
| | | 0,200 | 0,060 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 590 (530 – 650) |
| H31 | M | 0.150 | 0.060 | 0.090 | 0.12 | 0.15 | 0.18 | 125 (130 – 180) |
| | | 0,150 | 0,060 | 0,0036 | 0,0048 | 0,0060 | 0,0070 | 410 (430 – 590) |

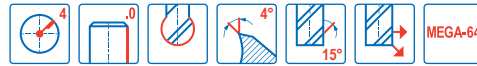
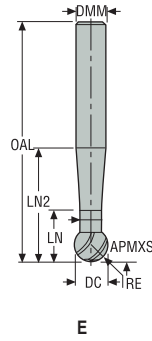
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Univerrsell
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Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

JH160

Hochgeschwindigkeitsfräsen – Gehärteter Stahl – Kugelkopf – 4 Schneiden – Zylindrisch



- Toleranzen:
- DMM= h5
- DC= 0,02/-0,06 mm
- SA=250°

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | LN2 | DN | RE | PCEDC | Zylindrisch |
|----------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | | |
| 160030-MEGA-64 | 00040365 | 2 | E | 3,0 | 3,0 | 2,3 | 60,0 | 4,5 | 9,0 | 1,8 | 1,5 | 4 | ■ |
| 160040-MEGA-64 | 00040366 | 2 | E | 4,0 | 4,0 | 3,1 | 60,0 | 5,6 | 11,0 | 2,4 | 2,0 | 4 | ■ |
| 160050-MEGA-64 | 00040367 | 2 | E | 5,0 | 5,0 | 3,9 | 70,0 | 6,4 | 13,0 | 3,0 | 2,5 | 4 | ■ |
| 160060-MEGA-64 | 00040368 | 2 | E | 6,0 | 6,0 | 4,7 | 80,0 | 9,7 | 17,3 | 3,6 | 3,0 | 4 | ■ |
| 160080-MEGA-64 | 00040369 | 2 | E | 8,0 | 8,0 | 6,2 | 85,0 | 11,2 | 21,3 | 4,8 | 4,0 | 4 | ■ |
| 160100-MEGA-64 | 00040370 | 2 | E | 10,0 | 10,0 | 7,8 | 100,0 | 15,6 | 27,9 | 6,0 | 5,0 | 4 | ■ |
| 160120-MEGA-64 | 00040371 | 2 | E | 12,0 | 12,0 | 9,4 | 125,0 | 17,2 | 31,8 | 7,2 | 6,0 | 4 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JH160 Kopierfräsen/ Feinbearbeitung

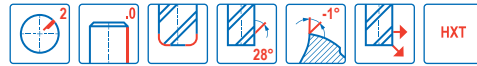
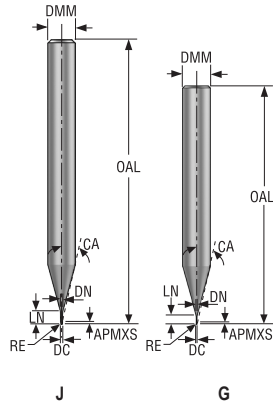
| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------------------|----------------|
| | | | | 3 | 4 | 5 | 6 | 8 | 10 | 12 | | |
| P1 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 550 (450 – 700) | |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1800 (1500 – 2200) | |
| P2 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 530 (440 – 680) | |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1750 (1500 – 2200) | |
| P3 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 460 (380 – 590) | |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1500 (1300 – 1900) | |
| P4 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 405 (340 – 520) | |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1325 (1200 – 1700) | |
| P5 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 385 (320 – 490) | |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1275 (1100 – 1600) | |
| P6 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 430 (360 – 520) | |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1400 (1200 – 1800) | |
| P7 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 410 (340 – 520) | |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1350 (1100 – 1700) | |
| P8 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 385 (320 – 490) | |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1275 (1100 – 1600) | |
| P11 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 395 (330 – 510) | |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1300 (1100 – 1600) | |
| P12 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 235 (200 – 300) | |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 770 (660 – 980) | |
| H3 | M/E/A | 0.0100 | 0.0075 | 0.040 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 85 (91 – 110) | |
| | | 0,0100 | 0,0075 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 280 (300 – 360) | |
| H5 | M/E/A | 0.0100 | 0.016 | 0.040 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 340 (320 – 360) | |
| | | 0,0100 | 0,016 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 1125 (1100 – 1100) | |
| H7 | M/E/A | 0.0100 | 0.0075 | 0.040 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 85 (91 – 110) | |
| | | 0,0100 | 0,0075 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 280 (300 – 360) | |
| H8 | M/E/A | 0.0100 | 0.016 | 0.040 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 340 (320 – 360) | |
| | | 0,0100 | 0,016 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 1125 (1100 – 1100) | |
| H11 | M/E/A | 0.0100 | 0.016 | 0.040 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 430 (400 – 460) | |
| | | 0,0100 | 0,016 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 1400 (1400 – 1500) | |
| H12 | M/E/A | 0.0200 | 0.024 | 0.050 | 0.070 | 0.085 | 0.10 | 0.14 | 0.17 | 0.20 | 355 (340 – 380) | |
| | | 0,0200 | 0,024 | 0,0020 | 0,0028 | 0,0034 | 0,0040 | 0,0055 | 0,0065 | 0,0080 | 1175 (1200 – 1200) | |
| H21 | M/E/A | 0.0100 | 0.016 | 0.040 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 340 (320 – 360) | |
| | | 0,0100 | 0,016 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 1125 (1100 – 1100) | |
| H31 | M/E/A | 0.0100 | 0.016 | 0.040 | 0.050 | 0.065 | 0.080 | 0.10 | 0.13 | 0.16 | 165 (180 – 210) | |
| | | 0,0100 | 0,016 | 0,0016 | 0,0020 | 0,0026 | 0,0032 | 0,0040 | 0,0050 | 0,0065 | 540 (600 – 680) | |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

JME142

Mini – Gehärteter Stahl – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC = $\varnothing 0,6 = 0/-0,008\text{ mm}$
- DC = >math>\varnothing 0,6 = 0/-0,01\text{ mm}</math>
- RE = $\pm 0,005\text{ mm}$

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | NA° | CA° | PCEDC | Zylindrisch |
|-------------------------|----------------|--------------|---------------|-----|-----|-------|------|------|------|------|-----|-------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | | | |
| JME142002G1R005Z2.0-HXT | 03205080 | 1 | G | 0,2 | 4,0 | 0,15 | 40,0 | 0,4 | 0,18 | 0,05 | 0,0 | 15,12 | 2 | ■ |
| JME142003G1R005Z2.0-HXT | 03205082 | 1 | G | 0,3 | 4,0 | 0,225 | 40,0 | 0,6 | 0,28 | 0,05 | 0,0 | 14,77 | 2 | ■ |
| JME142004G1R005Z2.0-HXT | 03205084 | 1 | G | 0,4 | 4,0 | 0,3 | 40,0 | 0,8 | 0,37 | 0,05 | 0,0 | 14,39 | 2 | ■ |
| JME142005G1R005Z2.0-HXT | 03205086 | 1 | G | 0,5 | 4,0 | 0,375 | 40,0 | 0,75 | 0,46 | 0,05 | 0,0 | 14,01 | 2 | ■ |
| JME142006G1R005Z2.0-HXT | 03205099 | 1 | G | 0,6 | 4,0 | 0,45 | 40,0 | 0,9 | 0,56 | 0,05 | 0,0 | 13,67 | 2 | ■ |
| JME142008G1R005Z2.0-HXT | 03205121 | 1 | G | 0,8 | 6,0 | 0,6 | 50,0 | 1,2 | 0,76 | 0,05 | 0,0 | 13,98 | 2 | ■ |
| JME142010G1R005Z2.0-HXT | 03205139 | 1 | G | 1,0 | 6,0 | 0,75 | 50,0 | 1,5 | 0,95 | 0,05 | 0,0 | 13,49 | 2 | ■ |
| JME142012G1R005Z2.0-HXT | 03205151 | 1 | G | 1,2 | 6,0 | 0,9 | 50,0 | 1,8 | 1,15 | 0,05 | 0,0 | 13,02 | 2 | ■ |
| JME142015G1R005Z2.0-HXT | 03205161 | 1 | G | 1,5 | 6,0 | 1,125 | 50,0 | 2,25 | 1,45 | 0,05 | 0,0 | 12,3 | 2 | ■ |
| JME142002J2R005Z2.0-HXT | 03205081 | 2 | J | 0,2 | 4,0 | 0,15 | 40,0 | 0,6 | 0,18 | 0,05 | 0,9 | 14,23 | 2 | ■ |
| JME142003J2R005Z2.0-HXT | 03205083 | 2 | J | 0,3 | 4,0 | 0,225 | 40,0 | 0,9 | 0,28 | 0,05 | 0,9 | 13,67 | 2 | ■ |
| JME142004J2R005Z2.0-HXT | 03205085 | 2 | J | 0,4 | 4,0 | 0,3 | 40,0 | 1,2 | 0,37 | 0,05 | 0,9 | 13,1 | 2 | ■ |
| JME142005J2R005Z2.0-HXT | 03205087 | 2 | J | 0,5 | 4,0 | 0,375 | 40,0 | 1,5 | 0,46 | 0,05 | 0,9 | 12,54 | 2 | ■ |
| JME142005J2R010Z2.0-HXT | 03205093 | 2 | J | 0,5 | 4,0 | 0,375 | 40,0 | 1,5 | 0,46 | 0,1 | 0,9 | 12,61 | 2 | ■ |
| JME142005G2R005Z2.0-HXT | 03205088 | 2 | G | 0,5 | 6,0 | 0,375 | 50,0 | 1,5 | 0,46 | 0,05 | 0,0 | 13,5 | 2 | ■ |
| JME142005G2R010Z2.0-HXT | 03205094 | 2 | G | 0,5 | 6,0 | 0,375 | 50,0 | 1,5 | 0,46 | 0,1 | 0,0 | 13,55 | 2 | ■ |
| JME142006J2R005Z2.0-HXT | 03205100 | 2 | J | 0,6 | 4,0 | 0,45 | 40,0 | 2,0 | 0,56 | 0,05 | 0,9 | 11,76 | 2 | ■ |
| JME142006J2R010Z2.0-HXT | 03205107 | 2 | J | 0,6 | 4,0 | 0,45 | 40,0 | 2,0 | 0,56 | 0,1 | 0,9 | 11,83 | 2 | ■ |
| JME142006G2R005Z2.0-HXT | 03205101 | 2 | G | 0,6 | 6,0 | 0,45 | 50,0 | 2,0 | 0,56 | 0,05 | 0,0 | 9,48 | 2 | ■ |
| JME142006G2R010Z2.0-HXT | 03205108 | 2 | G | 0,6 | 6,0 | 0,45 | 50,0 | 2,0 | 0,56 | 0,1 | 0,0 | 9,51 | 2 | ■ |
| JME142008J2R005Z2.0-HXT | 03205122 | 2 | J | 0,8 | 4,0 | 0,6 | 40,0 | 2,5 | 0,76 | 0,05 | 0,9 | 10,92 | 2 | ■ |
| JME142008J2R010Z2.0-HXT | 03205129 | 2 | J | 0,8 | 4,0 | 0,6 | 40,0 | 2,5 | 0,76 | 0,1 | 0,9 | 10,98 | 2 | ■ |
| JME142008J2R020Z2.0-HXT | 03205135 | 2 | J | 0,8 | 4,0 | 0,6 | 40,0 | 2,5 | 0,76 | 0,2 | 0,9 | 11,1 | 2 | ■ |
| JME142008G2R005Z2.0-HXT | 03205123 | 2 | G | 0,8 | 6,0 | 0,6 | 50,0 | 2,5 | 0,76 | 0,05 | 0,0 | 9,15 | 2 | ■ |
| JME142008G2R010Z2.0-HXT | 03205130 | 2 | G | 0,8 | 6,0 | 0,6 | 50,0 | 2,5 | 0,76 | 0,1 | 0,0 | 9,17 | 2 | ■ |
| JME142008G2R020Z2.0-HXT | 03205136 | 2 | G | 0,8 | 6,0 | 0,6 | 50,0 | 2,5 | 0,76 | 0,2 | 0,0 | 9,22 | 2 | ■ |
| JME142010G2R005Z2.0-HXT | 03205140 | 2 | G | 1,0 | 6,0 | 0,75 | 50,0 | 4,0 | 0,95 | 0,05 | 0,0 | 8,29 | 2 | ■ |
| JME142010G2R010Z2.0-HXT | 03205145 | 2 | G | 1,0 | 6,0 | 0,75 | 50,0 | 4,0 | 0,95 | 0,1 | 0,0 | 8,31 | 2 | ■ |
| JME142010G2R020Z2.0-HXT | 03205148 | 2 | G | 1,0 | 6,0 | 0,75 | 50,0 | 4,0 | 0,95 | 0,2 | 0,0 | 8,36 | 2 | ■ |
| JME142012G2R005Z2.0-HXT | 03205152 | 2 | G | 1,2 | 6,0 | 0,9 | 50,0 | 4,5 | 1,15 | 0,05 | 0,0 | 7,97 | 2 | ■ |
| JME142012G2R010Z2.0-HXT | 03205155 | 2 | G | 1,2 | 6,0 | 0,9 | 50,0 | 4,5 | 1,15 | 0,1 | 0,0 | 7,99 | 2 | ■ |
| JME142012G2R020Z2.0-HXT | 03205158 | 2 | G | 1,2 | 6,0 | 0,9 | 50,0 | 4,5 | 1,15 | 0,2 | 0,0 | 8,04 | 2 | ■ |
| JME142015G2R005Z2.0-HXT | 03205162 | 2 | G | 1,5 | 6,0 | 1,125 | 50,0 | 5,0 | 1,45 | 0,05 | 0,0 | 7,6 | 2 | ■ |
| JME142015G2R010Z2.0-HXT | 03205167 | 2 | G | 1,5 | 6,0 | 1,125 | 50,0 | 5,0 | 1,45 | 0,1 | 0,0 | 9,7 | 2 | ■ |
| JME142015G2R020Z2.0-HXT | 03205171 | 2 | G | 1,5 | 6,0 | 1,125 | 50,0 | 5,0 | 1,45 | 0,2 | 0,0 | 9,76 | 2 | ■ |

■ Lagerstandard.

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NE-Metalle

Harder

Kunststoffe und Composite

Graphit

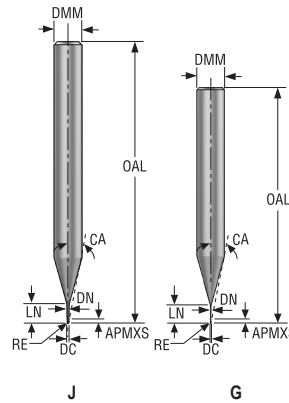
X-Heads

Minimaster Plus

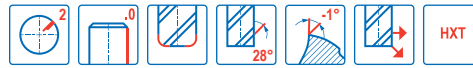
Minimaster

JME142

Mini – Gehärteter Stahl – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- Rundlaufabweichung = <math><0,005\text{ mm}</math>
- DMM = h5
- DC = <math><0,6 = 0/-0,008\text{ mm}</math>
- DC = $\geq 0,6 = 0/-0,01\text{ mm}$
- RE = $\pm 0,005\text{ mm}$



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | NA° | CA° | PCEDC | Zylindrisch |
|-------------------------|----------------|--------------|---------------|-----|-----|-------|------|------|------|------|-----|-------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| JME142020G2R005Z2.0-HXT | 03205180 | 2 | G | 2,0 | 6,0 | 1,5 | 50,0 | 6,0 | 1,94 | 0,05 | 0,0 | 8,52 | 2 | ■ |
| JME142020G2R010Z2.0-HXT | 03205185 | 2 | G | 2,0 | 6,0 | 1,5 | 50,0 | 6,0 | 1,94 | 0,1 | 0,0 | 8,55 | 2 | ■ |
| JME142020G2R020Z2.0-HXT | 03205188 | 2 | G | 2,0 | 6,0 | 1,5 | 50,0 | 6,0 | 1,94 | 0,2 | 0,0 | 8,6 | 2 | ■ |
| JME142020G2R030Z2.0-HXT | 03205191 | 2 | G | 2,0 | 6,0 | 1,5 | 50,0 | 6,0 | 1,94 | 0,3 | 0,0 | 8,66 | 2 | ■ |
| JME142030G2R005Z2.0-HXT | 03205201 | 2 | G | 3,0 | 6,0 | 2,25 | 50,0 | 9,0 | 2,85 | 0,05 | 0,0 | 5,81 | 2 | ■ |
| JME142030G2R010Z2.0-HXT | 03205205 | 2 | G | 3,0 | 6,0 | 2,25 | 50,0 | 9,0 | 2,85 | 0,1 | 0,0 | 5,82 | 2 | ■ |
| JME142030G2R020Z2.0-HXT | 03205208 | 2 | G | 3,0 | 6,0 | 2,25 | 50,0 | 9,0 | 2,85 | 0,2 | 0,0 | 5,86 | 2 | ■ |
| JME142030G2R030Z2.0-HXT | 03205211 | 2 | G | 3,0 | 6,0 | 2,25 | 50,0 | 9,0 | 2,85 | 0,3 | 0,0 | 5,9 | 2 | ■ |
| JME142005J3R005Z2.0-HXT | 03205089 | 3 | J | 0,5 | 4,0 | 0,375 | 40,0 | 2,5 | 0,46 | 0,05 | 0,9 | 11,24 | 2 | ■ |
| JME142005J3R010Z2.0-HXT | 03205095 | 3 | J | 0,5 | 4,0 | 0,375 | 40,0 | 2,5 | 0,46 | 0,1 | 0,9 | 11,29 | 2 | ■ |
| JME142005G3R005Z2.0-HXT | 03205090 | 3 | G | 0,5 | 6,0 | 0,375 | 50,0 | 3,5 | 0,46 | 0,05 | 0,0 | 11,55 | 2 | ■ |
| JME142005G3R010Z2.0-HXT | 03205096 | 3 | G | 0,5 | 6,0 | 0,375 | 50,0 | 3,5 | 0,46 | 0,1 | 0,0 | 11,59 | 2 | ■ |
| JME142006J3R005Z2.0-HXT | 03205103 | 3 | J | 0,6 | 4,0 | 0,45 | 40,0 | 3,0 | 0,56 | 0,05 | 0,9 | 10,58 | 2 | ■ |
| JME142006J3R010Z2.0-HXT | 03205109 | 3 | J | 0,6 | 4,0 | 0,45 | 40,0 | 3,0 | 0,56 | 0,1 | 0,9 | 10,63 | 2 | ■ |
| JME142006G3R005Z2.0-HXT | 03205104 | 3 | G | 0,6 | 6,0 | 0,45 | 50,0 | 4,0 | 0,56 | 0,05 | 0,0 | 8,46 | 2 | ■ |
| JME142006G3R010Z2.0-HXT | 03205110 | 3 | G | 0,6 | 6,0 | 0,45 | 50,0 | 4,0 | 0,56 | 0,1 | 0,0 | 8,48 | 2 | ■ |
| JME142008J3R005Z2.0-HXT | 03205124 | 3 | J | 0,8 | 4,0 | 0,6 | 40,0 | 4,0 | 0,76 | 0,05 | 0,9 | 9,36 | 2 | ■ |
| JME142008J3R010Z2.0-HXT | 03205131 | 3 | J | 0,8 | 4,0 | 0,6 | 40,0 | 4,0 | 0,76 | 0,1 | 0,9 | 9,4 | 2 | ■ |
| JME142008G3R005Z2.0-HXT | 03205126 | 3 | G | 0,8 | 6,0 | 0,6 | 50,0 | 5,5 | 0,76 | 0,05 | 0,0 | 9,89 | 2 | ■ |
| JME142008G3R010Z2.0-HXT | 03205132 | 3 | G | 0,8 | 6,0 | 0,6 | 50,0 | 5,5 | 0,76 | 0,1 | 0,0 | 9,92 | 2 | ■ |
| JME142008G3R020Z2.0-HXT | 03205137 | 3 | G | 0,8 | 6,0 | 0,6 | 50,0 | 5,5 | 0,76 | 0,2 | 0,0 | 9,98 | 2 | ■ |
| JME142010G3R005Z2.0-HXT | 03205141 | 3 | G | 1,0 | 6,0 | 0,75 | 50,0 | 7,0 | 0,95 | 0,05 | 0,0 | 8,84 | 2 | ■ |
| JME142010G3R010Z2.0-HXT | 03205146 | 3 | G | 1,0 | 6,0 | 0,75 | 50,0 | 7,0 | 0,95 | 0,1 | 0,0 | 8,86 | 2 | ■ |
| JME142010G3R020Z2.0-HXT | 03205149 | 3 | G | 1,0 | 6,0 | 0,75 | 50,0 | 7,0 | 0,95 | 0,2 | 0,0 | 8,91 | 2 | ■ |
| JME142012G3R005Z2.0-HXT | 03205153 | 3 | G | 1,2 | 6,0 | 0,9 | 50,0 | 8,0 | 1,15 | 0,05 | 0,0 | 8,16 | 2 | ■ |
| JME142012G3R010Z2.0-HXT | 03205156 | 3 | G | 1,2 | 6,0 | 0,9 | 50,0 | 8,0 | 1,15 | 0,1 | 0,0 | 8,19 | 2 | ■ |
| JME142012G3R020Z2.0-HXT | 03205159 | 3 | G | 1,2 | 6,0 | 0,9 | 50,0 | 8,0 | 1,15 | 0,2 | 0,0 | 8,23 | 2 | ■ |
| JME142015G3R005Z2.0-HXT | 03205163 | 3 | G | 1,5 | 6,0 | 1,125 | 50,0 | 10,0 | 1,45 | 0,05 | 0,0 | 7,05 | 2 | ■ |
| JME142015G3R010Z2.0-HXT | 03205169 | 3 | G | 1,5 | 6,0 | 1,125 | 50,0 | 10,0 | 1,45 | 0,1 | 0,0 | 7,06 | 2 | ■ |
| JME142015G3R020Z2.0-HXT | 03205172 | 3 | G | 1,5 | 6,0 | 1,125 | 50,0 | 10,0 | 1,45 | 0,2 | 0,0 | 7,1 | 2 | ■ |

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Harder

Kunststoffe und Composite

Graphit

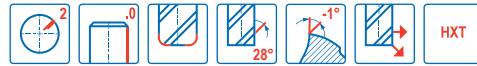
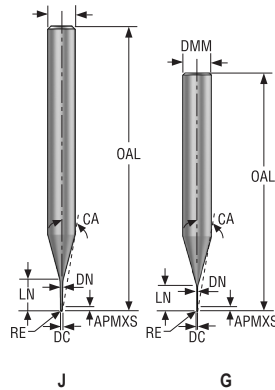
X-Heads

Minimaster Plus

Minimaster

JME142

Mini – Gehärteter Stahl – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC = $\varnothing 0,6 = 0/-0,008\text{ mm}$
- DC = $\ge \varnothing 0,6 = 0/-0,01\text{ mm}$
- RE = $\pm 0,005\text{ mm}$

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | NA° | CA° | PCEDC | Zylindrisch |
|-------------------------|----------------|--------------|---------------|-----|-----|-------|------|------|------|------|-----|-------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | mm | | |
| JME142020G3R005Z2.0-HXT | 03205181 | 3 | G | 2,0 | 6,0 | 1,5 | 50,0 | 12,0 | 1,94 | 0,05 | 0,0 | 5,9 | 2 | ■ |
| JME142020G3R010Z2.0-HXT | 03205186 | 3 | G | 2,0 | 6,0 | 1,5 | 50,0 | 12,0 | 1,94 | 0,1 | 0,0 | 5,92 | 2 | ■ |
| JME142020G3R020Z2.0-HXT | 03205189 | 3 | G | 2,0 | 6,0 | 1,5 | 50,0 | 12,0 | 1,94 | 0,2 | 0,0 | 5,95 | 2 | ■ |
| JME142030G3R005Z2.0-HXT | 03205202 | 3 | G | 3,0 | 6,0 | 2,25 | 60,0 | 15,0 | 2,85 | 0,05 | 0,0 | 4,14 | 2 | ■ |
| JME142030G3R010Z2.0-HXT | 03205206 | 3 | G | 3,0 | 6,0 | 2,25 | 60,0 | 15,0 | 2,85 | 0,1 | 0,0 | 4,15 | 2 | ■ |
| JME142030G3R020Z2.0-HXT | 03205209 | 3 | G | 3,0 | 6,0 | 2,25 | 60,0 | 15,0 | 2,85 | 0,2 | 0,0 | 4,17 | 2 | ■ |
| JME142030G3R030Z2.0-HXT | 03205212 | 3 | G | 3,0 | 6,0 | 2,25 | 60,0 | 15,0 | 2,85 | 0,3 | 0,0 | 4,19 | 2 | ■ |
| JME142005J4R005Z2.0-HXT | 03205091 | 4 | J | 0,5 | 4,0 | 0,375 | 40,0 | 4,0 | 0,46 | 0,05 | 0,9 | 9,71 | 2 | ■ |
| JME142005J4R010Z2.0-HXT | 03205097 | 4 | J | 0,5 | 4,0 | 0,375 | 40,0 | 4,0 | 0,46 | 0,1 | 0,9 | 9,76 | 2 | ■ |
| JME142005G4R005Z2.0-HXT | 03205092 | 4 | G | 0,5 | 6,0 | 0,375 | 50,0 | 5,0 | 0,46 | 0,05 | 0,0 | 10,42 | 2 | ■ |
| JME142005G4R010Z2.0-HXT | 03205098 | 4 | G | 0,5 | 6,0 | 0,375 | 50,0 | 5,0 | 0,46 | 0,1 | 0,0 | 10,45 | 2 | ■ |
| JME142006J4R005Z2.0-HXT | 03205105 | 4 | J | 0,6 | 4,0 | 0,45 | 40,0 | 5,0 | 0,56 | 0,05 | 0,9 | 8,79 | 2 | ■ |
| JME142006J4R010Z2.0-HXT | 03205118 | 4 | J | 0,6 | 4,0 | 0,45 | 40,0 | 5,0 | 0,56 | 0,1 | 0,9 | 8,83 | 2 | ■ |
| JME142006G4R005Z2.0-HXT | 03205106 | 4 | G | 0,6 | 6,0 | 0,45 | 50,0 | 6,0 | 0,56 | 0,05 | 0,0 | 9,72 | 2 | ■ |
| JME142006G4R010Z2.0-HXT | 03205120 | 4 | G | 0,6 | 6,0 | 0,45 | 50,0 | 6,0 | 0,56 | 0,1 | 0,0 | 9,75 | 2 | ■ |
| JME142008J4R005Z2.0-HXT | 03205127 | 4 | J | 0,8 | 4,0 | 0,6 | 40,0 | 7,0 | 0,76 | 0,05 | 0,9 | 7,28 | 2 | ■ |
| JME142008J4R010Z2.0-HXT | 03205133 | 4 | J | 0,8 | 4,0 | 0,6 | 40,0 | 7,0 | 0,76 | 0,1 | 0,9 | 7,3 | 2 | ■ |
| JME142008G4R005Z2.0-HXT | 03205128 | 4 | G | 0,8 | 6,0 | 0,6 | 50,0 | 8,0 | 0,76 | 0,05 | 0,0 | 8,49 | 2 | ■ |
| JME142008G4R010Z2.0-HXT | 03205134 | 4 | G | 0,8 | 6,0 | 0,6 | 50,0 | 8,0 | 0,76 | 0,1 | 0,0 | 8,51 | 2 | ■ |
| JME142008G4R020Z2.0-HXT | 03205138 | 4 | G | 0,8 | 6,0 | 0,6 | 50,0 | 8,0 | 0,76 | 0,2 | 0,0 | 8,56 | 2 | ■ |
| JME142010G4R005Z2.0-HXT | 03205142 | 4 | G | 1,0 | 6,0 | 0,75 | 50,0 | 10,0 | 0,95 | 0,05 | 0,0 | 7,47 | 2 | ■ |
| JME142010G4R010Z2.0-HXT | 03205147 | 4 | G | 1,0 | 6,0 | 0,75 | 50,0 | 10,0 | 0,95 | 0,1 | 0,0 | 7,48 | 2 | ■ |
| JME142010G4R020Z2.0-HXT | 03205150 | 4 | G | 1,0 | 6,0 | 0,75 | 50,0 | 10,0 | 0,95 | 0,2 | 0,0 | 7,52 | 2 | ■ |
| JME142012G4R005Z2.0-HXT | 03205154 | 4 | G | 1,2 | 6,0 | 0,9 | 50,0 | 12,0 | 1,15 | 0,05 | 0,0 | 6,61 | 2 | ■ |
| JME142012G4R010Z2.0-HXT | 03205157 | 4 | G | 1,2 | 6,0 | 0,9 | 50,0 | 12,0 | 1,15 | 0,1 | 0,0 | 6,62 | 2 | ■ |
| JME142012G4R020Z2.0-HXT | 03205160 | 4 | G | 1,2 | 6,0 | 0,9 | 50,0 | 12,0 | 1,15 | 0,2 | 0,0 | 6,65 | 2 | ■ |
| JME142015G4R005Z2.0-HXT | 03205164 | 4 | G | 1,5 | 6,0 | 1,125 | 60,0 | 15,0 | 1,45 | 0,05 | 0,0 | 5,54 | 2 | ■ |
| JME142015G4R010Z2.0-HXT | 03205170 | 4 | G | 1,5 | 6,0 | 1,125 | 60,0 | 15,0 | 1,45 | 0,1 | 0,0 | 5,55 | 2 | ■ |
| JME142015G4R020Z2.0-HXT | 03205173 | 4 | G | 1,5 | 6,0 | 1,125 | 60,0 | 15,0 | 1,45 | 0,2 | 0,0 | 5,58 | 2 | ■ |

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Harder

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Graphit

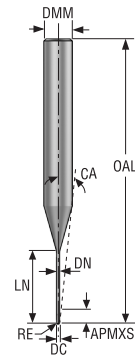
X-Heads

Minimaster Plus

Minimaster

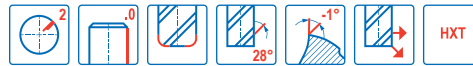
JME142

Mini – Gehärteter Stahl – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius



G

- Toleranzen:
- Rundlaufabweichung = <math><0,005\text{ mm}</math>
- DMM = h5
- DC = <math><0,6= 0/-0,008\text{ mm}</math>
- DC = $\geq 0,6= 0/-0,01\text{ mm}$
- RE = $\pm 0,005\text{ mm}$



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | CA° | PCEDC | Zylindrisch |
|-------------------------|--------------------|------------------|-------------------|-----|-----|-------|------|------|------|------|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | | |
| JME142020G4R005Z2.0-HXT | 03205182 | 4 | G | 2,0 | 6,0 | 1,5 | 60,0 | 20,0 | 1,94 | 0,05 | 4,19 | 2 | ■ |
| JME142020G4R010Z2.0-HXT | 03205187 | 4 | G | 2,0 | 6,0 | 1,5 | 60,0 | 20,0 | 1,94 | 0,1 | 4,19 | 2 | ■ |
| JME142020G4R020Z2.0-HXT | 03205190 | 4 | G | 2,0 | 6,0 | 1,5 | 60,0 | 20,0 | 1,94 | 0,2 | 4,21 | 2 | ■ |
| JME142030G4R010Z2.0-HXT | 03205207 | 4 | G | 3,0 | 6,0 | 2,25 | 80,0 | 30,0 | 2,85 | 0,1 | 2,41 | 2 | ■ |
| JME142030G4R020Z2.0-HXT | 03205210 | 4 | G | 3,0 | 6,0 | 2,25 | 80,0 | 30,0 | 2,85 | 0,2 | 2,42 | 2 | ■ |
| JME142030G4R030Z2.0-HXT | 03205213 | 4 | G | 3,0 | 6,0 | 2,25 | 80,0 | 30,0 | 2,85 | 0,3 | 2,42 | 2 | ■ |
| JME142010G5R005Z2.0-HXT | 03205143 | 5 | G | 1,0 | 6,0 | 0,75 | 60,0 | 15,0 | 0,95 | 0,05 | 5,93 | 2 | ■ |
| JME142015G5R005Z2.0-HXT | 03205165 | 5 | G | 1,5 | 6,0 | 1,125 | 80,0 | 22,5 | 1,45 | 0,05 | 4,2 | 2 | ■ |
| JME142020G5R005Z2.0-HXT | 03205183 | 5 | G | 2,0 | 6,0 | 1,5 | 80,0 | 30,0 | 1,94 | 0,05 | 3,07 | 2 | ■ |
| JME142030G5R005Z2.0-HXT | 03205203 | 5 | G | 3,0 | 6,0 | 2,25 | 90,0 | 45,0 | 2,85 | 0,05 | 1,7 | 2 | ■ |
| JME142010G6R005Z2.0-HXT | 03205144 | 6 | G | 1,0 | 6,0 | 0,75 | 60,0 | 20,0 | 0,95 | 0,05 | 4,92 | 2 | ■ |
| JME142015G6R005Z2.0-HXT | 03205166 | 6 | G | 1,5 | 6,0 | 1,125 | 80,0 | 30,0 | 1,45 | 0,05 | 3,37 | 2 | ■ |
| JME142020G6R005Z2.0-HXT | 03205184 | 6 | G | 2,0 | 6,0 | 1,5 | 80,0 | 40,0 | 1,94 | 0,05 | 2,42 | 2 | ■ |
| JME142030G6R005Z2.0-HXT | 03205204 | 6 | G | 3,0 | 6,0 | 2,25 | 90,0 | 60,0 | 2,85 | 0,05 | 1,31 | 2 | ■ |

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NE-Metalle

Harter

Kunststoffe und
Composite


Graphit

X-Heads


Minimaster Plus

Minimaster

Schnittdaten – JME142 Eckfräsen/Schruppen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|---------|---------|---------|---------|---------|--------|--------|--------|--------|--------|-----------------|
| | | | | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.8 | 1 | 1.2 | 1.5 | 1.8 | 2 | 2.5 | 3 | |
| H3 | M/A | 0.0500 | 0.30 | 0.0036 | 0.0055 | 0.0070 | 0.0090 | 0.011 | 0.014 | 0.018 | 0.022 | 0.026 | 0.032 | 0.036 | 0.044 | 0.055 | 90 (59 — 110) |
| | | 0,0500 | 0,30 | 0,00014 | 0,00022 | 0,00028 | 0,00036 | 0,00044 | 0,00055 | 0,00070 | 0,00085 | 0,0010 | 0,0013 | 0,0014 | 0,0017 | 0,0022 | 295 (200 — 360) |
| H5 | M/A | 0.0500 | 0.46 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.036 | 0.040 | 0.050 | 0.060 | 160 (140 — 190) |
| | | 0,0500 | 0,46 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 520 (460 — 620) |
| H7 | M/A | 0.0500 | 0.30 | 0.0036 | 0.0055 | 0.0070 | 0.0090 | 0.011 | 0.014 | 0.018 | 0.022 | 0.026 | 0.032 | 0.036 | 0.044 | 0.055 | 90 (59 — 110) |
| | | 0,0500 | 0,30 | 0,00014 | 0,00022 | 0,00028 | 0,00036 | 0,00044 | 0,00055 | 0,00070 | 0,00085 | 0,0010 | 0,0013 | 0,0014 | 0,0017 | 0,0022 | 295 (200 — 360) |
| H8 | M/A | 0.0500 | 0.46 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.036 | 0.040 | 0.050 | 0.060 | 160 (140 — 190) |
| | | 0,0500 | 0,46 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 520 (460 — 620) |
| H11 | M/A | 0.0500 | 0.46 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.036 | 0.040 | 0.050 | 0.060 | 205 (170 — 240) |
| | | 0,0500 | 0,46 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 670 (560 — 780) |
| H12 | M/A | 0.0500 | 0.46 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.036 | 0.040 | 0.050 | 0.060 | 190 (160 — 220) |
| | | 0,0500 | 0,46 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 620 (530 — 720) |
| H21 | M/A | 0.0500 | 0.46 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.036 | 0.040 | 0.050 | 0.060 | 160 (140 — 190) |
| | | 0,0500 | 0,46 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 520 (460 — 620) |
| H31 | M/A | 0.0500 | 0.46 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.036 | 0.040 | 0.050 | 0.060 | 120 (110 — 140) |
| | | 0,0500 | 0,46 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 395 (370 — 450) |

Schnittdaten – JME142 Nutfräsen

| SMG |  | a _p /DC | f _z | | | | | | | | | | | | | v _c |
|-----|---|--------------------|----------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|---------|--------|--------|-----------------|
| | | | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.8 | 1 | 1.2 | 1.5 | 1.8 | 2 | 2.5 | 3 | |
| H3 | M/A | 0.012 | 0.0024 | 0.0036 | 0.0048 | 0.0060 | 0.0070 | 0.0095 | 0.012 | 0.014 | 0.018 | 0.022 | 0.024 | 0.030 | 0.036 | 65 (43 — 85) |
| | | 0,012 | 0,000095 | 0,00014 | 0,00019 | 0,00024 | 0,00028 | 0,00038 | 0,00048 | 0,00055 | 0,00070 | 0,00085 | 0,00095 | 0,0012 | 0,0014 | 215 (150 — 270) |
| H5 | M/A | 0.020 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.036 | 0.040 | 0.050 | 0.060 | 120 (97 — 130) |
| | | 0,020 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 395 (320 — 420) |
| H7 | M/A | 0.012 | 0.0024 | 0.0036 | 0.0048 | 0.0060 | 0.0070 | 0.0095 | 0.012 | 0.014 | 0.018 | 0.022 | 0.024 | 0.030 | 0.036 | 65 (43 — 85) |
| | | 0,012 | 0,000095 | 0,00014 | 0,00019 | 0,00024 | 0,00028 | 0,00038 | 0,00048 | 0,00055 | 0,00070 | 0,00085 | 0,00095 | 0,0012 | 0,0014 | 215 (150 — 270) |
| H8 | M/A | 0.020 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.036 | 0.040 | 0.050 | 0.060 | 120 (97 — 130) |
| | | 0,020 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 395 (320 — 420) |
| H11 | M/A | 0.020 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.036 | 0.040 | 0.050 | 0.060 | 150 (130 — 170) |
| | | 0,020 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 490 (430 — 550) |
| H12 | M/A | 0.020 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.036 | 0.040 | 0.050 | 0.060 | 135 (120 — 160) |
| | | 0,020 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 445 (400 — 520) |
| H21 | M/A | 0.012 | 0.0024 | 0.0036 | 0.0048 | 0.0060 | 0.0070 | 0.0095 | 0.012 | 0.014 | 0.018 | 0.022 | 0.024 | 0.030 | 0.036 | 120 (98 — 140) |
| | | 0,012 | 0,000095 | 0,00014 | 0,00019 | 0,00024 | 0,00028 | 0,00038 | 0,00048 | 0,00055 | 0,00070 | 0,00085 | 0,00095 | 0,0012 | 0,0014 | 395 (330 — 450) |
| H31 | M/A | 0.020 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.036 | 0.040 | 0.050 | 0.060 | 90 (73 — 100) |
| | | 0,020 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 295 (240 — 320) |

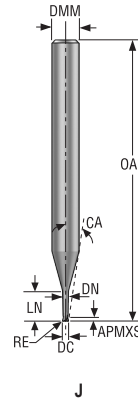
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

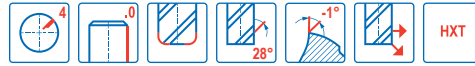
Unversell
 Stahl und Guss
 Rostfrei und ISO-S-Werkstoffe
 NE-Metalle
 Harter
 Kunststoffe und Composite
 Graphit
 X-Heads
 Minmaster Plus
 Minmaster

JME144

Mini – Gehärteter Stahl – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius




- Toleranzen:
- Rundlaufabweichung = <math><0,005\text{ mm}</math>
- DMM=h5
- DC = 0-0,01 mm
- RE= ±0,005 mm




| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | NA° | CA° | PCEDC | Zylindrisch |
|-------------------------|----------------|--------------|---------------|-----|-----|-------|------|------|------|------|-----|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | mm | | |
| JME144010J2R005Z4.0-HXT | 03205214 | 2 | J | 1,0 | 4,0 | 0,75 | 40,0 | 4,0 | 0,95 | 0,05 | 0,9 | 9,08 | 4 | ■ |
| JME144010J2R010Z4.0-HXT | 03205217 | 2 | J | 1,0 | 4,0 | 0,75 | 40,0 | 4,0 | 0,95 | 0,1 | 0,9 | 9,13 | 4 | ■ |
| JME144010J2R020Z4.0-HXT | 03205220 | 2 | J | 1,0 | 4,0 | 0,75 | 40,0 | 4,0 | 0,95 | 0,2 | 0,9 | 9,22 | 4 | ■ |
| JME144012J2R005Z4.0-HXT | 03205221 | 2 | J | 1,2 | 4,0 | 0,9 | 50,0 | 4,5 | 1,15 | 0,05 | 0,9 | 8,37 | 4 | ■ |
| JME144012J2R010Z4.0-HXT | 03205224 | 2 | J | 1,2 | 4,0 | 0,9 | 50,0 | 4,5 | 1,15 | 0,1 | 0,9 | 8,41 | 4 | ■ |
| JME144015J2R005Z4.0-HXT | 03205227 | 2 | J | 1,5 | 4,0 | 1,125 | 50,0 | 5,0 | 1,45 | 0,05 | 0,9 | 7,52 | 4 | ■ |
| JME144015J2R010Z4.0-HXT | 03205229 | 2 | J | 1,5 | 4,0 | 1,125 | 50,0 | 5,0 | 1,45 | 0,1 | 0,9 | 7,56 | 4 | ■ |
| JME144015J2R020Z4.0-HXT | 03205232 | 2 | J | 1,5 | 4,0 | 1,125 | 50,0 | 5,0 | 1,45 | 0,2 | 0,9 | 7,63 | 4 | ■ |
| JME144020J2R005Z4.0-HXT | 03205234 | 2 | J | 2,0 | 4,0 | 1,5 | 50,0 | 6,0 | 1,94 | 0,05 | 0,9 | 5,97 | 4 | ■ |
| JME144020J2R010Z4.0-HXT | 03205236 | 2 | J | 2,0 | 4,0 | 1,5 | 50,0 | 6,0 | 1,94 | 0,1 | 0,9 | 6,0 | 4 | ■ |
| JME144020J2R020Z4.0-HXT | 03205239 | 2 | J | 2,0 | 4,0 | 1,5 | 50,0 | 6,0 | 1,94 | 0,2 | 0,9 | 6,06 | 4 | ■ |
| JME144020J2R030Z4.0-HXT | 03205241 | 2 | J | 2,0 | 4,0 | 1,5 | 50,0 | 6,0 | 1,94 | 0,3 | 0,9 | 6,12 | 4 | ■ |
| JME144030J2R010Z4.0-HXT | 03205243 | 2 | J | 3,0 | 4,0 | 2,25 | 50,0 | 9,0 | 2,85 | 0,1 | 0,9 | 2,66 | 4 | ■ |
| JME144030J2R020Z4.0-HXT | 03205246 | 2 | J | 3,0 | 4,0 | 2,25 | 50,0 | 9,0 | 2,85 | 0,2 | 0,9 | 2,69 | 4 | ■ |
| JME144010J3R005Z4.0-HXT | 03205215 | 3 | J | 1,0 | 4,0 | 0,75 | 40,0 | 5,0 | 0,95 | 0,05 | 0,9 | 8,27 | 4 | ■ |
| JME144010J3R010Z4.0-HXT | 03205218 | 3 | J | 1,0 | 4,0 | 0,75 | 40,0 | 5,0 | 0,95 | 0,1 | 0,9 | 8,3 | 4 | ■ |
| JME144012J3R005Z4.0-HXT | 03205222 | 3 | J | 1,2 | 4,0 | 0,9 | 50,0 | 6,0 | 1,15 | 0,05 | 0,9 | 7,3 | 4 | ■ |
| JME144012J3R010Z4.0-HXT | 03205225 | 3 | J | 1,2 | 4,0 | 0,9 | 50,0 | 6,0 | 1,15 | 0,1 | 0,9 | 7,33 | 4 | ■ |
| JME144015J3R005Z4.0-HXT | 03205228 | 3 | J | 1,5 | 4,0 | 1,125 | 50,0 | 7,5 | 1,45 | 0,05 | 0,9 | 6,04 | 4 | ■ |
| JME144015J3R010Z4.0-HXT | 03205230 | 3 | J | 1,5 | 4,0 | 1,125 | 50,0 | 7,5 | 1,45 | 0,1 | 0,9 | 6,06 | 4 | ■ |
| JME144020J3R005Z4.0-HXT | 03205235 | 3 | J | 2,0 | 4,0 | 1,5 | 50,0 | 10,0 | 1,94 | 0,05 | 0,9 | 4,29 | 4 | ■ |
| JME144020J3R010Z4.0-HXT | 03205237 | 3 | J | 2,0 | 4,0 | 1,5 | 50,0 | 10,0 | 1,94 | 0,1 | 0,9 | 4,31 | 4 | ■ |
| JME144030J3R005Z4.0-HXT | 03205242 | 3 | J | 3,0 | 4,0 | 2,25 | 50,0 | 15,0 | 2,85 | 0,05 | 0,9 | 1,74 | 4 | ■ |
| JME144030J3R010Z4.0-HXT | 03205244 | 3 | J | 3,0 | 4,0 | 2,25 | 50,0 | 15,0 | 2,85 | 0,1 | 0,9 | 1,75 | 4 | ■ |
| JME144010J4R005Z4.0-HXT | 03205216 | 4 | J | 1,0 | 4,0 | 0,75 | 40,0 | 8,5 | 0,95 | 0,05 | 0,9 | 6,28 | 4 | ■ |
| JME144010J4R010Z4.0-HXT | 03205219 | 4 | J | 1,0 | 4,0 | 0,75 | 40,0 | 8,5 | 0,95 | 0,1 | 0,9 | 6,31 | 4 | ■ |
| JME144012J4R005Z4.0-HXT | 03205223 | 4 | J | 1,2 | 4,0 | 0,9 | 50,0 | 10,0 | 1,15 | 0,05 | 0,9 | 5,44 | 4 | ■ |
| JME144012J4R010Z4.0-HXT | 03205226 | 4 | J | 1,2 | 4,0 | 0,9 | 50,0 | 10,0 | 1,15 | 0,1 | 0,9 | 5,46 | 4 | ■ |
| JME144015J4R010Z4.0-HXT | 03205231 | 4 | J | 1,5 | 4,0 | 1,125 | 60,0 | 12,0 | 1,45 | 0,1 | 0,9 | 4,46 | 4 | ■ |
| JME144015J4R020Z4.0-HXT | 03205233 | 4 | J | 1,5 | 4,0 | 1,125 | 60,0 | 12,0 | 1,45 | 0,2 | 0,9 | 4,49 | 4 | ■ |
| JME144020J4R010Z4.0-HXT | 03205238 | 4 | J | 2,0 | 4,0 | 1,5 | 60,0 | 16,0 | 1,94 | 0,1 | 0,9 | 3,02 | 4 | ■ |
| JME144020J4R020Z4.0-HXT | 03205240 | 4 | J | 2,0 | 4,0 | 1,5 | 60,0 | 16,0 | 1,94 | 0,2 | 0,9 | 3,04 | 4 | ■ |
| JME144030J4R010Z4.0-HXT | 03205245 | 4 | J | 3,0 | 4,0 | 2,25 | 60,0 | 24,0 | 2,85 | 0,1 | 0,9 | 1,16 | 4 | ■ |
| JME144030J4R020Z4.0-HXT | 03205248 | 4 | J | 3,0 | 4,0 | 2,25 | 60,0 | 24,0 | 2,85 | 0,2 | 0,9 | 1,16 | 4 | ■ |

■ Lagerstandard.

Schnittdaten – JME144 Eckfräsen/Schruppen

| SMG |  | a _p /DC | a _e /DC | f _z | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|--------|--------|-----------------|
| | | | | 1.0 | 1.2 | 1.5 | 2.0 | 3 | |
| H3 | M/A | 0.0500 | 0.095 | 0.013 | 0.016 | 0.020 | 0.026 | 0.040 | 95 (65 – 120) |
| | | 0,0500 | 0,095 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0016 | 310 (220 – 390) |
| H5 | M/A | 0.0500 | 0.22 | 0.014 | 0.017 | 0.020 | 0.028 | 0.042 | 165 (140 – 190) |
| | | 0,0500 | 0,22 | 0,00055 | 0,00065 | 0,00080 | 0,0011 | 0,0017 | 540 (460 – 620) |
| H7 | M/A | 0.0500 | 0.095 | 0.013 | 0.016 | 0.020 | 0.026 | 0.040 | 95 (65 – 120) |
| | | 0,0500 | 0,095 | 0,00050 | 0,00065 | 0,00080 | 0,0010 | 0,0016 | 310 (220 – 390) |
| H8 | M/A | 0.0500 | 0.22 | 0.014 | 0.017 | 0.020 | 0.028 | 0.042 | 165 (140 – 190) |
| | | 0,0500 | 0,22 | 0,00055 | 0,00065 | 0,00080 | 0,0011 | 0,0017 | 540 (460 – 620) |
| H11 | M/A | 0.0500 | 0.22 | 0.014 | 0.017 | 0.020 | 0.028 | 0.042 | 210 (180 – 240) |
| | | 0,0500 | 0,22 | 0,00055 | 0,00065 | 0,00080 | 0,0011 | 0,0017 | 690 (600 – 780) |
| H12 | M/A | 0.0500 | 0.22 | 0.014 | 0.017 | 0.020 | 0.028 | 0.042 | 190 (160 – 220) |
| | | 0,0500 | 0,22 | 0,00055 | 0,00065 | 0,00080 | 0,0011 | 0,0017 | 620 (530 – 720) |
| H21 | M/A | 0.0500 | 0.22 | 0.014 | 0.017 | 0.020 | 0.028 | 0.042 | 165 (140 – 190) |
| | | 0,0500 | 0,22 | 0,00055 | 0,00065 | 0,00080 | 0,0011 | 0,0017 | 540 (460 – 620) |
| H31 | M/A | 0.0500 | 0.22 | 0.014 | 0.017 | 0.020 | 0.028 | 0.042 | 125 (110 – 140) |
| | | 0,0500 | 0,22 | 0,00055 | 0,00065 | 0,00080 | 0,0011 | 0,0017 | 410 (370 – 450) |

Schnittdaten – JME144 Nutfräsen

| SMG |  | a _p /DC | f _z | | | | | v _c |
|-----|---|--------------------|----------------|---------|---------|---------|---------|-----------------|
| | | | 1.0 | 1.2 | 1.5 | 2.0 | 3,0 | |
| H3 | M/A | 0.0090 | 0.0065 | 0.0075 | 0.0095 | 0.013 | 0.019 | 65 (43 – 84) |
| | | 0,0090 | 0,00026 | 0,00030 | 0,00038 | 0,00050 | 0,00075 | 215 (150 – 270) |
| H5 | M/A | 0.019 | 0.012 | 0.014 | 0.018 | 0.024 | 0.036 | 115 (96 – 130) |
| | | 0,019 | 0,00048 | 0,00055 | 0,00070 | 0,00095 | 0,0014 | 375 (320 – 420) |
| H7 | M/A | 0.0090 | 0.0065 | 0.0075 | 0.0095 | 0.013 | 0.019 | 65 (43 – 84) |
| | | 0,0090 | 0,00026 | 0,00030 | 0,00038 | 0,00050 | 0,00075 | 215 (150 – 270) |
| H8 | M/A | 0.019 | 0.012 | 0.014 | 0.018 | 0.024 | 0.036 | 115 (96 – 130) |
| | | 0,019 | 0,00048 | 0,00055 | 0,00070 | 0,00095 | 0,0014 | 375 (320 – 420) |
| H11 | M/A | 0.019 | 0.012 | 0.014 | 0.018 | 0.024 | 0.036 | 150 (130 – 170) |
| | | 0,019 | 0,00048 | 0,00055 | 0,00070 | 0,00095 | 0,0014 | 490 (430 – 550) |
| H12 | M/A | 0.019 | 0.012 | 0.014 | 0.018 | 0.024 | 0.036 | 135 (120 – 160) |
| | | 0,019 | 0,00048 | 0,00055 | 0,00070 | 0,00095 | 0,0014 | 445 (400 – 520) |
| H21 | M/A | 0.019 | 0.012 | 0.014 | 0.018 | 0.024 | 0.036 | 115 (96 – 130) |
| | | 0,019 | 0,00048 | 0,00055 | 0,00070 | 0,00095 | 0,0014 | 375 (320 – 420) |
| H31 | M/A | 0.019 | 0.012 | 0.014 | 0.018 | 0.024 | 0.036 | 90 (73 – 100) |
| | | 0,019 | 0,00048 | 0,00055 | 0,00070 | 0,00095 | 0,0014 | 295 (240 – 320) |

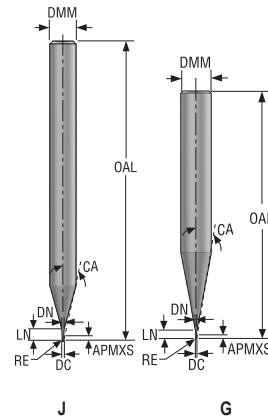
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

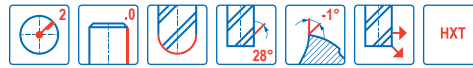
Unversell
 Stahl und Guss
 Stahl und Guss
 Rostfrei und ISO-S-Werkstoffe
 NE-Metalle
 Harter
 Kunststoffe und Composite
 Graphit
 X-Heads
 Minimeter Plus
 Minimeter

JMB112

Mini – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch



- Toleranzen:
- Rundlaufabweichung = <math><0,005\text{ mm}</math>
- DMM = h5
- DC= <math><0,6= 0/-0,008\text{ mm}</math>
- DC= $\geq 0,6= 0/-0,01\text{ mm}$
- RE= <math><0,5= \pm 0,004\text{ mm}</math>
- RE= $\geq 0,5= \pm 0,005\text{ mm}$



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | NA° | CA° | PCEDC | Zylindrisch |
|----------------------|----------------|--------------|---------------|-----|-----|-------|------|-----|------|------|-----|-------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | mm | | |
| JMB112002G1BZ2.0-HXT | 03204964 | 1 | G | 0,2 | 4,0 | 0,15 | 40,0 | 0,4 | 0,18 | 0,1 | 0,0 | 15,11 | 2 | ■ |
| JMB112003G1BZ2.0-HXT | 03204966 | 1 | G | 0,3 | 4,0 | 0,225 | 40,0 | 0,6 | 0,28 | 0,15 | 0,0 | 14,77 | 2 | ■ |
| JMB112004G1BZ2.0-HXT | 03204968 | 1 | G | 0,4 | 4,0 | 0,3 | 40,0 | 0,8 | 0,37 | 0,2 | 0,0 | 14,32 | 2 | ■ |
| JMB112005G1BZ2.0-HXT | 03204970 | 1 | G | 0,5 | 4,0 | 0,5 | 40,0 | 1,0 | 0,46 | 0,25 | 0,0 | 13,97 | 2 | ■ |
| JMB112006G1BZ2.0-HXT | 03204977 | 1 | G | 0,6 | 4,0 | 0,6 | 40,0 | 1,2 | 0,56 | 0,3 | 0,0 | 13,64 | 2 | ■ |
| JMB112008G1BZ2.0-HXT | 03204984 | 1 | G | 0,8 | 6,0 | 0,8 | 50,0 | 1,6 | 0,76 | 0,4 | 0,0 | 13,96 | 2 | ■ |
| JMB112010G1BZ2.0-HXT | 03204991 | 1 | G | 1,0 | 6,0 | 1,0 | 50,0 | 2,0 | 0,95 | 0,5 | 0,0 | 13,49 | 2 | ■ |
| JMB112012G1BZ2.0-HXT | 03205000 | 1 | G | 1,2 | 6,0 | 1,2 | 50,0 | 2,4 | 1,15 | 0,6 | 0,0 | 13,02 | 2 | ■ |
| JMB112015G1BZ2.0-HXT | 03205009 | 1 | G | 1,5 | 6,0 | 1,5 | 50,0 | 3,0 | 1,45 | 0,75 | 0,0 | 12,2 | 2 | ■ |
| JMB112002J2BZ2.0-HXT | 03204965 | 2 | J | 0,2 | 4,0 | 0,15 | 40,0 | 0,6 | 0,18 | 0,1 | 0,9 | 14,33 | 2 | ■ |
| JMB112003J2BZ2.0-HXT | 03204967 | 2 | J | 0,3 | 4,0 | 0,225 | 40,0 | 0,9 | 0,28 | 0,15 | 0,9 | 13,85 | 2 | ■ |
| JMB112004J2BZ2.0-HXT | 03204969 | 2 | J | 0,4 | 4,0 | 0,3 | 40,0 | 1,2 | 0,37 | 0,2 | 0,9 | 13,3 | 2 | ■ |
| JMB112005J2BZ2.0-HXT | 03204971 | 2 | J | 0,5 | 4,0 | 0,5 | 40,0 | 1,5 | 0,46 | 0,25 | 0,9 | 12,85 | 2 | ■ |
| JMB112005G2BZ2.0-HXT | 03204972 | 2 | G | 0,5 | 6,0 | 0,5 | 50,0 | 1,5 | 0,46 | 0,25 | 0,0 | 9,91 | 2 | ■ |
| JMB112006J2BZ2.0-HXT | 03204978 | 2 | J | 0,6 | 4,0 | 0,6 | 50,0 | 2,0 | 0,56 | 0,3 | 0,9 | 12,09 | 2 | ■ |
| JMB112006G2BZ2.0-HXT | 03204979 | 2 | G | 0,6 | 6,0 | 0,6 | 50,0 | 2,0 | 0,56 | 0,3 | 0,0 | 9,62 | 2 | ■ |
| JMB112008J2BZ2.0-HXT | 03204985 | 2 | J | 0,8 | 4,0 | 0,8 | 50,0 | 2,5 | 0,76 | 0,4 | 0,9 | 11,34 | 2 | ■ |
| JMB112008G2BZ2.0-HXT | 03204986 | 2 | G | 0,8 | 6,0 | 0,8 | 50,0 | 2,5 | 0,76 | 0,4 | 0,0 | 9,33 | 2 | ■ |
| JMB112010J2BZ2.0-HXT | 03204992 | 2 | J | 1,0 | 4,0 | 1,0 | 40,0 | 4,0 | 0,95 | 0,5 | 0,9 | 9,49 | 2 | ■ |
| JMB112010G2BZ2.0-HXT | 03204993 | 2 | G | 1,0 | 6,0 | 1,0 | 50,0 | 4,0 | 0,95 | 0,5 | 0,0 | 8,49 | 2 | ■ |
| JMB112012J2BZ2.0-HXT | 03205001 | 2 | J | 1,2 | 4,0 | 1,2 | 50,0 | 4,5 | 1,15 | 0,6 | 0,9 | 8,83 | 2 | ■ |
| JMB112012G2BZ2.0-HXT | 03205002 | 2 | G | 1,2 | 6,0 | 1,2 | 50,0 | 4,5 | 1,15 | 0,6 | 0,0 | 8,21 | 2 | ■ |
| JMB112015J2BZ2.0-HXT | 03205010 | 2 | J | 1,5 | 4,0 | 1,5 | 50,0 | 5,0 | 1,45 | 0,75 | 0,9 | 8,1 | 2 | ■ |
| JMB112015G2BZ2.0-HXT | 03205011 | 2 | G | 1,5 | 6,0 | 1,5 | 50,0 | 5,0 | 1,45 | 0,75 | 0,0 | 10,14 | 2 | ■ |
| JMB112020J2BZ2.0-HXT | 03205024 | 2 | J | 2,0 | 4,0 | 2,0 | 50,0 | 6,0 | 1,94 | 1,0 | 0,9 | 6,6 | 2 | ■ |
| JMB112020G2BZ2.0-HXT | 03205025 | 2 | G | 2,0 | 6,0 | 2,0 | 50,0 | 6,0 | 1,94 | 1,0 | 0,0 | 9,1 | 2 | ■ |
| JMB112030J2BZ2.0-HXT | 03205037 | 2 | J | 3,0 | 4,0 | 3,0 | 50,0 | 9,0 | 2,85 | 1,5 | 0,9 | 3,04 | 2 | ■ |
| JMB112030G2BZ2.0-HXT | 03205038 | 2 | G | 3,0 | 6,0 | 3,0 | 50,0 | 9,0 | 2,85 | 1,5 | 0,0 | 6,35 | 2 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und Composite

Graphit

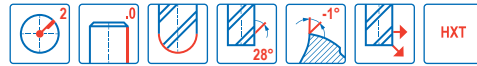
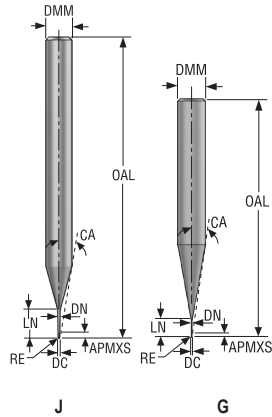
X-Heads

Minimaster Plus

Minimaster

JMB112

Mini – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch



- Toleranzen:
- Rundlaufabweichung = <0,005 mm
- DMM = h5
- DC= $\lt;0,6= 0/-0,008\text{ mm}$
- DC= $\geq 0,6= 0/-0,01\text{ mm}$
- RE= $\lt;0,5= \pm 0,004\text{ mm}$
- RE= $\geq 0,5= \pm 0,005\text{ mm}$

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | NA° | CA° | PCEDC | Zylindrisch |
|----------------------|----------------|--------------|---------------|-----|-----|-------|------|------|------|------|-----|-------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | | | |
| JMB112005J3BZ2.0-HXT | 03204973 | 3 | J | 0,5 | 4,0 | 0,5 | 40,0 | 2,5 | 0,46 | 0,25 | 0,9 | 11,49 | 2 | ■ |
| JMB112005G3BZ2.0-HXT | 03204974 | 3 | G | 0,5 | 6,0 | 0,5 | 50,0 | 3,5 | 0,46 | 0,25 | 0,0 | 8,81 | 2 | ■ |
| JMB112006J3BZ2.0-HXT | 03204980 | 3 | J | 0,6 | 4,0 | 0,6 | 40,0 | 3,0 | 0,56 | 0,3 | 0,9 | 10,83 | 2 | ■ |
| JMB112006G3BZ2.0-HXT | 03204981 | 3 | G | 0,6 | 6,0 | 0,6 | 50,0 | 4,0 | 0,56 | 0,3 | 0,0 | 8,56 | 2 | ■ |
| JMB112008J3BZ2.0-HXT | 03204987 | 3 | J | 0,8 | 4,0 | 0,8 | 40,0 | 4,0 | 0,76 | 0,4 | 0,9 | 9,67 | 2 | ■ |
| JMB112008G3BZ2.0-HXT | 03204988 | 3 | G | 0,8 | 6,0 | 0,8 | 50,0 | 5,5 | 0,76 | 0,4 | 0,0 | 10,1 | 2 | ■ |
| JMB112010J3BZ2.0-HXT | 03204994 | 3 | J | 1,0 | 4,0 | 1,0 | 40,0 | 5,0 | 0,95 | 0,5 | 0,9 | 8,6 | 2 | ■ |
| JMB112010G3BZ2.0-HXT | 03204995 | 3 | G | 1,0 | 6,0 | 1,0 | 50,0 | 7,0 | 0,95 | 0,5 | 0,0 | 9,06 | 2 | ■ |
| JMB112012J3BZ2.0-HXT | 03205003 | 3 | J | 1,2 | 4,0 | 1,2 | 50,0 | 6,0 | 1,15 | 0,6 | 0,9 | 7,65 | 2 | ■ |
| JMB112012G3BZ2.0-HXT | 03205004 | 3 | G | 1,2 | 6,0 | 1,2 | 50,0 | 8,0 | 1,15 | 0,6 | 0,0 | 8,42 | 2 | ■ |
| JMB112015J3BZ2.0-HXT | 03205012 | 3 | J | 1,5 | 4,0 | 1,5 | 40,0 | 7,5 | 1,45 | 0,75 | 0,9 | 6,4 | 2 | ■ |
| JMB112015G3BZ2.0-HXT | 03205013 | 3 | G | 1,5 | 6,0 | 1,5 | 50,0 | 10,0 | 1,45 | 0,75 | 0,0 | 7,31 | 2 | ■ |
| JMB112020J3BZ2.0-HXT | 03205026 | 3 | J | 2,0 | 4,0 | 2,0 | 50,0 | 10,0 | 1,94 | 1,0 | 0,9 | 4,61 | 2 | ■ |
| JMB112020G3BZ2.0-HXT | 03205027 | 3 | G | 2,0 | 6,0 | 2,0 | 50,0 | 12,0 | 1,94 | 1,0 | 0,0 | 6,19 | 2 | ■ |
| JMB112030J3BZ2.0-HXT | 03205039 | 3 | J | 3,0 | 4,0 | 3,0 | 50,0 | 15,0 | 2,85 | 1,5 | 0,9 | 1,91 | 2 | ■ |
| JMB112030G3BZ2.0-HXT | 03205040 | 3 | G | 3,0 | 6,0 | 3,0 | 60,0 | 15,0 | 2,85 | 1,5 | 0,0 | 4,41 | 2 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

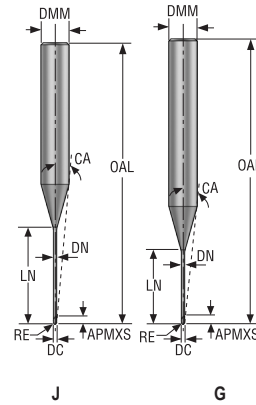
X-Heads

Minimaster Plus

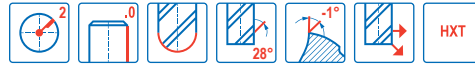
Minimaster

JMB112

Mini – Gehärteter Stahl – Kugelkopf – 2 Schneiden – Zylindrisch



- Toleranzen:
- Rundlaufabweichung = <math><0,005\text{ mm}</math>
- DMM = h5
- DC= <math><0,6= 0/-0,008\text{ mm}</math>
- DC= $\geq 0,6= 0/-0,01\text{ mm}$
- RE= <math><0,5= \pm 0,004\text{ mm}</math>
- RE= $\geq 0,5= \pm 0,005\text{ mm}$



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | NA° | CA° | PCEDC | Zylindrisch |
|----------------------|----------------|--------------|---------------|-----|-----|-------|------|------|------|------|-----|-------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | | | |
| JMB112005J4BZ2.0-HXT | 03204975 | 4 | J | 0,5 | 4,0 | 0,5 | 40,0 | 4,0 | 0,46 | 0,25 | 0,9 | 9,9 | 2 | ■ |
| JMB112005G4BZ2.0-HXT | 03204976 | 4 | G | 0,5 | 6,0 | 0,5 | 50,0 | 5,0 | 0,46 | 0,25 | 0,0 | 10,55 | 2 | ■ |
| JMB112006J4BZ2.0-HXT | 03204982 | 4 | J | 0,6 | 4,0 | 0,6 | 40,0 | 5,0 | 0,56 | 0,3 | 0,9 | 8,97 | 2 | ■ |
| JMB112006G4BZ2.0-HXT | 03204983 | 4 | G | 0,6 | 6,0 | 0,6 | 50,0 | 6,0 | 0,56 | 0,3 | 0,0 | 9,86 | 2 | ■ |
| JMB112008J4BZ2.0-HXT | 03204989 | 4 | J | 0,8 | 4,0 | 0,8 | 40,0 | 7,0 | 0,76 | 0,4 | 0,9 | 7,46 | 2 | ■ |
| JMB112008G4BZ2.0-HXT | 03204990 | 4 | G | 0,8 | 6,0 | 0,8 | 50,0 | 8,0 | 0,76 | 0,4 | 0,0 | 8,65 | 2 | ■ |
| JMB112010J4BZ2.0-HXT | 03204996 | 4 | J | 1,0 | 4,0 | 1,0 | 40,0 | 8,5 | 0,95 | 0,5 | 0,9 | 6,48 | 2 | ■ |
| JMB112010G4BZ2.0-HXT | 03204998 | 4 | G | 1,0 | 6,0 | 1,0 | 50,0 | 10,0 | 0,95 | 0,5 | 0,0 | 7,63 | 2 | ■ |
| JMB112012J4BZ2.0-HXT | 03205005 | 4 | J | 1,2 | 4,0 | 1,2 | 50,0 | 10,0 | 1,15 | 0,6 | 0,9 | 5,63 | 2 | ■ |
| JMB112012G4BZ2.0-HXT | 03205006 | 4 | G | 1,2 | 6,0 | 1,2 | 50,0 | 12,0 | 1,15 | 0,6 | 0,0 | 8,77 | 2 | ■ |
| JMB112015J4BZ2.0-HXT | 03205014 | 4 | J | 1,5 | 4,0 | 1,5 | 60,0 | 12,0 | 1,45 | 0,75 | 0,9 | 4,65 | 2 | ■ |
| JMB112015G4BZ2.0-HXT | 03205015 | 4 | G | 1,5 | 6,0 | 1,5 | 70,0 | 15,0 | 1,45 | 0,75 | 0,0 | 5,7 | 2 | ■ |
| JMB112020J4BZ2.0-HXT | 03205028 | 4 | J | 2,0 | 4,0 | 2,0 | 60,0 | 16,0 | 1,94 | 1,0 | 0,9 | 3,17 | 2 | ■ |
| JMB112020G4BZ2.0-HXT | 03205029 | 4 | G | 2,0 | 6,0 | 2,0 | 60,0 | 18,0 | 1,94 | 1,0 | 0,0 | 4,68 | 2 | ■ |
| JMB112030J4BZ2.0-HXT | 03205041 | 4 | J | 3,0 | 4,0 | 3,0 | 60,0 | 24,0 | 2,85 | 1,5 | 0,9 | 1,22 | 2 | ■ |
| JMB112030G4BZ2.0-HXT | 03205042 | 4 | G | 3,0 | 6,0 | 3,0 | 80,0 | 30,0 | 2,85 | 1,5 | 0,0 | 2,51 | 2 | ■ |
| JMB112010G5BZ2.0-HXT | 03204999 | 5 | G | 1,0 | 6,0 | 1,0 | 60,0 | 15,0 | 0,95 | 0,5 | 0,0 | 6,04 | 2 | ■ |
| JMB112012G5BZ2.0-HXT | 03205007 | 5 | G | 1,2 | 6,0 | 1,2 | 60,0 | 18,0 | 1,15 | 0,6 | 0,0 | 5,24 | 2 | ■ |
| JMB112015G5BZ2.0-HXT | 03205016 | 5 | G | 1,5 | 6,0 | 1,5 | 70,0 | 22,5 | 1,45 | 0,75 | 0,0 | 4,29 | 2 | ■ |
| JMB112020G5BZ2.0-HXT | 03205030 | 5 | G | 2,0 | 6,0 | 2,0 | 80,0 | 30,0 | 1,94 | 1,0 | 0,0 | 3,15 | 2 | ■ |
| JMB112030G5BZ2.0-HXT | 03205043 | 5 | G | 3,0 | 6,0 | 3,0 | 90,0 | 45,0 | 2,85 | 1,5 | 0,0 | 1,75 | 2 | ■ |
| JMB112010G6BZ2.0-HXT | 03205054 | 6 | G | 1,0 | 6,0 | 1,0 | 60,0 | 20,0 | 0,95 | 0,5 | 0,0 | 4,99 | 2 | ■ |
| JMB112012G6BZ2.0-HXT | 03205008 | 6 | G | 1,2 | 6,0 | 1,2 | 70,0 | 24,0 | 1,15 | 0,6 | 0,0 | 4,27 | 2 | ■ |
| JMB112015G6BZ2.0-HXT | 03205017 | 6 | G | 1,5 | 6,0 | 1,5 | 80,0 | 30,0 | 1,45 | 0,75 | 0,0 | 3,44 | 2 | ■ |
| JMB112020G6BZ2.0-HXT | 03205031 | 6 | G | 2,0 | 6,0 | 2,0 | 80,0 | 40,0 | 1,94 | 1,0 | 0,0 | 2,47 | 2 | ■ |
| JMB112030G6BZ2.0-HXT | 03205045 | 6 | G | 3,0 | 6,0 | 3,0 | 90,0 | 60,0 | 2,85 | 1,5 | 0,0 | 1,34 | 2 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und Composite


Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JMB112 Kopierfräsen/Schruppen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|---------|---------|---------|---------|---------|--------|--------|--------|--------|--------|------------------|
| | | | | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.8 | 1 | 1.2 | 1.5 | 1.8 | 2 | 2,5 | 3 | |
| H3 | M | 0.0500 | 0.30 | 0.0036 | 0.0055 | 0.0070 | 0.0090 | 0.011 | 0.014 | 0.018 | 0.022 | 0.026 | 0.032 | 0.036 | 0.044 | 0.048 | 150 (130 – 170) |
| | | 0,0500 | 0,30 | 0,00014 | 0,00022 | 0,00028 | 0,00036 | 0,00044 | 0,00055 | 0,00070 | 0,00085 | 0,0010 | 0,0013 | 0,0014 | 0,0017 | 0,0019 | 490 (430 – 550) |
| H5 | M | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.036 | 0.040 | 0.050 | 0.060 | 220 (200 – 240) |
| | | 0,0500 | 0,44 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 720 (660 – 780) |
| H7 | M | 0.0500 | 0.30 | 0.0036 | 0.0055 | 0.0070 | 0.0090 | 0.011 | 0.014 | 0.018 | 0.022 | 0.026 | 0.032 | 0.036 | 0.044 | 0.048 | 150 (130 – 170) |
| | | 0,0500 | 0,30 | 0,00014 | 0,00022 | 0,00028 | 0,00036 | 0,00044 | 0,00055 | 0,00070 | 0,00085 | 0,0010 | 0,0013 | 0,0014 | 0,0017 | 0,0019 | 490 (430 – 550) |
| H8 | M | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.036 | 0.040 | 0.048 | 0.050 | 220 (200 – 240) |
| | | 0,0500 | 0,44 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0016 | 0,0019 | 0,0020 | 720 (660 – 780) |
| H11 | M | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.036 | 0.040 | 0.050 | 0.060 | 280 (250 – 310) |
| | | 0,0500 | 0,44 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0016 | 0,0020 | 0,0024 | 920 (830 – 1000) |
| H12 | M | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.036 | 0.040 | 0.048 | 0.050 | 255 (230 – 280) |
| | | 0,0500 | 0,44 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0016 | 0,0019 | 0,0020 | 840 (760 – 910) |
| H21 | M | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.036 | 0.040 | 0.048 | 0.050 | 220 (200 – 240) |
| | | 0,0500 | 0,44 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0014 | 0,0016 | 0,0019 | 0,0020 | 720 (660 – 780) |
| H31 | M | 0.0500 | 0.44 | 0.0040 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.024 | 0.030 | 0.034 | 0.036 | 0.042 | 0.044 | 165 (150 – 180) |
| | | 0,0500 | 0,44 | 0,00016 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,00095 | 0,0012 | 0,0013 | 0,0014 | 0,0017 | 0,0017 | 540 (500 – 590) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Unversell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

| |
|-------------------------------|
| Univesell |
| Stahl und Guss |
| Rostfrei und ISO-S-Werkstoffe |
| NE-Metalle |
| Harter |
| Kunststoffe und Composite |
| Graphit |
| X-Heads |
| Minimaster Plus |
| Minimaster |


























KUNSTSTOFFE UND COMPOSITE

Seco präsentiert ein Komplettdprogramm an Vollhartmetallfräsern für die Bearbeitung glasfaser- und kohlenstofffaserverstärkter Kunststoffe. Es besteht aus diamantbeschichteten, unbeschichteten und PKD-Fräsern mit verschiedenen

Geometrien sowie Fräser mit eingelöteter PKD-Spitze. Die Werkzeuge sind speziell für schwierige Zerspanungsbedingungen in anspruchsvollen Werkstoffen optimiert.

- JC860, JC870, JC871, JC899, JPD890, J93F und J28 Schaftfräser mit scharfer Ecke.
- JC845, JC880, JC885 und JC898 Schaftfräser mit Eckenradius
- JC875, JC876, JC877 und JPD880 mit 45° Fase
- JC850 und JPD850 Kugelkopffräser

Werkzeugauswahl Kunststoff und CFK

| | | | | | |
|---------------------|---|---|---|---|---|
| |  |  |  |  |  |
| |  |  |  |  |  |
| Werkzeugbezeichnung | JC845 | JC850 | JC860 | JC870 | JC871 |
| Seite(n) | 412 | 414 | 416 | 418 | 424 |
| Produktfamilie | COMPOSITE | COMPOSITE | COMPOSITE | COMPOSITE | COMPOSITE |
| Fräserausführung |  |  |  |  |  |
| Aufnahmen | Zylindrisch | ■ | ■ | ■ | ■ |
| | Weldon | | | | |
| Schneidenzahl | 3 | 4 | 5,6,8,9 | | |
| ICC | Metrisch | 6-8 | 3-12 | 6-12 | 3-12 |
| | Zoll | | | | 1/4 -1/2 |
| Verfügbare Längen | 2 | 2 | 2 | 2 | 2 |
| Bearbeitung |  | |  |  |  |
| |  | |  |  |  |
| |  | | | | |
| SMG | | | | | |
| TS1 | | | | | |
| TS2 | ● | ● | ● | ● | ● |
| TS3 | ● | ● | ● | ● | ● |
| TP1 | | | | | |
| TP2 | ● | ● | ● | ● | ● |
| TP3 | ● | ● | ● | ● | ● |
| Honeycomb* | | | ● | ● | ● |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

Unversell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

























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Werkzeugauswahl Kunststoff und CFK

| Werkzeugbezeichnung | | JC875 | JC876 | JC877 | JC880 | JC885 | JC898 | JC899 |
|---------------------|-------------|-----------|--------------|--------------|-----------|-----------|-----------|-----------|
| Seite(n) | | 430 | 434 | 438 | 442 | 444 | 446 | 448 |
| Produktfamilie | | COMPOSITE | COMPOSITE | COMPOSITE | COMPOSITE | COMPOSITE | COMPOSITE | COMPOSITE |
| Fräserausführung | | | | | | | | |
| Aufnahmen | Zylindrisch | ■ | ■ | ■ | ■ | ■ | ■ | ■ |
| | Weldon | | | | | | | |
| Schneidenzahl | | 5,6,10 | 6,8,10,12,14 | 6,8,10,12,14 | 4 | 4 | 4 | 4 |
| ICC | | | | | | | ■ | |
| | Metrisch | 3-10 | 3-12 | 3-12 | 4-20 | 4-10 | 8-15 | 8,5-14,8 |
| | Zoll | 1/4 -1/2 | 1/4-1/2 | 1/4-1/2 | | | | |
| Verfügbare Längen | | 2 | 2 | 2 | 2 | 2 | 2 | 2 |
| Bearbeitung | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| SMG | | | | | | | | |
| TS1 | | | | | | | | |
| TS2 | | ● | ● | ● | ● | ● | | |
| TS3 | | ● | ● | ● | ● | ● | | |
| TP1 | | | | | | | | |
| TP2 | | ● | ● | ● | ● | ● | | |
| TP3 | | ● | ● | ● | ● | ● | | |
| Honeycomb* | | | | | | | | |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
 ● Erste Wahl ○ Alternative

Werkzeugauswahl Kunststoff und CFK

| | |  |  |  |  |  |
|---------------------|-------------|---|---|---|---|---|
| | |  |  |  |  |  |
| Werkzeugbezeichnung | | JPD850 | JPD880 | JPD890 | J93F | J28 |
| Seite(n) | | 451 | 453 | 455 | 457 | 459 |
| Produktfamilie | | PCD | PCD | PCD | VHM | VHM |
| Fräserausführung | |  |  |  |  |  |
| Aufnahmen | Zylindrisch | ■ | ■ | ■ | ■ | ■ |
| | Weldon | | | | | |
| Schneidenzahl | | 2 | 3 | 2 | 2 | 1 |
| ICC | | ■ | ■ | ■ | | |
| | Metrisch | 4-10 | 6-16 | 6-12 | 1,5-20 | 3-12 |
| | Zoll | | | | | |
| Verfügbare Längen | | 2 | 2,3 | 2,3 | 1,2,3,4 | 2 |
| Bearbeitung | | |  |  |  |  |
| | | |  |  |  |  |
| | |  | | | | |
| SMG | | | | | | |
| TS1 | | | | | ● | ● |
| TS2 | | ● | ● | ● | | |
| TS3 | | ● | ● | ● | | |
| TP1 | | | | | ● | |
| TP2 | | ● | ● | ● | | |
| TP3 | | ● | ● | ● | | |
| Honeycomb* | | | | | | |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
● Erste Wahl ○ Alternative

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Graphit

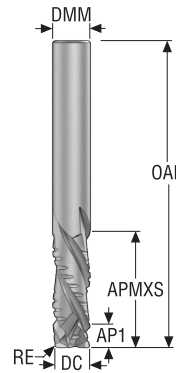
X-Heads

Minimaster Plus

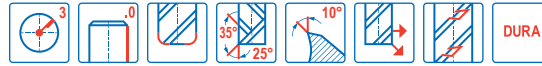
Minimaster

JC845

Verbundwerkstoff – Kompression – 3 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE=±0,01 mm



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | AP1 | OAL | RE | PCEDC | Zylindrisch |
|-------------------------|----------------|--------------|---------------|------|------|-------|-----|-------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | | |
| JC845060D2R050.0Z3-DURA | 02843006 | 2 | D | 6,0 | 6,0 | 18,0 | 4,2 | 65,0 | 0,5 | 3 | ■ |
| JC845080D2R050.0Z3-DURA | 02843007 | 2 | D | 8,0 | 8,0 | 24,0 | 5,2 | 75,0 | 0,5 | 3 | ■ |
| JC845100D2R050.0Z3-DURA | 02843008 | 2 | D | 10,0 | 10,0 | 30,0 | 6,3 | 85,0 | 0,5 | 3 | ■ |
| JC845120D2R050.0Z5-DURA | 02843009 | 2 | D | 12,0 | 12,0 | 36,0 | 8,3 | 100,0 | 0,5 | 5 | ■ |

■ Lagerstandard.

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Kunststoffe und Composite


Graphit

X-Heads


Minimaster Plus

Minimaster

Schnittdaten – JC845 Eckfräsen/Schruppen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|-----------------|
| | | | | 6 | 8 | 10 | 12 | |
| TS2 | E/A/D | 0,376 | 1,5 | 0,038 | 0,050 | 0,060 | 0,075 | 185 (130 – 240) |
| | | 0,376 | 1,5 | 0,0015 | 0,0020 | 0,0024 | 0,0030 | 610 (430 – 780) |
| TS3 | E/A/D | 0,376 | 1,4 | 0,038 | 0,050 | 0,060 | 0,075 | 125 (87 – 160) |
| | | 0,376 | 1,4 | 0,0015 | 0,0020 | 0,0024 | 0,0030 | 410 (290 – 520) |
| TP2 | E/A/D | 0,376 | 1,5 | 0,038 | 0,050 | 0,060 | 0,075 | 125 (87 – 180) |
| | | 0,376 | 1,5 | 0,0015 | 0,0020 | 0,0024 | 0,0030 | 410 (290 – 590) |
| TP3 | E/A/D | 0,376 | 1,4 | 0,038 | 0,050 | 0,060 | 0,075 | 85 (62 – 110) |
| | | 0,376 | 1,4 | 0,0015 | 0,0020 | 0,0024 | 0,0030 | 280 (210 – 360) |

Schnittdaten – JC845 Nutfräsen

| SMG |  | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|-----------------|
| | | | 6 | 8 | 10 | 12 | |
| TS2 | E/A/D | 1,0 | 0,025 | 0,032 | 0,040 | 0,050 | 160 (110 – 210) |
| | | 1,0 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 520 (370 – 680) |
| TS3 | E/A/D | 0,75 | 0,025 | 0,032 | 0,040 | 0,050 | 105 (76 – 130) |
| | | 0,75 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 345 (250 – 420) |
| TP2 | E/A/D | 1,0 | 0,025 | 0,032 | 0,040 | 0,050 | 105 (75 – 160) |
| | | 1,0 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 345 (250 – 520) |
| TP3 | E/A/D | 0,75 | 0,025 | 0,032 | 0,040 | 0,050 | 75 (54 – 96) |
| | | 0,75 | 0,0010 | 0,0013 | 0,0016 | 0,0020 | 245 (180 – 310) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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Graphit

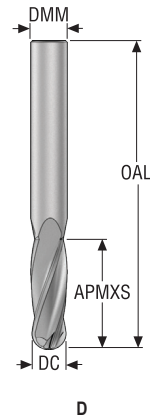
X-Heads

Minimaster Plus

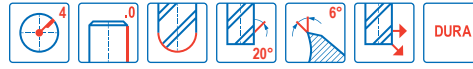
Minimaster

JC850

Verbundwerkstoff – Kugelkopf – 4 Schneiden – Zylindrisch



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE= ±0,02 mm



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | PCEDC | Zylindrisch |
|-----------------|--------------------|------------------|-------------------|------|------|-------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | | |
| 850030Z4.0-DURA | 02719949 | 2 | D | 3,0 | 3,0 | 9,0 | 50,0 | 4 | ■ |
| 850040Z4.0-DURA | 02719952 | 2 | D | 4,0 | 4,0 | 12,0 | 50,0 | 4 | ■ |
| 850060Z4.0-DURA | 02719953 | 2 | D | 6,0 | 6,0 | 18,0 | 65,0 | 4 | ■ |
| 850080Z4.0-DURA | 02719954 | 2 | D | 8,0 | 8,0 | 24,0 | 70,0 | 4 | ■ |
| 850100Z4.0-DURA | 02719955 | 2 | D | 10,0 | 10,0 | 30,0 | 85,0 | 4 | ■ |
| 850120Z4.0-DURA | 02719956 | 2 | D | 12,0 | 12,0 | 36,0 | 100,0 | 4 | ■ |

■ Lagerstandard.

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Composite

Graphit

X-Heads

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Minimaster

Schnittdaten – JC850 Kopierfräser

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|------------------|
| | | | | 3 | 4 | 6 | 8 | 10 | 12 | |
| TS2 | E/A/D | 0,200 | 2,0 | 0,030 | 0,040 | 0,060 | 0,080 | 0,10 | 0,12 | 265 (220 – 320) |
| | | 0,200 | 2,0 | 0,0012 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 870 (730 – 1000) |
| TS3 | E/A/D | 0,200 | 2,0 | 0,024 | 0,032 | 0,048 | 0,065 | 0,080 | 0,095 | 160 (110 – 210) |
| | | 0,200 | 2,0 | 0,00095 | 0,0013 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 520 (370 – 680) |
| TP2 | E/A/D | 0,200 | 2,0 | 0,030 | 0,040 | 0,060 | 0,080 | 0,10 | 0,12 | 215 (110 – 320) |
| | | 0,200 | 2,0 | 0,0012 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 710 (370 – 1000) |
| TP3 | E/A/D | 0,200 | 2,0 | 0,024 | 0,032 | 0,048 | 0,065 | 0,080 | 0,095 | 105 (54 – 150) |
| | | 0,200 | 2,0 | 0,00095 | 0,0013 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 345 (180 – 490) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

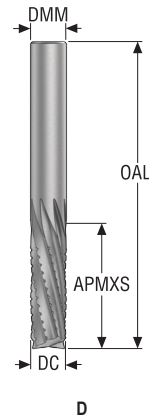
a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

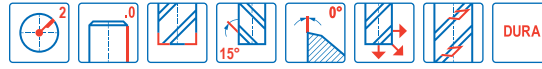
| |
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| X-Heads |
| Minimaster Plus |
| Minimaster |

JC860

Honeycomb – Eckfräser – 5-9 Schneiden – Zylindrisch – Scharfe Schneide



- Toleranzen:
- DMM=h5
- DC= -0.02-0.08 mm
- FCEDC=Stimverzahnung



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | FCEDC | PCEDC | Zylindrisch |
|-----------------|----------------|--------------|---------------|------|------|-------|-------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | | | |
| 860060Z5.0-DURA | 02720211 | 2 | D | 6,0 | 6,0 | 18,0 | 70,0 | 2 | 5 | ■ |
| 860080Z6.0-DURA | 02720212 | 2 | D | 8,0 | 8,0 | 24,0 | 80,0 | 2 | 6 | ■ |
| 860100Z8.0-DURA | 02720216 | 2 | D | 10,0 | 10,0 | 30,0 | 90,0 | 2 | 8 | ■ |
| 860120Z9.0-DURA | 02720217 | 2 | D | 12,0 | 12,0 | 36,0 | 110,0 | 2 | 9 | ■ |

■ Lagerstandard.

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Kunststoffe und Composite


Graphit

X-Heads


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Schnittdaten – JC860 Eckfräsen/Schruppen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|-----------------|
| | | | | 6 | 8 | 10 | 12 | |
| TS2 | E/A/D | 0,100 | 1,0 | 0,024 | 0,032 | 0,040 | 0,048 | 235 (200 – 270) |
| | | 0,100 | 1,0 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 770 (660 – 880) |
| TS3 | E/A/D | 0,100 | 1,0 | 0,024 | 0,032 | 0,040 | 0,048 | 160 (130 – 180) |
| | | 0,100 | 1,0 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 520 (430 – 590) |
| TP2 | E/A/D | 0,100 | 1,0 | 0,024 | 0,032 | 0,040 | 0,048 | 165 (130 – 200) |
| | | 0,100 | 1,0 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 540 (430 – 650) |
| TP3 | E/A/D | 0,100 | 1,0 | 0,024 | 0,032 | 0,040 | 0,048 | 65 (50 – 110) |
| | | 0,100 | 1,0 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 215 (170 – 360) |

Schnittdaten – JC860 Nutfräsen

| SMG |  | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|----------------|---------|---------|--------|-----------------|
| | | | 6 | 8 | 10 | 12 | |
| TS2 | E/A/D | 0,50 | 0,012 | 0,016 | 0,020 | 0,025 | 160 (140 – 180) |
| | | 0,50 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 520 (460 – 590) |
| TS3 | E/A/D | 0,50 | 0,012 | 0,016 | 0,020 | 0,025 | 105 (85 – 120) |
| | | 0,50 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 345 (280 – 390) |
| TP2 | E/A/D | 0,50 | 0,012 | 0,016 | 0,020 | 0,025 | 110 (84 – 130) |
| | | 0,50 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 360 (280 – 420) |
| TP3 | E/A/D | 0,50 | 0,012 | 0,016 | 0,020 | 0,025 | 44 (34 – 78) |
| | | 0,50 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 145 (120 – 250) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

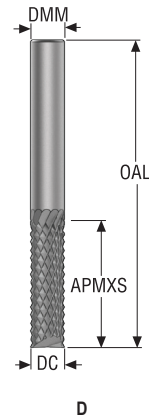
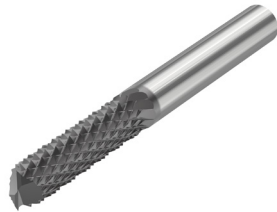
a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

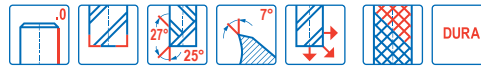
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JC870

Verbundwerkstoff – Fräser – Eckfräser – Zylindrisch – Scharfe Schneide



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,08 mm
- Fräser (Linksdrall)*



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | FCEDC | PCEDC | Zylindrisch |
|---------------|----------------|--------------|---------------|------|------|-------|-------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | | | |
| 870030.0-DURA | 02720219 | 2 | D | 3,0 | 3,0 | 9,0 | 50,0 | 2 | 8 | ■ |
| 870040.0-DURA | 02720226 | 2 | D | 4,0 | 4,0 | 12,0 | 50,0 | 2 | 8 | ■ |
| 870060.0-DURA | 02720228 | 2 | D | 6,0 | 6,0 | 18,0 | 65,0 | 2 | 10 | ■ |
| 870080.0-DURA | 02720229 | 2 | D | 8,0 | 8,0 | 24,0 | 75,0 | 2 | 12 | ■ |
| 870100.0-DURA | 02720231 | 2 | D | 10,0 | 10,0 | 30,0 | 85,0 | 2 | 12 | ■ |
| 870120.0-DURA | 02720232 | 2 | D | 12,0 | 12,0 | 36,0 | 100,0 | 2 | 14 | ■ |

■ Lagerstandard.

* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

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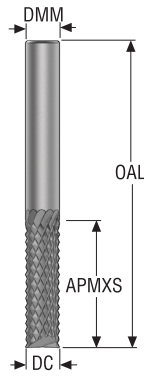
X-Heads

Minimaster Plus

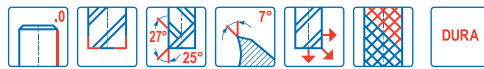
Minimaster

JC870

Verbundwerkstoff – Fräser – Eckfräser – Zylindrisch – Scharfe Schneide – Zoll



D



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,08 mm
- Fräser (Linksdrall)*

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | FCEDC | Zylindrisch |
|----------------|--------------------|------------------|-------------------|-------|-------|-------|-------|-------|-------------|
| | | | | Zoll | Zoll | Zoll | Zoll | | |
| 8700250.0-DURA | 02720784 | 2 | D | 0.250 | 0.250 | 0.750 | 2.250 | 2 | ■ |
| 8700375.0-DURA | 02720785 | 2 | D | 0.375 | 0.375 | 1.250 | 3.500 | 2 | ■ |

■ Lagerstandard.

* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

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ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

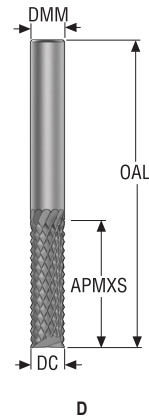
X-Heads

Minimaster Plus

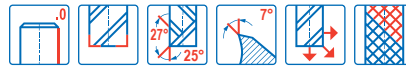
Minimaster

JC870

Verbundwerkstoff – Fräser – Eckfräser – Zylindrisch – Scharfe Schneide



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,08 mm
- Fräser (Linksdrall)*



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | FCEDC | PCEDC | Zylindrisch |
|-------------|--------------------|------------------|-------------------|------|------|-------|-------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | | | |
| 870030.0 | 02742789 | 2 | D | 3,0 | 3,0 | 9,0 | 50,0 | 2 | 8 | ■ |
| 870040.0 | 02742792 | 2 | D | 4,0 | 4,0 | 12,0 | 50,0 | 2 | 8 | ■ |
| 870050.0 | 02742793 | 2 | D | 5,0 | 5,0 | 15,0 | 50,0 | 2 | 10 | ■ |
| 870060.0 | 02742794 | 2 | D | 6,0 | 6,0 | 18,0 | 65,0 | 2 | 10 | ■ |
| 870080.0 | 02742795 | 2 | D | 8,0 | 8,0 | 24,0 | 75,0 | 2 | 12 | ■ |
| 870100.0 | 02742796 | 2 | D | 10,0 | 10,0 | 30,0 | 85,0 | 2 | 12 | ■ |
| 870120.0 | 02742797 | 2 | D | 12,0 | 12,0 | 36,0 | 100,0 | 2 | 14 | ■ |

■ Lagerstandard.

* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

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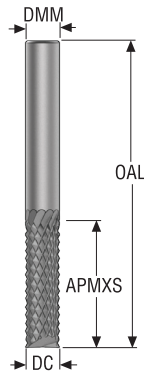
X-Heads

Minimaster Plus

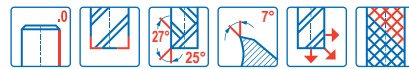
Minimaster

JC870

Verbundwerkstoff – Fräser – Eckfräser – Zylindrisch – Scharfe Schneide – Zoll



D



- Toleranzen:
- DMM=h5
- DC=-.0008 / -.0015 Zoll
- Fräser (Linksdrall)*

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | FCEDC | PCEDC | Zylindrisch |
|-------------|--------------------|------------------|-------------------|-------|-------|-------|-------|-------|-------|-------------|
| | | | | Zoll | Zoll | Zoll | Zoll | | | |
| 8700250.0 | 02742798 | 2 | D | 0.250 | 0.250 | 0.750 | 2.250 | 2 | 10 | ■ |
| 8700500.0 | 02742800 | 2 | D | 0.500 | 0.500 | 1.500 | 4.250 | 2 | 14 | ■ |

■ Lagerstandard.

* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

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NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JC870 Eckfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|---------|---------|---------|--------|--------|--------|-----------------|
| | | | | 3 | 4 | 5 | 6 | 8 | 10 | 12 | |
| TS2 | E/A/D | 0.350 | 2.0 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.025 | 0.032 | 0.038 | 175 (150 – 200) |
| | | 0,350 | 2,0 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 570 (500 – 650) |
| TS3 | E/A/D | 0.350 | 2.0 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.025 | 0.032 | 0.038 | 115 (94 – 130) |
| | | 0,350 | 2,0 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 375 (310 – 420) |
| TP2 | E/A/D | 0.350 | 2.0 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.025 | 0.032 | 0.038 | 115 (88 – 140) |
| | | 0,350 | 2,0 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 375 (290 – 450) |
| TP3 | E/A/D | 0.350 | 2.0 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.025 | 0.032 | 0.038 | 46 (36 – 81) |
| | | 0,350 | 2,0 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 150 (120 – 260) |

Schnittdaten – JC870 Nutfräsen


| SMG | | a _p /DC | f _z | | | | | | | v _c |
|-----|-------|--------------------|----------------|---------|---------|---------|---------|---------|--------|-----------------|
| | | | 3 | 4 | 5 | 6 | 8 | 10 | 12 | |
| TS2 | E/A/D | 1.0 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.025 | 145 (130 – 170) |
| | | 1,0 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 475 (430 – 550) |
| TS3 | E/A/D | 1.0 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.025 | 100 (79 – 110) |
| | | 1,0 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 330 (260 – 360) |
| TP2 | E/A/D | 1.0 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.025 | 100 (74 – 120) |
| | | 1,0 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 330 (250 – 390) |
| TP3 | E/A/D | 1.0 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.025 | 39 (30 – 68) |
| | | 1,0 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 130 (99 – 220) |

Schnittdaten, siehe Seite 561 - 568


SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

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Schnittdaten – JC870 Eckfräsen/Schruppen – Zoll

| SMG |  | a _e /DC | a _p /DC | f _z | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|-----------------|
| | | | | 1/4 | 3/8 | 1/2 | |
| TS2 | E/A/D | 0.350 | 2.0 | 0.020 | 0.030 | 0.038 | 175 (150 – 200) |
| | | 0,350 | 2,0 | 0,00080 | 0,0012 | 0,0015 | 570 (500 – 650) |
| TS3 | E/A/D | 0.350 | 2.0 | 0.020 | 0.030 | 0.038 | 115 (94 – 130) |
| | | 0,350 | 2,0 | 0,00080 | 0,0012 | 0,0015 | 375 (310 – 420) |
| TP2 | E/A/D | 0.350 | 2.0 | 0.020 | 0.030 | 0.038 | 115 (88 – 140) |
| | | 0,350 | 2,0 | 0,00080 | 0,0012 | 0,0015 | 375 (290 – 450) |
| TP3 | E/A/D | 0.350 | 2.0 | 0.020 | 0.030 | 0.038 | 46 (36 – 81) |
| | | 0,350 | 2,0 | 0,00080 | 0,0012 | 0,0015 | 150 (120 – 260) |

Schnittdaten – JC870 Nutfräsen – Zoll

| SMG |  | a _p /DC | f _z | | | v _c |
|-----|---|--------------------|----------------|---------|--------|-----------------|
| | | | 1/4 | 3/8 | 1/2 | |
| TS2 | E/A/D | 1.0 | 0.013 | 0.019 | 0.026 | 145 (130 – 170) |
| | | 1,0 | 0,00050 | 0,00075 | 0,0010 | 475 (430 – 550) |
| TS3 | E/A/D | 1.0 | 0.013 | 0.019 | 0.026 | 100 (79 – 110) |
| | | 1,0 | 0,00050 | 0,00075 | 0,0010 | 330 (260 – 360) |
| TP2 | E/A/D | 1.0 | 0.013 | 0.019 | 0.026 | 100 (74 – 120) |
| | | 1,0 | 0,00050 | 0,00075 | 0,0010 | 330 (250 – 390) |
| TP3 | E/A/D | 1.0 | 0.013 | 0.019 | 0.026 | 39 (30 – 68) |
| | | 1,0 | 0,00050 | 0,00075 | 0,0010 | 130 (99 – 220) |

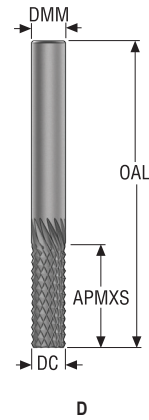
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

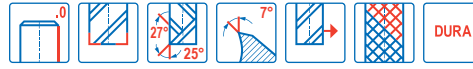
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 Minimeter

JC871

Verbundwerkstoff – Fräser – Eckfräser – Zylindrisch – Scharfe Schneide



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,08 mm
- Fräser (Linksdrall)*



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | PCEDC | Zylindrisch |
|---------------|--------------------|------------------|-------------------|------|------|-------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | | |
| 871030.0-DURA | 02720249 | 2 | D | 3,0 | 3,0 | 9,0 | 50,0 | 8 | ■ |
| 871040.0-DURA | 02720250 | 2 | D | 4,0 | 4,0 | 12,0 | 50,0 | 8 | ■ |
| 871060.0-DURA | 02720252 | 2 | D | 6,0 | 6,0 | 18,0 | 65,0 | 10 | ■ |
| 871080.0-DURA | 02720253 | 2 | D | 8,0 | 8,0 | 24,0 | 75,0 | 12 | ■ |
| 871100.0-DURA | 02720254 | 2 | D | 10,0 | 10,0 | 30,0 | 85,0 | 12 | ■ |
| 871120.0-DURA | 02720257 | 2 | D | 12,0 | 12,0 | 36,0 | 100,0 | 14 | ■ |

■ Lagerstandard.

* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

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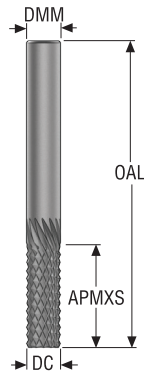
X-Heads

Minimaster Plus

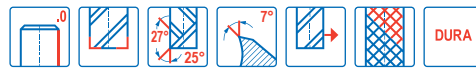
Minimaster

JC871

Verbundwerkstoff – Fräser – Eckfräser – Zylindrisch – Scharfe Schneide – Zoll



D



- Toleranzen:
- DMM=h5
- DC=-.0008 / -.0015 Zoll
- Fräser (Linksdrall)*

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | PCEDC | Zylindrisch |
|----------------|--------------------|------------------|-------------------|-------|-------|-------|-------|-------|-------------|
| | | | | Zoll | Zoll | Zoll | Zoll | | |
| 8710250.0-DURA | 02720788 | 2 | D | 0.250 | 0.250 | 0.750 | 2.250 | 10 | ■ |
| 8710375.0-DURA | 02720789 | 2 | D | 0.375 | 0.375 | 1.250 | 3.500 | 12 | ■ |
| 8710500.0-DURA | 02720790 | 2 | D | 0.500 | 0.500 | 1.500 | 4.250 | 14 | ■ |

■ Lagerstandard.

* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

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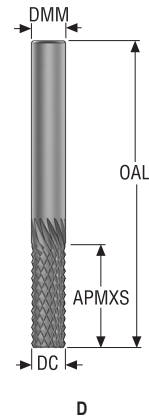
X-Heads

Minimaster Plus

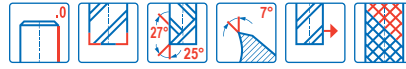
Minimaster

JC871

Verbundwerkstoff – Fräser – Eckfräser – Zylindrisch – Scharfe Schneide



- Toleranzen:
- DMM=h5
- DC=-0.02/-0.04
- Fräser (Linksdrall)*



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | PCEDC | Zylindrisch |
|-------------|--------------------|------------------|-------------------|------|------|-------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | | |
| 871030.0 | 02742801 | 2 | D | 3,0 | 3,0 | 9,0 | 50,0 | 8 | ■ |
| 871040.0 | 02742803 | 2 | D | 4,0 | 4,0 | 12,0 | 50,0 | 8 | ■ |
| 871060.0 | 02742806 | 2 | D | 6,0 | 6,0 | 18,0 | 65,0 | 10 | ■ |
| 871080.0 | 02742807 | 2 | D | 8,0 | 8,0 | 24,0 | 75,0 | 12 | ■ |
| 871100.0 | 02742808 | 2 | D | 10,0 | 10,0 | 30,0 | 85,0 | 12 | ■ |
| 871120.0 | 02742809 | 2 | D | 12,0 | 12,0 | 36,0 | 100,0 | 14 | ■ |

■ Lagerstandard.

* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

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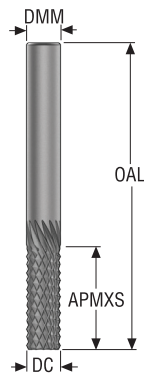
X-Heads

Minimaster Plus

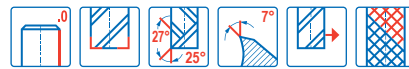
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Verbundwerkstoff – Fräser – Eckfräser – Zylindrisch – Scharfe Schneide – Zoll



D



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,08 mm
- Fräser (Linksdrall)*

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | PCEDC | Zylindrisch |
|-------------|----------------|--------------|---------------|-------|-------|-------|-------|-------|-------------|
| 8710500.0 | 02742814 | 2 | D | 0.500 | 0.500 | 1.500 | 4.250 | 14 | ■ |

■ Lagerstandard.

* Linksdrall bedeutet, dass die Spannut-Geometrien kombiniert werden, um geringe Kräfte zu erzeugen, die zum Erhalt der Komponenten-Aufspannung beitragen, besonders bei Vakuum-Aufspannung.

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Graphit

X-Heads

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Schnittdaten – JC871 Eckfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|---------|---------|---------|--------|--------|--------|-----------------|
| | | | | 3 | 4 | 5 | 6 | 8 | 10 | 12 | |
| TS2 | E/A/D | 0.350 | 2.0 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.025 | 0.032 | 0.038 | 175 (150 – 200) |
| | | 0,350 | 2,0 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 570 (500 – 650) |
| TS3 | E/A/D | 0.350 | 2.0 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.025 | 0.032 | 0.038 | 115 (94 – 130) |
| | | 0,350 | 2,0 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 375 (310 – 420) |
| TP2 | E/A/D | 0.350 | 2.0 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.025 | 0.032 | 0.038 | 115 (88 – 140) |
| | | 0,350 | 2,0 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 375 (290 – 450) |
| TP3 | E/A/D | 0.350 | 2.0 | 0.0095 | 0.013 | 0.016 | 0.019 | 0.025 | 0.032 | 0.038 | 46 (36 – 81) |
| | | 0,350 | 2,0 | 0,00038 | 0,00050 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 150 (120 – 260) |

Schnittdaten – JC871 Nutfräsen


| SMG | | a _p /DC | f _z | | | | | | | v _c |
|-----|-------|--------------------|----------------|---------|---------|---------|---------|---------|--------|-----------------|
| | | | 3 | 4 | 5 | 6 | 8 | 10 | 12 | |
| TS2 | E/A/D | 1.0 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.025 | 155 (140 – 180) |
| | | 1,0 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 510 (460 – 590) |
| TS3 | E/A/D | 1.0 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.025 | 105 (84 – 120) |
| | | 1,0 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 345 (280 – 390) |
| TP2 | E/A/D | 1.0 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.025 | 105 (79 – 130) |
| | | 1,0 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 345 (260 – 420) |
| TP3 | E/A/D | 1.0 | 0.0060 | 0.0080 | 0.010 | 0.012 | 0.016 | 0.020 | 0.025 | 40 (31 – 70) |
| | | 1,0 | 0,00024 | 0,00032 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 130 (110 – 220) |

Schnittdaten, siehe Seite 561 - 568


SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

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Schnittdaten – JC871 Eckfräsen/Schruppen – Zoll

| SMG |  | a _e /DC | a _p /DC | f _z | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|-----------------|
| | | | | 1/4 | 3/8 | 1/2 | |
| TS2 | E/A/D | 0.350 | 2.0 | 0.020 | 0.030 | 0.038 | 175 (150 – 200) |
| | | 0,350 | 2,0 | 0,00080 | 0,0012 | 0,0015 | 570 (500 – 650) |
| TS3 | E/A/D | 0.350 | 2.0 | 0.020 | 0.030 | 0.038 | 115 (94 – 130) |
| | | 0,350 | 2,0 | 0,00080 | 0,0012 | 0,0015 | 375 (310 – 420) |
| TP2 | E/A/D | 0.350 | 2.0 | 0.020 | 0.030 | 0.038 | 115 (88 – 140) |
| | | 0,350 | 2,0 | 0,00080 | 0,0012 | 0,0015 | 375 (290 – 450) |
| TP3 | E/A/D | 0.350 | 2.0 | 0.020 | 0.030 | 0.038 | 46 (36 – 81) |
| | | 0,350 | 2,0 | 0,00080 | 0,0012 | 0,0015 | 150 (120 – 260) |

Schnittdaten – JC871 Nutfräsen – Zoll

| SMG |  | a _p /DC | f _z | | | v _c |
|-----|---|--------------------|----------------|---------|--------|-----------------|
| | | | 1/4 | 3/8 | 1/2 | |
| TS2 | E/A/D | 1.0 | 0.013 | 0.019 | 0.026 | 145 (130 – 170) |
| | | 1,0 | 0,00050 | 0,00075 | 0,0010 | 475 (430 – 550) |
| TS3 | E/A/D | 1.0 | 0.013 | 0.019 | 0.026 | 100 (79 – 110) |
| | | 1,0 | 0,00050 | 0,00075 | 0,0010 | 330 (260 – 360) |
| TP2 | E/A/D | 1.0 | 0.013 | 0.019 | 0.026 | 100 (74 – 120) |
| | | 1,0 | 0,00050 | 0,00075 | 0,0010 | 330 (250 – 390) |
| TP3 | E/A/D | 1.0 | 0.013 | 0.019 | 0.026 | 39 (30 – 68) |
| | | 1,0 | 0,00050 | 0,00075 | 0,0010 | 130 (99 – 220) |

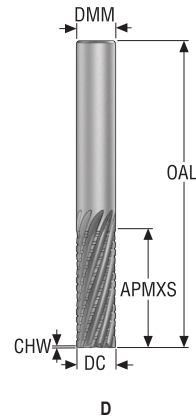
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

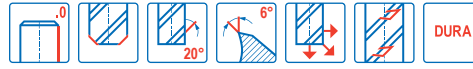
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 X-Heads
 Minimeter Plus
 Minimeter

JC875

Verbundwerkstoff – Eckfräser – 5-10 Schneiden – Zylindrisch – Fase



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,08 mm



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | CHW | PCEDC | Zylindrisch |
|-------------------|----------------|--------------|---------------|------|------|-------|------|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | | |
| JC875030D2.0-DURA | 02968155 | 2 | D | 3,0 | 3,0 | 9,0 | 50,0 | 0,05 | 5 | ■ |
| JC875050D2.0-DURA | 02968157 | 2 | D | 5,0 | 5,0 | 15,0 | 50,0 | 0,05 | 6 | ■ |
| JC875060D2.0-DURA | 02968158 | 2 | D | 6,0 | 6,0 | 18,0 | 65,0 | 0,06 | 6 | ■ |
| JC875080D2.0-DURA | 02968159 | 2 | D | 8,0 | 8,0 | 24,0 | 70,0 | 0,08 | 10 | ■ |
| JC875100D2.0-DURA | 02968160 | 2 | D | 10,0 | 10,0 | 30,0 | 80,0 | 0,1 | 10 | ■ |

■ Lagerstandard.

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Graphit

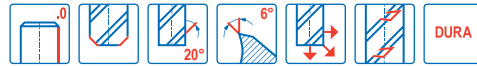
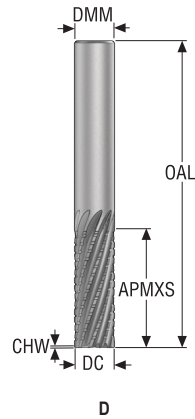
X-Heads

Minimaster Plus

Minimaster

JC875

Verbundwerkstoff – Eckfräser – 6-10 Schneiden – Zylindrisch – Fase – Zoll



- Toleranzen:
- DMM=h5
- DC= -.0008/- .0030 Zoll

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | CHW | PCEDC | Zylindrisch |
|--------------------|--------------------|------------------|-------------------|-------|-------|-------|-------|-------|-------|-------------|
| | | | | Zoll | Zoll | Zoll | Zoll | Zoll | | |
| JC875.250D2.0-DURA | 02968162 | 2 | D | 0.250 | 0.250 | 0.750 | 3.000 | 0.002 | 6 | ■ |

■ Lagerstandard.

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Kunststoffe und
Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JC875 Eckfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|---------|---------|--------|--------|-----------------|
| | | | | 3 | 5 | 6 | 8 | 10 | |
| TS2 | E/A/D | 0.350 | 2.0 | 0.0095 | 0.016 | 0.019 | 0.025 | 0.032 | 190 (160 – 220) |
| | | 0,350 | 2,0 | 0,00038 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 620 (530 – 720) |
| TS3 | E/A/D | 0.350 | 2.0 | 0.0095 | 0.016 | 0.019 | 0.025 | 0.032 | 130 (110 – 150) |
| | | 0,350 | 2,0 | 0,00038 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 425 (370 – 490) |
| TP2 | E/A/D | 0.350 | 2.0 | 0.0095 | 0.016 | 0.019 | 0.025 | 0.032 | 130 (96 – 150) |
| | | 0,350 | 2,0 | 0,00038 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 425 (320 – 490) |
| TP3 | E/A/D | 0.350 | 2.0 | 0.0095 | 0.016 | 0.019 | 0.025 | 0.032 | 50 (39 – 89) |
| | | 0,350 | 2,0 | 0,00038 | 0,00065 | 0,00075 | 0,0010 | 0,0013 | 165 (130 – 290) |

Schnittdaten – JC875 Nutfräsen


| SMG | | a _p /DC | f _z | | | | | v _c |
|-----|-------|--------------------|----------------|---------|---------|---------|---------|-----------------|
| | | | 3 | 5 | 6 | 8 | 10 | |
| TS2 | E/A/D | 1.0 | 0.0060 | 0.010 | 0.012 | 0.016 | 0.020 | 160 (140 – 180) |
| | | 1,0 | 0,00024 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 520 (460 – 590) |
| TS3 | E/A/D | 1.0 | 0.0060 | 0.010 | 0.012 | 0.016 | 0.020 | 105 (86 – 120) |
| | | 1,0 | 0,00024 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 345 (290 – 390) |
| TP2 | E/A/D | 1.0 | 0.0060 | 0.010 | 0.012 | 0.016 | 0.020 | 105 (81 – 130) |
| | | 1,0 | 0,00024 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 345 (270 – 420) |
| TP3 | E/A/D | 1.0 | 0.0060 | 0.010 | 0.012 | 0.016 | 0.020 | 42 (33 – 74) |
| | | 1,0 | 0,00024 | 0,00040 | 0,00048 | 0,00065 | 0,00080 | 140 (110 – 240) |

Schnittdaten, siehe Seite 561 - 568


SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

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Minimaster Plus
Minimaster

Schnittdaten – JC875 Eckfräsen – Zoll

| SMG |  | a _e /DC | a _p /DC | f _z | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|-----------------|
| | | | | 1/4 | 3/8 | 1/2 | |
| TS2 | E/A/D | 0.350 | 2.0 | 0.020 | 0.030 | 0.038 | 190 (160 – 220) |
| | | 0,350 | 2,0 | 0,00080 | 0,0012 | 0,0015 | 620 (530 – 720) |
| TS3 | E/A/D | 0.350 | 2.0 | 0.020 | 0.030 | 0.038 | 130 (110 – 150) |
| | | 0,350 | 2,0 | 0,00080 | 0,0012 | 0,0015 | 425 (370 – 490) |
| TP2 | E/A/D | 0.350 | 2.0 | 0.020 | 0.030 | 0.038 | 130 (96 – 150) |
| | | 0,350 | 2,0 | 0,00080 | 0,0012 | 0,0015 | 425 (320 – 490) |
| TP3 | E/A/D | 0.350 | 2.0 | 0.020 | 0.030 | 0.038 | 50 (39 – 89) |
| | | 0,350 | 2,0 | 0,00080 | 0,0012 | 0,0015 | 165 (130 – 290) |

Schnittdaten – JC875 Nutfräsen – Zoll

| SMG |  | a _p /DC | f _z | | | v _c |
|-----|---|--------------------|----------------|---------|--------|-----------------|
| | | | 1/4 | 3/8 | 1/2 | |
| TS2 | E/A/D | 1.0 | 0.013 | 0.019 | 0.026 | 160 (140 – 180) |
| | | 1,0 | 0,00050 | 0,00075 | 0,0010 | 520 (460 – 590) |
| TS3 | E/A/D | 1.0 | 0.013 | 0.019 | 0.026 | 105 (86 – 120) |
| | | 1,0 | 0,00050 | 0,00075 | 0,0010 | 345 (290 – 390) |
| TP2 | E/A/D | 1.0 | 0.013 | 0.019 | 0.026 | 105 (81 – 130) |
| | | 1,0 | 0,00050 | 0,00075 | 0,0010 | 345 (270 – 420) |
| TP3 | E/A/D | 1.0 | 0.013 | 0.019 | 0.026 | 42 (33 – 74) |
| | | 1,0 | 0,00050 | 0,00075 | 0,0010 | 140 (110 – 240) |

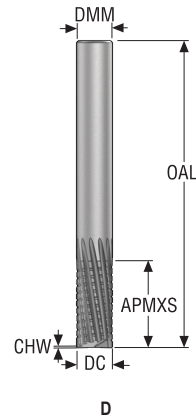
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

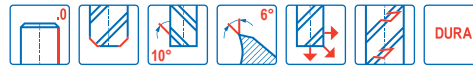
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 Kunststoffe und Composite
 Graphit
 X-Heads
 Minimeter Plus
 Minimeter

JC876

Verbundwerkstoff – Eckfräser – 6-14 Schneiden – Zylindrisch – Fase



- Toleranzen:
- DMM=h5
- DC=-0,02 -0,08 mm
- Linksdrall



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | CHW | PCEDC | Zylindrisch |
|-----------------------|--------------------|------------------|-------------------|------|------|-------|------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | | |
| JC876030D2C.0Z6-DURA | 03135004 | 2 | D | 3,0 | 3,0 | 7,5 | 50,0 | 0,035 | 6 | ■ |
| JC876040D2C.0Z6-DURA | 03135005 | 2 | D | 4,0 | 4,0 | 10,0 | 54,0 | 0,045 | 6 | ■ |
| JC876060D2C.0Z8-DURA | 03135006 | 2 | D | 6,0 | 6,0 | 15,0 | 62,0 | 0,075 | 8 | ■ |
| JC876060D2C.0Z10-DURA | 03135007 | 2 | D | 6,0 | 6,0 | 15,0 | 62,0 | 0,075 | 10 | ■ |
| JC876080D2C.0Z10-DURA | 03135009 | 2 | D | 8,0 | 8,0 | 20,0 | 70,0 | 0,1 | 10 | ■ |
| JC876100D2C.0Z12-DURA | 03135011 | 2 | D | 10,0 | 10,0 | 25,0 | 82,0 | 0,125 | 12 | ■ |
| JC876120D2C.0Z14-DURA | 03135012 | 2 | D | 12,0 | 12,0 | 30,0 | 95,0 | 0,15 | 14 | ■ |

■ Lagerstandard.

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Composite

Graphit

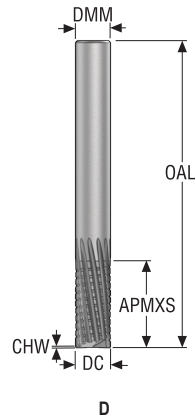
X-Heads

Minimaster Plus

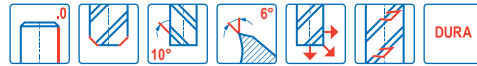
Minimaster

JC876

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D



- Toleranzen:
- DMM=h5
- DC= -.0008/- .0030 Zoll
- Linksdrall

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | CHW | PCEDC | Zylindrisch |
|------------------------|--------------------|------------------|-------------------|-------|-------|-------|-------|-------|-------|-------------|
| | | | | Zoll | Zoll | Zoll | Zoll | Zoll | | |
| JC876.250D2C.0Z8-DURA | 03135125 | 2 | D | 0.250 | 0.250 | 0.625 | 2.500 | 0.003 | 8 | ■ |
| JC876.375D2C.0Z12-DURA | 03135127 | 2 | D | 0.375 | 0.375 | 1.000 | 3.000 | 0.005 | 12 | ■ |

■ Lagerstandard.

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Composite

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Schnittdaten – JC876 Eckfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|---------|---------|--------|--------|--------|-----------------|
| | | | | 3 | 4 | 6 | 8 | 10 | 12 | |
| TS2 | E/A/D | 0.334 | 1.7 | 0.0095 | 0.013 | 0.019 | 0.026 | 0.032 | 0.038 | 220 (190 – 250) |
| | | 0,334 | 1,7 | 0,00038 | 0,00050 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 720 (630 – 820) |
| TS3 | E/A/D | 0.334 | 1.7 | 0.0095 | 0.013 | 0.019 | 0.026 | 0.032 | 0.038 | 145 (120 – 170) |
| | | 0,334 | 1,7 | 0,00038 | 0,00050 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 475 (400 – 550) |
| TP2 | E/A/D | 0.334 | 1.7 | 0.0095 | 0.013 | 0.019 | 0.026 | 0.032 | 0.038 | 145 (110 – 180) |
| | | 0,334 | 1,7 | 0,00038 | 0,00050 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 475 (370 – 590) |
| TP3 | E/A/D | 0.334 | 1.7 | 0.0095 | 0.013 | 0.019 | 0.026 | 0.032 | 0.038 | 75 (44 – 100) |
| | | 0,334 | 1,7 | 0,00038 | 0,00050 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 245 (150 – 320) |

Schnittdaten – JC876 Nutfräsen

| SMG | | a _p /DC | f _z | | | | | | v _c |
|-----|-------|--------------------|----------------|---------|---------|---------|---------|--------|-----------------|
| | | | 3 | 4 | 6 | 8 | 10 | 12 | |
| TS2 | E/A/D | 1.0 | 0.0060 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.025 | 175 (150 – 200) |
| | | 1,0 | 0,00024 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 570 (500 – 650) |
| TS3 | E/A/D | 1.0 | 0.0060 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.025 | 115 (94 – 140) |
| | | 1,0 | 0,00024 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 375 (310 – 450) |
| TP2 | E/A/D | 1.0 | 0.0060 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.025 | 115 (88 – 140) |
| | | 1,0 | 0,00024 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 375 (290 – 450) |
| TP3 | E/A/D | 1.0 | 0.0060 | 0.0080 | 0.012 | 0.016 | 0.020 | 0.025 | 60 (36 – 81) |
| | | 1,0 | 0,00024 | 0,00032 | 0,00048 | 0,00065 | 0,00080 | 0,0010 | 195 (120 – 260) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

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Schnittdaten – JC876 Eckfräsen/Schruppen – Zoll

| SMG | | a_e/DC | a_p/DC | f_z | | | v_c |
|-----|-------|----------|----------|---------|--------|--------|-----------------|
| | | | | 1/4 | 3/8 | 1/2 | |
| TS2 | E/A/D | 0,334 | 1,7 | 0,020 | 0,030 | 0,040 | 220 (190 – 250) |
| | | 0,334 | 1,7 | 0,00080 | 0,0012 | 0,0016 | 720 (630 – 820) |
| TS3 | E/A/D | 0,334 | 1,7 | 0,020 | 0,030 | 0,040 | 145 (120 – 170) |
| | | 0,334 | 1,7 | 0,00080 | 0,0012 | 0,0016 | 475 (400 – 550) |
| TP2 | E/A/D | 0,334 | 1,7 | 0,020 | 0,030 | 0,040 | 145 (110 – 180) |
| | | 0,334 | 1,7 | 0,00080 | 0,0012 | 0,0016 | 475 (370 – 590) |
| TP3 | E/A/D | 0,334 | 1,7 | 0,020 | 0,030 | 0,040 | 75 (44 – 100) |
| | | 0,334 | 1,7 | 0,00080 | 0,0012 | 0,0016 | 245 (150 – 320) |

Schnittdaten – JC876 Nutfräsen – Zoll

| SMG | | a_p/DC | f_z | | | v_c |
|-----|-------|----------|---------|---------|--------|-----------------|
| | | | 1/4 | 3/8 | 1/2 | |
| TS2 | E/A/D | 1,0 | 0,013 | 0,019 | 0,026 | 175 (150 – 200) |
| | | 1,0 | 0,00050 | 0,00075 | 0,0010 | 570 (500 – 650) |
| TS3 | E/A/D | 1,0 | 0,013 | 0,019 | 0,026 | 115 (94 – 140) |
| | | 1,0 | 0,00050 | 0,00075 | 0,0010 | 375 (310 – 450) |
| TP2 | E/A/D | 1,0 | 0,013 | 0,019 | 0,026 | 115 (88 – 140) |
| | | 1,0 | 0,00050 | 0,00075 | 0,0010 | 375 (290 – 450) |
| TP3 | E/A/D | 1,0 | 0,013 | 0,019 | 0,026 | 60 (36 – 81) |
| | | 1,0 | 0,00050 | 0,00075 | 0,0010 | 195 (120 – 260) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge

 v_c = m/min (sf/min)

 f_z = mm/Zahn (Zoll/Zahn)

 a_p = mm/DC (Zoll/DC) = Faktor

 a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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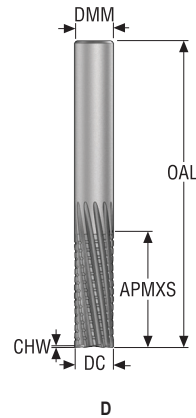
X-Heads

Minimeter Plus

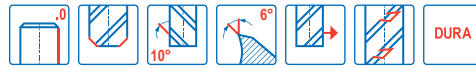
Minimeter

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Verbundwerkstoff – Eckfräser – 6-14 Schneiden – Zylindrisch – Fase



- Toleranzen:
- DMM=h5
- DC=-0,02, -0,08 mm
- Linksdrall



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | CHW | PCEDC | Zylindrisch |
|-----------------------|--------------------|------------------|-------------------|------|------|-------|------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | | |
| JC877030D2C.0Z6-DURA | 03135013 | 2 | D | 3,0 | 3,0 | 9,0 | 50,0 | 0,035 | 6 | ■ |
| JC877040D2C.0Z6-DURA | 03135014 | 2 | D | 4,0 | 4,0 | 12,0 | 54,0 | 0,045 | 6 | ■ |
| JC877060D2C.0Z8-DURA | 03135015 | 2 | D | 6,0 | 6,0 | 18,0 | 62,0 | 0,075 | 8 | ■ |
| JC877060D2C.0Z10-DURA | 03135016 | 2 | D | 6,0 | 6,0 | 18,0 | 62,0 | 0,075 | 10 | ■ |
| JC877080D2C.0Z10-DURA | 03135018 | 2 | D | 8,0 | 8,0 | 24,0 | 70,0 | 0,1 | 10 | ■ |
| JC877100D2C.0Z12-DURA | 03135020 | 2 | D | 10,0 | 10,0 | 30,0 | 82,0 | 0,125 | 12 | ■ |
| JC877120D2C.0Z14-DURA | 03135021 | 2 | D | 12,0 | 12,0 | 36,0 | 95,0 | 0,15 | 14 | ■ |

■ Lagerstandard.

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Composite

Graphit

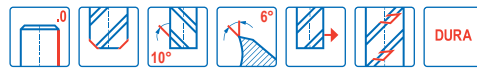
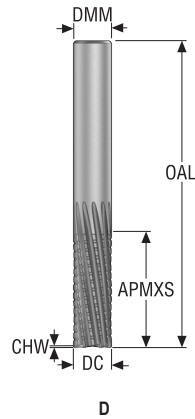
X-Heads

Minimaster Plus

Minimaster

JC877

Verbundwerkstoff – Eckfräser – 8-14 Schneiden – Zylindrisch – Fase – Zoll



- Toleranzen:
- DMM=h5
- DC= -.0008/- .0030 Zoll
- Linksdrall

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | CHW | PCEDC | Zylindrisch |
|-----------------------|--------------------|------------------|-------------------|-------|-------|-------|-------|-------|-------|-------------|
| | | | | Zoll | Zoll | Zoll | Zoll | Zoll | | |
| JC877.250D2C.0Z8-DURA | 03135129 | 2 | D | 0.250 | 0.250 | 0.750 | 2.500 | 0.003 | 8 | ■ |

■ Lagerstandard.

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Schnittdaten – JC877 Eckfräsen/Schruppen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|---------|---------|--------|--------|--------|-----------------|
| | | | | 3 | 4 | 6 | 8 | 10 | 12 | |
| TS2 | E/A/D | 0.334 | 2.0 | 0.0095 | 0.013 | 0.019 | 0.026 | 0.032 | 0.038 | 195 (170 – 220) |
| | | 0,334 | 2,0 | 0,00038 | 0,00050 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 640 (560 – 720) |
| TS3 | E/A/D | 0.334 | 2.0 | 0.0095 | 0.013 | 0.019 | 0.026 | 0.032 | 0.038 | 130 (110 – 150) |
| | | 0,334 | 2,0 | 0,00038 | 0,00050 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 425 (370 – 490) |
| TP2 | E/A/D | 0.334 | 2.0 | 0.0095 | 0.013 | 0.019 | 0.026 | 0.032 | 0.038 | 130 (98 – 160) |
| | | 0,334 | 2,0 | 0,00038 | 0,00050 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 425 (330 – 520) |
| TP3 | E/A/D | 0.334 | 2.0 | 0.0095 | 0.013 | 0.019 | 0.026 | 0.032 | 0.038 | 65 (40 – 91) |
| | | 0,334 | 2,0 | 0,00038 | 0,00050 | 0,00075 | 0,0010 | 0,0013 | 0,0015 | 215 (140 – 290) |

Schnittdaten – JC877 Nutfräsen

| SMG | | a _p /DC | f _z | | | | | | v _c |
|-----|-------|--------------------|----------------|--------|-------|-------|-------|-------|-----------------|
| | | | 3 | 4 | 6 | 8 | 10 | 12 | |
| TS2 | E/A/D | 1,0 | 0,0060 | 0,0080 | 0,012 | 0,016 | 0,020 | 0,025 | 170 (150 – 200) |
| | | 1,0 | 0,0060 | 0,0080 | 0,012 | 0,016 | 0,020 | 0,025 | 115 (92 – 130) |
| TP2 | E/A/D | 1,0 | 0,0060 | 0,0080 | 0,012 | 0,016 | 0,020 | 0,025 | 115 (86 – 140) |
| | | 1,0 | 0,0060 | 0,0080 | 0,012 | 0,016 | 0,020 | 0,025 | 55 (35 – 80) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)


a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor


Alle Schnittdaten sind Richtwerte

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Schnittdaten – JC877 Eckfräsen/Schruppen – Zoll

| SMG |  | a _e /DC | a _p /DC | f _z | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|-----------------|
| | | | | 1/4 | 3/8 | 1/2 | |
| TS2 | E/A/D | 0.334 | 2.0 | 0.020 | 0.030 | 0.040 | 195 (170 – 220) |
| | | 0,334 | 2,0 | 0,00080 | 0,0012 | 0,0016 | 640 (560 – 720) |
| TS3 | E/A/D | 0.334 | 2.0 | 0.020 | 0.030 | 0.040 | 130 (110 – 150) |
| | | 0,334 | 2,0 | 0,00080 | 0,0012 | 0,0016 | 425 (370 – 490) |
| TP2 | E/A/D | 0.334 | 2.0 | 0.020 | 0.030 | 0.040 | 130 (98 – 160) |
| | | 0,334 | 2,0 | 0,00080 | 0,0012 | 0,0016 | 425 (330 – 520) |
| TP3 | E/A/D | 0.334 | 2.0 | 0.020 | 0.030 | 0.040 | 65 (40 – 91) |
| | | 0,334 | 2,0 | 0,00080 | 0,0012 | 0,0016 | 215 (140 – 290) |

Schnittdaten – JC877 Nutfräsen – Zoll

| SMG |  | a _p /DC | f _z | | | v _c |
|-----|---|--------------------|----------------|---------|--------|-----------------|
| | | | 1/4 | 3/8 | 1/2 | |
| TS2 | E/A/D | 1.0 | 0.013 | 0.019 | 0.026 | 160 (140 – 180) |
| | | 1,0 | 0,00050 | 0,00075 | 0,0010 | 520 (460 – 590) |
| TS3 | E/A/D | 1.0 | 0.013 | 0.019 | 0.026 | 105 (85 – 120) |
| | | 1,0 | 0,00050 | 0,00075 | 0,0010 | 345 (280 – 390) |
| TP2 | E/A/D | 1.0 | 0.013 | 0.019 | 0.026 | 105 (80 – 130) |
| | | 1,0 | 0,00050 | 0,00075 | 0,0010 | 345 (270 – 420) |
| TP3 | E/A/D | 1.0 | 0.013 | 0.019 | 0.026 | 55 (32 – 74) |
| | | 1,0 | 0,00050 | 0,00075 | 0,0010 | 180 (110 – 240) |

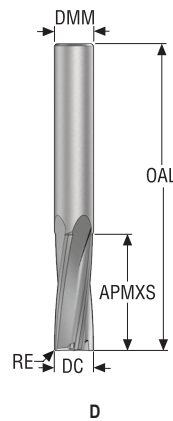
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlschmiermittel: A = Luft, D = Trockenbearbeitung, E = Emulsion, M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

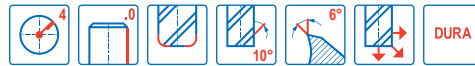
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Verbundwerkstoff – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE=±0,01 mm



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | RE | PCEDC | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|------|------|-------|-------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | | |
| 880040R020Z4.0-DURA | 02843012 | 2 | D | 4,0 | 4,0 | 12,0 | 50,0 | 0,2 | 4 | ■ |
| 880050R020Z4.0-DURA | 02843013 | 2 | D | 5,0 | 5,0 | 15,0 | 50,0 | 0,2 | 4 | ■ |
| 880060R020Z4.0-DURA | 02720258 | 2 | D | 6,0 | 6,0 | 18,0 | 65,0 | 0,2 | 4 | ■ |
| 880080R020Z4.0-DURA | 02720259 | 2 | D | 8,0 | 8,0 | 24,0 | 70,0 | 0,2 | 4 | ■ |
| 880100R020Z4.0-DURA | 02720260 | 2 | D | 10,0 | 10,0 | 30,0 | 80,0 | 0,2 | 4 | ■ |
| 880120R020Z4.0-DURA | 02720261 | 2 | D | 12,0 | 12,0 | 36,0 | 100,0 | 0,2 | 4 | ■ |
| 880160R020Z4.0-DURA | 02720262 | 2 | D | 16,0 | 16,0 | 48,0 | 110,0 | 0,2 | 4 | ■ |
| 880200R020Z4.0-DURA | 02720263 | 2 | D | 20,0 | 20,0 | 60,0 | 130,0 | 0,2 | 4 | ■ |

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Schnittdaten – JC880 Eckfräsen/Schruppen

| SMG |  | a _p /DC | a _p /DC | f _z | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | | 4 | 6 | 8 | 10 | 12 | 16 | 20 | |
| TS2 | E/A/D | 0.400 | 1.9 | 0.024 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 190 (160 – 210) |
| | | 0,400 | 1,9 | 0,00095 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 620 (530 – 680) |
| TS3 | E/A/D | 0.300 | 2.0 | 0.017 | 0.025 | 0.034 | 0.042 | 0.050 | 0.060 | 0.070 | 130 (93 – 170) |
| | | 0,300 | 2,0 | 0,00065 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 0,0028 | 425 (310 – 550) |
| TP2 | E/A/D | 0.400 | 1.9 | 0.024 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 125 (95 – 150) |
| | | 0,400 | 1,9 | 0,00095 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 410 (320 – 490) |
| TP3 | E/A/D | 0.300 | 2.0 | 0.017 | 0.025 | 0.034 | 0.042 | 0.050 | 0.060 | 0.070 | 50 (40 – 92) |
| | | 0,300 | 2,0 | 0,00065 | 0,0010 | 0,0013 | 0,0017 | 0,0020 | 0,0024 | 0,0028 | 165 (140 – 300) |

Schnittdaten – JC880 Nutfräsen

| SMG |  | a _p /DC | f _z | | | | | | | | v _c |
|-----|---|--------------------|----------------|---------|---------|--------|--------|--------|--------|--------|-----------------|
| | | | 4 | 5 | 6 | 8 | 10 | 12 | 16 | 20 | |
| TS2 | E/A/D | 1.0 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 150 (130 – 170) |
| | | 1,0 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 490 (430 – 550) |
| TS3 | E/A/D | 1.0 | 0.015 | 0.019 | 0.022 | 0.030 | 0.038 | 0.044 | 0.055 | 0.065 | 100 (71 – 130) |
| | | 1,0 | 0,00060 | 0,00075 | 0,00085 | 0,0012 | 0,0015 | 0,0017 | 0,0022 | 0,0026 | 330 (240 – 420) |
| TP2 | E/A/D | 1.0 | 0.024 | 0.030 | 0.036 | 0.048 | 0.060 | 0.070 | 0.090 | 0.10 | 100 (76 – 120) |
| | | 1,0 | 0,00095 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 330 (250 – 390) |
| TP3 | E/A/D | 1.0 | 0.015 | 0.019 | 0.022 | 0.030 | 0.038 | 0.044 | 0.055 | 0.065 | 40 (31 – 70) |
| | | 1,0 | 0,00060 | 0,00075 | 0,00085 | 0,0012 | 0,0015 | 0,0017 | 0,0022 | 0,0026 | 130 (110 – 220) |

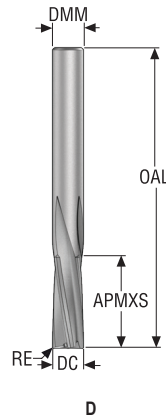
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

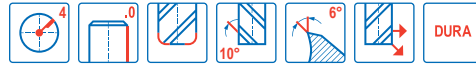
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Verbundwerkstoff – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- DMM=h5
- DC=-0,02/-0,04 mm
- RE=±0,01 mm
- Linksdrall



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | RE | PCEDC | Zylindrisch |
|-------------------------|--------------------|------------------|-------------------|-----|-----|-------|------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | | |
| JC885040D2R020.0Z4-DURA | 02843014 | 2 | D | 4,0 | 4,0 | 12,0 | 50,0 | 0,2 | 4 | ■ |
| JC885060D2R020.0Z4-DURA | 02843016 | 2 | D | 6,0 | 6,0 | 18,0 | 70,0 | 0,2 | 4 | ■ |
| JC885080D2R020.0Z4-DURA | 02843017 | 2 | D | 8,0 | 8,0 | 24,0 | 80,0 | 0,2 | 4 | ■ |

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Schnittdaten – JC885 Eckfräsen/Schruppen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|-----------------|
| | | | | 4 | 6 | 8 | 10 | |
| TS2 | E/A/D | 0.400 | 2.0 | 0.024 | 0.036 | 0.048 | 0.060 | 190 (160 – 210) |
| | | 0,400 | 2,0 | 0,00095 | 0,0014 | 0,0019 | 0,0024 | 620 (530 – 680) |
| TS3 | E/A/D | 0.300 | 2.0 | 0.017 | 0.025 | 0.034 | 0.042 | 130 (99 – 170) |
| | | 0,300 | 2,0 | 0,00065 | 0,0010 | 0,0013 | 0,0017 | 425 (330 – 550) |
| TP2 | E/A/D | 0.400 | 2.0 | 0.024 | 0.036 | 0.048 | 0.060 | 125 (94 – 150) |
| | | 0,400 | 2,0 | 0,00095 | 0,0014 | 0,0019 | 0,0024 | 410 (310 – 490) |
| TP3 | E/A/D | 0.300 | 2.0 | 0.017 | 0.025 | 0.034 | 0.042 | 50 (33 – 92) |
| | | 0,300 | 2,0 | 0,00065 | 0,0010 | 0,0013 | 0,0017 | 165 (110 – 300) |

Schnittdaten – JC885 Nutfräsen

| SMG |  | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|----------------|---------|--------|--------|-----------------|
| | | | 4 | 6 | 8 | 10 | |
| TS2 | E/A/D | 1.0 | 0.024 | 0.036 | 0.048 | 0.060 | 150 (130 – 170) |
| | | 1,0 | 0,00095 | 0,0014 | 0,0019 | 0,0024 | 490 (430 – 550) |
| TS3 | E/A/D | 0.70 | 0.015 | 0.022 | 0.030 | 0.038 | 100 (76 – 130) |
| | | 0,70 | 0,00060 | 0,00085 | 0,0012 | 0,0015 | 330 (250 – 420) |
| TP2 | E/A/D | 1.0 | 0.024 | 0.036 | 0.048 | 0.060 | 100 (75 – 120) |
| | | 1,0 | 0,00095 | 0,0014 | 0,0019 | 0,0024 | 330 (250 – 390) |
| TP3 | E/A/D | 0.70 | 0.015 | 0.022 | 0.030 | 0.038 | 40 (26 – 70) |
| | | 0,70 | 0,00060 | 0,00085 | 0,0012 | 0,0015 | 130 (86 – 220) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

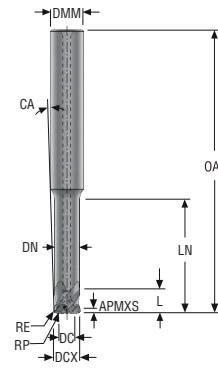
a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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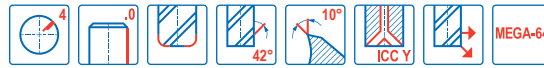
JC898

Hochvorschubfräser – Plattenpakete – Eckenradius – 4 Schneiden – Zylindrisch – Eckenradius



G

- Toleranzen:
- DMM=h5
- DC= e7
- RE= ±0,1 mm



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DC | DCX | DMM | APMXS | L | OAL | LN | DN | RE | RP | CA° | PCEDC | Zylindrisch |
|----------------------|--------------------|------------------|-------------------|-----|-----|------|------|-------|------|-------|------|------|------|------|------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | mm | mm | mm | mm | mm | mm |
| JC898080G3HZ4A.0-M64 | 03245308 | 3 | G | ■ | 4,0 | 8,0 | 10,0 | 0,43 | 6,0 | 88,0 | 35,0 | 7,6 | 0,5 | 0,87 | 1,5° | 4 | ■ |
| JC898150G3HZ4A.0-M64 | 03245309 | 3 | G | ■ | 7,5 | 15,0 | 16,0 | 0,796 | 12,0 | 125,0 | 70,0 | 14,3 | 0,94 | 1,63 | 0,4° | 4 | ■ |

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Schnittdaten – JC898 Eckfräsen

| SMG |  | a _p /DCX | | f _z | | v _c |
|-------------|---|---------------------|-------|----------------|--------|----------------|
| | | | | 8 | 15 | |
| S12+TS2/TP2 | D | 0,30 | 0,020 | 0,1 | 0,15 | 90 (80-120) |
| | | 0,30 | 0,020 | 0,0040 | 0,0060 | 300 (270-400) |
| TP2+TS2/TP2 | D | 0,30 | 0,034 | 0,12 | 0,25 | 120 (90-150) |
| | | 0,30 | 0,034 | 0,0048 | 0,0100 | 400 (300-490) |

Schnittdaten – JC898 Nutfräsen

| SMG |  | a _p /DCX | | f _z | | v _c |
|-------------|---|---------------------|--------|----------------|----|----------------|
| | | | | 8 | 15 | |
| S12+TP2/TS2 | D | 0.020 | 0.08 | 0.10 | | 90 (80-120) |
| | | 0.020 | 0.0032 | 0.0040 | | 300 (270-400) |
| N1+TP2/TS2 | D | 0.034 | 0.1 | 0.10 | | 120 (90-150) |
| | | 0.034 | 0.0040 | 0.0040 | | 400 (300-490) |

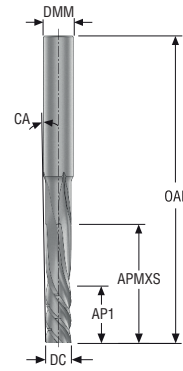
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

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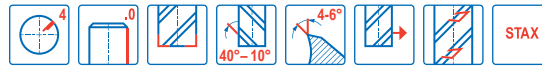
JC899

Hochleistungsfräser – Plattenpakete – Eckfräser – 4 Schneiden – Zylindrisch – Scharfe Schneide



F

- Toleranzen:
- DMM=h5
- DC= ±0,02 mm



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | Spanteiler | DC | DMM | APMXS | AP1 | OAL | CA° | PCEDC | Zylindrisch |
|----------------------|--------------------|------------------|-------------------|------------|------|------|-------|------|-------|-------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | | | |
| JC899085F3S.0Z4-STAX | 03245482 | 3 | F | ■ | 8,5 | 10,0 | 38,0 | 19,0 | 100,0 | 0,8° | 4 | ■ |
| JC899148F3S.0Z4-STAX | 03245480 | 3 | F | ■ | 14,8 | 16,0 | 55,0 | 30,0 | 150,0 | 0,53° | 4 | ■ |
| JC899148F4S.0Z4-STAX | 03245481 | 4 | F | ■ | 14,8 | 16,0 | 62,0 | 37,0 | 150,0 | 0,48° | 4 | ■ |

■ Lagerstandard.

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Graphit

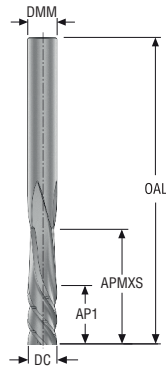
X-Heads

Minimaster Plus

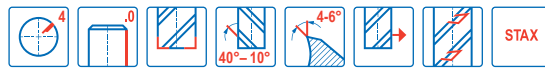
Minimaster

JC899

Hochleistungsfräser – Plattenpakete – Eckfräser – 4 Schneiden – Zylindrisch – Scharfe Schneide – Zoll



D



- Toleranzen:
- DMM=h5
- DC= ±0,0008 Zoll

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | Spanteiler | DC | DMM | APMXS | AP1 | OAL | PCEDC | Zylindrisch |
|-----------------------|--------------------|------------------|-------------------|------------|-------|-------|-------|-------|-------|-------|-------------|
| | | | | | Zoll | Zoll | Zoll | Zoll | Zoll | | |
| JC8990375D4S.0Z4-STAX | 03245483 | 4 | D | ■ | 0.373 | 0.375 | 1.500 | 0.625 | 4.000 | 4 | ■ |

■ Lagerstandard.

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Schnittdaten – JC899 Schichten

| SMG | | a _e /DC | | a _p /DC | | f _z | | v _c | |
|-------------|---|--------------------|-----|--------------------|--------|----------------|-------------|----------------|--|
| | | | | | | | | | |
| | | | | | | 8.5 | 14.8 | | |
| S12+TP2/TS2 | D | 0,025 | 4,0 | 0,04 | 0,075 | 40 | (30 – 50) | | |
| | | 0,025 | 4,0 | 0,0016 | 0,0030 | 140 | (100 – 170) | | |
| N1+TP2/TS2 | D | 0,025 | 4,0 | 0,06 | 0,09 | 60 | (50 – 75) | | |
| | | 0,025 | 4,0 | 0,0032 | 0,0036 | 200 | (170 – 250) | | |

Schnittdaten – JC899 Schichten – Zoll

| SMG | | a _e /DC | | a _p /DC | | f _z | | v _c | |
|-------------|---|--------------------|-----|--------------------|-----|----------------|--|----------------|--|
| | | | | | | | | | |
| | | | | | | 3/8 | | | |
| S12+TP2/TS2 | D | 0,025 | 4,0 | 0,05 | 40 | (30 – 50) | | | |
| | | 0,025 | 4,0 | 0,0022 | 140 | (100 – 170) | | | |
| N1+TP2/TS2 | D | 0,025 | 4,0 | 0,07 | 60 | (50 – 75) | | | |
| | | 0,025 | 4,0 | 0,0028 | 200 | (170 – 250) | | | |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

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Graphit

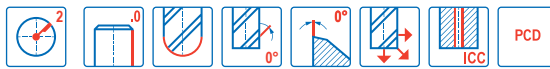
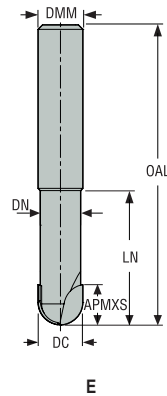
X-Heads

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JPD850

Verbundwerkstoff – Kugelkopf – 2 Schneiden – Zylindrisch – ICC



- Toleranzen:
- DMM=h5
- DC= h10
- ICC= 2 gerade Kanäle

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DC | DMM | APMXS | OAL | LN | DN | PCEDC | Zylindrisch |
|-------------------|--------------------|------------------|-------------------|-----|------|------|-------|------|------|-----|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | | |
| JPD850060E2B.0Z2A | 02968184 | 2 | E | ■ | 6,0 | 6,0 | 7,0 | 58,0 | 18,0 | 5,4 | 2 | ■ |
| JPD850080E2B.0Z2A | 02968185 | 2 | E | ■ | 8,0 | 8,0 | 8,0 | 64,0 | 24,0 | 7,2 | 2 | ■ |
| JPD850100E2B.0Z2A | 02968186 | 2 | E | ■ | 10,0 | 10,0 | 10,0 | 73,0 | 30,0 | 9,0 | 2 | ■ |

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Minimaster Plus

Minimaster

Schnittdaten – JPD850 Kopierfräser

| SMG | | a _e /DC | a _p /DC | f _z | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------------------|
| | | | | 4 | 5 | 6 | 8 | 10 | |
| TS2 | E/A/D | 0.200 | 0.50 | 0.040 | 0.048 | 0.060 | 0.080 | 0.10 | 550 (470 – 820) |
| | | 0,200 | 0,50 | 0,0016 | 0,0019 | 0,0024 | 0,0032 | 0,0040 | 1800 (1600 – 2600) |
| TS3 | E/A/D | 0.200 | 0.50 | 0.040 | 0.048 | 0.060 | 0.080 | 0.10 | 310 (270 – 460) |
| | | 0,200 | 0,50 | 0,0016 | 0,0019 | 0,0024 | 0,0032 | 0,0040 | 1025 (890 – 1500) |
| TP2 | E/A/D | 0.200 | 0.50 | 0.040 | 0.048 | 0.060 | 0.080 | 0.10 | 890 (750 – 1300) |
| | | 0,200 | 0,50 | 0,0016 | 0,0019 | 0,0024 | 0,0032 | 0,0040 | 2925 (2500 – 4200) |
| TP3 | E/A/D | 0.200 | 0.50 | 0.040 | 0.048 | 0.060 | 0.080 | 0.10 | 580 (500 – 870) |
| | | 0,200 | 0,50 | 0,0016 | 0,0019 | 0,0024 | 0,0032 | 0,0040 | 1900 (1700 – 2800) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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Graphit

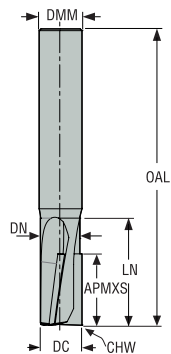
X-Heads

Minimaster Plus

Minimaster

JPD880

Verbundwerkstoff – Eckfräser – 3 Schneiden – Zylindrisch – Fase – ICC



E



- Toleranzen:
- DMM=h5
- DC=h10
- ICC=Y

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | ICC | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Zylindrisch |
|-------------------|----------------|--------------|---------------|-----|------|------|-------|------|------|------|-----|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JPD880060G2C.0Z3A | 02968190 | 2 | G | ■ | 6,0 | 8,0 | 13,0 | 64,0 | 20,0 | 5,3 | 0,1 | 3 | ■ |
| JPD880080E2C.0Z3A | 02968191 | 2 | E | ■ | 8,0 | 8,0 | 15,0 | 64,0 | 20,0 | 7,3 | 0,1 | 3 | ■ |
| JPD880100E2C.0Z3A | 02968192 | 2 | E | ■ | 10,0 | 10,0 | 13,0 | 73,0 | 30,0 | 9,2 | 0,1 | 3 | ■ |
| JPD880120E2C.0Z3A | 02968194 | 2 | E | ■ | 12,0 | 12,0 | 13,0 | 83,0 | 30,0 | 11,0 | 0,1 | 3 | ■ |
| JPD880160E2C.0Z3A | 02968196 | 2 | E | ■ | 16,0 | 16,0 | 13,0 | 90,0 | 35,0 | 14,8 | 0,1 | 3 | ■ |
| JPD880100E3C.0Z3A | 02968193 | 3 | E | ■ | 10,0 | 10,0 | 20,0 | 73,0 | 30,0 | 9,2 | 0,1 | 3 | ■ |
| JPD880160E3C.0Z3A | 02968197 | 3 | E | ■ | 16,0 | 16,0 | 20,0 | 90,0 | 35,0 | 14,8 | 0,1 | 3 | ■ |

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Graphit

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Schnittdaten – JPD880 Eckfräsen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------|--------|--------------------|
| | | | | 6 | 8 | 10 | 12 | 16 | |
| TS2 | E/A/D | 0.300 | 1.2 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 510 (430 – 750) |
| | | 0,300 | 1,2 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 1675 (1500 – 2400) |
| TS3 | E/A/D | 0.300 | 1.2 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 275 (230 – 410) |
| | | 0,300 | 1,2 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 900 (760 – 1300) |
| TP2 | E/A/D | 0.300 | 1.2 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 810 (680 – 940) |
| | | 0,300 | 1,2 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 2650 (2300 – 3000) |
| TP3 | E/A/D | 0.300 | 1.2 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 520 (440 – 780) |
| | | 0,300 | 1,2 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 1700 (1500 – 2500) |

Schnittdaten – JPD880 Nutfräsen

| SMG | | a _p /DC | f _z | | | | | v _c |
|-----|-------|--------------------|----------------|--------|--------|--------|--------|--------------------|
| | | | 6 | 8 | 10 | 12 | 16 | |
| TS2 | E/A/D | 1.0 | 0.055 | 0.075 | 0.090 | 0.11 | 0.14 | 385 (330 – 570) |
| | | 1,0 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0055 | 1275 (1100 – 1800) |
| TS3 | E/A/D | 1.0 | 0.055 | 0.075 | 0.090 | 0.11 | 0.14 | 210 (180 – 310) |
| | | 1,0 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0055 | 690 (600 – 1000) |
| TP2 | E/A/D | 1.0 | 0.055 | 0.075 | 0.090 | 0.11 | 0.14 | 620 (520 – 710) |
| | | 1,0 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0055 | 2025 (1800 – 2300) |
| TP3 | E/A/D | 1.0 | 0.055 | 0.075 | 0.090 | 0.11 | 0.14 | 395 (340 – 590) |
| | | 1,0 | 0,0022 | 0,0030 | 0,0036 | 0,0044 | 0,0055 | 1300 (1200 – 1900) |

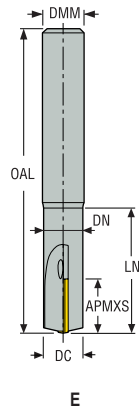
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

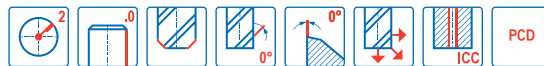
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JPD890

Verbundwerkstoff – Eckfräser – 2 Schneiden – Zylindrisch – Fase – ICC



E



- Toleranzen:
- DMM=h5
- DC=h10
- ICC=2 gerade Kanäle

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | ICC | DC | DMM | APMXS | OAL | LN | DN | CHW | PCEDC | Zylindrisch |
|-------------------|--------------------|------------------|-------------------|-----|------|------|-------|------|------|------|-----|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | |
| JPD890060G2S.0Z2A | 02791382 | 2 | G | ■ | 6,0 | 8,0 | 13,0 | 64,0 | 20,0 | 5,4 | 0,1 | 2 | ■ |
| JPD890080E2S.0Z2A | 02791383 | 2 | E | ■ | 8,0 | 8,0 | 15,0 | 64,0 | 20,0 | 7,4 | 0,1 | 2 | ■ |
| JPD890100E2S.0Z2A | 02791384 | 2 | E | ■ | 10,0 | 10,0 | 13,0 | 73,0 | 30,0 | 9,4 | 0,1 | 2 | ■ |
| JPD890120E2S.0Z2A | 02791386 | 2 | E | ■ | 12,0 | 12,0 | 13,0 | 83,0 | 30,0 | 11,4 | 0,1 | 2 | ■ |
| JPD890100E3S.0Z2A | 02791385 | 3 | E | ■ | 10,0 | 10,0 | 20,0 | 73,0 | 30,0 | 9,4 | 0,1 | 2 | ■ |
| JPD890120E3S.0Z2A | 02791387 | 3 | E | ■ | 12,0 | 12,0 | 20,0 | 83,0 | 30,0 | 11,4 | 0,1 | 2 | ■ |

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Schnittdaten – JPD890 Eckfräsen

| SMG | | a _p /DC | a _p /DC | f _z | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------|--------------------|
| | | | | 6 | 8 | 10 | 12 | |
| TS2 | E/A/D | 0.300 | 1.2 | 0.12 | 0.16 | 0.20 | 0.24 | 415 (360 – 620) |
| | | 0,300 | 1,2 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 1350 (1200 – 2000) |
| TS3 | E/A/D | 0.200 | 1.2 | 0.060 | 0.080 | 0.10 | 0.12 | 305 (260 – 450) |
| | | 0,200 | 1,2 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 1000 (860 – 1400) |
| TP2 | E/A/D | 0.300 | 1.2 | 0.12 | 0.16 | 0.20 | 0.24 | 670 (560 – 770) |
| | | 0,300 | 1,2 | 0,0048 | 0,0065 | 0,0080 | 0,0095 | 2200 (1900 – 2500) |
| TP3 | E/A/D | 0.200 | 1.2 | 0.060 | 0.080 | 0.10 | 0.12 | 580 (490 – 860) |
| | | 0,200 | 1,2 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 1900 (1700 – 2800) |

Schnittdaten – JPD890 Nutfräsen

| SMG | | a _p /DC | a _p /DC | f _z | | | | v _c |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------------------|----------------|
| | | | | 6 | 8 | 10 | 12 | |
| TS2 | E/A/D | 1.0 | 0.060 | 0.080 | 0.10 | 0.12 | 375 (320 – 550) | |
| | | 1,0 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 1225 (1100 – 1800) | |
| TS3 | E/A/D | 1.0 | 0.042 | 0.055 | 0.070 | 0.085 | 225 (190 – 330) | |
| | | 1,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 740 (630 – 1000) | |
| TP2 | E/A/D | 1.0 | 0.060 | 0.080 | 0.10 | 0.12 | 600 (500 – 690) | |
| | | 1,0 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 1975 (1700 – 2200) | |
| TP3 | E/A/D | 1.0 | 0.042 | 0.055 | 0.070 | 0.085 | 420 (360 – 630) | |
| | | 1,0 | 0,0017 | 0,0022 | 0,0028 | 0,0034 | 1375 (1200 – 2000) | |

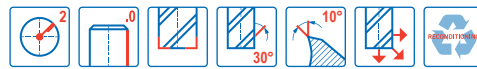
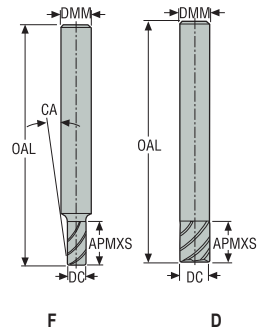
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_s = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

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J93F

Allgemeine Anwendung – Kunststoff – Eckfräser – 2 Schneiden – Zylindrisch – Scharfe Schneide



- Toleranzen:
- DMM= h5
- DC= Ø1-Ø6= -0,02/-0,034 mm
- DC= Ø8-Ø20= -0,02/-0,044 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | CA | PCEDC | Zylindrisch |
|-------------|----------------|--------------|---------------|------|------|-------|-------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | | |
| 93015-F | 02605874 | 2 | F | 1,5 | 3,0 | 6,0 | 40,0 | 4,0 | 2 | ■ |
| 93020-F | 02605888 | 2 | F | 2,0 | 3,0 | 9,0 | 40,0 | 2,5 | 2 | ■ |
| 93030-F | 02606060 | 2 | D | 3,0 | 3,0 | 12,0 | 40,0 | - | 2 | ■ |
| 93040-F | 02606061 | 2 | D | 4,0 | 4,0 | 14,0 | 50,0 | - | 2 | ■ |
| 93060-F | 02606063 | 2 | D | 6,0 | 6,0 | 20,0 | 65,0 | - | 2 | ■ |
| 93080-F | 02606064 | 2 | D | 8,0 | 8,0 | 20,0 | 70,0 | - | 2 | ■ |
| 93100-F | 02606065 | 2 | D | 10,0 | 10,0 | 25,0 | 80,0 | - | 2 | ■ |
| 93120-F | 02606066 | 2 | D | 12,0 | 12,0 | 25,0 | 90,0 | - | 2 | ■ |
| 93160-F | 02606068 | 2 | D | 16,0 | 16,0 | 30,0 | 90,0 | - | 2 | ■ |
| 93L060-F | 02606071 | 3 | D | 6,0 | 6,0 | 40,0 | 100,0 | - | 2 | ■ |
| 93L080-F | 02606072 | 3 | D | 8,0 | 8,0 | 40,0 | 100,0 | - | 2 | ■ |
| 93L100-F | 02606073 | 3 | D | 10,0 | 10,0 | 40,0 | 100,0 | - | 2 | ■ |
| 93L120-F | 02606074 | 3 | D | 12,0 | 12,0 | 45,0 | 100,0 | - | 2 | ■ |
| 93L160-F | 02606077 | 3 | D | 16,0 | 16,0 | 45,0 | 100,0 | - | 2 | ■ |
| 93L200-F | 02606078 | 3 | D | 20,0 | 20,0 | 55,0 | 125,0 | - | 2 | ■ |
| 93XL120-F | 02606079 | 4 | D | 12,0 | 12,0 | 30,0 | 150,0 | - | 2 | ■ |
| 93XL160-F | 02606080 | 4 | D | 16,0 | 16,0 | 65,0 | 150,0 | - | 2 | ■ |
| 93XL200-F | 02606081 | 4 | D | 20,0 | 20,0 | 65,0 | 150,0 | - | 2 | ■ |

■ Lagerstandard.

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Schnittdaten – J93F Eckfräsen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|--------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | | 1.5 | 2 | 3 | 4 | 6 | 8 | 10 | 12 | 16 | 20 | |
| TS1 | A | 0.400 | 1.4 | 0.015 | 0.020 | 0.030 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 590 (480 – 710) |
| | | 0,400 | 1,4 | 0,00060 | 0,00080 | 0,0012 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 1925 (1600 – 2300) |
| TP1 | A | 0.400 | 1.4 | 0.015 | 0.020 | 0.030 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 0.15 | 0.17 | 570 (460 – 680) |
| | | 0,400 | 1,4 | 0,00060 | 0,00080 | 0,0012 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 1875 (1600 – 2200) |

Schnittdaten – J93F Nutfräsen

| SMG | | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|----------------|---------|---------|--------|--------|--------|--------|--------|--------|--------|--------------------|
| | | | 1.5 | 2 | 3 | 4 | 6 | 8 | 10 | 12 | 16 | 20 | |
| TS1 | A | 0.50 | 0.012 | 0.016 | 0.024 | 0.032 | 0.048 | 0.065 | 0.080 | 0.095 | 0.13 | 0.16 | 500 (400 – 590) |
| | | 0,50 | 0,00048 | 0,00065 | 0,00095 | 0,0013 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 1650 (1400 – 1900) |
| TP1 | A | 0.50 | 0.012 | 0.016 | 0.024 | 0.032 | 0.048 | 0.065 | 0.080 | 0.095 | 0.13 | 0.16 | 485 (390 – 580) |
| | | 0,50 | 0,00048 | 0,00065 | 0,00095 | 0,0013 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 1600 (1300 – 1900) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

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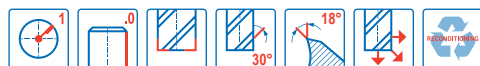
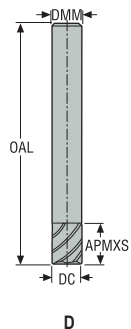
X-Heads

Minimaster Plus

Minimaster

J28

Allgemeine Anwendung – Kunststoff – Eckfräser – 1 Schneide – Zylindrisch – Scharfe Schneide



- Toleranzen:
- DMM= h5
- DC= Ø2-Ø6= -0,02/-0,034 mm
- DC= Ø8-Ø12= -0,02/-0,044 mm
- Nachschleifen möglich, wenn DC ≥ Ø6 ist

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | PCEDC | Zylindrisch |
|-------------|----------------|--------------|---------------|------|------|-------|------|-------|-------------|
| | | | | mm | mm | mm | mm | | |
| 28030 | 00029353 | 2 | D | 3,0 | 3,0 | 10,0 | 40,0 | 1 | ■ |
| 28040 | 00029361 | 2 | D | 4,0 | 4,0 | 14,0 | 50,0 | 1 | ■ |
| 28050 | 00029363 | 2 | D | 5,0 | 5,0 | 16,0 | 60,0 | 1 | ■ |
| 28060 | 00029366 | 2 | D | 6,0 | 6,0 | 20,0 | 65,0 | 1 | ■ |
| 28080 | 00029369 | 2 | D | 8,0 | 8,0 | 25,0 | 75,0 | 1 | ■ |
| 28100 | 00029370 | 2 | D | 10,0 | 10,0 | 25,0 | 75,0 | 1 | ■ |
| 28120 | 00029372 | 2 | D | 12,0 | 12,0 | 25,0 | 75,0 | 1 | ■ |

■ Lagerstandard.

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Schnittdaten – J28 Eckfräsen $a_e/DC=0,4$

| SMG | | a_e/DC | a_p/DC | f_z | | | | | | | | v_c |
|-----|-----|----------------|------------|-----------------|-----------------|-----------------|-----------------|----------------|----------------|----------------|---------------------------------------|-------|
| | | | | 3 | 4 | 5 | 6 | 8 | 10 | 12 | | |
| TS1 | A/D | 0.300 0,300 | 1.5 1,5 | 0.040 0,0016 | 0.050 0,0020 | 0.065 0,0026 | 0.080 0,0032 | 0.10 0,0040 | 0.13 0,0050 | 0.16 0,0065 | 490 (370 – 610) 1600 (1300 – 2000) | |

Schnittdaten – J28 Nutfräsen

| SMG | | a_p/DC | f_z | | | | | | | | v_c |
|-----|-----|------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|----------------|---------------------------------------|-------|
| | | | 3 | 4 | 5 | 6 | 8 | 10 | 12 | | |
| TS1 | A/D | 1.0 1,0 | 0.026 0,0010 | 0.036 0,0014 | 0.044 0,0017 | 0.055 0,0022 | 0.070 0,0028 | 0.090 0,0036 | 0.11 0,0044 | 400 (310 – 490) 1300 (1100 – 1600) | |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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Die diamantbeschichteten Vollhartmetallfräser von Seco wurden speziell für die Bearbeitung von Graphit entwickelt. Sie bieten eine bis zu 10-mal höhere Werkzeugstandzeit als Fräser mit konventionellen Beschichtungen. Verfügbar in einer Vielzahl an Geometrien in einem großen Durchmesserbereich mit bestmöglichem Substrat für perfekte Adhäsion der Diamantbeschichtung bei unterschiedlichen Schnittparametern.

- JD620, JD630, JD640 und JME642 Schaftfräser mit Eckenradius
- JD660, SMB614, SMB616 und JMB642 Kugelkopffräser

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


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- Stahl und Guss
- Rostfrei und ISO-S-Werkstoffe
- NE-Metalle
- Harter
- Kunststoffe und Composite
- Graphit
- X-Heads
- Minimaster Plus
- Minimaster

Werkzeugauswahl Graphit

| Werkzeugbezeichnung | | JD620 | JD630 | JD640 | JD660 |
|----------------------------|-------------|---------|---------|---------|-----------|
| Seite(n) | | 464 | 466 | 468 | 470 |
| Produktfamilie | | DIAMOND | DIAMOND | DIAMOND | DIAMOND |
| Fräserausführung | | | | | |
| Aufnahmen | Zylindrisch | ■ | ■ | ■ | ■ |
| | Weldon | | | | |
| Schneidenzahl | | 2 | 3 | 4 | 2 |
| ICC | | | | | |
| | Metrisch | 3-12 | 3-8 | 6-12 | 3-6 |
| | Zoll | | | | |
| Verfügbare Längen | | 2,3,4 | 2,3,4 | 2,3,4 | 1,2,3,4,5 |
| Bearbeitung | | | | | |
| | | | | | |
| | | | | | |
| SMG | | | | | |
| GR | | ● | ● | ● | ● |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
 ● Erste Wahl ○ Alternative

Werkzeugauswahl Graphit

| | |  |  |  |
|---------------------|-------------|---|---|---|
| Werkzeugbezeichnung | | SMB614/616 | JME642 | JMB642/JMB662 |
| Seite(n) | | 474 | 474 | 476 |
| Produktfamilie | | MINI DIAMOND | MINI DIAMOND | MINI DIAMOND |
| Fräserausführung | |  |  |  |
| Aufnahmen | Zylindrisch | ■ | ■ | ■ |
| | Weldon | | | |
| Schneidenzahl | | 2 | 2 | 2 |
| ICC | | | | |
| | Metrisch | 0,2-2,0 | 0,2-2,0 | 0,2-3,0 |
| | Zoll | | | |
| Verfügbare Längen | | 1,3,5,6,7 | 1,3,5,6,7 | 1,3,5,6,7 |
| Bearbeitung | |  |  |  |
| | |  |  | |
| | |  | |  |
| SMG | | | | |
| GR | | ● | ● | ● |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage.
 ● Erste Wahl ○ Alternative

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JD620

Diamant – Graphit – Eckfräser – 2 Schneiden – Zylindrisch – Eckenradius

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

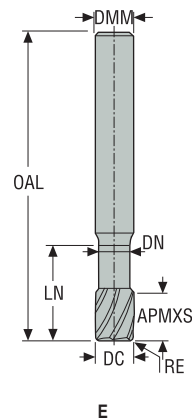
Kunststoffe und Composite

Graphit

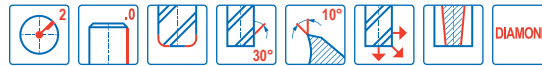
X-Heads

Minimaster Plus

Minimaster




- Toleranzen:
- Rundlaufabweichung = <math><0,01\text{ mm}</math>
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= $\pm 0,05\text{ mm}$




| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|-----------------------|----------------|--------------|---------------|------|------|-------|-------|-------|------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| 620V030R050-DIAMOND | 00023425 | 2 | E | 3,0 | 3,0 | 5,0 | 60,0 | 30,0 | 2,85 | 0,5 | 2 | ■ |
| 620V040R050-DIAMOND | 00023427 | 2 | E | 4,0 | 4,0 | 5,0 | 60,0 | 30,0 | 3,85 | 0,5 | 2 | ■ |
| 620V060R050-DIAMOND | 00023429 | 2 | E | 6,0 | 6,0 | 10,0 | 80,0 | 40,0 | 5,8 | 0,5 | 2 | ■ |
| 620V080R050-DIAMOND | 00023431 | 2 | E | 8,0 | 8,0 | 10,0 | 80,0 | 40,0 | 7,7 | 0,5 | 2 | ■ |
| 620V100R050-DIAMOND | 00023435 | 2 | E | 10,0 | 10,0 | 10,0 | 80,0 | 40,0 | 9,7 | 0,5 | 2 | ■ |
| 620V120R050-DIAMOND | 00023437 | 2 | E | 12,0 | 12,0 | 10,0 | 80,0 | 40,0 | 11,7 | 0,5 | 2 | ■ |
| 620VL060R050-DIAMOND | 00023444 | 3 | E | 6,0 | 6,0 | 10,0 | 100,0 | 70,0 | 5,8 | 0,5 | 2 | ■ |
| 620VL080R050-DIAMOND | 00023446 | 3 | E | 8,0 | 8,0 | 10,0 | 100,0 | 70,0 | 7,8 | 0,5 | 2 | ■ |
| 620VL080R100-DIAMOND | 00023447 | 3 | E | 8,0 | 8,0 | 10,0 | 100,0 | 70,0 | 7,8 | 1,0 | 2 | ■ |
| 620VL100R050-DIAMOND | 00023448 | 3 | E | 10,0 | 10,0 | 10,0 | 100,0 | 70,0 | 9,8 | 0,5 | 2 | ■ |
| 620VL100R100-DIAMOND | 00023449 | 3 | E | 10,0 | 10,0 | 10,0 | 100,0 | 70,0 | 9,8 | 1,0 | 2 | ■ |
| 620VL120R050-DIAMOND | 00023450 | 3 | E | 12,0 | 12,0 | 10,0 | 100,0 | 70,0 | 11,8 | 0,5 | 2 | ■ |
| 620VL120R100-DIAMOND | 00023451 | 3 | E | 12,0 | 12,0 | 10,0 | 100,0 | 70,0 | 11,7 | 1,0 | 2 | ■ |
| 620VSL100R100-DIAMOND | 00023452 | 4 | E | 10,0 | 10,0 | 10,0 | 150,0 | 100,0 | 9,8 | 1,0 | 2 | ■ |
| 620VSL120R100-DIAMOND | 00023453 | 4 | E | 12,0 | 12,0 | 10,0 | 150,0 | 100,0 | 11,8 | 1,0 | 2 | ■ |

■ Lagerstandard.

Schnittdaten – JD620 Eckfräsen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|---------------------------------------|
| | | | | 3 | 4 | 6 | 8 | 10 | 12 | |
| GR1 | D | 0.500 | 0.50 | 0.030 | 0.040 | 0.060 | 0.080 | 0.10 | 0.12 | 690 (580 – 800) 2275 (2000 – 2600) |
| | | 0,500 | 0,50 | 0,0012 | 0,0016 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | |

Schnittdaten – JD620 Nutfräsen

| SMG |  | a _p /DC | f _z | | | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------|--------|---------------------------------------|
| | | | 3 | 4 | 6 | 8 | 10 | 12 | |
| GR1 | D | 0.50 | 0.024 | 0.032 | 0.048 | 0.065 | 0.080 | 0.095 | 610 (520 – 710) 2000 (1800 – 2300) |
| | | 0,50 | 0,00095 | 0,0013 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

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Rostfrei und ISO-S-Werkstoffe

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Kunststoffe und Composite

Graphit

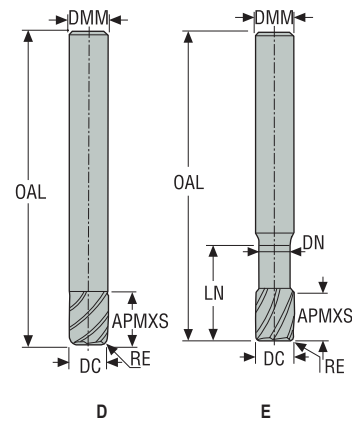
X-Heads

Minimaster Plus

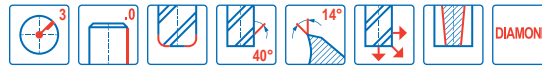
Minimaster

JD630

Diamant – Graphit – Eckfräser – 3 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- Rundlaufabweichung = <math><0,01\text{ mm}</math>
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= $\pm 0,05\text{ mm}$



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|----------------------|--------------------|------------------|-------------------|-----|-----|-------|-------|------|-----|------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| 630030R015-DIAMOND | 00023454 | 2 | D | 3,0 | 3,0 | 12,0 | 40,0 | – | – | 0,15 | 3 | ■ |
| 630040R020-DIAMOND | 00023456 | 2 | D | 4,0 | 4,0 | 14,0 | 50,0 | – | – | 0,2 | 3 | ■ |
| 630050R030-DIAMOND | 00023457 | 2 | D | 5,0 | 5,0 | 16,0 | 50,0 | – | – | 0,3 | 3 | ■ |
| 630060R030-DIAMOND | 00023458 | 2 | D | 6,0 | 6,0 | 20,0 | 65,0 | – | – | 0,3 | 3 | ■ |
| 630080R050-DIAMOND | 00023459 | 2 | D | 8,0 | 8,0 | 20,0 | 65,0 | – | – | 0,5 | 3 | ■ |
| 630V030R030-DIAMOND | 00023464 | 3 | E | 3,0 | 3,0 | 5,0 | 40,0 | 15,0 | 2,9 | 0,3 | 3 | ■ |
| 630V040R030-DIAMOND | 00023465 | 3 | E | 4,0 | 4,0 | 5,0 | 50,0 | 20,0 | 3,9 | 0,3 | 3 | ■ |
| 630VL030R020-DIAMOND | 00023467 | 4 | E | 3,0 | 3,0 | 5,0 | 60,0 | 25,0 | 2,9 | 0,2 | 3 | ■ |
| 630VL040R020-DIAMOND | 00023470 | 4 | E | 4,0 | 4,0 | 5,0 | 60,0 | 30,0 | 3,9 | 0,2 | 3 | ■ |
| 630VL050R020-DIAMOND | 00023471 | 4 | E | 5,0 | 5,0 | 6,0 | 70,0 | 40,0 | 4,9 | 0,2 | 3 | ■ |
| 630VL060R050-DIAMOND | 00023472 | 4 | E | 6,0 | 6,0 | 10,0 | 100,0 | 60,0 | 5,9 | 0,5 | 3 | ■ |

■ Lagerstandard.

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NE-Metalle

Harter

Kunststoffe und
Composite


Graphit

X-Heads


Minimaster Plus

Minimaster

Schnittdaten – JD630 Eckfräsen

| SMG |  | a _p /DC | | f _z | | | | | v _c |
|-----|---|--------------------|-----|----------------|--------|--------|--------|--------|--------------------|
| | | | | 3 | 4 | 5 | 6 | 8 | |
| GR1 | D | 0.500 | 1.0 | 0.030 | 0.040 | 0.050 | 0.060 | 0.080 | 680 (580 – 790) |
| | | 0,500 | 1,0 | 0,0012 | 0,0016 | 0,0020 | 0,0024 | 0,0032 | 2225 (2000 – 2500) |

Schnittdaten – JD630 Nutfräsen

| SMG |  | a _p /DC | | f _z | | | | | v _c |
|-----|---|--------------------|---------|----------------|--------|--------|--------|--------------------|----------------|
| | | | | 3 | 4 | 5 | 6 | 8 | |
| GR1 | D | 0.50 | 0.024 | 0.032 | 0.040 | 0.048 | 0.065 | 620 (520 – 720) | |
| | | 0,50 | 0,00095 | 0,0013 | 0,0016 | 0,0019 | 0,0026 | 2025 (1800 – 2300) | |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

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Kunststoffe und Composite

Graphit

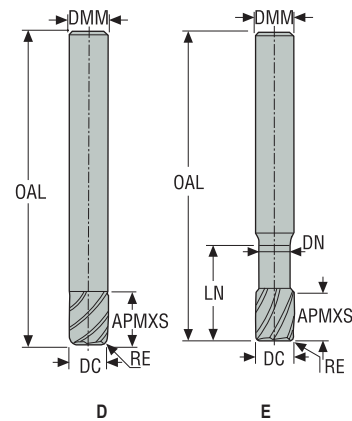
X-Heads

Minimaster Plus

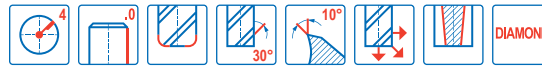
Minimaster

JD640

Diamant – Graphit – Eckfräser – 4 Schneiden – Zylindrisch – Eckenradius



- Toleranzen:
- Rundlaufabweichung = <math><0,01\text{ mm}</math>
- DMM= h5
- DC= -0,02/-0,04 mm
- RE= $\pm 0,05\text{ mm}$



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|----------------------|--------------------|------------------|-------------------|------|------|-------|-------|------|------|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| 640100R050-DIAMOND | 00023474 | 2 | D | 10,0 | 10,0 | 25,0 | 75,0 | – | – | 0,5 | 4 | ■ |
| 640120R050-DIAMOND | 00023475 | 2 | D | 12,0 | 12,0 | 25,0 | 80,0 | – | – | 0,5 | 4 | ■ |
| 640V060R050-DIAMOND | 00023479 | 3 | E | 6,0 | 6,0 | 10,0 | 80,0 | 40,0 | 5,9 | 0,5 | 4 | ■ |
| 640V080R050-DIAMOND | 00023480 | 3 | E | 8,0 | 8,0 | 10,0 | 80,0 | 40,0 | 7,8 | 0,5 | 4 | ■ |
| 640V100R050-DIAMOND | 00023481 | 3 | E | 10,0 | 10,0 | 12,0 | 80,0 | 40,0 | 9,8 | 0,5 | 4 | ■ |
| 640V120R050-DIAMOND | 00023483 | 3 | E | 12,0 | 12,0 | 15,0 | 80,0 | 40,0 | 11,8 | 0,5 | 4 | ■ |
| 640VL100R050-DIAMOND | 00023486 | 4 | E | 10,0 | 10,0 | 12,0 | 125,0 | 80,0 | 9,8 | 0,5 | 4 | ■ |
| 640VL120R050-DIAMOND | 02462698 | 4 | E | 12,0 | 12,0 | 15,0 | 125,0 | 80,0 | 11,7 | 0,5 | 4 | ■ |

■ Lagerstandard.

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Harter

Kunststoffe und
Composite


Graphit

X-Heads


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Schnittdaten – JD640 Eckfräsen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------------------|
| | | | | 6 | 8 | 10 | 12 | |
| GR1 | D | 0.500 | 1.0 | 0.060 | 0.080 | 0.10 | 0.12 | 680 (570 – 780) |
| | | 0,500 | 1,0 | 0,0024 | 0,0032 | 0,0040 | 0,0048 | 2225 (1900 – 2500) |

Schnittdaten – JD640 Nutfräsen

| SMG |  | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------------------|
| | | | 6 | 8 | 10 | 12 | |
| GR1 | D | 0.50 | 0.048 | 0.065 | 0.080 | 0.095 | 610 (520 – 710) |
| | | 0,50 | 0,0019 | 0,0026 | 0,0032 | 0,0038 | 2000 (1800 – 2300) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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Kunststoffe und Composite

Graphit

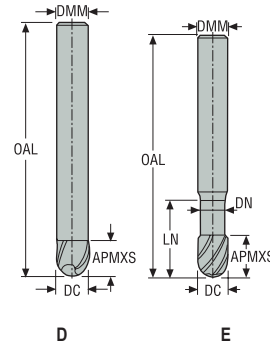
X-Heads

Minimaster Plus

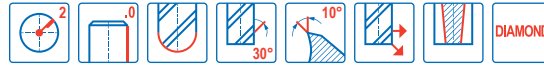
Minimaster

JD660

Diamant – Graphit – Kugelkopf – 2 Schneiden – Zylindrisch



- Toleranzen:
- Rundlaufabweichung $\leq 0,01$ mm
- DMM=h5
- DC= -0,02/-0,04 mm
- RE= $\pm 0,01$ mm
- B=0,9°



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | PCEDC | Zylindrisch |
|------------------|----------------|--------------|---------------|-----|-----|-------|-------|------|-----|-----|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | | |
| 660030-DIAMOND | 00023488 | 1 | D | 3,0 | 3,0 | 8,0 | 40,0 | - | - | 1,5 | 2 | ■ |
| 660040-DIAMOND | 00023489 | 1 | D | 4,0 | 4,0 | 14,0 | 50,0 | - | - | 2,0 | 2 | ■ |
| 660060-DIAMOND | 00023491 | 1 | D | 6,0 | 6,0 | 20,0 | 65,0 | - | - | 3,0 | 2 | ■ |
| 660V030-DIAMOND | 00023501 | 2 | E | 3,0 | 3,0 | 6,0 | 40,0 | 15,0 | 2,9 | 1,5 | 2 | ■ |
| 660V040-DIAMOND | 00023502 | 2 | E | 4,0 | 4,0 | 6,0 | 40,0 | 15,0 | 3,9 | 2,0 | 2 | ■ |
| 660V060-DIAMOND | 00023505 | 2 | E | 6,0 | 6,0 | 10,0 | 65,0 | 35,0 | 5,9 | 3,0 | 2 | ■ |
| 660L030-DIAMOND | 00023494 | 3 | D | 3,0 | 3,0 | 20,0 | 60,0 | - | - | 1,5 | 2 | ■ |
| 660L040-DIAMOND | 00023496 | 3 | D | 4,0 | 4,0 | 30,0 | 60,0 | - | - | 2,0 | 2 | ■ |
| 660L060-DIAMOND | 00023498 | 3 | D | 6,0 | 6,0 | 40,0 | 100,0 | - | - | 3,0 | 2 | ■ |
| 660VL030-DIAMOND | 00023511 | 4 | E | 3,0 | 3,0 | 6,0 | 60,0 | 30,0 | 2,9 | 1,5 | 2 | ■ |
| 660VL040-DIAMOND | 00023512 | 4 | E | 4,0 | 4,0 | 6,0 | 60,0 | 30,0 | 3,9 | 2,0 | 2 | ■ |
| 660VL060-DIAMOND | 00023516 | 4 | E | 6,0 | 6,0 | 10,0 | 100,0 | 70,0 | 5,8 | 3,0 | 2 | ■ |

■ Lagerstandard.

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NE-Metalle

Harder

Kunststoffe und Composite


Graphit

X-Heads

Minimaster Plus

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Schnittdaten – JD660 Kopierfräsen/Schruppen

| SMG |  | a_e/DC | | f_z | | | v_c |
|-----|---|----------|-----|---------|--------|--------|--------------------|
| | | | | 3 | 4 | 6 | |
| GR1 | D | 0.400 | 2.4 | 0.024 | 0.032 | 0.046 | 920 (780 – 1000) |
| | | 0.400 | 2.4 | 0,00095 | 0,0013 | 0,0018 | 3025 (2600 – 3200) |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Universell

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Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

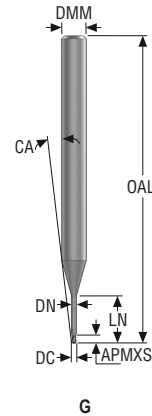
X-Heads

Minimaster Plus

Minimaster

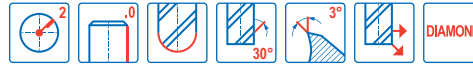
SMB614/616

Mini – Graphit – Kugelkopf – 2 Schneiden – Zylindrisch



G


- Toleranzen:
- Rundlaufabweichung = <math><0,005\text{ mm}</math>
- DMM = h5
- DC Beschichtet = $-0,01/-0,025\text{ mm}$
- DC Beschichtet = $0/-0,015\text{ mm}$
- RE = $\pm 0,01\text{ mm}$



| Bezeichnung | Beschichtung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | DN | LN | CA° | PCEDC | Zylindrisch |
|------------------|--------------|----------------|--------------|---------------|-----|-----|-------|-----|------|------|-------|-------|-------------|
| | | | | | mm | mm | mm | mm | mm | mm | | | |
| SMB614010G4B.0Z2 | - | 10108702 | 4 | G | 1,0 | 4 | 1,0 | 50 | 0,95 | 7,5 | 6,54° | 2 | ■ |
| SMB614010G4B.0Z2 | DIA | 10108776 | 4 | G | 1,0 | 4 | 1,0 | 50 | 0,95 | 7,5 | 6,54° | 2 | ■ |
| SMB614020G4B.0Z2 | - | 10108703 | 4 | G | 2,0 | 4 | 2,0 | 50 | 1,9 | 12,0 | 3,74° | 2 | ■ |
| SMB614020G4B.0Z2 | DIA | 10108777 | 4 | G | 2,0 | 4 | 2,0 | 50 | 1,9 | 12,0 | 3,74° | 2 | ■ |
| SMB616020G4B.0Z2 | - | 10108768 | 4 | G | 2,0 | 6 | 2,0 | 50 | 1,9 | 12,0 | 5,99° | 2 | ■ |
| SMB614030G4B.0Z2 | - | 10108704 | 4 | G | 3,0 | 4 | 3,0 | 50 | 2,85 | 20,0 | 1,36° | 2 | ■ |
| SMB614030G4B.0Z2 | DIA | 10108778 | 4 | G | 3,0 | 4 | 3,0 | 50 | 2,85 | 20,0 | 1,36° | 2 | ■ |
| SMB616030G4B.0Z2 | - | 10108769 | 4 | G | 3,0 | 6 | 3,0 | 55 | 2,85 | 20,0 | 3,47° | 2 | ■ |
| SMB614020G5B.0Z2 | - | 10108705 | 5 | G | 2,0 | 4 | 2,0 | 50 | 1,9 | 16,0 | 2,96° | 2 | ■ |
| SMB614020G5B.0Z2 | DIA | 10108779 | 5 | G | 2,0 | 4 | 2,0 | 50 | 1,9 | 16,0 | 3,13° | 2 | ■ |
| SMB616020G5B.0Z2 | - | 10108770 | 5 | G | 2,0 | 6 | 2,0 | 50 | 1,9 | 16,0 | 4,96° | 2 | ■ |
| SMB614006G6B.0Z2 | - | 10108706 | 6 | G | 0,6 | 4 | 0,6 | 50 | 0,55 | 6,0 | 7,72° | 2 | ■ |
| SMB614006G6B.0Z2 | DIA | 10108780 | 6 | G | 0,6 | 4 | 0,6 | 50 | 0,55 | 6,0 | 7,72° | 2 | ■ |
| SMB616006G6B.0Z2 | - | 10108771 | 6 | G | 0,6 | 6 | 0,6 | 50 | 0,55 | 6,0 | 9,43° | 2 | ■ |
| SMB614008G6B.0Z2 | - | 10108707 | 6 | G | 0,8 | 4 | 0,8 | 50 | 0,75 | 10,0 | 5,69° | 2 | ■ |
| SMB614008G6B.0Z2 | DIA | 10108781 | 6 | G | 0,8 | 4 | 0,8 | 50 | 0,75 | 10,0 | 5,69° | 2 | ■ |
| SMB614010G6B.0Z2 | - | 10108708 | 6 | G | 1,0 | 4 | 0,5 | 50 | 0,95 | 12,0 | 4,88° | 2 | ■ |
| SMB614010G6B.0Z2 | DIA | 10108782 | 6 | G | 1,0 | 4 | 0,5 | 50 | 0,95 | 12,0 | 4,88° | 2 | ■ |
| SMB616010G6B.0Z2 | - | 10108772 | 6 | G | 1,0 | 6 | 1,0 | 50 | 0,95 | 12,0 | 6,69° | 2 | ■ |
| SMB614020G6B.0Z2 | - | 10108709 | 6 | G | 2,0 | 4 | 2,0 | 50 | 1,9 | 20,0 | 2,46° | 2 | ■ |
| SMB614020G6B.0Z2 | DIA | 10108783 | 6 | G | 2,0 | 4 | 2,0 | 50 | 1,9 | 20,0 | 2,46° | 2 | ■ |
| SMB616020G6B.0Z2 | - | 10108773 | 6 | G | 2,0 | 6 | 2,0 | 55 | 1,9 | 20,0 | 4,23° | 2 | ■ |
| SMB614006G7B.0Z2 | - | 10108710 | 7 | G | 0,6 | 4 | 0,6 | 50 | 0,55 | 10,0 | 5,87° | 2 | ■ |
| SMB614006G7B.0Z2 | DIA | 10108784 | 7 | G | 0,6 | 4 | 0,6 | 50 | 0,55 | 10,0 | 5,87° | 2 | ■ |
| SMB616006G7B.0Z2 | - | 10108774 | 7 | G | 0,6 | 6 | 0,6 | 50 | 0,55 | 10,0 | 7,59° | 2 | ■ |
| SMB614010G7B.0Z2 | - | 10108711 | 7 | G | 1,0 | 4 | 1,0 | 50 | 0,95 | 18,0 | 3,64° | 2 | ■ |
| SMB614010G7B.0Z2 | DIA | 10108785 | 7 | G | 1,0 | 4 | 1,0 | 50 | 0,95 | 18,0 | 3,64° | 2 | ■ |
| SMB616010G7B.0Z2 | - | 10108775 | 7 | G | 1,0 | 6 | 1,0 | 55 | 0,95 | 18,0 | 5,23° | 2 | ■ |

■ Lagerstandard.


Schnittdaten – SMB614 Kopierfräsen/Schruppen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|--------|--------|--------|----------------------------------|
| | | | | 0.6 | 0.8 | 1 | 2 | 3 | |
| GR1 | D | 0,0700 | 0,10 | 0,018 | 0,024 | 0,030 | 0,060 | 0,090 | 95 (54 – 120) 310 (180 – 390) |
| | | 0.0700 | 0.10 | 0.00070 | 0.00095 | 0.0012 | 0.0024 | 0.0036 | |

Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – SMB616 Kopierfräsen/Schruppen

| SMG |  | a _e /DC | a _p /DC | f _z | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|----------------------------------|
| | | | | 0.6 | 1 | 2 | |
| GR1 | D | 0,0700 | 0,10 | 0,018 | 0,030 | 0,060 | 95 (54 – 120) 310 (180 – 390) |
| | | 0.0700 | 0.10 | 0.00070 | 0.0012 | 0.0024 | |

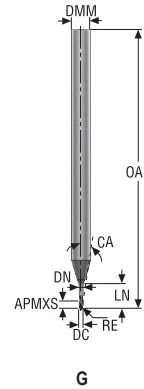
Schnittdaten, siehe Seite 561 - 568

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

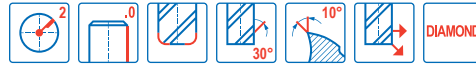
- Universell
- Stahl und Guss
- Rostfrei und ISO-S-Werkstoffe
- NE-Metalle
- Harter
- Kunststoffe und Composite
- Graphit
- X-Heads
- Minimaster Plus
- Minimaster

JME642

Mini – Graphit – Eckfräser – Diamant – 2 Schneiden – DMM 4 – Zylindrisch – Eckenradius



- Toleranzen:
- Rundlaufabweichung = <math><0,005\text{ mm}</math>
- DMM= h5
- DC= 0/-0,015 mm
- RE= $\pm 0,007\text{ mm}$



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | DC | DMM | APMXS | OAL | LN | DN | RE | CA° | PCEDC | Zylindrisch |
|-------------------------|--------------------|------------------|-------------------|-----|-----|-------|------|------|------|------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | mm | |
| JME642002G1R002.0Z2-DIA | 03215524 | 1 | G | 0,2 | 4,0 | 0,3 | 40,0 | 0,4 | 0,18 | 0,02 | 14,32 | 2 | ■ |
| JME642003G1R002.0Z2-DIA | 03215525 | 1 | G | 0,3 | 4,0 | 0,5 | 40,0 | 0,5 | 0,28 | 0,02 | 14,1 | 2 | ■ |
| JME642004G1R004.0Z2-DIA | 03215526 | 1 | G | 0,4 | 4,0 | 0,6 | 40,0 | 2,0 | 0,37 | 0,04 | 11,67 | 2 | ■ |
| JME642005G3R005.0Z2-DIA | 03215527 | 3 | G | 0,5 | 4,0 | 0,7 | 40,0 | 2,5 | 0,45 | 0,05 | 10,97 | 2 | ■ |
| JME642006G3R006.0Z2-DIA | 03215528 | 3 | G | 0,6 | 4,0 | 1,0 | 60,0 | 3,0 | 0,55 | 0,06 | 10,31 | 2 | ■ |
| JME642008G3R008.0Z2-DIA | 03215529 | 3 | G | 0,8 | 4,0 | 1,2 | 60,0 | 4,0 | 0,75 | 0,08 | 9,31 | 2 | ■ |
| JME642010G3R010.0Z2-DIA | 03215530 | 3 | G | 1,0 | 4,0 | 1,6 | 60,0 | 5,0 | 0,95 | 0,1 | 8,04 | 2 | ■ |
| JME642012G3R012.0Z2-DIA | 03215531 | 3 | G | 1,2 | 4,0 | 1,6 | 60,0 | 6,0 | 1,15 | 0,12 | 7,09 | 2 | ■ |
| JME642015G3R015.0Z2-DIA | 03215532 | 3 | G | 1,5 | 4,0 | 2,4 | 60,0 | 7,5 | 1,4 | 0,15 | 5,8 | 2 | ■ |
| JME642020G3R015.0Z2-DIA | 03236441 | 3 | G | 2,0 | 4,0 | 2,2 | 60,0 | 10,0 | 1,9 | 0,15 | 4,11 | 2 | ■ |
| JME642020G3R020.0Z2-DIA | 03215533 | 3 | G | 2,0 | 4,0 | 3,0 | 60,0 | 10,0 | 1,9 | 0,2 | 4,11 | 2 | ■ |
| JME642005G5R005.0Z2-DIA | 03215534 | 5 | G | 0,5 | 4,0 | 0,7 | 40,0 | 4,0 | 0,45 | 0,05 | 9,43 | 2 | ■ |
| JME642006G5R006.0Z2-DIA | 03215535 | 5 | G | 0,6 | 4,0 | 1,0 | 60,0 | 5,0 | 0,55 | 0,06 | 8,5 | 2 | ■ |
| JME642008G5R008.0Z2-DIA | 03215536 | 5 | G | 0,8 | 4,0 | 1,2 | 60,0 | 7,0 | 0,75 | 0,08 | 7,02 | 2 | ■ |
| JME642010G5R010.0Z2-DIA | 03215537 | 5 | G | 1,0 | 4,0 | 1,6 | 60,0 | 8,5 | 0,95 | 0,1 | 6,06 | 2 | ■ |
| JME642012G5R012.0Z2-DIA | 03215538 | 5 | G | 1,2 | 4,0 | 1,6 | 60,0 | 10,0 | 1,15 | 0,12 | 5,23 | 2 | ■ |
| JME642015G5R015.0Z2-DIA | 03215539 | 5 | G | 1,5 | 4,0 | 2,4 | 60,0 | 12,0 | 1,4 | 0,15 | 4,25 | 2 | ■ |
| JME642020G5R015.0Z2-DIA | 03236442 | 5 | G | 2,0 | 4,0 | 2,2 | 60,0 | 16,0 | 1,9 | 0,15 | 2,87 | 2 | ■ |
| JME642020G5R020.0Z2-DIA | 03215540 | 5 | G | 2,0 | 4,0 | 3,0 | 60,0 | 16,0 | 1,9 | 0,2 | 2,87 | 2 | ■ |
| JME642010G6R010.0Z2-DIA | 03215541 | 6 | G | 1,0 | 4,0 | 1,6 | 60,0 | 12,0 | 0,95 | 0,1 | 4,86 | 2 | ■ |
| JME642015G6R015.0Z2-DIA | 03215542 | 6 | G | 1,5 | 4,0 | 2,4 | 50,0 | 18,0 | 1,4 | 0,15 | 3,13 | 2 | ■ |
| JME642020G6R020.0Z2-DIA | 03215543 | 6 | G | 2,0 | 4,0 | 3,0 | 60,0 | 25,0 | 1,9 | 0,2 | 1,97 | 2 | ■ |
| JME642020G7R020.0Z2-DIA | 03215544 | 7 | G | 2,0 | 4,0 | 3,0 | 60,0 | 30,0 | 1,9 | 0,2 | 1,68 | 2 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harder

Kunststoffe und Composite


Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JME642/JME662 Eckfräsen/Schruppen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|------------------|
| | | | | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.8 | 1 | 1.2 | 1.5 | 2 | |
| GR1 | D | 0.300 | 0.80 | 0.024 | 0.036 | 0.044 | 0.048 | 0.055 | 0.060 | 0.065 | 0.070 | 0.075 | 0.085 | 175 (130 – 370) |
| | | 0,300 | 0,80 | 0,00095 | 0,0014 | 0,0017 | 0,0019 | 0,0022 | 0,0024 | 0,0026 | 0,0028 | 0,0030 | 0,0034 | 570 (430 – 1200) |

Schnittdaten – JME642 Nutfräsen


| SMG |  | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------|--------|--------|--------|--------|--------|-----------------|
| | | | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.8 | 1 | 1.2 | 1.5 | 2 | |
| GR1 | D | 0.30 | 0.022 | 0.032 | 0.040 | 0.046 | 0.050 | 0.055 | 0.065 | 0.065 | 0.075 | 0.080 | 140 (110 – 300) |
| | | 0,30 | 0,00085 | 0,0013 | 0,0016 | 0,0018 | 0,0020 | 0,0022 | 0,0026 | 0,0026 | 0,0030 | 0,0032 | 460 (370 – 980) |

Tabelle basierend auf LV3, auf Basis der gewählten Version neu berechnen. Siehe Seite(n). 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

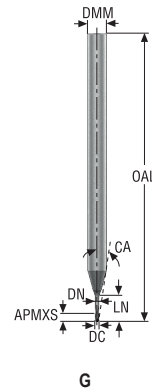
X-Heads

Minimaster Plus

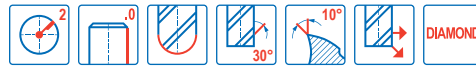
Minimaster

JMB642/JMB662

Mini – Graphit – Kugelkopf – Diamant – 2 Schneiden – DMM 4-6 – Zylindrisch



- Toleranzen:
- Rundlaufabweichung = <math><0,005\text{ mm}</math>
- DMM= h5
- DC= 0/-0,015 mm
- RE= $\pm 0,007\text{ mm}$



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | DC | DMM | APMXS | OAL | LN | DN | RE | CA° | PCEDC | Zylindrisch |
|----------------------|----------------|--------------|---------------|-----|-----|-------|------|------|------|------|-------|-------|-------------|
| | | | | mm | mm | mm | mm | mm | mm | mm | mm | mm | |
| JMB642002G1B.0Z2-DIA | 03215373 | 1 | G | 0,2 | 4,0 | 0,3 | 40,0 | 0,4 | 0,18 | 0,1 | 14,5 | 2 | ■ |
| JMB642003G1B.0Z2-DIA | 03215374 | 1 | G | 0,3 | 4,0 | 0,5 | 40,0 | 0,6 | 0,28 | 0,15 | 14,17 | 2 | ■ |
| JMB642004G1B.0Z2-DIA | 03215375 | 1 | G | 0,4 | 4,0 | 2,0 | 40,0 | 0,8 | 0,37 | 0,2 | 13,8 | 2 | ■ |
| JMB642005G3B.0Z2-DIA | 03215376 | 3 | G | 0,5 | 4,0 | 0,7 | 40,0 | 2,5 | 0,45 | 0,25 | 11,19 | 2 | ■ |
| JMB642006G3B.0Z2-DIA | 03215377 | 3 | G | 0,6 | 4,0 | 1,0 | 60,0 | 3,0 | 0,55 | 0,3 | 10,55 | 2 | ■ |
| JMB642008G3B.0Z2-DIA | 03215378 | 3 | G | 0,8 | 4,0 | 1,2 | 60,0 | 4,0 | 0,75 | 0,4 | 9,38 | 2 | ■ |
| JMB642010G3B.0Z2-DIA | 03215379 | 3 | G | 1,0 | 4,0 | 1,6 | 60,0 | 5,0 | 0,95 | 0,5 | 8,33 | 2 | ■ |
| JMB642012G3B.0Z2-DIA | 03215380 | 3 | G | 1,2 | 4,0 | 1,6 | 60,0 | 6,0 | 1,15 | 0,6 | 7,38 | 2 | ■ |
| JMB642015G3B.0Z2-DIA | 03215381 | 3 | G | 1,5 | 4,0 | 2,4 | 60,0 | 7,5 | 1,4 | 0,75 | 6,08 | 2 | ■ |
| JMB642020G3B.0Z2-DIA | 03215382 | 3 | G | 2,0 | 4,0 | 3,0 | 60,0 | 10,0 | 1,9 | 1,0 | 4,35 | 2 | ■ |
| JMB662030G3B.0Z2-DIA | 03215384 | 3 | G | 3,0 | 6,0 | 3,0 | 60,0 | 15,0 | 2,8 | 1,5 | 4,38 | 2 | ■ |
| JMB642005G5B.0Z2-DIA | 03215387 | 5 | G | 0,5 | 4,0 | 0,7 | 40,0 | 4,0 | 0,45 | 0,25 | 9,6 | 2 | ■ |
| JMB642006G5B.0Z2-DIA | 03215388 | 5 | G | 0,6 | 4,0 | 1,0 | 60,0 | 5,0 | 0,55 | 0,3 | 8,68 | 2 | ■ |
| JMB642008G5B.0Z2-DIA | 03215389 | 5 | G | 0,8 | 4,0 | 1,2 | 60,0 | 7,0 | 0,75 | 0,4 | 7,18 | 2 | ■ |
| JMB642010G5B.0Z2-DIA | 03215390 | 5 | G | 1,0 | 4,0 | 1,6 | 60,0 | 8,5 | 0,95 | 0,5 | 6,22 | 2 | ■ |
| JMB642012G5B.0Z2-DIA | 03215391 | 5 | G | 1,2 | 4,0 | 1,6 | 60,0 | 10,0 | 1,15 | 0,6 | 5,4 | 2 | ■ |
| JMB642015G5B.0Z2-DIA | 03215392 | 5 | G | 1,5 | 4,0 | 2,4 | 60,0 | 12,0 | 1,4 | 0,75 | 4,4 | 2 | ■ |
| JMB642020G5B.0Z2-DIA | 03215393 | 5 | G | 2,0 | 4,0 | 3,0 | 60,0 | 16,0 | 1,9 | 1,0 | 2,99 | 2 | ■ |
| JMB662030G5B.0Z2-DIA | 03215395 | 5 | G | 3,0 | 6,0 | 3,0 | 60,0 | 24,0 | 2,8 | 1,5 | 3,0 | 2 | ■ |
| JMB642010G6B.0Z2-DIA | 03215396 | 6 | G | 1,0 | 4,0 | 1,6 | 60,0 | 12,0 | 0,95 | 0,5 | 4,96 | 2 | ■ |
| JMB642015G6B.0Z2-DIA | 03215397 | 6 | G | 1,5 | 4,0 | 2,4 | 60,0 | 18,0 | 1,4 | 0,75 | 3,21 | 2 | ■ |
| JMB642020G6B.0Z2-DIA | 03215398 | 6 | G | 2,0 | 4,0 | 3,0 | 60,0 | 25,0 | 1,9 | 1,0 | 2,03 | 2 | ■ |
| JMB642020G7B.0Z2-DIA | 03215399 | 7 | G | 2,0 | 4,0 | 3,0 | 60,0 | 30,0 | 1,9 | 1,0 | 1,72 | 2 | ■ |

■ Lagerstandard.

Universell

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Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite


Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – JMB642/662 Eckfräsen/Schruppen

| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|------------------------------------|
| | | | | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.8 | 1 | 1.2 | 1.5 | 2 | |
| GR1 | D | 0.300 | 0.50 | 0.0024 | 0.0036 | 0.0048 | 0.0060 | 0.0070 | 0.0095 | 0.012 | 0.014 | 0.017 | 0.020 | 250 (200 – 300) 820 (660 – 980) |
| | | 0,300 | 0,50 | 0,000095 | 0,00014 | 0,00019 | 0,00024 | 0,00028 | 0,00038 | 0,00048 | 0,00055 | 0,00065 | 0,00080 | |

Schnittdaten – JMB642/662 Kopierfräsen/Schruppen


| SMG |  | a _e /DC | a _p /DC | f _z | | | | | | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|---------|---------|---------|---------|---------|---------|---------|---------|------------------------------------|
| | | | | 0.2 | 0.3 | 0.4 | 0.5 | 0.6 | 0.8 | 1 | 1.2 | 1.5 | 2 | |
| GR1 | D | 0.300 | 0.50 | 0.0024 | 0.0036 | 0.0048 | 0.0060 | 0.0070 | 0.0095 | 0.012 | 0.014 | 0.017 | 0.020 | 250 (200 – 300) 820 (660 – 980) |
| | | 0,300 | 0,50 | 0,000095 | 0,00014 | 0,00019 | 0,00024 | 0,00028 | 0,00038 | 0,00048 | 0,00055 | 0,00065 | 0,00080 | |

Tabelle basierend auf LV3, auf Basis der gewählten Version neu berechnen. Siehe Seite(n) 561 - 568

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster




























SECO X-HEADS

Das neue Programm an austauschbaren Köpfen von Seco ist ein umfassendes Angebot, das den Anforderungen der meisten Kunden entspricht. Mit unseren bewährten Vollhartmetallgeometrien bieten wir verschiedene Typen für die Bearbeitung der meisten Materialien und zur Durchführung verschiedener Bearbeitungsvorgänge an. Der Anschluss ist eine bewährte Konstruktion austauschbarer Köpfe, die eine hohe Prozesssicherheit und Zuverlässigkeit bietet. Es gibt viele Arten von Schäften für Anwendungen mit kurzen bis langen Werkzeugen. Gerade und konische Freilegungen für die beste Kombination von Stabilität je nach Bedarf bei Ihre Bearbeitungsvorgänge.

- XSE550, XSE720, XSE450, XHF580, XHF780 XVE540 und XVE510 mit Fase oder Eckenradius.
- XSB540, XSB720 und XVB510 Kugelkopffräsen.
- XVC506, XVC509 und XVC512 konisch
- XHT740 Tonnenfräser.

Werkzeugauswahl X-Heads

| | |  |  |  |  |  |  |
|-----------------------------|---|---|---|--|--|---|---|
| Werkzeugbezeichnung | | XSE550 | XSB540 | XSE720 | XSB720 | XSE450 | XHT740 |
| Seite(n) | | 488-495 | 504 | 506-507 | 512 | 518-519 | 296 |
| Produktfamilie | | X-HEADS SOLID ² | X-HEADS SOLID ² | X-HEADS SOLID ² | X-HEADS SOLID ² | X-HEADS SOLID ² | X-HEADS HSM/TORNADO |
| Fräseausführung | |  |  |  |  |  |  |
| Schneidenzahl | | 4 | 4 | 4 | 4 | 4 | 4 |
| ICC | | | ■ | | | | |
| | Metrisch | 10-20 | 10-16 | 10-25 | 10-20 | 10-20 | 10-16 |
| | Zoll | 3/8-1 | | 3/8-1 | 3/8-1 | 3/8-1 | |
| Verfügbare Längen | | 1,2,3 | 1,2,3 | 1,2,3 | 1,2,3 | 1,2,3 | 2,4 |
| Bearbeitung |  | | | | |  | |
| |  | | |  |  |  |  |
| |  | | | |  | |  |
| |  | | |  |  | | |
| SMG | | | | | | | |
| P1-8 | ● | ● | ○ | ○ | ○ | ○ | ○ |
| P11-12 | ● | ○ | ● | ● | ● | ● | ● |
| M1-3 | ● | ● | ● | ● | ● | ● | ● |
| M4-5 | ● | ● | ● | ● | ● | ● | ● |
| K1-7 | ● | ● | ● | ● | ● | ● | ● |
| S1-3 | ● | ○ | ● | ● | ● | ○ | ○ |
| S11-13 | ● | ● | ● | ● | ● | ● | ● |
| H3 H5 H7 H8 H11 H12 H21 H31 | ● | ○ | | | | | |
| N1 | ● | ● | | | | ● | |
| N2-3 | ● | ● | | | | ● | |
| N11 | ● | ● | | | | ● | |
| TS1 | ● | ● | | | | ● | |
| TP1 | ● | ● | | | | ● | |
| GR | ○ | ○ | | | | | |

■ Lagerstandard.
● Erste Wahl, ○ Alternative

Universell
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

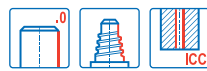
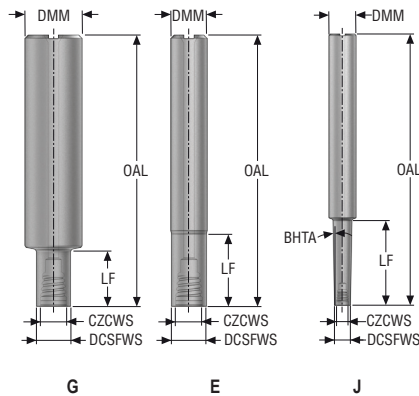
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 Harter
 Kunststoffe und Composite
 Graphit
 X-Heads
 Minimaster Plus
 Minimaster

Werkzeugauswahl X-Heads

| Werkzeugbezeichnung | XHF580 | XHF780 | XVE540 | XVE510 | XVB510 | XVC506/509/512 | XVK310 | |
|-----------------------------|-------------|-------------|-------------|-------------|-------------|----------------|-------------|-------|
| Seite(n) | 525 | 530 | 543 | 548 | 551-552 | 555 | 559 | |
| Produktfamilie | X-HEADS HFM | X-HEADS HFM | X-HEADS VHM | X-HEADS VHM | X-HEADS VHM | X-HEADS VHM | X-HEADS VHM | |
| Fräserausführung | | | | | | | | |
| Schneidenzahl | 4 | 4 | 4 | 4 | 4 | 4 | 4 | |
| ICC | ■ | | ■ | | | | | |
| | Metrisch | 10-16 | 10-16 | 10-20 | 10-12 | 10-16 | 10-16 | 12-20 |
| | Zoll | 3/8-5/8 | 3/8-5/8 | 3/8-3/4 | | 3/8-5/8 | | |
| Verfügbare Längen | 1,2,3 | 1,2,3 | 1,2,3 | 1,2,3 | 1,2,3 | 1,2,3 | 1,2,3 | |
| Bearbeitung | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |
| SMG | | | | | | | | |
| P1-8 | ● | ○ | ● | ● | ● | ● | ● | |
| P11-12 | ● | ○ | ● | ● | ● | ● | ● | |
| M1-3 | ● | ● | ● | ● | ● | ● | ● | |
| M4-5 | ● | ● | ● | ● | ● | ● | ● | |
| K1-7 | ● | ● | ● | ● | ● | ● | ● | |
| S1-3 | ○ | ● | ○ | ○ | ○ | ○ | ○ | |
| S11-13 | ○ | ● | ○ | ○ | ○ | ○ | ○ | |
| H3 H5 H7 H8 H11 H12 H21 H31 | ○ | ○ | ○ | | | | ○ | |
| N1 | | | ● | ○ | ○ | ○ | ● | |
| N2-3 | | | ● | ○ | ○ | ○ | ● | |
| N11 | | | ● | ○ | ○ | ○ | ● | |
| TS1 | | | ● | ● | ● | ● | ● | |
| TP1 | | | ● | ● | ● | ● | ● | |
| GR | | | ○ | ○ | ○ | ○ | ○ | |

■ Lagerstandard □ Weldon verfügbar, die Lieferzeit beträgt 3 Tage. □ Safe-Lock verfügbar, die Lieferzeit beträgt 6 Tage.
 ● Erste Wahl ○ Alternative

Stahl - Metrisch



- Toleranzen:
- DMM= h6
- DCSFWS= ±0,05 mm
- BHTA= ±20'

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | CZCMS | DCSFWS | DMM | LF | OAL | BHTA° | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|-------|--------|------|------|-------|-------|-------------|
| | | | | | | | | | | |
| XE10160G1-065-00.0S | 10138083 | 1 | G | E10 | 9,6 | 16,0 | 5,0 | 65,0 | 0,0 | ■ |
| XE10100E2-055-00.0S | 10138092 | 2 | E | E10 | 9,6 | 10,0 | 10,0 | 55,0 | 0,0 | ■ |
| XE10100E2-075-00.0S | 10138093 | 2 | E | E10 | 9,6 | 10,0 | 20,0 | 75,0 | 0,0 | ■ |
| XE10160G2-075-00.0S | 10138088 | 2 | G | E10 | 9,6 | 16,0 | 15,0 | 75,0 | 0,0 | ■ |
| XE10160J3-120-01.0S | 10138099 | 3 | J | E10 | 9,6 | 16,0 | 35,0 | 120,0 | 1,0 | ■ |
| XE10160J5-160-01.0S | 10138100 | 5 | J | E10 | 9,6 | 16,0 | 50,0 | 160,0 | 1,0 | ■ |
| XE10160J3-140-05.0S | 10138106 | 3 | J | E10 | 9,6 | 16,0 | 36,6 | 140,0 | 5,0 | ■ |
| XE10200J5-140-05.0S | 10138108 | 5 | J | E10 | 9,6 | 20,0 | 59,4 | 140,0 | 5,0 | ■ |
| XE10320J6-250-10.0S | 10138113 | 6 | J | E10 | 9,6 | 32,0 | 63,5 | 250,0 | 10,0 | ■ |
| XE12160G1-065-00.0S | 10138084 | 1 | G | E12 | 11,6 | 16,0 | 5,0 | 65,0 | 0,0 | ■ |
| XE12120E2-065-00.0S | 10138094 | 2 | E | E12 | 11,6 | 12,0 | 12,0 | 65,0 | 0,0 | ■ |
| XE12120E2-100-00.0S | 10138095 | 2 | E | E12 | 11,6 | 12,0 | 22,0 | 100,0 | 0,0 | ■ |
| XE12160G2-080-00.0S | 10138089 | 2 | G | E12 | 11,6 | 16,0 | 18,0 | 80,0 | 0,0 | ■ |
| XE12160J3-155-01.0S | 10138101 | 3 | J | E12 | 11,6 | 16,0 | 42,0 | 155,0 | 1,0 | ■ |
| XE12160J5-170-01.0S | 10138102 | 5 | J | E12 | 11,6 | 16,0 | 60,0 | 170,0 | 1,0 | ■ |
| XE12160J2-140-05.0S | 10138107 | 2 | J | E12 | 11,6 | 16,0 | 25,1 | 140,0 | 5,0 | ■ |
| XE12200J4-155-05.0S | 10138109 | 4 | J | E12 | 11,6 | 20,0 | 48,0 | 155,0 | 5,0 | ■ |
| XE12320J4-250-10.0S | 10138114 | 4 | J | E12 | 11,6 | 32,0 | 57,8 | 250,0 | 10,0 | ■ |
| XE16200G1-070-00.0S | 10138085 | 1 | G | E16 | 15,4 | 20,0 | 5,0 | 70,0 | 0,0 | ■ |
| XE16160E2-070-00.0S | 10138096 | 2 | E | E16 | 15,4 | 16,0 | 16,0 | 70,0 | 0,0 | ■ |
| XE16200G2-090-00.0S | 10138090 | 2 | G | E16 | 15,4 | 20,0 | 24,0 | 90,0 | 0,0 | ■ |
| XE16200G2-110-00.0S | 10138091 | 2 | G | E16 | 15,4 | 20,0 | 25,0 | 110,0 | 0,0 | ■ |
| XE16200J3-190-01.0S | 10138103 | 3 | J | E16 | 15,4 | 20,0 | 56,0 | 190,0 | 1,0 | ■ |
| XE16200J4-190-01.0S | 10138104 | 4 | J | E16 | 15,4 | 20,0 | 75,0 | 190,0 | 1,0 | ■ |
| XE16250J3-170-05.0S | 10138110 | 3 | J | E16 | 15,4 | 25,0 | 54,9 | 170,0 | 5,0 | ■ |
| XE20250G1-080-00.0S | 10138086 | 1 | G | E20 | 19,2 | 25,0 | 5,0 | 80,0 | 0,0 | ■ |
| XE20200E2-120-00.0S | 10138097 | 2 | E | E20 | 19,2 | 20,0 | 30,0 | 120,0 | 0,0 | ■ |
| XE20250J4-200-01.0S | 10138105 | 4 | J | E20 | 19,2 | 25,0 | 80,0 | 200,0 | 1,0 | ■ |
| XE20320J3-180-05.0S | 10138111 | 3 | J | E20 | 19,2 | 32,0 | 73,2 | 180,0 | 5,0 | ■ |
| XE25320G1-080-00.0S | 10138087 | 1 | G | E25 | 24,1 | 32,0 | 5,0 | 80,0 | 0,0 | ■ |
| XE25250E2-140-00.0S | 10138098 | 2 | E | E25 | 24,1 | 25,0 | 40,0 | 140,0 | 0,0 | ■ |
| XE25320J2-200-05.0S | 10138112 | 2 | J | E25 | 24,1 | 32,0 | 45,1 | 200,0 | 5,0 | ■ |

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

| | Ersatzteile, im Lieferumfang enthalten | | Zubehör | | |
|----------------|--|---------------------|--------------|----------------|--------------------------|
| | CZCMS | Spann- schlüssel | Ersatzklinge | Ersatzklinge 1 | Drehmoment- schlüssel |
| Universell | | | | | |
| Stahl und Guss | E10 | XW-E10 | XTWH-E10.08 | XTWH-E10.06 | XTW-E10.E12 |
| | E12 | XW-E12 | XTWH-E12.10 | XTWH-E12.08 | XTW-E10.E12 |
| | E16 | XW-E16 | XTWH-E16.12 | XTWH-E16.10 | XTW-E16.E25 |
| | E20 | XW-E20 | XTWH-E20.16 | - | XTW-E16.E25 |
| | E25 | XW-E25 | XTWH-E25.20 | - | XTW-E16.E25 |

■ Lagerstandard.

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

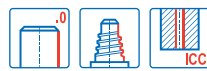
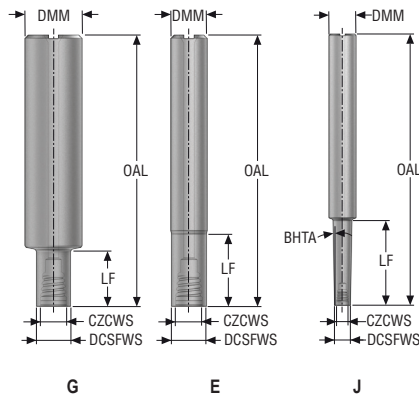
Graphit

X-Heads

Minimaster Plus

Minimaster

Stahl - Zoll



- Toleranzen:
- DMM= h6
- DCSFWS= ±.002 Zoll
- BHTA= ±20'

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | CZCMS | DCSFMS | DMM | LF | OAL | BHTA° | Zylindrisch |
|-----------------------|--------------------|------------------|-------------------|-------|--------|-------|-------|-------|-------|-------------|
| | | | | | Zoll | Zoll | Zoll | Zoll | | |
| XE10.500G1-2.50-00.0S | 10138050 | 1 | G | E10 | 0.360 | 0.500 | 0.250 | 2.500 | 0,0 | ■ |
| XE10.375E2-2.50-00.0S | 10138053 | 2 | E | E10 | 0.360 | 0.375 | 0.402 | 2.500 | 0,0 | ■ |
| XE10.500G2-3.00-00.0S | 10138051 | 2 | G | E10 | 0.360 | 0.500 | 1.000 | 3.000 | 0,0 | ■ |
| XE10.625J3-4.50-01.0S | 10138063 | 3 | J | E10 | 0.360 | 0.625 | 1.402 | 4.500 | 1,0 | ■ |
| XE10.625J5-6.50-01.0S | 10138064 | 5 | J | E10 | 0.360 | 0.625 | 2.000 | 6.500 | 1,0 | ■ |
| XE10.625J4-4.00-03.0S | 10138071 | 4 | J | E10 | 0.360 | 0.625 | 1.799 | 4.000 | 3,0 | ■ |
| XE10.750J9-6.00-03.0S | 10138072 | 9 | J | E10 | 0.360 | 0.750 | 3.720 | 6.000 | 3,0 | ■ |
| XE12.500E1-3.00-00.0S | 10138054 | 1 | E | E12 | 0.480 | 0.500 | 0.250 | 3.000 | 0,0 | ■ |
| XE12.500E2-2.50-00.0S | 10138055 | 2 | E | E12 | 0.480 | 0.500 | 0.500 | 2.500 | 0,0 | ■ |
| XE12.500E2-4.50-00.0S | 10138056 | 2 | E | E12 | 0.480 | 0.500 | 1.000 | 4.500 | 0,0 | ■ |
| XE12.625J3-6.00-01.0S | 10138065 | 3 | J | E12 | 0.480 | 0.625 | 1.650 | 6.000 | 1,0 | ■ |
| XE12.625J4-7.50-01.0S | 10138066 | 4 | J | E12 | 0.480 | 0.625 | 2.400 | 7.500 | 1,0 | ■ |
| XE12.750J5-6.50-01.0S | 10138067 | 5 | J | E12 | 0.480 | 0.750 | 2.850 | 6.500 | 1,0 | ■ |
| XE12.750J4-4.50-03.0S | 10138073 | 4 | J | E12 | 0.480 | 0.750 | 2.201 | 4.500 | 3,0 | ■ |
| XE12.750J5-6.00-03.0S | 10138074 | 5 | J | E12 | 0.480 | 0.750 | 2.575 | 6.000 | 3,0 | ■ |
| XE12.625J2-6.50-05.0S | 10138075 | 2 | J | E12 | 0.480 | 0.625 | 0.827 | 6.500 | 5,0 | ■ |
| XE16.625E1-3.00-00.0S | 10138057 | 1 | E | E16 | 0.606 | 0.625 | 0.250 | 3.000 | 0,0 | ■ |
| XE16.625E2-3.00-00.0S | 10138058 | 2 | E | E16 | 0.606 | 0.625 | 0.650 | 3.000 | 0,0 | ■ |
| XE16.625E2-4.50-00.0S | 10138059 | 2 | E | E16 | 0.606 | 0.625 | 1.000 | 4.500 | 0,0 | ■ |
| XE16.750J3-7.50-01.0S | 10138068 | 3 | J | E16 | 0.606 | 0.750 | 2.252 | 7.500 | 1,0 | ■ |
| XE16.750J4-7.50-01.0S | 10138070 | 4 | J | E16 | 0.606 | 0.750 | 3.000 | 7.500 | 1,0 | ■ |
| XE16.750J6-7.50-01.0S | 10138069 | 6 | J | E16 | 0.606 | 0.750 | 3.748 | 7.500 | 1,0 | ■ |
| XE16.750J2-6.50-05.0S | 10138076 | 2 | J | E16 | 0.606 | 0.750 | 0.821 | 6.500 | 5,0 | ■ |
| XE161.00J3-7.00-05.0S | 10138077 | 3 | J | E16 | 0.606 | 1.000 | 2.250 | 7.000 | 5,0 | ■ |
| XE20.750E1-3.00-00.0S | 10138060 | 1 | E | E20 | 0.724 | 0.750 | 0.250 | 3.000 | 0,0 | ■ |
| XE20.750E2-4.50-00.0S | 10138061 | 2 | E | E20 | 0.724 | 0.750 | 1.000 | 4.500 | 0,0 | ■ |
| XE251.00E1-3.50-00.0S | 10138062 | 1 | E | E25 | 0.961 | 1.000 | 0.250 | 3.500 | 0,0 | ■ |
| XE251.25G2-6.50-00.0S | 10138052 | 2 | G | E25 | 0.961 | 1.250 | 2.500 | 6.500 | 0,0 | ■ |

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

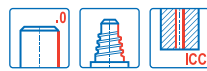
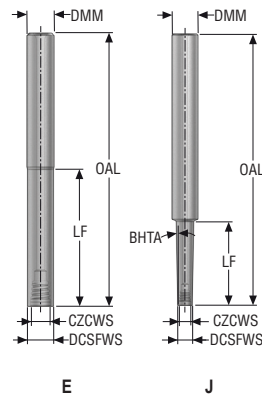
Minimaster

| | Ersatzteile, im Lieferumfang enthalten | | Zubehör | | |
|----------------|--|---------------------|--------------|----------------|--------------------------|
| | CZCMS | Spann- schlüssel | Ersatzklinge | Ersatzklinge 1 | Drehmoment- schlüssel |
| Universell | | | | | |
| Stahl und Guss | E10 | XW-E10 | XTWH-E10.08 | XTWH-E10.06 | XTW-E10.E12 |
| | E12 | XW-E12 | XTWH-E12.10 | XTWH-E12.08 | XTW-E10.E12 |
| | E16 | XW-E16 | XTWH-E16.12 | XTWH-E16.10 | XTW-E16.E25 |
| | E20 | XW-E20 | XTWH-E20.16 | - | XTW-E16.E25 |
| | E25 | XW-E25 | XTWH-E25.20 | - | XTW-E16.E25 |

■ Lagerstandard.

- Rostfrei und ISO-S-Werkstoffe
- NE-Metalle
- Harter
- Kunststoffe und Composite
- Graphit
- X-Heads**
- Minimaster Plus
- Minimaster

Vollhartmetall - Metrisch



- Toleranzen:
- DMM= h6
- DCSFWS= ±0,05 mm
- BHTA= ±20'

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | CZCMS | DCSFWS | DMM | LF | OAL | BHTA° | Zylindrisch |
|---------------------|--------------------|------------------|-------------------|-------|--------|------|-------|-------|-------|-------------|
| | | | | | mm | mm | mm | mm | | |
| XE10100E5-100-00.0E | 10138120 | 5 | E | E10 | 9,6 | 10,0 | 50,0 | 100,0 | 0,0 | ■ |
| XE10160J9-155-01.0E | 10138126 | 9 | J | E10 | 9,6 | 16,0 | 100,0 | 155,0 | 1,0 | ■ |
| XE12120E4-100-00.0E | 10138121 | 4 | E | E12 | 11,6 | 12,0 | 48,0 | 100,0 | 0,0 | ■ |
| XE12160J7-150-01.0E | 10138127 | 7 | J | E12 | 11,6 | 16,0 | 90,0 | 150,0 | 1,0 | ■ |
| XE16160E5-135-00.0E | 10138122 | 5 | E | E16 | 15,4 | 16,0 | 80,0 | 135,0 | 0,0 | ■ |
| XE16200J7-175-01.0E | 10138128 | 7 | J | E16 | 15,4 | 20,0 | 118,0 | 175,0 | 1,0 | ■ |
| XE20200E2-095-00.0E | 10138123 | 2 | E | E20 | 19,2 | 20,0 | 38,0 | 95,0 | 0,0 | ■ |
| XE20200E5-180-00.0E | 10138124 | 5 | E | E20 | 19,2 | 20,0 | 110,0 | 180,0 | 0,0 | ■ |
| XE20250J4-200-02.0E | 10138129 | 4 | J | E20 | 19,2 | 25,0 | 83,0 | 200,0 | 2,0 | ■ |
| XE25250E4-200-00.0E | 10138125 | 4 | E | E25 | 24,1 | 25,0 | 120,0 | 200,0 | 0,0 | ■ |

Ersatzteile, im Lieferumfang enthalten

Zubehör

| CZCMS | Spann- schlüssel | Ersatzklinge | Ersatzklinge 1 | Drehmoment- schlüssel |
|-------|---------------------|--------------|----------------|--------------------------|
| E10 | XW-E10 | XTWH-E10.08 | XTWH-E10.06 | XTW-E10.E12 |
| E12 | XW-E12 | XTWH-E12.10 | XTWH-E12.08 | XTW-E10.E12 |
| E16 | XW-E16 | XTWH-E16.12 | XTWH-E16.10 | XTW-E16.E25 |
| E20 | XW-E20 | XTWH-E20.16 | - | XTW-E16.E25 |
| E25 | XW-E25 | XTWH-E25.20 | - | XTW-E16.E25 |

■ Lagerstandard.

Unversell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

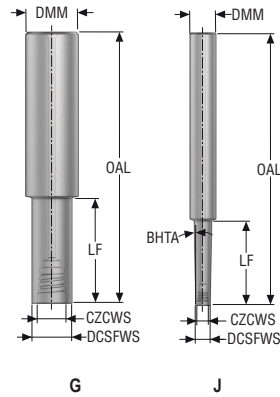
Graphit

X-Heads

Minimaster Plus

Minimaster

Vollhartmetall - Zoll



- Toleranzen:
- DMM= h6
- DCSFWS= ±.002 Zoll
- BHTA= ±20°

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | CZCMS | DCSFMS | DMM | LF | OAL | BHTA° | Zylindrisch |
|-----------------------|--------------------|------------------|-------------------|-------|--------|-------|-------|-------|-------|-------------|
| | | | | | | | | | | |
| XE10.625J5-6.50-01.0E | 10138079 | 5 | J | E10 | 0.360 | 0.625 | 2.000 | 6.500 | 1,0 | ■ |
| XE12.625J4-7.50-01.0E | 10138080 | 4 | J | E12 | 0.480 | 0.625 | 2.400 | 7.500 | 1,0 | ■ |
| XE16.750J4-7.50-01.0E | 10138081 | 4 | J | E16 | 0.606 | 0.750 | 3.000 | 7.500 | 1,0 | ■ |
| XE201.00J4-8.00-01.0E | 10138082 | 4 | J | E20 | 0.724 | 1.000 | 3.150 | 8.000 | 1,0 | ■ |
| XE251.25G2-6.50-00.0E | 10138078 | 2 | G | E25 | 0.961 | 1.250 | 2.500 | 6.500 | 0,0 | ■ |

Ersatzteile, im Lieferumfang enthalten

Zubehör

| CZCMS | Spann- schlüssel | Ersatzklinge | Ersatzklinge 1 | Drehmoment- schlüssel |
|-------|---------------------|--------------|----------------|--------------------------|
| E10 | XW-E10 | XTWH-E10.08 | XTWH-E10.06 | XTW-E10.E12 |
| E12 | XW-E12 | XTWH-E12.10 | XTWH-E12.08 | XTW-E10.E12 |
| E16 | XW-E16 | XTWH-E16.12 | XTWH-E16.10 | XTW-E16.E25 |
| E20 | XW-E20 | XTWH-E20.16 | - | XTW-E16.E25 |
| E25 | XW-E25 | XTWH-E25.20 | - | XTW-E16.E25 |

■ Lagerstandard.

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Kunststoffe und
Composite

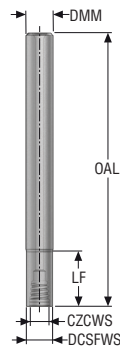
Graphit

X-Heads

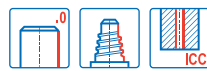
Minimaster Plus

Minimaster

Densimet - Metrisch



E



- Toleranzen:
- DMM= h6
- DCSFWS= ±0,05 mm
- BHTA= ±20'

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | CZCMS | DCSFWS | DMM | LF | OAL | BHTA° | Zylindrisch |
|----------------------|--------------------|------------------|-------------------|-------|--------|------|------|-------|-------|-------------|
| | | | | | mm | mm | mm | mm | | |
| XE10100E2-100-00.0DM | 10138115 | 2 | E | E10 | 9,6 | 10,0 | 20,0 | 100,0 | 0,0 | ■ |
| XE12120E2-110-00.0DM | 10138116 | 2 | E | E12 | 11,6 | 12,0 | 25,0 | 110,0 | 0,0 | ■ |
| XE16160E2-130-00.0DM | 10138117 | 2 | E | E16 | 15,4 | 16,0 | 35,0 | 130,0 | 0,0 | ■ |
| XE20200E2-160-00.0DM | 10138118 | 2 | E | E20 | 19,2 | 20,0 | 45,0 | 160,0 | 0,0 | ■ |
| XE25250E2-185-00.0DM | 10138119 | 2 | E | E25 | 24,1 | 25,0 | 65,0 | 185,0 | 0,0 | ■ |

Ersatzteile, im Lieferumfang enthalten

Zubehör

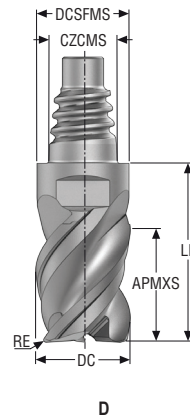
| CZCMS | Spann- schlüssel | Ersatzklinge | Ersatzklinge 1 | Drehmoment- schlüssel |
|-------|---------------------|--------------|----------------|--------------------------|
| | | | | |
| E10 | XW-E10 | XTWH-E10.08 | XTWH-E10.06 | XTW-E10.E12 |
| E12 | XW-E12 | XTWH-E12.10 | XTWH-E12.08 | XTW-E10.E12 |
| E16 | XW-E16 | XTWH-E16.12 | XTWH-E16.10 | XTW-E16.E25 |
| E20 | XW-E20 | XTWH-E20.16 | - | XTW-E16.E25 |
| E25 | XW-E25 | XTWH-E25.20 | - | XTW-E16.E25 |

■ Lagerstandard.

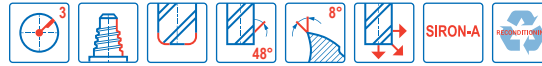
Unversell
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Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

XSE550

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Eckenradius



- Toleranzen:
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø12 ist mm

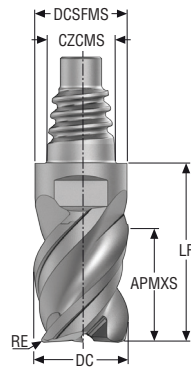


| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | CZCMS | DC | DCSFMS | APMXS | LF | RE | PCEDC | SW | Beschichtung |
|----------------------|----------------|--------------|---------------|-------|------|--------|-------|------|-----|-------|----|--------------|
| | | | | | mm | mm | mm | mm | mm | | | SIRA |
| XSE550E10100D1R050Z3 | 10138138 | 1 | D | E10 | 10,0 | 9,7 | 5,5 | 12,3 | 0,5 | 3 | 8 | ■ |
| XSE550E12120D1R050Z3 | 10138139 | 1 | D | E12 | 12,0 | 11,7 | 6,6 | 14,4 | 0,5 | 3 | 10 | ■ |
| XSE550E16160D1R050Z3 | 10138140 | 1 | D | E16 | 16,0 | 15,5 | 8,8 | 18,6 | 0,5 | 3 | 12 | ■ |
| XSE550E20200D1R050Z3 | 10138141 | 1 | D | E20 | 20,0 | 19,3 | 11,0 | 21,2 | 0,5 | 3 | 16 | ■ |
| XSE550E10100D2R050Z3 | 10138142 | 2 | D | E10 | 10,0 | 9,7 | 12,0 | 18,7 | 0,5 | 3 | 8 | ■ |
| XSE550E12120D2R050Z3 | 10138143 | 2 | D | E12 | 12,0 | 11,7 | 14,4 | 22,1 | 0,5 | 3 | 10 | ■ |
| XSE550E16160D2R050Z3 | 10138144 | 2 | D | E16 | 16,0 | 15,5 | 19,2 | 29,2 | 0,5 | 3 | 12 | ■ |
| XSE550E20200D2R050Z3 | 10138145 | 2 | D | E20 | 20,0 | 19,3 | 24,0 | 34,3 | 0,5 | 3 | 16 | ■ |

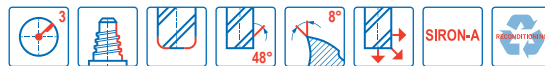
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Graphit
X-Heads
Minimaster Plus
Minimaster

XSE550 – Zoll

Hochleistungsfräser – Universell – Eckfräser – 3 Schneiden – Eckenradius – Zoll



D



- Toleranzen:
- DC= e7
- RE= ±.0008 Zoll
- Nachschleifen möglich, wenn DC ≥ Ø.500 ist Zoll

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | CZCMS | DC | DCSFMS | APMXS | LF | RE | PCEDC | SW | Beschichtung |
|-----------------------|----------------|--------------|---------------|-------|-------|--------|-------|-------|-------|-------|----|--------------|
| | | | | | Zoll | Zoll | Zoll | Zoll | Zoll | | | SIRA |
| XSE550E10.375D1R030Z3 | 10138146 | 1 | D | E10 | 0.375 | 0.364 | 0.206 | 0.484 | 0.030 | 3 | 8 | ■ |
| XSE550E12.500D1R030Z3 | 10138147 | 1 | D | E12 | 0.500 | 0.484 | 0.275 | 0.567 | 0.030 | 3 | 10 | ■ |
| XSE550E20.750D1R030Z3 | 10138148 | 1 | D | E20 | 0.750 | 0.728 | 0.413 | 0.835 | 0.030 | 3 | 16 | ■ |
| XSE550E10.375D2R030Z3 | 10138149 | 2 | D | E10 | 0.375 | 0.364 | 0.450 | 0.720 | 0.030 | 3 | 8 | ■ |
| XSE550E12.500D2R030Z3 | 10138150 | 2 | D | E12 | 0.500 | 0.484 | 0.600 | 0.906 | 0.030 | 3 | 10 | ■ |
| XSE550E20.750D2R030Z3 | 10138151 | 2 | D | E20 | 0.750 | 0.728 | 0.900 | 1.295 | 0.030 | 3 | 16 | ■ |

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Graphit

X-Heads


Minimaster Plus

Minimaster

Schnittdaten – XSE550 – Eckfräsen PCEDC 3

| SMG | | a _d /DC | a _p /DC | f _z | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|--------|--------|--------|--------------------|
| | | | | 10 | 12 | 16 | 20 | |
| P1 | E/M/A/D | 0,40 | 1,1 | 0,095 | 0,12 | 0,14 | 0,16 | 185 (140 – 220) |
| | | 0,40 | 1,1 | 0,0038 | 0,0048 | 0,0055 | 0,0065 | 610 (460 – 720) |
| P2 | E/M/A/D | 0,40 | 1,1 | 0,10 | 0,12 | 0,15 | 0,17 | 175 (140 – 210) |
| | | 0,40 | 1,1 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 570 (460 – 680) |
| P3 | E/M/A/D | 0,40 | 1,1 | 0,095 | 0,11 | 0,14 | 0,16 | 155 (120 – 190) |
| | | 0,40 | 1,1 | 0,0038 | 0,0044 | 0,0055 | 0,0065 | 510 (400 – 620) |
| P4 | E/M/A/D | 0,40 | 1,1 | 0,090 | 0,11 | 0,14 | 0,16 | 135 (110 – 170) |
| | | 0,40 | 1,1 | 0,0036 | 0,0044 | 0,0055 | 0,0065 | 445 (370 – 550) |
| P5 | E/M/A/D | 0,40 | 1,1 | 0,090 | 0,11 | 0,13 | 0,15 | 130 (98 – 160) |
| | | 0,40 | 1,1 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 425 (330 – 520) |
| P6 | E/M/A/D | 0,40 | 1,1 | 0,090 | 0,11 | 0,13 | 0,15 | 145 (110 – 180) |
| | | 0,40 | 1,1 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 475 (370 – 590) |
| P7 | E/M/A/D | 0,40 | 1,1 | 0,090 | 0,11 | 0,13 | 0,15 | 140 (110 – 170) |
| | | 0,40 | 1,1 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 460 (370 – 550) |
| P8 | E/M/A/D | 0,40 | 1,1 | 0,095 | 0,11 | 0,14 | 0,16 | 130 (97 – 160) |
| | | 0,40 | 1,1 | 0,0038 | 0,0044 | 0,0055 | 0,0065 | 425 (320 – 520) |
| P11 | E/M/A/D | 0,30 | 1,1 | 0,065 | 0,075 | 0,095 | 0,11 | 95 (80 – 100) |
| | | 0,30 | 1,1 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 310 (270 – 320) |
| P12 | E/M/A/D | 0,30 | 1,1 | 0,044 | 0,055 | 0,065 | 0,075 | 60 (51 – 67) |
| | | 0,30 | 1,1 | 0,0017 | 0,0022 | 0,0026 | 0,0030 | 195 (170 – 210) |
| M1 | E/M/A | 0,30 | 1,1 | 0,070 | 0,085 | 0,11 | 0,12 | 105 (92 – 120) |
| | | 0,30 | 1,1 | 0,0028 | 0,0034 | 0,0044 | 0,0048 | 345 (310 – 390) |
| M2 | E/M/A | 0,30 | 1,1 | 0,065 | 0,075 | 0,095 | 0,11 | 90 (76 – 100) |
| | | 0,30 | 1,1 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 295 (250 – 320) |
| M3 | E/M/A | 0,30 | 0,95 | 0,055 | 0,065 | 0,080 | 0,090 | 55 (44 – 68) |
| | | 0,30 | 0,95 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 180 (150 – 220) |
| M4 | E/M/A | 0,30 | 0,95 | 0,048 | 0,055 | 0,070 | 0,080 | 43 (34 – 52) |
| | | 0,30 | 0,95 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 140 (120 – 170) |
| M5 | E/M/A | 0,30 | 0,95 | 0,048 | 0,055 | 0,070 | 0,080 | 36 (28 – 43) |
| | | 0,30 | 0,95 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 120 (92 – 140) |
| K1 | E/M/A/D | 0,40 | 1,1 | 0,090 | 0,11 | 0,14 | 0,16 | 160 (140 – 180) |
| | | 0,40 | 1,1 | 0,0036 | 0,0044 | 0,0055 | 0,0065 | 520 (460 – 590) |
| K2 | E/M/A/D | 0,40 | 1,1 | 0,085 | 0,10 | 0,12 | 0,14 | 140 (130 – 160) |
| | | 0,40 | 1,1 | 0,0034 | 0,0040 | 0,0048 | 0,0055 | 460 (430 – 520) |
| K3 | E/M/A/D | 0,40 | 1,1 | 0,085 | 0,10 | 0,12 | 0,14 | 120 (110 – 130) |
| | | 0,40 | 1,1 | 0,0034 | 0,0040 | 0,0048 | 0,0055 | 395 (370 – 420) |
| K4 | E/M/A/D | 0,40 | 1,1 | 0,085 | 0,10 | 0,12 | 0,14 | 115 (97 – 120) |
| | | 0,40 | 1,1 | 0,0034 | 0,0040 | 0,0048 | 0,0055 | 375 (320 – 390) |
| K5 | E/M/A/D | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 140 (120 – 150) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 460 (400 – 490) |
| K6 | E/M/A/D | 0,40 | 0,95 | 0,090 | 0,11 | 0,13 | 0,15 | 200 (170 – 220) |
| | | 0,40 | 0,95 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 660 (560 – 720) |
| K7 | E/M/A/D | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 180 (150 – 200) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 590 (500 – 650) |
| N1 | E/M/A | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 600 (560 – 780) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 1975 (1900 – 2500) |
| N2 | E/M/A | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 390 (360 – 500) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 1275 (1200 – 1600) |
| N3 | E/M/A | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 260 (240 – 330) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 850 (790 – 1000) |
| N11 | E/M/A | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 335 (280 – 380) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 1100 (920 – 1200) |
| S1 | E | 0,15 | 0,95 | 0,090 | 0,11 | 0,13 | 0,15 | 32 (26 – 40) |
| | | 0,15 | 0,95 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 105 (86 – 130) |
| S2 | E | 0,15 | 0,95 | 0,090 | 0,11 | 0,13 | 0,15 | 28 (21 – 34) |
| | | 0,15 | 0,95 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 90 (69 – 110) |
| S3 | E | 0,15 | 0,95 | 0,085 | 0,10 | 0,12 | 0,14 | 24 (19 – 30) |
| | | 0,15 | 0,95 | 0,0034 | 0,0040 | 0,0048 | 0,0055 | 80 (63 – 98) |
| S11 | E | 0,40 | 0,95 | 0,060 | 0,070 | 0,090 | 0,10 | 105 (77 – 130) |
| | | 0,40 | 0,95 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 345 (260 – 420) |
| S12 | E | 0,40 | 0,95 | 0,060 | 0,070 | 0,090 | 0,10 | 80 (59 – 100) |
| | | 0,40 | 0,95 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 260 (200 – 320) |
| S13 | E | 0,40 | 0,95 | 0,055 | 0,065 | 0,080 | 0,090 | 65 (47 – 83) |
| | | 0,40 | 0,95 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 215 (160 – 270) |
| H5 | M/A | 0,050 | 0,95 | 0,090 | 0,11 | 0,14 | 0,16 | 75 (62 – 92) |
| | | 0,050 | 0,95 | 0,0036 | 0,0044 | 0,0055 | 0,0065 | 245 (210 – 300) |
| H8 | M/A | 0,050 | 0,95 | 0,070 | 0,085 | 0,10 | 0,12 | 80 (64 – 95) |
| | | 0,050 | 0,95 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 260 (210 – 310) |
| H21 | M/A | 0,050 | 0,95 | 0,070 | 0,085 | 0,10 | 0,12 | 80 (64 – 95) |
| | | 0,050 | 0,95 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 260 (210 – 310) |
| H31 | M/A | 0,050 | 0,95 | 0,060 | 0,070 | 0,090 | 0,10 | 60 (50 – 74) |
| | | 0,050 | 0,95 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 195 (170 – 240) |
| TS1 | A/D | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 280 (170 – 390) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 920 (560 – 1200) |
| TP1 | A/D | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 280 (170 – 390) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 920 (560 – 1200) |
| GR1 | A/D | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 550 (450 – 660) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 1800 (1500 – 2100) |

Schnittdaten – XSE550 – Nutfräsen PCEDC 3


| SMG |  | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------------------|
| | | | 10 | 12 | 16 | 20 | |
| P1 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 165 (130 – 200) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 540 (430 – 650) |
| P2 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 160 (120 – 190) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 520 (400 – 620) |
| P3 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 135 (110 – 170) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 445 (370 – 550) |
| P4 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 120 (90 – 140) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 395 (300 – 450) |
| P5 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 115 (86 – 140) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 375 (290 – 450) |
| P6 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 130 (97 – 160) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 425 (320 – 520) |
| P7 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 120 (92 – 150) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 395 (310 – 490) |
| P8 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 115 (86 – 140) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 375 (290 – 450) |
| P11 | E/M/A/D | 0,80 | 0,050 | 0,060 | 0,080 | 0,10 | 75 (64 – 84) |
| | | 0,80 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 245 (210 – 270) |
| P12 | E/M/A/D | 0,65 | 0,040 | 0,048 | 0,060 | 0,070 | 46 (40 – 52) |
| | | 0,65 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 150 (140 – 170) |
| M1 | E/M/A | 0,80 | 0,050 | 0,060 | 0,080 | 0,10 | 85 (75 – 99) |
| | | 0,80 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 280 (250 – 320) |
| M2 | E/M/A | 0,80 | 0,050 | 0,060 | 0,080 | 0,10 | 70 (60 – 79) |
| | | 0,80 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 230 (200 – 250) |
| M3 | E/M/A | 0,70 | 0,040 | 0,048 | 0,065 | 0,080 | 45 (35 – 54) |
| | | 0,70 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 150 (120 – 170) |
| M4 | E/M/A | 0,50 | 0,040 | 0,048 | 0,065 | 0,075 | 34 (27 – 41) |
| | | 0,50 | 0,0016 | 0,0019 | 0,0026 | 0,0030 | 110 (89 – 130) |
| M5 | E/M/A | 0,50 | 0,040 | 0,048 | 0,065 | 0,075 | 29 (23 – 34) |
| | | 0,50 | 0,0016 | 0,0019 | 0,0026 | 0,0030 | 95 (76 – 110) |
| K1 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 140 (120 – 160) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 460 (400 – 520) |
| K2 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 120 (110 – 130) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 395 (370 – 420) |
| K3 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 105 (88 – 110) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 345 (290 – 360) |
| K4 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 100 (84 – 110) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 330 (280 – 360) |
| K5 | E/M/A/D | 0,80 | 0,050 | 0,060 | 0,080 | 0,10 | 125 (100 – 130) |
| | | 0,80 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 410 (330 – 420) |
| K6 | E/M/A/D | 0,80 | 0,050 | 0,060 | 0,080 | 0,10 | 185 (150 – 200) |
| | | 0,80 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 610 (500 – 650) |
| K7 | E/M/A/D | 0,80 | 0,050 | 0,060 | 0,080 | 0,10 | 160 (130 – 170) |
| | | 0,80 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 520 (430 – 550) |
| N1 | E/M/A | 0,70 | 0,050 | 0,060 | 0,080 | 0,10 | 540 (500 – 690) |
| | | 0,70 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 1775 (1700 – 2200) |
| N2 | E/M/A | 0,70 | 0,050 | 0,060 | 0,080 | 0,10 | 345 (330 – 440) |
| | | 0,70 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 1125 (1100 – 1400) |
| N3 | E/M/A | 0,70 | 0,050 | 0,060 | 0,080 | 0,10 | 230 (220 – 290) |
| | | 0,70 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 750 (730 – 950) |
| N11 | E/M/A | 0,60 | 0,050 | 0,060 | 0,080 | 0,10 | 300 (250 – 340) |
| | | 0,60 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 980 (830 – 1100) |
| S1 | E | 0,30 | 0,030 | 0,036 | 0,048 | 0,060 | 27 (21 – 33) |
| | | 0,30 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 90 (69 – 100) |
| S2 | E | 0,30 | 0,030 | 0,036 | 0,048 | 0,060 | 23 (17 – 28) |
| | | 0,30 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 75 (56 – 91) |
| S3 | E | 0,30 | 0,030 | 0,036 | 0,048 | 0,060 | 20 (15 – 25) |
| | | 0,30 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 65 (50 – 82) |
| S11 | E | 0,50 | 0,050 | 0,060 | 0,080 | 0,10 | 90 (66 – 110) |
| | | 0,50 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 295 (220 – 360) |
| S12 | E | 0,50 | 0,050 | 0,060 | 0,080 | 0,10 | 70 (50 – 89) |
| | | 0,50 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 230 (170 – 290) |
| S13 | E | 0,42 | 0,050 | 0,060 | 0,075 | 0,090 | 55 (39 – 70) |
| | | 0,42 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 180 (130 – 220) |
| H5 | M/A | 0,30 | 0,030 | 0,036 | 0,048 | 0,060 | 50 (41 – 60) |
| | | 0,30 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 165 (140 – 190) |
| H8 | M/A | 0,26 | 0,030 | 0,036 | 0,046 | 0,050 | 50 (41 – 61) |
| | | 0,26 | 0,0012 | 0,0014 | 0,0018 | 0,0020 | 165 (140 – 200) |
| H21 | M/A | 0,26 | 0,030 | 0,036 | 0,046 | 0,050 | 50 (41 – 61) |
| | | 0,26 | 0,0012 | 0,0014 | 0,0018 | 0,0020 | 165 (140 – 200) |
| H31 | M/A | 0,26 | 0,026 | 0,032 | 0,040 | 0,046 | 40 (32 – 47) |
| | | 0,26 | 0,0010 | 0,0013 | 0,0016 | 0,0018 | 130 (110 – 150) |
| TS1 | A/D | 0,70 | 0,050 | 0,060 | 0,080 | 0,10 | 250 (150 – 340) |
| | | 0,70 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 820 (500 – 1100) |
| TP1 | A/D | 0,70 | 0,050 | 0,060 | 0,080 | 0,10 | 250 (150 – 340) |
| | | 0,70 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 820 (500 – 1100) |
| GR1 | A/D | 0,70 | 0,050 | 0,060 | 0,080 | 0,10 | 490 (410 – 600) |
| | | 0,70 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 1600 (1400 – 1900) |

Unversell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

Schnittdaten – XSE550 – Eckfräsen PCEDC 3 – Zoll

| SMG | | a _d /DC | a _p /DC | f _z | | | | v _c |
|---------------------------|---------|--------------------|--------------------|-----------------|-----------------|-----------------|-----------------|---------------------------------------|
| | | | | 3/8 | 1/2 | 5/8 | 3/4 | |
| Univerrsell | | | | | | | | |
| P1 | E/M/A/D | 0,40 0,40 | 1,1 1,1 | 0,095 0,0038 | 0,12 0,0048 | 0,14 0,0055 | 0,16 0,0065 | 215 (190 – 240) 710 (630 – 780) |
| P2 | E/M/A/D | 0,40 0,40 | 1,1 1,1 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 0,17 0,0065 | 205 (180 – 230) 670 (600 – 750) |
| P3 | E/M/A/D | 0,40 0,40 | 1,1 1,1 | 0,095 0,0038 | 0,11 0,0044 | 0,14 0,0055 | 0,16 0,0065 | 180 (160 – 200) 590 (530 – 650) |
| P4 | E/M/A/D | 0,40 0,40 | 1,1 1,1 | 0,090 0,0036 | 0,11 0,0044 | 0,14 0,0055 | 0,16 0,0065 | 160 (140 – 180) 520 (460 – 590) |
| P5 | E/M/A/D | 0,40 0,40 | 1,1 1,1 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,15 0,0060 | 150 (140 – 170) 490 (460 – 550) |
| P6 | E/M/A/D | 0,40 0,40 | 1,1 1,1 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,15 0,0060 | 170 (150 – 190) 560 (500 – 620) |
| P7 | E/M/A/D | 0,40 0,40 | 1,1 1,1 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,15 0,0060 | 160 (140 – 180) 520 (460 – 590) |
| P8 | E/M/A/D | 0,40 0,40 | 1,1 1,1 | 0,095 0,0038 | 0,11 0,0044 | 0,14 0,0055 | 0,16 0,0065 | 150 (130 – 170) 490 (430 – 550) |
| P11 | E/M/A/D | 0,30 0,30 | 1,1 1,1 | 0,065 0,0026 | 0,075 0,0030 | 0,095 0,0038 | 0,11 0,0044 | 105 (93 – 110) 345 (310 – 360) |
| P12 | E/M/A/D | 0,30 0,30 | 1,1 1,1 | 0,044 0,0017 | 0,055 0,0022 | 0,065 0,0026 | 0,075 0,0030 | 65 (60 – 75) 215 (200 – 240) |
| NE-Metalle | | | | | | | | |
| M1 | E/M/A | 0,30 0,30 | 1,1 1,1 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 0,12 0,0048 | 120 (110 – 130) 395 (370 – 420) |
| M2 | E/M/A | 0,30 0,30 | 1,1 1,1 | 0,065 0,0026 | 0,075 0,0030 | 0,095 0,0038 | 0,11 0,0044 | 100 (88 – 110) 330 (290 – 360) |
| M3 | E/M/A | 0,30 0,30 | 0,95 0,95 | 0,055 0,0022 | 0,065 0,0026 | 0,080 0,0032 | 0,090 0,0036 | 60 (50 – 74) 195 (170 – 240) |
| M4 | E/M/A | 0,30 0,30 | 0,95 0,95 | 0,048 0,0019 | 0,055 0,0022 | 0,070 0,0028 | 0,080 0,0032 | 48 (39 – 57) 155 (130 – 180) |
| M5 | E/M/A | 0,30 0,30 | 0,95 0,95 | 0,048 0,0019 | 0,055 0,0022 | 0,070 0,0028 | 0,080 0,0032 | 40 (32 – 47) 130 (110 – 150) |
| Harter | | | | | | | | |
| K1 | E/M/A/D | 0,40 0,40 | 1,1 1,1 | 0,090 0,0036 | 0,11 0,0044 | 0,14 0,0055 | 0,16 0,0065 | 170 (160 – 200) 560 (530 – 650) |
| K2 | E/M/A/D | 0,40 0,40 | 1,1 1,1 | 0,085 0,0034 | 0,10 0,0040 | 0,12 0,0048 | 0,14 0,0055 | 150 (150 – 180) 490 (500 – 590) |
| K3 | E/M/A/D | 0,40 0,40 | 1,1 1,1 | 0,085 0,0034 | 0,10 0,0040 | 0,12 0,0048 | 0,14 0,0055 | 125 (120 – 150) 410 (400 – 490) |
| K4 | E/M/A/D | 0,40 0,40 | 1,1 1,1 | 0,085 0,0034 | 0,10 0,0040 | 0,12 0,0048 | 0,14 0,0055 | 120 (120 – 140) 395 (400 – 450) |
| K5 | E/M/A/D | 0,40 0,40 | 0,95 0,95 | 0,080 0,0032 | 0,095 0,0038 | 0,12 0,0048 | 0,14 0,0055 | 155 (140 – 170) 510 (460 – 550) |
| K6 | E/M/A/D | 0,40 0,40 | 0,95 0,95 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,15 0,0060 | 225 (200 – 250) 740 (660 – 820) |
| K7 | E/M/A/D | 0,40 0,40 | 0,95 0,95 | 0,080 0,0032 | 0,095 0,0038 | 0,12 0,0048 | 0,14 0,0055 | 200 (180 – 220) 660 (600 – 720) |
| Kunststoffe und Composite | | | | | | | | |
| N1 | E/M/A | 0,40 0,40 | 0,95 0,95 | 0,080 0,0032 | 0,095 0,0038 | 0,12 0,0048 | 0,14 0,0055 | 670 (560 – 780) 2200 (1900 – 2500) |
| N2 | E/M/A | 0,40 0,40 | 0,95 0,95 | 0,080 0,0032 | 0,095 0,0038 | 0,12 0,0048 | 0,14 0,0055 | 430 (360 – 500) 1400 (1200 – 1600) |
| N3 | E/M/A | 0,40 0,40 | 0,95 0,95 | 0,080 0,0032 | 0,095 0,0038 | 0,12 0,0048 | 0,14 0,0055 | 285 (240 – 330) 940 (790 – 1000) |
| N11 | E/M/A | 0,40 0,40 | 0,95 0,95 | 0,080 0,0032 | 0,095 0,0038 | 0,12 0,0048 | 0,14 0,0055 | 335 (280 – 380) 1100 (920 – 1200) |
| X-Heads | | | | | | | | |
| S1 | E | 0,15 0,15 | 0,95 0,95 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,15 0,0060 | 43 (26 – 60) 140 (86 – 190) |
| S2 | E | 0,15 0,15 | 0,95 0,95 | 0,090 0,0036 | 0,11 0,0044 | 0,13 0,0050 | 0,15 0,0060 | 35 (21 – 48) 115 (69 – 150) |
| S3 | E | 0,15 0,15 | 0,95 0,95 | 0,085 0,0034 | 0,10 0,0040 | 0,12 0,0048 | 0,14 0,0055 | 30 (19 – 42) 100 (63 – 130) |
| S11 | E | 0,40 0,40 | 0,95 0,95 | 0,060 0,0024 | 0,070 0,0028 | 0,090 0,0036 | 0,10 0,0040 | 105 (77 – 130) 345 (260 – 420) |
| S12 | E | 0,40 0,40 | 0,95 0,95 | 0,060 0,0024 | 0,070 0,0028 | 0,090 0,0036 | 0,10 0,0040 | 80 (59 – 100) 260 (200 – 320) |
| S13 | E | 0,40 0,40 | 0,95 0,95 | 0,055 0,0022 | 0,065 0,0026 | 0,080 0,0032 | 0,090 0,0036 | 65 (47 – 83) 215 (160 – 270) |
| Minimaster Plus | | | | | | | | |
| H5 | M/A | 0,050 0,050 | 0,95 0,95 | 0,090 0,0036 | 0,11 0,0044 | 0,14 0,0055 | 0,16 0,0065 | 75 (62 – 92) 245 (210 – 300) |
| H8 | M/A | 0,050 0,050 | 0,95 0,95 | 0,070 0,0028 | 0,085 0,0034 | 0,10 0,0040 | 0,12 0,0048 | 80 (64 – 95) 260 (210 – 310) |
| Minimaster | | | | | | | | |
| H21 | M/A | 0,050 0,050 | 0,95 0,95 | 0,070 0,0028 | 0,085 0,0034 | 0,10 0,0040 | 0,12 0,0048 | 80 (64 – 95) 260 (210 – 310) |
| H31 | M/A | 0,050 0,050 | 0,95 0,95 | 0,060 0,0024 | 0,070 0,0028 | 0,090 0,0036 | 0,10 0,0040 | 60 (50 – 74) 195 (170 – 240) |
| TS1 | A/D | 0,40 0,40 | 0,95 0,95 | 0,080 0,0032 | 0,095 0,0038 | 0,12 0,0048 | 0,14 0,0055 | 280 (170 – 390) 920 (560 – 1200) |
| TP1 | A/D | 0,40 0,40 | 0,95 0,95 | 0,080 0,0032 | 0,095 0,0038 | 0,12 0,0048 | 0,14 0,0055 | 280 (170 – 390) 920 (560 – 1200) |
| GR1 | A/D | 0,40 0,40 | 0,95 0,95 | 0,080 0,0032 | 0,095 0,0038 | 0,12 0,0048 | 0,14 0,0055 | 670 (560 – 780) 2200 (1900 – 2500) |

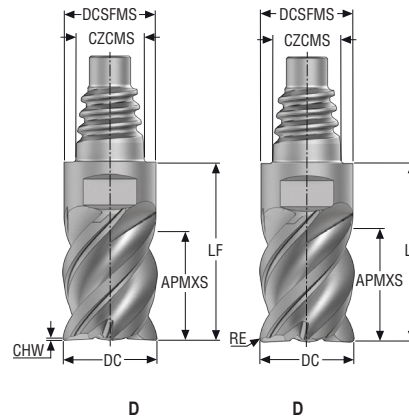
Schnittdaten – XSE550 – Nutfräsen PCEDC 3 – Zoll

| SMG |  | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------------------|
| | | | 3/8 | 1/2 | 5/8 | 3/4 | |
| P1 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 190 (170 – 210) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 620 (560 – 680) |
| P2 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 185 (160 – 210) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 610 (530 – 680) |
| P3 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 160 (140 – 180) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 520 (460 – 590) |
| P4 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 140 (120 – 150) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 460 (400 – 490) |
| P5 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 135 (120 – 150) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 445 (400 – 490) |
| P6 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 150 (130 – 170) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 490 (430 – 550) |
| P7 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 140 (130 – 160) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 460 (430 – 520) |
| P8 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 135 (120 – 150) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 445 (400 – 490) |
| P11 | E/M/A/D | 0,80 | 0,050 | 0,060 | 0,080 | 0,10 | 85 (74 – 94) |
| | | 0,80 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 280 (250 – 300) |
| P12 | E/M/A/D | 0,80 | 0,040 | 0,048 | 0,060 | 0,070 | 50 (46 – 58) |
| | | 0,80 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 165 (160 – 190) |
| M1 | E/M/A | 0,80 | 0,050 | 0,060 | 0,080 | 0,10 | 100 (87 – 110) |
| | | 0,80 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 330 (290 – 360) |
| M2 | E/M/A | 0,80 | 0,050 | 0,060 | 0,080 | 0,10 | 80 (70 – 89) |
| | | 0,80 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 260 (230 – 290) |
| M3 | E/M/A | 0,70 | 0,040 | 0,048 | 0,065 | 0,080 | 50 (41 – 60) |
| | | 0,70 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 165 (140 – 190) |
| M4 | E/M/A | 0,70 | 0,040 | 0,048 | 0,065 | 0,075 | 37 (30 – 45) |
| | | 0,70 | 0,0016 | 0,0019 | 0,0026 | 0,0030 | 120 (99 – 140) |
| M5 | E/M/A | 0,70 | 0,040 | 0,048 | 0,065 | 0,075 | 31 (25 – 37) |
| | | 0,70 | 0,0016 | 0,0019 | 0,0026 | 0,0030 | 100 (83 – 120) |
| K1 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 150 (140 – 180) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 490 (460 – 590) |
| K2 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 130 (130 – 150) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 425 (430 – 490) |
| K3 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 110 (110 – 130) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 360 (370 – 420) |
| K4 | E/M/A/D | 1,0 | 0,060 | 0,070 | 0,095 | 0,12 | 105 (99 – 120) |
| | | 1,0 | 0,0024 | 0,0028 | 0,0038 | 0,0048 | 345 (330 – 390) |
| K5 | E/M/A/D | 0,80 | 0,050 | 0,060 | 0,080 | 0,10 | 140 (120 – 150) |
| | | 0,80 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 460 (400 – 490) |
| K6 | E/M/A/D | 0,80 | 0,050 | 0,060 | 0,080 | 0,10 | 205 (180 – 230) |
| | | 0,80 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 670 (600 – 750) |
| K7 | E/M/A/D | 0,80 | 0,050 | 0,060 | 0,080 | 0,10 | 180 (160 – 200) |
| | | 0,80 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 590 (530 – 650) |
| N1 | E/M/A | 0,70 | 0,050 | 0,060 | 0,080 | 0,10 | 600 (510 – 690) |
| | | 0,70 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 1975 (1700 – 2200) |
| N2 | E/M/A | 0,70 | 0,050 | 0,060 | 0,080 | 0,10 | 385 (330 – 440) |
| | | 0,70 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 1275 (1100 – 1400) |
| N3 | E/M/A | 0,70 | 0,050 | 0,060 | 0,080 | 0,10 | 255 (220 – 290) |
| | | 0,70 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 840 (730 – 950) |
| N11 | E/M/A | 0,60 | 0,050 | 0,060 | 0,080 | 0,10 | 300 (250 – 340) |
| | | 0,60 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 980 (830 – 1100) |
| S1 | E | 0,30 | 0,030 | 0,036 | 0,048 | 0,060 | 36 (22 – 50) |
| | | 0,30 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 120 (73 – 160) |
| S2 | E | 0,30 | 0,030 | 0,036 | 0,048 | 0,060 | 29 (18 – 40) |
| | | 0,30 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 95 (60 – 130) |
| S3 | E | 0,30 | 0,030 | 0,036 | 0,048 | 0,060 | 25 (15 – 34) |
| | | 0,30 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 80 (50 – 110) |
| S11 | E | 0,50 | 0,050 | 0,060 | 0,080 | 0,10 | 90 (66 – 110) |
| | | 0,50 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 295 (220 – 360) |
| S12 | E | 0,50 | 0,050 | 0,060 | 0,080 | 0,10 | 70 (50 – 89) |
| | | 0,50 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 230 (170 – 290) |
| S13 | E | 0,50 | 0,050 | 0,060 | 0,075 | 0,090 | 55 (39 – 69) |
| | | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 180 (130 – 220) |
| H5 | M/A | 0,30 | 0,030 | 0,036 | 0,048 | 0,060 | 50 (41 – 60) |
| | | 0,30 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 165 (140 – 190) |
| H8 | M/A | 0,30 | 0,030 | 0,036 | 0,044 | 0,050 | 50 (41 – 60) |
| | | 0,30 | 0,0012 | 0,0014 | 0,0017 | 0,0020 | 165 (140 – 190) |
| H21 | M/A | 0,30 | 0,030 | 0,036 | 0,044 | 0,050 | 50 (41 – 60) |
| | | 0,30 | 0,0012 | 0,0014 | 0,0017 | 0,0020 | 165 (140 – 190) |
| H31 | M/A | 0,30 | 0,026 | 0,032 | 0,038 | 0,044 | 39 (32 – 46) |
| | | 0,30 | 0,0010 | 0,0013 | 0,0015 | 0,0017 | 130 (110 – 150) |
| TS1 | A/D | 0,70 | 0,050 | 0,060 | 0,080 | 0,10 | 250 (150 – 340) |
| | | 0,70 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 820 (500 – 1100) |
| TP1 | A/D | 0,70 | 0,050 | 0,060 | 0,080 | 0,10 | 250 (150 – 340) |
| | | 0,70 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 820 (500 – 1100) |
| GR1 | A/D | 0,70 | 0,050 | 0,060 | 0,080 | 0,10 | 600 (510 – 690) |
| | | 0,70 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 1975 (1700 – 2200) |

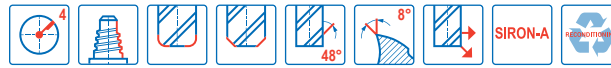
Unversell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

XSE550

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Eckenradius oder Fase



- Toleranzen:
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø12 ist mm



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | CZCMS | DC | DCSFMS | APMXS | LF | CHW | RE | PCEDC | SW | Beschichtung |
|----------------------|----------------|--------------|---------------|-------|------|--------|-------|------|-------|-----|-------|----|--------------|
| | | | | | mm | mm | mm | mm | mm | mm | | | SIRA |
| XSE550E10100D2CZ4 | 10138152 | 2 | D | E10 | 10,0 | 9,7 | 12,0 | 18,7 | 0,125 | – | 4 | 8 | ■ |
| XSE550E12120D2CZ4 | 10138153 | 2 | D | E12 | 12,0 | 11,7 | 14,4 | 22,1 | 0,15 | – | 4 | 10 | ■ |
| XSE550E16160D2CZ4 | 10138154 | 2 | D | E16 | 16,0 | 15,5 | 19,2 | 29,2 | 0,2 | – | 4 | 12 | ■ |
| XSE550E20200D2CZ4 | 10138155 | 2 | D | E20 | 20,0 | 19,3 | 24,0 | 34,3 | 0,25 | – | 4 | 16 | ■ |
| XSE550E10100D1R050Z4 | 10138156 | 1 | D | E10 | 10,0 | 9,7 | 5,5 | 12,3 | – | 0,5 | 4 | 8 | ■ |
| XSE550E12120D1R050Z4 | 10138157 | 1 | D | E12 | 12,0 | 11,7 | 6,6 | 14,4 | – | 0,5 | 4 | 10 | ■ |
| XSE550E16160D1R050Z4 | 10138158 | 1 | D | E16 | 16,0 | 15,5 | 8,8 | 18,6 | – | 0,5 | 4 | 12 | ■ |
| XSE550E20200D1R100Z4 | 10138159 | 1 | D | E20 | 20,0 | 19,3 | 11,0 | 21,2 | – | 1,0 | 4 | 16 | ■ |
| XSE550E10100D2R100Z4 | 10138161 | 2 | D | E10 | 10,0 | 9,7 | 12,0 | 18,7 | – | 1,0 | 4 | 8 | ■ |
| XSE550E12120D2R100Z4 | 10138165 | 2 | D | E12 | 12,0 | 11,7 | 14,4 | 22,1 | – | 1,0 | 4 | 10 | ■ |
| XSE550E16160D2R100Z4 | 10138169 | 2 | D | E16 | 16,0 | 15,5 | 19,2 | 29,2 | – | 1,0 | 4 | 12 | ■ |
| XSE550E20200D2R100Z4 | 10138172 | 2 | D | E20 | 20,0 | 19,3 | 24,0 | 34,3 | – | 1,0 | 4 | 16 | ■ |
| XSE550E10100D2R050Z4 | 10138160 | 2 | D | E10 | 10,0 | 9,7 | 12,0 | 18,7 | – | 0,5 | 4 | 8 | ■ |
| XSE550E10100D2R200Z4 | 10138162 | 2 | D | E10 | 10,0 | 9,7 | 12,0 | 18,7 | – | 2,0 | 4 | 8 | ■ |
| XSE550E10100D2R250Z4 | 10138163 | 2 | D | E10 | 10,0 | 9,7 | 12,0 | 18,7 | – | 2,5 | 4 | 8 | ■ |
| XSE550E12120D2R050Z4 | 10138164 | 2 | D | E12 | 12,0 | 11,7 | 14,4 | 22,1 | – | 0,5 | 4 | 10 | ■ |
| XSE550E12120D2R200Z4 | 10138166 | 2 | D | E12 | 12,0 | 11,7 | 14,4 | 22,1 | – | 2,0 | 4 | 10 | ■ |
| XSE550E12120D2R300Z4 | 10138167 | 2 | D | E12 | 12,0 | 11,7 | 14,4 | 22,1 | – | 3,0 | 4 | 10 | ■ |
| XSE550E16160D2R050Z4 | 10138168 | 2 | D | E16 | 16,0 | 15,5 | 19,2 | 29,2 | – | 0,5 | 4 | 12 | ■ |
| XSE550E16160D2R200Z4 | 10138170 | 2 | D | E16 | 16,0 | 15,5 | 19,2 | 29,2 | – | 2,0 | 4 | 12 | ■ |
| XSE550E16160D2R300Z4 | 10138171 | 2 | D | E16 | 16,0 | 15,5 | 19,2 | 29,2 | – | 3,0 | 4 | 12 | ■ |
| XSE550E20200D2R200Z4 | 10138173 | 2 | D | E20 | 20,0 | 19,3 | 24,0 | 34,3 | – | 2,0 | 4 | 16 | ■ |
| XSE550E20200D2R300Z4 | 10138174 | 2 | D | E20 | 20,0 | 19,3 | 24,0 | 34,3 | – | 3,0 | 4 | 16 | ■ |
| XSE550E20200D2R400Z4 | 10138175 | 2 | D | E20 | 20,0 | 19,3 | 24,0 | 34,3 | – | 4,0 | 4 | 16 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

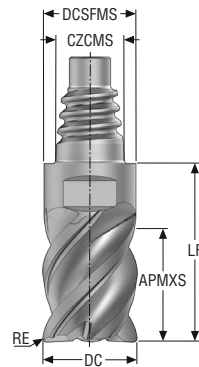
X-Heads

Minimaster Plus

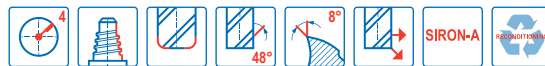
Minimaster

XSE550 – Zoll

Hochleistungsfräser – Universell – Eckfräser – 4 Schneiden – Eckenradius – Zoll



D



- Toleranzen:
- DC= e7
- RE= ±.0008 Zoll
- Nachschleifen möglich, wenn DC ≥ Ø.500 ist Zoll

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | CZCMS | DC | DCSFMS | APMXS | LF | RE | PCEDC | SW | Beschichtung |
|-----------------------|----------------|--------------|---------------|-------|-------|--------|-------|-------|-------|-------|----|--------------|
| | | | | | Zoll | Zoll | Zoll | Zoll | Zoll | | | SIRA |
| XSE550E10.375D1R030Z4 | 10138176 | 1 | D | E10 | 0.375 | 0.364 | 0.206 | 0.484 | 0.030 | 4 | 8 | ■ |
| XSE550E12.500D1R030Z4 | 10138177 | 1 | D | E12 | 0.500 | 0.484 | 0.275 | 0.567 | 0.030 | 4 | 10 | ■ |
| XSE550E20.750D1R030Z4 | 10138178 | 1 | D | E20 | 0.750 | 0.728 | 0.413 | 0.835 | 0.030 | 4 | 16 | ■ |
| XSE550E10.375D2R030Z4 | 10138179 | 2 | D | E10 | 0.375 | 0.364 | 0.450 | 0.720 | 0.030 | 4 | 8 | ■ |
| XSE550E12.500D2R030Z4 | 10138180 | 2 | D | E12 | 0.500 | 0.484 | 0.600 | 0.906 | 0.030 | 4 | 10 | ■ |
| XSE550E20.750D2R030Z4 | 10138181 | 2 | D | E20 | 0.750 | 0.728 | 0.900 | 1.295 | 0.030 | 4 | 16 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads


Minimaster Plus

Minimaster

Schnittdaten – XSE550 – Eckfräsen PCEDC 4

| SMG | | a _d /DC | a _p /DC | f _z | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|--------|--------|--------|--------------------|
| | | | | 10 | 12 | 16 | 20 | |
| P1 | E/M/A/D | 0,40 | 0,95 | 0,085 | 0,10 | 0,13 | 0,15 | 170 (130 – 210) |
| | | 0,40 | 0,95 | 0,0034 | 0,0040 | 0,0050 | 0,0060 | 560 (430 – 680) |
| P2 | E/M/A/D | 0,40 | 0,95 | 0,090 | 0,10 | 0,13 | 0,15 | 165 (130 – 200) |
| | | 0,40 | 0,95 | 0,0036 | 0,0040 | 0,0050 | 0,0060 | 540 (430 – 650) |
| P3 | E/M/A/D | 0,40 | 0,95 | 0,085 | 0,10 | 0,12 | 0,14 | 145 (110 – 180) |
| | | 0,40 | 0,95 | 0,0034 | 0,0040 | 0,0048 | 0,0055 | 475 (370 – 590) |
| P4 | E/M/A/D | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 130 (97 – 160) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 425 (320 – 520) |
| P5 | E/M/A/D | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 125 (93 – 150) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 410 (310 – 490) |
| P6 | E/M/A/D | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,13 | 140 (110 – 170) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0050 | 460 (370 – 550) |
| P7 | E/M/A/D | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,13 | 130 (98 – 160) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0050 | 425 (330 – 520) |
| P8 | E/M/A/D | 0,40 | 0,95 | 0,085 | 0,10 | 0,12 | 0,14 | 120 (91 – 150) |
| | | 0,40 | 0,95 | 0,0034 | 0,0040 | 0,0048 | 0,0055 | 395 (300 – 490) |
| P11 | E/M/A/D | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 85 (72 – 100) |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 280 (240 – 320) |
| P12 | E/M/A/D | 0,30 | 0,95 | 0,044 | 0,055 | 0,065 | 0,075 | 55 (46 – 68) |
| | | 0,30 | 0,95 | 0,0017 | 0,0022 | 0,0026 | 0,0030 | 180 (160 – 220) |
| M1 | E/M/A | 0,30 | 0,95 | 0,070 | 0,085 | 0,11 | 0,12 | 95 (83 – 120) |
| | | 0,30 | 0,95 | 0,0028 | 0,0034 | 0,0044 | 0,0048 | 310 (280 – 390) |
| M2 | E/M/A | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 80 (69 – 100) |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 260 (230 – 320) |
| M3 | E/M/A | 0,30 | 0,95 | 0,055 | 0,065 | 0,080 | 0,090 | 47 (36 – 58) |
| | | 0,30 | 0,95 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 155 (120 – 190) |
| M4 | E/M/A | 0,30 | 0,95 | 0,048 | 0,055 | 0,070 | 0,080 | 36 (28 – 45) |
| | | 0,30 | 0,95 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 120 (92 – 140) |
| M5 | E/M/A | 0,30 | 0,95 | 0,048 | 0,055 | 0,070 | 0,080 | 30 (23 – 37) |
| | | 0,30 | 0,95 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 100 (76 – 120) |
| K1 | E/M/A/D | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 150 (130 – 170) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 490 (430 – 550) |
| K2 | E/M/A/D | 0,40 | 0,95 | 0,075 | 0,090 | 0,11 | 0,13 | 130 (120 – 150) |
| | | 0,40 | 0,95 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 425 (400 – 490) |
| K3 | E/M/A/D | 0,40 | 0,95 | 0,075 | 0,090 | 0,11 | 0,13 | 110 (96 – 120) |
| | | 0,40 | 0,95 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 360 (320 – 390) |
| K4 | E/M/A/D | 0,40 | 0,95 | 0,075 | 0,090 | 0,11 | 0,13 | 105 (92 – 120) |
| | | 0,40 | 0,95 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 345 (310 – 390) |
| K5 | E/M/A/D | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 150 (130 – 170) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 490 (430 – 550) |
| K6 | E/M/A/D | 0,40 | 0,95 | 0,090 | 0,11 | 0,13 | 0,15 | 215 (190 – 240) |
| | | 0,40 | 0,95 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 710 (630 – 780) |
| K7 | E/M/A/D | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 190 (170 – 210) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 620 (560 – 680) |
| N1 | E/M/A | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 550 (450 – 660) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 1800 (1500 – 2100) |
| N2 | E/M/A | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 355 (290 – 420) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 1175 (960 – 1300) |
| N3 | E/M/A | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 240 (200 – 280) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 790 (660 – 910) |
| N11 | E/M/A | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 310 (280 – 380) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 1025 (920 – 1200) |
| S1 | E | 0,15 | 0,95 | 0,090 | 0,11 | 0,13 | 0,15 | 32 (26 – 40) |
| | | 0,15 | 0,95 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 105 (86 – 130) |
| S2 | E | 0,15 | 0,95 | 0,090 | 0,11 | 0,13 | 0,15 | 28 (21 – 34) |
| | | 0,15 | 0,95 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 90 (69 – 110) |
| S3 | E | 0,15 | 0,95 | 0,085 | 0,10 | 0,12 | 0,14 | 24 (19 – 30) |
| | | 0,15 | 0,95 | 0,0034 | 0,0040 | 0,0048 | 0,0055 | 80 (63 – 98) |
| S11 | E | 0,40 | 0,95 | 0,060 | 0,070 | 0,090 | 0,10 | 90 (77 – 120) |
| | | 0,40 | 0,95 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 295 (260 – 390) |
| S12 | E | 0,40 | 0,95 | 0,060 | 0,070 | 0,090 | 0,10 | 70 (59 – 93) |
| | | 0,40 | 0,95 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 230 (200 – 300) |
| S13 | E | 0,40 | 0,95 | 0,055 | 0,065 | 0,080 | 0,090 | 55 (47 – 74) |
| | | 0,40 | 0,95 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 180 (160 – 240) |
| H5 | M/A | 0,050 | 0,95 | 0,090 | 0,11 | 0,13 | 0,15 | 75 (59 – 73) |
| | | 0,050 | 0,95 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 245 (200 – 230) |
| H8 | M/A | 0,050 | 0,95 | 0,070 | 0,085 | 0,10 | 0,12 | 75 (62 – 76) |
| | | 0,050 | 0,95 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 245 (210 – 240) |
| H21 | M/A | 0,050 | 0,95 | 0,070 | 0,085 | 0,10 | 0,12 | 75 (62 – 76) |
| | | 0,050 | 0,95 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 245 (210 – 240) |
| H31 | M/A | 0,050 | 0,95 | 0,060 | 0,070 | 0,090 | 0,10 | 60 (48 – 59) |
| | | 0,050 | 0,95 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 195 (160 – 190) |
| TS1 | A/D | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 275 (170 – 380) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 900 (560 – 1200) |
| TP1 | A/D | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 275 (170 – 380) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 900 (560 – 1200) |
| GR1 | A/D | 0,40 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 550 (450 – 660) |
| | | 0,40 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 1800 (1500 – 2100) |


Schnittdaten – XSE550 – Nutfräsen PCEDC 4

| SMG |  | a _p /DC | f _z | | | | v _c | | | |
|-----|---|--------------------|-----------------|-----------------|-----------------|-----------------|---------------------------------------|-------------------------------|-------------------------------|----------------|
| | | | 10 | 12 | 16 | 20 | | | | |
| P1 | E/M/A/D | 0,80 0,80 | 0,040 0,0016 | 0,048 0,0019 | 0,065 0,0026 | 0,080 0,0032 | 165 (130 – 200) 540 (430 – 650) | Unversell | | |
| P2 | E/M/A/D | 0,80 0,80 | 0,040 0,0016 | 0,048 0,0019 | 0,065 0,0026 | 0,080 0,0032 | 160 (120 – 190) 520 (400 – 620) | | | |
| P3 | E/M/A/D | 0,80 0,80 | 0,040 0,0016 | 0,048 0,0019 | 0,065 0,0026 | 0,080 0,0032 | 135 (110 – 170) 445 (370 – 550) | | Stahl und Guss | |
| P4 | E/M/A/D | 0,80 0,80 | 0,040 0,0016 | 0,048 0,0019 | 0,065 0,0026 | 0,080 0,0032 | 120 (90 – 140) 395 (300 – 450) | | | |
| P5 | E/M/A/D | 0,80 0,80 | 0,040 0,0016 | 0,048 0,0019 | 0,065 0,0026 | 0,080 0,0032 | 115 (86 – 140) 375 (290 – 450) | | | Stahl und Guss |
| P6 | E/M/A/D | 0,80 0,80 | 0,040 0,0016 | 0,048 0,0019 | 0,065 0,0026 | 0,080 0,0032 | 130 (97 – 160) 425 (320 – 520) | | | |
| P7 | E/M/A/D | 0,80 0,80 | 0,040 0,0016 | 0,048 0,0019 | 0,065 0,0026 | 0,080 0,0032 | 120 (92 – 150) 395 (310 – 490) | | Rostfrei und ISO-S-Werkstoffe | |
| P8 | E/M/A/D | 0,80 0,80 | 0,040 0,0016 | 0,048 0,0019 | 0,065 0,0026 | 0,080 0,0032 | 115 (86 – 140) 375 (290 – 450) | | | |
| P11 | E/M/A/D | 0,60 0,60 | 0,030 0,0012 | 0,036 0,0014 | 0,048 0,0019 | 0,060 0,0024 | 75 (64 – 94) 245 (210 – 300) | Rostfrei und ISO-S-Werkstoffe | | |
| P12 | E/M/A/D | 0,48 0,48 | 0,030 0,0012 | 0,036 0,0014 | 0,048 0,0019 | 0,060 0,0024 | 44 (38 – 56) 145 (130 – 180) | | | |
| M1 | E/M/A | 0,60 0,60 | 0,030 0,0012 | 0,036 0,0014 | 0,048 0,0019 | 0,060 0,0024 | 85 (75 – 110) 280 (250 – 360) | NE-Metalle | | |
| M2 | E/M/A | 0,60 0,60 | 0,030 0,0012 | 0,036 0,0014 | 0,048 0,0019 | 0,060 0,0024 | 70 (60 – 90) 230 (200 – 290) | | | |
| M3 | E/M/A | 0,60 0,60 | 0,030 0,0012 | 0,036 0,0014 | 0,048 0,0019 | 0,060 0,0024 | 40 (30 – 50) 130 (99 – 160) | | | |
| M4 | E/M/A | 0,44 0,44 | 0,030 0,0012 | 0,036 0,0014 | 0,048 0,0019 | 0,060 0,0024 | 30 (23 – 38) 100 (76 – 120) | | | |
| M5 | E/M/A | 0,44 0,44 | 0,030 0,0012 | 0,036 0,0014 | 0,048 0,0019 | 0,060 0,0024 | 25 (20 – 31) 80 (66 – 100) | | | |
| K1 | E/M/A/D | 0,80 0,80 | 0,040 0,0016 | 0,048 0,0019 | 0,065 0,0026 | 0,080 0,0032 | 140 (120 – 160) 460 (400 – 520) | Harter | | |
| K2 | E/M/A/D | 0,80 0,80 | 0,040 0,0016 | 0,048 0,0019 | 0,065 0,0026 | 0,080 0,0032 | 120 (110 – 130) 395 (370 – 420) | | | |
| K3 | E/M/A/D | 0,80 0,80 | 0,040 0,0016 | 0,048 0,0019 | 0,065 0,0026 | 0,080 0,0032 | 105 (88 – 110) 345 (290 – 360) | | | |
| K4 | E/M/A/D | 0,80 0,80 | 0,040 0,0016 | 0,048 0,0019 | 0,065 0,0026 | 0,080 0,0032 | 100 (84 – 110) 330 (280 – 360) | | | |
| K5 | E/M/A/D | 0,80 0,80 | 0,040 0,0016 | 0,048 0,0019 | 0,065 0,0026 | 0,080 0,0032 | 140 (120 – 160) 460 (400 – 520) | | | |
| K6 | E/M/A/D | 0,80 0,80 | 0,040 0,0016 | 0,048 0,0019 | 0,065 0,0026 | 0,080 0,0032 | 205 (180 – 230) 670 (600 – 750) | | | |
| K7 | E/M/A/D | 0,80 0,80 | 0,040 0,0016 | 0,048 0,0019 | 0,065 0,0026 | 0,080 0,0032 | 180 (160 – 200) 590 (530 – 650) | | | |
| N1 | E/M/A | 0,60 0,60 | 0,050 0,0020 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 500 (410 – 590) 1650 (1400 – 1900) | Graphit | | |
| N2 | E/M/A | 0,60 0,60 | 0,050 0,0020 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 320 (260 – 380) 1050 (860 – 1200) | | | |
| N3 | E/M/A | 0,60 0,60 | 0,050 0,0020 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 215 (180 – 250) 710 (600 – 820) | | | |
| N11 | E/M/A | 0,60 0,60 | 0,050 0,0020 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 280 (250 – 340) 920 (830 – 1100) | | | |
| S1 | E | 0,30 0,30 | 0,030 0,0012 | 0,036 0,0014 | 0,048 0,0019 | 0,060 0,0024 | 27 (21 – 33) 90 (69 – 100) | X-Heads | | |
| S2 | E | 0,30 0,30 | 0,030 0,0012 | 0,036 0,0014 | 0,048 0,0019 | 0,060 0,0024 | 23 (17 – 28) 75 (56 – 91) | | | |
| S3 | E | 0,30 0,30 | 0,030 0,0012 | 0,036 0,0014 | 0,048 0,0019 | 0,060 0,0024 | 20 (15 – 24) 65 (50 – 78) | | | |
| S11 | E | 0,50 0,50 | 0,050 0,0020 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 80 (65 – 100) 260 (220 – 320) | | | |
| S12 | E | 0,50 0,50 | 0,050 0,0020 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 60 (50 – 79) 195 (170 – 250) | | | |
| S13 | E | 0,42 0,42 | 0,050 0,0020 | 0,060 0,0024 | 0,075 0,0030 | 0,090 0,0036 | 47 (39 – 62) 155 (130 – 200) | | | |
| H5 | M/A | 0,26 0,26 | 0,025 0,0010 | 0,030 0,0012 | 0,040 0,0016 | 0,050 0,0020 | 50 (41 – 50) 165 (140 – 160) | | Minimaster Plus | |
| H8 | M/A | 0,22 0,22 | 0,025 0,0010 | 0,030 0,0012 | 0,040 0,0016 | 0,050 0,0020 | 50 (42 – 51) 165 (140 – 160) | | | |
| H21 | M/A | 0,22 0,22 | 0,025 0,0010 | 0,030 0,0012 | 0,040 0,0016 | 0,050 0,0020 | 50 (42 – 51) 165 (140 – 160) | | | |
| H31 | M/A | 0,22 0,22 | 0,025 0,0010 | 0,030 0,0012 | 0,040 0,0016 | 0,046 0,0018 | 39 (32 – 38) 130 (110 – 120) | | | |
| TS1 | A/D | 0,60 0,60 | 0,050 0,0020 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 250 (150 – 340) 820 (500 – 1100) | Minimaster | | |
| TP1 | A/D | 0,60 0,60 | 0,050 0,0020 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 250 (150 – 340) 820 (500 – 1100) | | | |
| GR1 | A/D | 0,60 0,60 | 0,050 0,0020 | 0,060 0,0024 | 0,080 0,0032 | 0,10 0,0040 | 500 (410 – 590) 1650 (1400 – 1900) | | | |

Schnittdaten – XSE550 – Eckfräsen PCEDC 4 – Zoll

| SMG | | a _d /DC | a _p /DC | f _z | | | | v _c |
|---------------------------|---------|--------------------|--------------------|-----------------|-----------------|-----------------|-----------------|---------------------------------------|
| | | | | 3/8 | 1/2 | 5/8 | 3/4 | |
| Univerrsell | | | | | | | | |
| P1 | E/M/A/D | 0,40 0.40 | 0,95 0.95 | 0,085 0.0034 | 0,10 0.0040 | 0,13 0.0050 | 0,15 0.0060 | 200 (180 – 220) 660 (600 – 720) |
| P2 | E/M/A/D | 0,40 0.40 | 0,95 0.95 | 0,090 0.0036 | 0,10 0.0040 | 0,13 0.0050 | 0,15 0.0060 | 195 (170 – 220) 640 (560 – 720) |
| P3 | E/M/A/D | 0,40 0.40 | 0,95 0.95 | 0,085 0.0034 | 0,10 0.0040 | 0,12 0.0048 | 0,14 0.0055 | 170 (150 – 190) 560 (500 – 620) |
| P4 | E/M/A/D | 0,40 0.40 | 0,95 0.95 | 0,080 0.0032 | 0,095 0.0038 | 0,12 0.0048 | 0,14 0.0055 | 150 (130 – 170) 490 (430 – 550) |
| P5 | E/M/A/D | 0,40 0.40 | 0,95 0.95 | 0,080 0.0032 | 0,095 0.0038 | 0,12 0.0048 | 0,14 0.0055 | 145 (130 – 160) 475 (430 – 520) |
| P6 | E/M/A/D | 0,40 0.40 | 0,95 0.95 | 0,080 0.0032 | 0,095 0.0038 | 0,12 0.0048 | 0,13 0.0050 | 160 (140 – 180) 520 (460 – 590) |
| P7 | E/M/A/D | 0,40 0.40 | 0,95 0.95 | 0,080 0.0032 | 0,095 0.0038 | 0,12 0.0048 | 0,13 0.0050 | 150 (140 – 170) 490 (460 – 550) |
| P8 | E/M/A/D | 0,40 0.40 | 0,95 0.95 | 0,085 0.0034 | 0,10 0.0040 | 0,12 0.0048 | 0,14 0.0055 | 140 (130 – 160) 460 (430 – 520) |
| P11 | E/M/A/D | 0,30 0.30 | 0,95 0.95 | 0,065 0.0026 | 0,075 0.0030 | 0,095 0.0038 | 0,11 0.0044 | 95 (84 – 100) 310 (280 – 320) |
| P12 | E/M/A/D | 0,30 0.30 | 0,95 0.95 | 0,044 0.0017 | 0,055 0.0022 | 0,065 0.0026 | 0,075 0.0030 | 60 (54 – 68) 195 (180 – 220) |
| M1 | E/M/A | 0,30 0.30 | 0,95 0.95 | 0,070 0.0028 | 0,085 0.0034 | 0,11 0.0044 | 0,12 0.0048 | 110 (97 – 120) 360 (320 – 390) |
| M2 | E/M/A | 0,30 0.30 | 0,95 0.95 | 0,065 0.0026 | 0,075 0.0030 | 0,095 0.0038 | 0,11 0.0044 | 90 (80 – 100) 295 (270 – 320) |
| M3 | E/M/A | 0,30 0.30 | 0,95 0.95 | 0,055 0.0022 | 0,065 0.0026 | 0,080 0.0032 | 0,090 0.0036 | 60 (47 – 70) 195 (160 – 220) |
| M4 | E/M/A | 0,30 0.30 | 0,95 0.95 | 0,048 0.0019 | 0,055 0.0022 | 0,070 0.0028 | 0,080 0.0032 | 45 (37 – 54) 150 (130 – 170) |
| M5 | E/M/A | 0,30 0.30 | 0,95 0.95 | 0,048 0.0019 | 0,055 0.0022 | 0,070 0.0028 | 0,080 0.0032 | 38 (31 – 45) 125 (110 – 140) |
| Harter | | | | | | | | |
| K1 | E/M/A/D | 0,40 0.40 | 0,95 0.95 | 0,080 0.0032 | 0,095 0.0038 | 0,12 0.0048 | 0,14 0.0055 | 160 (160 – 190) 520 (530 – 620) |
| K2 | E/M/A/D | 0,40 0.40 | 0,95 0.95 | 0,075 0.0030 | 0,090 0.0036 | 0,11 0.0044 | 0,13 0.0050 | 140 (140 – 170) 460 (460 – 550) |
| K3 | E/M/A/D | 0,40 0.40 | 0,95 0.95 | 0,075 0.0030 | 0,090 0.0036 | 0,11 0.0044 | 0,13 0.0050 | 120 (120 – 140) 395 (400 – 450) |
| K4 | E/M/A/D | 0,40 0.40 | 0,95 0.95 | 0,075 0.0030 | 0,090 0.0036 | 0,11 0.0044 | 0,13 0.0050 | 115 (110 – 130) 375 (370 – 420) |
| K5 | E/M/A/D | 0,40 0.40 | 0,95 0.95 | 0,080 0.0032 | 0,095 0.0038 | 0,12 0.0048 | 0,14 0.0055 | 150 (130 – 170) 490 (430 – 550) |
| K6 | E/M/A/D | 0,40 0.40 | 0,95 0.95 | 0,090 0.0036 | 0,11 0.0044 | 0,13 0.0050 | 0,15 0.0060 | 215 (190 – 240) 710 (630 – 780) |
| K7 | E/M/A/D | 0,40 0.40 | 0,95 0.95 | 0,080 0.0032 | 0,095 0.0038 | 0,12 0.0048 | 0,14 0.0055 | 190 (170 – 210) 620 (560 – 680) |
| Kunststoffe und Composite | | | | | | | | |
| N1 | E/M/A | 0,40 0.40 | 0,95 0.95 | 0,080 0.0032 | 0,095 0.0038 | 0,12 0.0048 | 0,14 0.0055 | 670 (560 – 770) 2200 (1900 – 2500) |
| N2 | E/M/A | 0,40 0.40 | 0,95 0.95 | 0,080 0.0032 | 0,095 0.0038 | 0,12 0.0048 | 0,14 0.0055 | 430 (360 – 490) 1400 (1200 – 1600) |
| N3 | E/M/A | 0,40 0.40 | 0,95 0.95 | 0,080 0.0032 | 0,095 0.0038 | 0,12 0.0048 | 0,14 0.0055 | 285 (240 – 330) 940 (790 – 1000) |
| N11 | E/M/A | 0,40 0.40 | 0,95 0.95 | 0,080 0.0032 | 0,095 0.0038 | 0,12 0.0048 | 0,14 0.0055 | 335 (280 – 380) 1100 (920 – 1200) |
| Graphit | | | | | | | | |
| X-Heads | | | | | | | | |
| S1 | E | 0,15 0.15 | 0,95 0.95 | 0,090 0.0036 | 0,11 0.0044 | 0,13 0.0050 | 0,15 0.0060 | 43 (26 – 60) 140 (86 – 190) |
| S2 | E | 0,15 0.15 | 0,95 0.95 | 0,090 0.0036 | 0,11 0.0044 | 0,13 0.0050 | 0,15 0.0060 | 35 (21 – 48) 115 (69 – 150) |
| S3 | E | 0,15 0.15 | 0,95 0.95 | 0,085 0.0034 | 0,10 0.0040 | 0,12 0.0048 | 0,14 0.0055 | 30 (19 – 42) 100 (63 – 130) |
| S11 | E | 0,40 0.40 | 0,95 0.95 | 0,060 0.0024 | 0,070 0.0028 | 0,090 0.0036 | 0,10 0.0040 | 105 (77 – 130) 345 (260 – 420) |
| S12 | E | 0,40 0.40 | 0,95 0.95 | 0,060 0.0024 | 0,070 0.0028 | 0,090 0.0036 | 0,10 0.0040 | 80 (59 – 100) 260 (200 – 320) |
| S13 | E | 0,40 0.40 | 0,95 0.95 | 0,055 0.0022 | 0,065 0.0026 | 0,080 0.0032 | 0,090 0.0036 | 65 (47 – 83) 215 (160 – 270) |
| Minimaster Plus | | | | | | | | |
| H5 | M/A | 0,050 0.050 | 0,95 0.95 | 0,090 0.0036 | 0,11 0.0044 | 0,13 0.0050 | 0,15 0.0060 | 75 (59 – 73) 245 (200 – 230) |
| H8 | M/A | 0,050 0.050 | 0,95 0.95 | 0,070 0.0028 | 0,085 0.0034 | 0,10 0.0040 | 0,12 0.0048 | 75 (62 – 76) 245 (210 – 240) |
| Minimaster | | | | | | | | |
| H21 | M/A | 0,050 0.050 | 0,95 0.95 | 0,070 0.0028 | 0,085 0.0034 | 0,10 0.0040 | 0,12 0.0048 | 75 (62 – 76) 245 (210 – 240) |
| H31 | M/A | 0,050 0.050 | 0,95 0.95 | 0,060 0.0024 | 0,070 0.0028 | 0,090 0.0036 | 0,10 0.0040 | 60 (48 – 59) 195 (160 – 190) |
| TS1 | A/D | 0,40 0.40 | 0,95 0.95 | 0,080 0.0032 | 0,095 0.0038 | 0,12 0.0048 | 0,14 0.0055 | 275 (170 – 380) 900 (560 – 1200) |
| TP1 | A/D | 0,40 0.40 | 0,95 0.95 | 0,080 0.0032 | 0,095 0.0038 | 0,12 0.0048 | 0,14 0.0055 | 275 (170 – 380) 900 (560 – 1200) |
| GR1 | A/D | 0,40 0.40 | 0,95 0.95 | 0,080 0.0032 | 0,095 0.0038 | 0,12 0.0048 | 0,14 0.0055 | 670 (560 – 770) 2200 (1900 – 2500) |

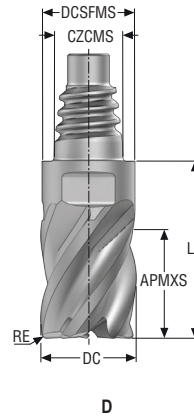
Schnittdaten – XSE550 – Nutfräsen PCEDC 4 – Zoll

| SMG |  | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------------------|
| | | | 3/8 | 1/2 | 5/8 | 3/4 | |
| P1 | E/M/A/D | 0,80 | 0,040 | 0,048 | 0,065 | 0,080 | 190 (170 – 210) |
| | | 0,80 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 620 (560 – 680) |
| P2 | E/M/A/D | 0,80 | 0,040 | 0,048 | 0,065 | 0,080 | 185 (160 – 210) |
| | | 0,80 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 610 (530 – 680) |
| P3 | E/M/A/D | 0,80 | 0,040 | 0,048 | 0,065 | 0,080 | 160 (140 – 180) |
| | | 0,80 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 520 (460 – 590) |
| P4 | E/M/A/D | 0,80 | 0,040 | 0,048 | 0,065 | 0,080 | 140 (120 – 150) |
| | | 0,80 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 460 (400 – 490) |
| P5 | E/M/A/D | 0,80 | 0,040 | 0,048 | 0,065 | 0,080 | 135 (120 – 150) |
| | | 0,80 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 445 (400 – 490) |
| P6 | E/M/A/D | 0,80 | 0,040 | 0,048 | 0,065 | 0,080 | 150 (130 – 170) |
| | | 0,80 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 490 (430 – 550) |
| P7 | E/M/A/D | 0,80 | 0,040 | 0,048 | 0,065 | 0,080 | 140 (130 – 160) |
| | | 0,80 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 460 (430 – 520) |
| P8 | E/M/A/D | 0,80 | 0,040 | 0,048 | 0,065 | 0,080 | 135 (120 – 150) |
| | | 0,80 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 445 (400 – 490) |
| P11 | E/M/A/D | 0,60 | 0,030 | 0,036 | 0,048 | 0,060 | 85 (74 – 94) |
| | | 0,60 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 280 (250 – 300) |
| P12 | E/M/A/D | 0,60 | 0,030 | 0,036 | 0,048 | 0,060 | 50 (44 – 55) |
| | | 0,60 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 165 (150 – 180) |
| M1 | E/M/A | 0,60 | 0,030 | 0,036 | 0,048 | 0,060 | 100 (87 – 110) |
| | | 0,60 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 330 (290 – 360) |
| M2 | E/M/A | 0,60 | 0,030 | 0,036 | 0,048 | 0,060 | 80 (70 – 90) |
| | | 0,60 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 260 (230 – 290) |
| M3 | E/M/A | 0,60 | 0,030 | 0,036 | 0,048 | 0,060 | 50 (40 – 60) |
| | | 0,60 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 165 (140 – 190) |
| M4 | E/M/A | 0,60 | 0,030 | 0,036 | 0,048 | 0,060 | 37 (30 – 45) |
| | | 0,60 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 120 (99 – 140) |
| M5 | E/M/A | 0,60 | 0,030 | 0,036 | 0,048 | 0,060 | 31 (25 – 37) |
| | | 0,60 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 100 (83 – 120) |
| K1 | E/M/A/D | 0,80 | 0,040 | 0,048 | 0,065 | 0,080 | 150 (150 – 180) |
| | | 0,80 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 490 (500 – 590) |
| K2 | E/M/A/D | 0,80 | 0,040 | 0,048 | 0,065 | 0,080 | 130 (130 – 150) |
| | | 0,80 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 425 (430 – 490) |
| K3 | E/M/A/D | 0,80 | 0,040 | 0,048 | 0,065 | 0,080 | 110 (110 – 130) |
| | | 0,80 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 360 (370 – 420) |
| K4 | E/M/A/D | 0,80 | 0,040 | 0,048 | 0,065 | 0,080 | 105 (99 – 120) |
| | | 0,80 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 345 (330 – 390) |
| K5 | E/M/A/D | 0,80 | 0,040 | 0,048 | 0,065 | 0,080 | 140 (120 – 160) |
| | | 0,80 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 460 (400 – 520) |
| K6 | E/M/A/D | 0,80 | 0,040 | 0,048 | 0,065 | 0,080 | 205 (180 – 230) |
| | | 0,80 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 670 (600 – 750) |
| K7 | E/M/A/D | 0,80 | 0,040 | 0,048 | 0,065 | 0,080 | 180 (160 – 200) |
| | | 0,80 | 0,0016 | 0,0019 | 0,0026 | 0,0032 | 590 (530 – 650) |
| N1 | E/M/A | 0,60 | 0,050 | 0,060 | 0,080 | 0,10 | 600 (510 – 700) |
| | | 0,60 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 1975 (1700 – 2200) |
| N2 | E/M/A | 0,60 | 0,050 | 0,060 | 0,080 | 0,10 | 385 (330 – 450) |
| | | 0,60 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 1275 (1100 – 1400) |
| N3 | E/M/A | 0,60 | 0,050 | 0,060 | 0,080 | 0,10 | 255 (220 – 300) |
| | | 0,60 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 840 (730 – 980) |
| N11 | E/M/A | 0,60 | 0,050 | 0,060 | 0,080 | 0,10 | 300 (250 – 350) |
| | | 0,60 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 980 (830 – 1100) |
| S1 | E | 0,30 | 0,030 | 0,036 | 0,048 | 0,060 | 36 (22 – 50) |
| | | 0,30 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 120 (73 – 160) |
| S2 | E | 0,30 | 0,030 | 0,036 | 0,048 | 0,060 | 29 (18 – 40) |
| | | 0,30 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 95 (60 – 130) |
| S3 | E | 0,30 | 0,030 | 0,036 | 0,048 | 0,060 | 25 (15 – 34) |
| | | 0,30 | 0,0012 | 0,0014 | 0,0019 | 0,0024 | 80 (50 – 110) |
| S11 | E | 0,50 | 0,050 | 0,060 | 0,080 | 0,10 | 90 (65 – 110) |
| | | 0,50 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 295 (220 – 360) |
| S12 | E | 0,50 | 0,050 | 0,060 | 0,080 | 0,10 | 70 (50 – 90) |
| | | 0,50 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 230 (170 – 290) |
| S13 | E | 0,50 | 0,050 | 0,060 | 0,075 | 0,090 | 55 (39 – 69) |
| | | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 180 (130 – 220) |
| H5 | M/A | 0,26 | 0,025 | 0,030 | 0,040 | 0,050 | 50 (41 – 50) |
| | | 0,26 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 165 (140 – 160) |
| H8 | M/A | 0,26 | 0,025 | 0,030 | 0,040 | 0,050 | 50 (41 – 50) |
| | | 0,26 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 165 (140 – 160) |
| H21 | M/A | 0,26 | 0,025 | 0,030 | 0,040 | 0,050 | 50 (41 – 50) |
| | | 0,26 | 0,0010 | 0,0012 | 0,0016 | 0,0020 | 165 (140 – 160) |
| H31 | M/A | 0,26 | 0,025 | 0,030 | 0,038 | 0,044 | 38 (31 – 38) |
| | | 0,26 | 0,0010 | 0,0012 | 0,0015 | 0,0017 | 125 (110 – 120) |
| TS1 | A/D | 0,60 | 0,050 | 0,060 | 0,080 | 0,10 | 250 (150 – 340) |
| | | 0,60 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 820 (500 – 1100) |
| TP1 | A/D | 0,60 | 0,050 | 0,060 | 0,080 | 0,10 | 250 (150 – 340) |
| | | 0,60 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 820 (500 – 1100) |
| GR1 | A/D | 0,60 | 0,050 | 0,060 | 0,080 | 0,10 | 600 (510 – 700) |
| | | 0,60 | 0,0020 | 0,0024 | 0,0032 | 0,0040 | 1975 (1700 – 2200) |

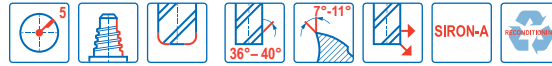
Unversell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

XSE550

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Eckenradius



- Toleranzen:
- DC= 0/-0,0508 mm
- RE= ±0,0254 mm
- Nachschleifen möglich, wenn DC ≥ Ø12 ist mm



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | CZCMS | DC | DCSFMS | APMXS | LF | RE | PCEDC | SW | Beschichtung |
|----------------------|--------------------|------------------|-------------------|-------|------|--------|-------|------|-----|-------|----|--------------|
| | | | | | mm | mm | mm | mm | mm | | | SIRA |
| XSE550E10100D2R050Z5 | 10138337 | 2 | D | E10 | 10,0 | 9,7 | 12,0 | 18,7 | 0,5 | 5 | 8 | ■ |
| XSE550E10100D2R100Z5 | 10138338 | 2 | D | E10 | 10,0 | 9,7 | 12,0 | 18,7 | 1,0 | 5 | 8 | ■ |
| XSE550E12120D2R050Z5 | 10138339 | 2 | D | E12 | 12,0 | 11,7 | 14,4 | 22,1 | 0,5 | 5 | 10 | ■ |
| XSE550E12120D2R100Z5 | 10138340 | 2 | D | E12 | 12,0 | 11,7 | 14,4 | 22,1 | 1,0 | 5 | 10 | ■ |
| XSE550E16160D2R050Z5 | 10138341 | 2 | D | E16 | 16,0 | 15,5 | 19,2 | 29,2 | 0,5 | 5 | 12 | ■ |
| XSE550E16160D2R100Z5 | 10138342 | 2 | D | E16 | 16,0 | 15,5 | 19,2 | 29,2 | 1,0 | 5 | 12 | ■ |
| XSE550E20200D2R050Z5 | 10138343 | 2 | D | E20 | 20,0 | 19,3 | 24,0 | 34,3 | 0,5 | 5 | 16 | ■ |
| XSE550E20200D2R100Z5 | 10138344 | 2 | D | E20 | 20,0 | 19,3 | 24,0 | 34,3 | 1,0 | 5 | 16 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

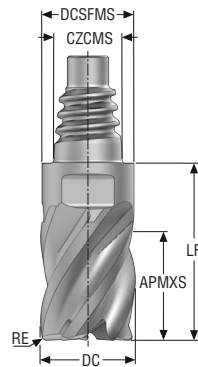
X-Heads

Minimaster Plus

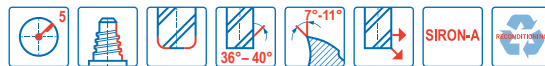
Minimaster

XSE550

Hochleistungsfräser – Universell – Eckfräser – 5 Schneiden – Eckenradius – Zoll



D



- Toleranzen:
- DC= 0/-0.002 Zoll
- RE= ±.001 Zoll
- Nachschleifen möglich, wenn DC ≥ Ø.500 ist Zoll

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | CZCMS | DC | DCSFMS | APMXS | LF | RE | PCEDC | SW | Beschichtung |
|-----------------------|----------------|--------------|---------------|-------|-------|--------|-------|-------|-------|-------|----|--------------|
| | | | | | | | | | | | | SIRA |
| XSE550E10.375D2R015Z5 | 10138345 | 2 | D | E10 | 0.375 | 0.364 | 0.450 | 0.720 | 0.015 | 5 | 8 | ■ |
| XSE550E10.375D2R030Z5 | 10138346 | 2 | D | E10 | 0.375 | 0.364 | 0.450 | 0.720 | 0.030 | 5 | 8 | ■ |
| XSE550E10.375D2R045Z5 | 10138347 | 2 | D | E10 | 0.375 | 0.364 | 0.450 | 0.720 | 0.044 | 5 | 8 | ■ |
| XSE550E12.500D2R030Z5 | 10138348 | 2 | D | E12 | 0.500 | 0.484 | 0.600 | 0.906 | 0.030 | 5 | 10 | ■ |
| XSE550E12.500D2R060Z5 | 10138349 | 2 | D | E12 | 0.500 | 0.484 | 0.600 | 0.906 | 0.060 | 5 | 10 | ■ |
| XSE550E12.500D2R120Z5 | 10138350 | 2 | D | E12 | 0.500 | 0.484 | 0.600 | 0.906 | 0.120 | 5 | 10 | ■ |
| XSE550E16.625D2R030Z5 | 10138351 | 2 | D | E16 | 0.625 | 0.610 | 0.750 | 1.150 | 0.030 | 5 | 12 | ■ |
| XSE550E16.625D2R060Z5 | 10138352 | 2 | D | E16 | 0.625 | 0.610 | 0.750 | 1.150 | 0.060 | 5 | 12 | ■ |
| XSE550E16.625D2R120Z5 | 10138353 | 2 | D | E16 | 0.625 | 0.610 | 0.750 | 1.150 | 0.120 | 5 | 12 | ■ |
| XSE550E20.750D2R030Z5 | 10138354 | 2 | D | E20 | 0.750 | 0.728 | 0.900 | 1.295 | 0.030 | 5 | 16 | ■ |
| XSE550E20.750D2R060Z5 | 10138355 | 2 | D | E20 | 0.750 | 0.728 | 0.900 | 1.295 | 0.060 | 5 | 16 | ■ |
| XSE550E20.750D2R120Z5 | 10138356 | 2 | D | E20 | 0.750 | 0.728 | 0.900 | 1.295 | 0.120 | 5 | 16 | ■ |
| XSE550E25.100D2R030Z5 | 10138357 | 2 | D | E25 | 1.000 | 0.965 | 1.200 | 1.673 | 0.030 | 5 | 20 | ■ |
| XSE550E25.100D2R060Z5 | 10138358 | 2 | D | E25 | 1.000 | 0.965 | 1.200 | 1.673 | 0.060 | 5 | 20 | ■ |
| XSE550E25.100D2R120Z5 | 10138359 | 2 | D | E25 | 1.000 | 0.965 | 1.200 | 1.673 | 0.120 | 5 | 20 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads


Minimaster Plus

Minimaster

Schnittdaten – XSE550 – Eckfräsen PCEDC 5

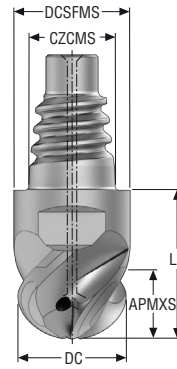
| SMG | | a _e /DC | a _p /DC | f _z | | | | v _c | |
|-----|---------|--------------------|--------------------|----------------|--------|--------|--------|----------------|--------------------|
| | | | | 10 | 12 | 16 | 20 | | |
| P1 | E/M/A/D | 0,30 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 0,15 | 165 (130 – 190) |
| | | 0,30 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0060 | 540 (430 – 620) |
| P2 | E/M/A/D | 0,30 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 0,16 | 160 (130 – 190) |
| | | 0,30 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0065 | 520 (430 – 620) |
| P3 | E/M/A/D | 0,30 | 0,95 | 0,075 | 0,090 | 0,11 | 0,13 | 0,15 | 140 (110 – 160) |
| | | 0,30 | 0,95 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 460 (370 – 520) |
| P4 | E/M/A/D | 0,30 | 0,95 | 0,075 | 0,090 | 0,11 | 0,13 | 0,14 | 125 (97 – 140) |
| | | 0,30 | 0,95 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0055 | 410 (320 – 450) |
| P5 | E/M/A/D | 0,30 | 0,95 | 0,075 | 0,090 | 0,11 | 0,13 | 0,14 | 110 (97 – 130) |
| | | 0,30 | 0,95 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0055 | 360 (320 – 420) |
| P6 | E/M/A/D | 0,30 | 0,95 | 0,075 | 0,085 | 0,11 | 0,12 | 0,14 | 125 (110 – 150) |
| | | 0,30 | 0,95 | 0,0030 | 0,0034 | 0,0044 | 0,0048 | 0,0055 | 410 (370 – 490) |
| P7 | E/M/A/D | 0,30 | 0,95 | 0,075 | 0,085 | 0,11 | 0,12 | 0,14 | 120 (110 – 140) |
| | | 0,30 | 0,95 | 0,0030 | 0,0034 | 0,0044 | 0,0048 | 0,0055 | 395 (370 – 450) |
| P8 | E/M/A/D | 0,30 | 0,95 | 0,075 | 0,090 | 0,11 | 0,13 | 0,15 | 110 (97 – 130) |
| | | 0,30 | 0,95 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 360 (320 – 420) |
| P11 | E/M/A/D | 0,20 | 0,95 | 0,060 | 0,070 | 0,090 | 0,10 | 0,12 | 100 (89 – 110) |
| | | 0,20 | 0,95 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0048 | 330 (300 – 360) |
| P12 | E/M/A/D | 0,20 | 0,95 | 0,042 | 0,050 | 0,060 | 0,070 | 0,080 | 65 (56 – 71) |
| | | 0,20 | 0,95 | 0,0017 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 215 (190 – 230) |
| M1 | E/M/A | 0,20 | 0,95 | 0,070 | 0,080 | 0,10 | 0,12 | 0,13 | 115 (110 – 120) |
| | | 0,20 | 0,95 | 0,0028 | 0,0032 | 0,0040 | 0,0048 | 0,0050 | 375 (370 – 390) |
| M2 | E/M/A | 0,20 | 0,95 | 0,060 | 0,075 | 0,090 | 0,10 | 0,12 | 95 (84 – 100) |
| | | 0,20 | 0,95 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 0,0048 | 310 (280 – 320) |
| M3 | E/M/A | 0,20 | 0,95 | 0,060 | 0,075 | 0,090 | 0,10 | 0,12 | 60 (47 – 69) |
| | | 0,20 | 0,95 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 0,0048 | 195 (160 – 220) |
| M4 | E/M/A | 0,20 | 0,95 | 0,055 | 0,065 | 0,080 | 0,090 | 0,10 | 44 (36 – 53) |
| | | 0,20 | 0,95 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 0,0040 | 145 (120 – 170) |
| M5 | E/M/A | 0,20 | 0,95 | 0,055 | 0,065 | 0,080 | 0,090 | 0,10 | 37 (30 – 44) |
| | | 0,20 | 0,95 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 0,0040 | 120 (99 – 140) |
| K1 | E/M/A/D | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 130 (120 – 150) |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 425 (400 – 490) |
| K2 | E/M/A/D | 0,30 | 0,95 | 0,060 | 0,070 | 0,085 | 0,10 | 0,11 | 115 (98 – 130) |
| | | 0,30 | 0,95 | 0,0024 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 375 (330 – 420) |
| K3 | E/M/A/D | 0,30 | 0,95 | 0,060 | 0,070 | 0,085 | 0,10 | 0,11 | 100 (83 – 110) |
| | | 0,30 | 0,95 | 0,0024 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 330 (280 – 360) |
| K4 | E/M/A/D | 0,30 | 0,95 | 0,060 | 0,070 | 0,085 | 0,10 | 0,11 | 95 (79 – 100) |
| | | 0,30 | 0,95 | 0,0024 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 310 (260 – 320) |
| K5 | E/M/A/D | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 105 (89 – 130) |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 345 (300 – 420) |
| K6 | E/M/A/D | 0,30 | 0,95 | 0,070 | 0,085 | 0,11 | 0,12 | 0,14 | 155 (130 – 190) |
| | | 0,30 | 0,95 | 0,0028 | 0,0034 | 0,0044 | 0,0048 | 0,0055 | 510 (430 – 620) |
| K7 | E/M/A/D | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 135 (120 – 160) |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 445 (400 – 520) |
| N1 | E/M/A | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 690 (580 – 800) |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 2275 (2000 – 2600) |
| N2 | E/M/A | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 445 (380 – 520) |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 1450 (1300 – 1700) |
| N3 | E/M/A | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 300 (250 – 340) |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 980 (830 – 1100) |
| N11 | E/M/A | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 345 (290 – 400) |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 1125 (960 – 1300) |
| S1 | E | 0,15 | 0,95 | 0,075 | 0,090 | 0,11 | 0,13 | 0,14 | 27 (24 – 41) |
| | | 0,15 | 0,95 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0055 | 90 (79 – 130) |
| S2 | E | 0,15 | 0,95 | 0,075 | 0,090 | 0,11 | 0,13 | 0,14 | 26 (21 – 35) |
| | | 0,15 | 0,95 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0055 | 85 (69 – 110) |
| S3 | E | 0,15 | 0,95 | 0,070 | 0,080 | 0,10 | 0,12 | 0,13 | 25 (19 – 30) |
| | | 0,15 | 0,95 | 0,0028 | 0,0032 | 0,0040 | 0,0048 | 0,0050 | 80 (63 – 98) |
| S11 | E | 0,30 | 0,95 | 0,055 | 0,065 | 0,080 | 0,090 | 0,10 | 65 (52 – 88) |
| | | 0,30 | 0,95 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 0,0040 | 215 (180 – 280) |
| S12 | E | 0,30 | 0,95 | 0,055 | 0,065 | 0,080 | 0,090 | 0,10 | 50 (40 – 68) |
| | | 0,30 | 0,95 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 0,0040 | 165 (140 – 220) |
| S13 | E | 0,30 | 0,95 | 0,048 | 0,055 | 0,070 | 0,080 | 0,090 | 41 (32 – 54) |
| | | 0,30 | 0,95 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 0,0036 | 135 (110 – 170) |
| H5 | M/A | 0,050 | 0,95 | 0,090 | 0,10 | 0,13 | 0,15 | 0,17 | 70 (56 – 83) |
| | | 0,050 | 0,95 | 0,0036 | 0,0040 | 0,0050 | 0,0060 | 0,0065 | 230 (190 – 270) |
| H8 | M/A | 0,050 | 0,95 | 0,070 | 0,080 | 0,10 | 0,11 | 0,13 | 70 (58 – 86) |
| | | 0,050 | 0,95 | 0,0028 | 0,0032 | 0,0040 | 0,0044 | 0,0050 | 230 (200 – 280) |
| H21 | M/A | 0,050 | 0,95 | 0,070 | 0,080 | 0,10 | 0,11 | 0,13 | 70 (58 – 86) |
| | | 0,050 | 0,95 | 0,0028 | 0,0032 | 0,0040 | 0,0044 | 0,0050 | 230 (200 – 280) |
| H31 | M/A | 0,050 | 0,95 | 0,060 | 0,070 | 0,085 | 0,10 | 0,11 | 55 (45 – 67) |
| | | 0,050 | 0,95 | 0,0024 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 180 (150 – 210) |
| TS1 | A/D | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 290 (180 – 400) |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 950 (600 – 1300) |
| TP1 | A/D | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 290 (180 – 400) |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 950 (600 – 1300) |

Schnittdaten – XSE550 – Eckfräsen PCEDC 5 – Zoll

| SMG |  | a _p /DC | | f _z | | | | | v _c | |
|-----|---|--------------------|------|----------------|--------|--------|--------|--------|--------------------|-------------------------------|
| | | | | 3/8 | 1/2 | 5/8 | 3/4 | 1 | | |
| P1 | E/M/A/D | 0,30 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 0,15 | 200 (180 – 220) | Unversell |
| | | 0,30 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0060 | 660 (600 – 720) | |
| P2 | E/M/A/D | 0,30 | 0,95 | 0,080 | 0,095 | 0,12 | 0,14 | 0,16 | 195 (170 – 220) | Stahl und Guss |
| | | 0,30 | 0,95 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0065 | 640 (560 – 720) | |
| P3 | E/M/A/D | 0,30 | 0,95 | 0,075 | 0,090 | 0,11 | 0,13 | 0,15 | 170 (150 – 190) | Stahl und Guss |
| | | 0,30 | 0,95 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 560 (500 – 620) | |
| P4 | E/M/A/D | 0,30 | 0,95 | 0,075 | 0,090 | 0,11 | 0,13 | 0,14 | 150 (130 – 170) | Stahl und Guss |
| | | 0,30 | 0,95 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0055 | 490 (430 – 550) | |
| P5 | E/M/A/D | 0,30 | 0,95 | 0,075 | 0,090 | 0,11 | 0,13 | 0,14 | 145 (130 – 160) | Stahl und Guss |
| | | 0,30 | 0,95 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0055 | 475 (430 – 520) | |
| P6 | E/M/A/D | 0,30 | 0,95 | 0,075 | 0,085 | 0,11 | 0,12 | 0,14 | 160 (140 – 180) | Stahl und Guss |
| | | 0,30 | 0,95 | 0,0030 | 0,0034 | 0,0044 | 0,0048 | 0,0055 | 520 (460 – 590) | |
| P7 | E/M/A/D | 0,30 | 0,95 | 0,075 | 0,085 | 0,11 | 0,12 | 0,14 | 150 (130 – 170) | Rostfrei und ISO-S-Werkstoffe |
| | | 0,30 | 0,95 | 0,0030 | 0,0034 | 0,0044 | 0,0048 | 0,0055 | 490 (430 – 550) | |
| P8 | E/M/A/D | 0,30 | 0,95 | 0,075 | 0,090 | 0,11 | 0,13 | 0,15 | 145 (130 – 160) | Rostfrei und ISO-S-Werkstoffe |
| | | 0,30 | 0,95 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 475 (430 – 520) | |
| P11 | E/M/A/D | 0,20 | 0,95 | 0,060 | 0,070 | 0,090 | 0,10 | 0,12 | 100 (89 – 110) | Rostfrei und ISO-S-Werkstoffe |
| | | 0,20 | 0,95 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0048 | 330 (300 – 360) | |
| P12 | E/M/A/D | 0,20 | 0,95 | 0,042 | 0,050 | 0,060 | 0,070 | 0,080 | 65 (56 – 71) | Rostfrei und ISO-S-Werkstoffe |
| | | 0,20 | 0,95 | 0,0017 | 0,0020 | 0,0024 | 0,0028 | 0,0032 | 215 (190 – 230) | |
| M1 | E/M/A | 0,20 | 0,95 | 0,070 | 0,080 | 0,10 | 0,12 | 0,13 | 115 (110 – 120) | NE-Metalle |
| | | 0,20 | 0,95 | 0,0028 | 0,0032 | 0,0040 | 0,0048 | 0,0050 | 375 (370 – 390) | |
| M2 | E/M/A | 0,20 | 0,95 | 0,060 | 0,075 | 0,090 | 0,10 | 0,12 | 95 (84 – 100) | NE-Metalle |
| | | 0,20 | 0,95 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 0,0048 | 310 (280 – 320) | |
| M3 | E/M/A | 0,20 | 0,95 | 0,060 | 0,075 | 0,090 | 0,10 | 0,12 | 60 (47 – 69) | NE-Metalle |
| | | 0,20 | 0,95 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 0,0048 | 195 (160 – 220) | |
| M4 | E/M/A | 0,20 | 0,95 | 0,055 | 0,065 | 0,080 | 0,090 | 0,10 | 44 (36 – 53) | NE-Metalle |
| | | 0,20 | 0,95 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 0,0040 | 145 (120 – 170) | |
| M5 | E/M/A | 0,20 | 0,95 | 0,055 | 0,065 | 0,080 | 0,090 | 0,10 | 37 (30 – 44) | NE-Metalle |
| | | 0,20 | 0,95 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 0,0040 | 120 (99 – 140) | |
| K1 | E/M/A/D | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 165 (160 – 190) | Harter |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 540 (530 – 620) | |
| K2 | E/M/A/D | 0,30 | 0,95 | 0,060 | 0,070 | 0,085 | 0,10 | 0,11 | 145 (140 – 170) | Harter |
| | | 0,30 | 0,95 | 0,0024 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 475 (460 – 550) | |
| K3 | E/M/A/D | 0,30 | 0,95 | 0,060 | 0,070 | 0,085 | 0,10 | 0,11 | 125 (120 – 140) | Harter |
| | | 0,30 | 0,95 | 0,0024 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 410 (400 – 450) | |
| K4 | E/M/A/D | 0,30 | 0,95 | 0,060 | 0,070 | 0,085 | 0,10 | 0,11 | 120 (110 – 140) | Kunststoffe und Composite |
| | | 0,30 | 0,95 | 0,0024 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 395 (370 – 450) | |
| K5 | E/M/A/D | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 155 (140 – 170) | Kunststoffe und Composite |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 510 (460 – 550) | |
| K6 | E/M/A/D | 0,30 | 0,95 | 0,070 | 0,085 | 0,11 | 0,12 | 0,14 | 225 (200 – 250) | Kunststoffe und Composite |
| | | 0,30 | 0,95 | 0,0028 | 0,0034 | 0,0044 | 0,0048 | 0,0055 | 740 (660 – 820) | |
| K7 | E/M/A/D | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 200 (170 – 220) | Kunststoffe und Composite |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 660 (560 – 720) | |
| N1 | E/M/A | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 690 (580 – 800) | Graphit |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 2275 (2000 – 2600) | |
| N2 | E/M/A | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 445 (380 – 520) | Graphit |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 1450 (1300 – 1700) | |
| N3 | E/M/A | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 300 (250 – 340) | Graphit |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 980 (830 – 1100) | |
| N11 | E/M/A | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 345 (290 – 400) | Graphit |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 1125 (960 – 1300) | |
| S1 | E | 0,15 | 0,95 | 0,075 | 0,090 | 0,11 | 0,13 | 0,14 | 44 (27 – 61) | X-Heads |
| | | 0,15 | 0,95 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0055 | 145 (89 – 200) | |
| S2 | E | 0,15 | 0,95 | 0,075 | 0,090 | 0,11 | 0,13 | 0,14 | 35 (22 – 49) | X-Heads |
| | | 0,15 | 0,95 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0055 | 115 (73 – 160) | |
| S3 | E | 0,15 | 0,95 | 0,070 | 0,080 | 0,10 | 0,12 | 0,13 | 31 (19 – 43) | X-Heads |
| | | 0,15 | 0,95 | 0,0028 | 0,0032 | 0,0040 | 0,0048 | 0,0050 | 100 (63 – 140) | |
| S11 | E | 0,30 | 0,95 | 0,055 | 0,065 | 0,080 | 0,090 | 0,10 | 105 (75 – 130) | X-Heads |
| | | 0,30 | 0,95 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 0,0040 | 345 (250 – 420) | |
| S12 | E | 0,30 | 0,95 | 0,055 | 0,065 | 0,080 | 0,090 | 0,10 | 80 (58 – 100) | X-Heads |
| | | 0,30 | 0,95 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 0,0040 | 260 (200 – 320) | |
| S13 | E | 0,30 | 0,95 | 0,048 | 0,055 | 0,070 | 0,080 | 0,090 | 65 (46 – 81) | X-Heads |
| | | 0,30 | 0,95 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 0,0036 | 215 (160 – 260) | |
| H5 | M/A | 0,050 | 0,95 | 0,090 | 0,10 | 0,13 | 0,15 | 0,17 | 70 (56 – 83) | Minimaster Plus |
| | | 0,050 | 0,95 | 0,0036 | 0,0040 | 0,0050 | 0,0060 | 0,0065 | 230 (190 – 270) | |
| H8 | M/A | 0,050 | 0,95 | 0,070 | 0,080 | 0,10 | 0,11 | 0,13 | 70 (58 – 86) | Minimaster Plus |
| | | 0,050 | 0,95 | 0,0028 | 0,0032 | 0,0040 | 0,0044 | 0,0050 | 230 (200 – 280) | |
| H21 | M/A | 0,050 | 0,95 | 0,070 | 0,080 | 0,10 | 0,11 | 0,13 | 70 (58 – 86) | Minimaster Plus |
| | | 0,050 | 0,95 | 0,0028 | 0,0032 | 0,0040 | 0,0044 | 0,0050 | 230 (200 – 280) | |
| H31 | M/A | 0,050 | 0,95 | 0,060 | 0,070 | 0,085 | 0,10 | 0,11 | 55 (45 – 67) | Minimaster Plus |
| | | 0,050 | 0,95 | 0,0024 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 180 (150 – 210) | |
| TS1 | A/D | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 290 (180 – 400) | Minimaster |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 950 (600 – 1300) | |
| TP1 | A/D | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 290 (180 – 400) | Minimaster |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 950 (600 – 1300) | |
| GR1 | A/D | 0,30 | 0,95 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 690 (580 – 800) | Minimaster |
| | | 0,30 | 0,95 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 2275 (2000 – 2600) | |

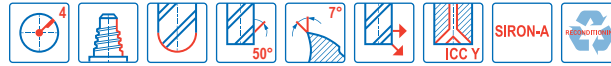
XSB540

Hochleistungsfräser – Universell – Kugelkopf – 4 Schneiden – ICC



D

- Toleranzen:
- DC= e8
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø12 ist mm



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | CSP | CZCMS | DC | DCSFMS | APMXS | LF | PCEDC | SW | Beschichtung |
|--------------------|--------------------|------------------|-------------------|-----|-------|------|--------|-------|------|-------|----|--------------|
| | | | | | | mm | mm | mm | mm | | | SIRA |
| XSB540E10100D1BZ4A | 10138334 | 1 | D | ✓ | E10 | 10,0 | 9,7 | 5,5 | 12,3 | 4 | 8 | ■ |
| XSB540E12120D1BZ4A | 10138335 | 1 | D | ✓ | E12 | 12,0 | 11,7 | 6,6 | 14,4 | 4 | 10 | ■ |
| XSB540E16160D1BZ4A | 10138336 | 1 | D | ✓ | E16 | 16,0 | 15,5 | 8,8 | 18,6 | 4 | 12 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite


Graphit

X-Heads

Minimaster Plus

Minimaster

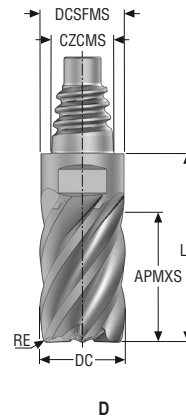
Schnittdaten – XSB540 Kopierfräsen/Schruppen

| SMG |  | a _d /DC | a _p /DC | f _z | | | v _c |
|-----|---|--------------------|--------------------|----------------|---------|--------|--------------------|
| | | | | 10 | 12 | 16 | |
| P1 | E/M/A/D | 0,10 | 0,50 | 0,055 | 0,065 | 0,080 | 210 (190 – 240) |
| | | 0,10 | 0,50 | 0,0022 | 0,0026 | 0,0032 | 690 (630 – 780) |
| P2 | E/M/A/D | 0,10 | 0,50 | 0,055 | 0,065 | 0,080 | 205 (180 – 230) |
| | | 0,10 | 0,50 | 0,0022 | 0,0026 | 0,0032 | 670 (600 – 750) |
| P3 | E/M/A/D | 0,10 | 0,50 | 0,050 | 0,060 | 0,075 | 180 (160 – 200) |
| | | 0,10 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 590 (530 – 650) |
| P4 | E/M/A/D | 0,10 | 0,50 | 0,050 | 0,060 | 0,075 | 155 (140 – 170) |
| | | 0,10 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 510 (460 – 550) |
| P5 | E/M/A/D | 0,10 | 0,50 | 0,050 | 0,060 | 0,075 | 150 (130 – 170) |
| | | 0,10 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 490 (430 – 550) |
| P6 | E/M/A/D | 0,10 | 0,50 | 0,050 | 0,060 | 0,075 | 170 (150 – 190) |
| | | 0,10 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 560 (500 – 620) |
| P7 | E/M/A/D | 0,10 | 0,50 | 0,050 | 0,060 | 0,075 | 160 (140 – 180) |
| | | 0,10 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 520 (460 – 590) |
| P8 | E/M/A/D | 0,10 | 0,50 | 0,050 | 0,060 | 0,075 | 150 (130 – 170) |
| | | 0,10 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 490 (430 – 550) |
| P11 | E/M/A/D | 0,10 | 0,50 | 0,070 | 0,085 | 0,11 | 190 (160 – 220) |
| | | 0,10 | 0,50 | 0,0028 | 0,0034 | 0,0044 | 620 (530 – 720) |
| P12 | E/M/A/D | 0,10 | 0,50 | 0,050 | 0,060 | 0,075 | 115 (97 – 130) |
| | | 0,10 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 375 (320 – 420) |
| M1 | E/M/A | 0,10 | 0,50 | 0,055 | 0,065 | 0,080 | 145 (120 – 170) |
| | | 0,10 | 0,50 | 0,0022 | 0,0026 | 0,0032 | 475 (400 – 550) |
| M2 | E/M/A | 0,10 | 0,50 | 0,050 | 0,060 | 0,075 | 115 (97 – 130) |
| | | 0,10 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 375 (320 – 420) |
| M3 | E/M/A | 0,10 | 0,50 | 0,040 | 0,048 | 0,060 | 95 (75 – 110) |
| | | 0,10 | 0,50 | 0,0016 | 0,0019 | 0,0024 | 310 (250 – 360) |
| M4 | E/M/A | 0,10 | 0,50 | 0,036 | 0,042 | 0,050 | 75 (57 – 88) |
| | | 0,10 | 0,50 | 0,0014 | 0,0017 | 0,0020 | 245 (190 – 280) |
| M5 | E/M/A | 0,10 | 0,50 | 0,036 | 0,042 | 0,050 | 60 (48 – 74) |
| | | 0,10 | 0,50 | 0,0014 | 0,0017 | 0,0020 | 195 (160 – 240) |
| K1 | E/M/A/D | 0,15 | 0,50 | 0,040 | 0,048 | 0,060 | 205 (190 – 220) |
| | | 0,15 | 0,50 | 0,0016 | 0,0019 | 0,0024 | 670 (630 – 720) |
| K2 | E/M/A/D | 0,15 | 0,50 | 0,036 | 0,044 | 0,055 | 180 (160 – 190) |
| | | 0,15 | 0,50 | 0,0014 | 0,0017 | 0,0022 | 590 (530 – 620) |
| K3 | E/M/A/D | 0,15 | 0,50 | 0,036 | 0,044 | 0,055 | 150 (140 – 160) |
| | | 0,15 | 0,50 | 0,0014 | 0,0017 | 0,0022 | 490 (460 – 520) |
| K4 | E/M/A/D | 0,10 | 0,50 | 0,040 | 0,048 | 0,060 | 170 (150 – 190) |
| | | 0,10 | 0,50 | 0,0016 | 0,0019 | 0,0024 | 560 (500 – 620) |
| K5 | E/M/A/D | 0,10 | 0,50 | 0,036 | 0,042 | 0,055 | 105 (90 – 110) |
| | | 0,10 | 0,50 | 0,0014 | 0,0017 | 0,0022 | 345 (300 – 360) |
| K6 | E/M/A/D | 0,10 | 0,50 | 0,040 | 0,048 | 0,060 | 150 (140 – 160) |
| | | 0,10 | 0,50 | 0,0016 | 0,0019 | 0,0024 | 490 (460 – 520) |
| K7 | E/M/A/D | 0,10 | 0,50 | 0,036 | 0,042 | 0,055 | 130 (120 – 140) |
| | | 0,10 | 0,50 | 0,0014 | 0,0017 | 0,0022 | 425 (400 – 450) |
| N1 | E/M/A | 0,20 | 0,50 | 0,070 | 0,085 | 0,10 | 640 (540 – 740) |
| | | 0,20 | 0,50 | 0,0028 | 0,0034 | 0,0040 | 2100 (1800 – 2400) |
| N2 | E/M/A | 0,20 | 0,50 | 0,070 | 0,085 | 0,10 | 415 (350 – 480) |
| | | 0,20 | 0,50 | 0,0028 | 0,0034 | 0,0040 | 1350 (1200 – 1500) |
| N3 | E/M/A | 0,20 | 0,50 | 0,070 | 0,085 | 0,10 | 275 (230 – 320) |
| | | 0,20 | 0,50 | 0,0028 | 0,0034 | 0,0040 | 900 (760 – 1000) |
| N11 | E/M/A | 0,15 | 0,50 | 0,070 | 0,085 | 0,10 | 430 (380 – 480) |
| | | 0,15 | 0,50 | 0,0028 | 0,0034 | 0,0040 | 1400 (1300 – 1500) |
| S1 | E | 0,10 | 0,50 | 0,050 | 0,060 | 0,075 | 65 (54 – 74) |
| | | 0,10 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 215 (180 – 240) |
| S2 | E | 0,10 | 0,50 | 0,050 | 0,060 | 0,075 | 65 (59 – 75) |
| | | 0,10 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 215 (200 – 240) |
| S3 | E | 0,10 | 0,50 | 0,020 | 0,024 | 0,030 | 32 (22 – 42) |
| | | 0,10 | 0,50 | 0,00080 | 0,00095 | 0,0012 | 105 (73 – 130) |
| S11 | E | 0,15 | 0,50 | 0,050 | 0,060 | 0,075 | 110 (98 – 120) |
| | | 0,15 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 360 (330 – 390) |
| S12 | E | 0,15 | 0,50 | 0,050 | 0,060 | 0,075 | 85 (75 – 96) |
| | | 0,15 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 280 (250 – 310) |
| S13 | E | 0,15 | 0,50 | 0,044 | 0,050 | 0,065 | 65 (59 – 75) |
| | | 0,15 | 0,50 | 0,0017 | 0,0020 | 0,0026 | 215 (200 – 240) |
| H5 | M/A | 0,030 | 0,44 | 0,050 | 0,060 | 0,075 | 135 (120 – 150) |
| | | 0,030 | 0,44 | 0,0020 | 0,0024 | 0,0030 | 445 (400 – 490) |
| H8 | M/A | 0,030 | 0,44 | 0,038 | 0,046 | 0,055 | 135 (120 – 150) |
| | | 0,030 | 0,44 | 0,0015 | 0,0018 | 0,0022 | 445 (400 – 490) |
| H21 | M/A | 0,030 | 0,44 | 0,038 | 0,046 | 0,055 | 135 (120 – 150) |
| | | 0,030 | 0,44 | 0,0015 | 0,0018 | 0,0022 | 445 (400 – 490) |
| H31 | M/A | 0,030 | 0,44 | 0,034 | 0,040 | 0,048 | 100 (86 – 110) |
| | | 0,030 | 0,44 | 0,0013 | 0,0016 | 0,0019 | 330 (290 – 360) |
| TS1 | A/D | 0,15 | 0,50 | 0,10 | 0,12 | 0,15 | 270 (170 – 370) |
| | | 0,15 | 0,50 | 0,0040 | 0,0048 | 0,0060 | 890 (560 – 1200) |
| TP1 | A/D | 0,15 | 0,50 | 0,10 | 0,12 | 0,15 | 270 (170 – 370) |
| | | 0,15 | 0,50 | 0,0040 | 0,0048 | 0,0060 | 890 (560 – 1200) |
| GR1 | A/D | 0,15 | 0,50 | 0,10 | 0,12 | 0,15 | 640 (540 – 740) |
| | | 0,15 | 0,50 | 0,0040 | 0,0048 | 0,0060 | 2100 (1800 – 2400) |

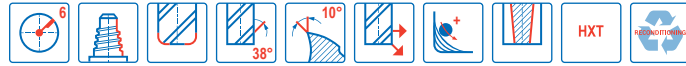
Unversell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

XSE720

Hochleistungsfräser – Superlegierung – Eckfräser – 6 Schneiden – Eckenradius



- Toleranzen:
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø12 ist mm

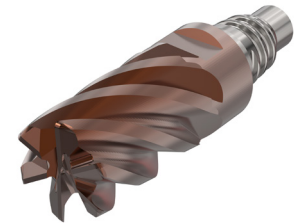
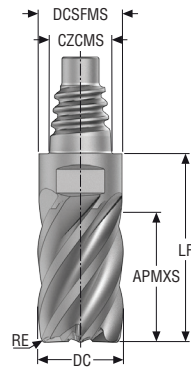


| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | CZCMS | DC | DCSFMS | APMXS | LF | RE | PCEDC | SW | Beschichtung |
|----------------------|----------------|--------------|---------------|-------|------|--------|-------|------|-----|-------|----|--------------|
| | | | | | mm | mm | mm | mm | mm | | | HXT |
| XSE720E10100D3R050Z6 | 10138187 | 3 | D | E10 | 10,0 | 9,7 | 15,0 | 21,8 | 0,5 | 6 | 8 | ■ |
| XSE720E10100D3R100Z6 | 10138188 | 3 | D | E10 | 10,0 | 9,7 | 15,0 | 21,8 | 1,0 | 6 | 8 | ■ |
| XSE720E12120D3R050Z6 | 10138189 | 3 | D | E12 | 12,0 | 11,7 | 18,0 | 25,9 | 0,5 | 6 | 10 | ■ |
| XSE720E12120D3R100Z6 | 10138190 | 3 | D | E12 | 12,0 | 11,7 | 18,0 | 25,9 | 1,0 | 6 | 10 | ■ |
| XSE720E12120D3R200Z6 | 10138191 | 3 | D | E12 | 12,0 | 11,7 | 18,0 | 25,9 | 2,0 | 6 | 10 | ■ |
| XSE720E12120D3R300Z6 | 10138192 | 3 | D | E12 | 12,0 | 11,7 | 18,0 | 25,9 | 3,0 | 6 | 10 | ■ |
| XSE720E16160D3R050Z6 | 10138193 | 3 | D | E16 | 16,0 | 15,5 | 24,0 | 34,1 | 0,5 | 6 | 12 | ■ |
| XSE720E16160D3R100Z6 | 10138194 | 3 | D | E16 | 16,0 | 15,5 | 24,0 | 34,1 | 1,0 | 6 | 12 | ■ |
| XSE720E16160D3R200Z6 | 10138195 | 3 | D | E16 | 16,0 | 15,5 | 24,0 | 34,1 | 2,0 | 6 | 12 | ■ |
| XSE720E16160D3R300Z6 | 10138196 | 3 | D | E16 | 16,0 | 15,5 | 24,0 | 34,1 | 3,0 | 6 | 12 | ■ |
| XSE720E20200D3R050Z6 | 10138197 | 3 | D | E20 | 20,0 | 19,3 | 30,0 | 40,2 | 0,5 | 6 | 16 | ■ |
| XSE720E20200D3R100Z6 | 10138198 | 3 | D | E20 | 20,0 | 19,3 | 30,0 | 40,2 | 1,0 | 6 | 16 | ■ |
| XSE720E20200D3R200Z6 | 10138199 | 3 | D | E20 | 20,0 | 19,3 | 30,0 | 40,2 | 2,0 | 6 | 16 | ■ |
| XSE720E20200D3R300Z6 | 10138200 | 3 | D | E20 | 20,0 | 19,3 | 30,0 | 40,2 | 3,0 | 6 | 16 | ■ |
| XSE720E25250D3R200Z6 | 10138201 | 3 | D | E25 | 25,0 | 24,2 | 37,5 | 49,5 | 2,0 | 6 | 20 | ■ |
| XSE720E25250D3R300Z6 | 10138202 | 3 | D | E25 | 25,0 | 24,2 | 37,5 | 49,5 | 3,0 | 6 | 20 | ■ |
| XSE720E25250D3R400Z6 | 10138203 | 3 | D | E25 | 25,0 | 24,2 | 37,5 | 49,5 | 4,0 | 6 | 20 | ■ |

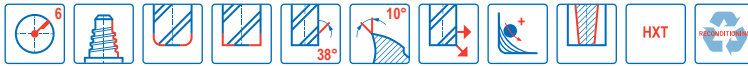
■ Lagerstandard.

XSE720

Hochleistungsfräser – Superlegierung – Eckfräser – 6 Schneiden – Eckenradius oder scharf – Zoll



D



- Toleranzen:
- DC= e7
- RE= ±.0008 Zoll
- Nachschleifen möglich, wenn DC ≥ Ø.500 ist Zoll

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | CZCMS | DC | DCSFMS | APMXS | LF | RE | PCEDC | SW | Beschichtung |
|-----------------------|----------------|--------------|---------------|-------|-------|--------|-------|-------|-------|-------|----|--------------|
| | | | | | | | | | | | | HXT |
| XSE720E10.375D3SZ6 | 10138204 | 3 | D | E10 | 0.375 | 0.364 | 0.563 | 0.827 | – | 6 | 8 | ■ |
| XSE720E12.500D3SZ6 | 10138205 | 3 | D | E12 | 0.500 | 0.484 | 0.750 | 1.055 | – | 6 | 10 | ■ |
| XSE720E16.625D3SZ6 | 10138206 | 3 | D | E16 | 0.625 | 0.610 | 0.938 | 1.343 | – | 6 | 12 | ■ |
| XSE720E20.750D3SZ6 | 10138207 | 3 | D | E20 | 0.750 | 0.728 | 1.125 | 1.524 | – | 6 | 16 | ■ |
| XSE720E25.00D3SZ6 | 10138208 | 3 | D | E25 | 1.000 | 0.965 | 1.500 | 1.980 | – | 6 | 20 | ■ |
| XSE720E10.375D3R030Z6 | 10138209 | 3 | D | E10 | 0.375 | 0.364 | 0.563 | 0.827 | 0.030 | 6 | 8 | ■ |
| XSE720E12.500D3R030Z6 | 10138210 | 3 | D | E12 | 0.500 | 0.484 | 0.750 | 1.055 | 0.030 | 6 | 10 | ■ |
| XSE720E12.500D3R060Z6 | 10138211 | 3 | D | E12 | 0.500 | 0.484 | 0.750 | 1.055 | 0.060 | 6 | 10 | ■ |
| XSE720E12.500D3R120Z6 | 10138212 | 3 | D | E12 | 0.500 | 0.484 | 0.750 | 1.055 | 0.120 | 6 | 10 | ■ |
| XSE720E16.625D3R030Z6 | 10138213 | 3 | D | E16 | 0.625 | 0.610 | 0.938 | 1.343 | 0.030 | 6 | 12 | ■ |
| XSE720E16.625D3R060Z6 | 10138214 | 3 | D | E16 | 0.625 | 0.610 | 0.938 | 1.343 | 0.060 | 6 | 12 | ■ |
| XSE720E16.625D3R120Z6 | 10138215 | 3 | D | E16 | 0.625 | 0.610 | 0.938 | 1.343 | 0.120 | 6 | 12 | ■ |
| XSE720E20.750D3R030Z6 | 10138216 | 3 | D | E20 | 0.750 | 0.728 | 1.125 | 1.524 | 0.030 | 6 | 16 | ■ |
| XSE720E20.750D3R060Z6 | 10138217 | 3 | D | E20 | 0.750 | 0.728 | 1.125 | 1.524 | 0.060 | 6 | 16 | ■ |
| XSE720E20.750D3R120Z6 | 10138218 | 3 | D | E20 | 0.750 | 0.728 | 1.125 | 1.524 | 0.120 | 6 | 16 | ■ |
| XSE720E25.00D3R030Z6 | 10138219 | 3 | D | E25 | 1.000 | 0.965 | 1.500 | 1.980 | 0.030 | 6 | 20 | ■ |
| XSE720E25.00D3R060Z6 | 10138220 | 3 | D | E25 | 1.000 | 0.965 | 1.500 | 1.980 | 0.060 | 6 | 20 | ■ |
| XSE720E25.00D3R120Z6 | 10138221 | 3 | D | E25 | 1.000 | 0.965 | 1.500 | 1.980 | 0.120 | 6 | 20 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus


Minimaster

Schnittdaten – XSE720 Eckfräsen

| SMG | | a _e /DC | a _p /DC | f _z | | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|--------|--------|--------|--------|-----------------|
| | | | | 10 | 12 | 16 | 20 | 25 | |
| P1 | E/M/A/D | 0,12 | 1,4 | 0,080 | 0,095 | 0,12 | 0,13 | 0,15 | 230 (180 – 280) |
| | | 0,12 | 1,4 | 0,0032 | 0,0038 | 0,0048 | 0,0050 | 0,0060 | 750 (600 – 910) |
| P2 | E/M/A/D | 0,12 | 1,4 | 0,080 | 0,095 | 0,12 | 0,14 | 0,15 | 220 (170 – 270) |
| | | 0,12 | 1,4 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0060 | 720 (560 – 880) |
| P3 | E/M/A/D | 0,12 | 1,4 | 0,075 | 0,090 | 0,11 | 0,13 | 0,15 | 195 (150 – 230) |
| | | 0,12 | 1,4 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 640 (500 – 750) |
| P4 | E/M/A/D | 0,12 | 1,4 | 0,075 | 0,090 | 0,11 | 0,13 | 0,14 | 170 (130 – 200) |
| | | 0,12 | 1,4 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0055 | 560 (430 – 650) |
| P5 | E/M/A/D | 0,12 | 1,4 | 0,060 | 0,070 | 0,090 | 0,10 | 0,11 | 130 (100 – 160) |
| | | 0,12 | 1,4 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0044 | 425 (330 – 520) |
| P6 | E/M/A/D | 0,12 | 1,4 | 0,060 | 0,070 | 0,085 | 0,10 | 0,11 | 145 (120 – 190) |
| | | 0,12 | 1,4 | 0,0024 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 475 (400 – 620) |
| P7 | E/M/A/D | 0,12 | 1,4 | 0,060 | 0,070 | 0,085 | 0,10 | 0,11 | 140 (110 – 180) |
| | | 0,12 | 1,4 | 0,0024 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 460 (370 – 590) |
| P8 | E/M/A/D | 0,12 | 1,4 | 0,060 | 0,075 | 0,090 | 0,11 | 0,12 | 130 (100 – 160) |
| | | 0,12 | 1,4 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 0,0048 | 425 (330 – 520) |
| P11 | E/M/A/D | 0,12 | 1,4 | 0,070 | 0,080 | 0,10 | 0,12 | 0,13 | 130 (110 – 170) |
| | | 0,12 | 1,4 | 0,0028 | 0,0032 | 0,0040 | 0,0048 | 0,0050 | 425 (370 – 550) |
| P12 | E/M/A/D | 0,12 | 1,4 | 0,048 | 0,055 | 0,070 | 0,080 | 0,090 | 95 (80 – 100) |
| | | 0,12 | 1,4 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 0,0036 | 310 (270 – 320) |
| M1 | E/M/A | 0,12 | 1,4 | 0,075 | 0,090 | 0,11 | 0,13 | 0,15 | 170 (150 – 190) |
| | | 0,12 | 1,4 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 560 (500 – 620) |
| M2 | E/M/A | 0,12 | 1,4 | 0,070 | 0,085 | 0,10 | 0,12 | 0,13 | 140 (120 – 150) |
| | | 0,12 | 1,4 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 460 (400 – 490) |
| M3 | E/M/A | 0,10 | 1,4 | 0,060 | 0,075 | 0,090 | 0,10 | 0,12 | 120 (100 – 130) |
| | | 0,10 | 1,4 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 0,0048 | 395 (330 – 420) |
| M4 | E/M/A | 0,10 | 1,4 | 0,055 | 0,065 | 0,080 | 0,090 | 0,10 | 90 (77 – 100) |
| | | 0,10 | 1,4 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 0,0040 | 295 (260 – 320) |
| M5 | E/M/A | 0,10 | 1,4 | 0,055 | 0,065 | 0,080 | 0,090 | 0,10 | 75 (64 – 88) |
| | | 0,10 | 1,4 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 0,0040 | 245 (210 – 280) |
| S1 | E | 0,060 | 1,4 | 0,046 | 0,055 | 0,070 | 0,080 | 0,090 | 45 (35 – 54) |
| | | 0,060 | 1,4 | 0,0018 | 0,0022 | 0,0028 | 0,0032 | 0,0036 | 150 (120 – 170) |
| S2 | E | 0,060 | 1,4 | 0,042 | 0,050 | 0,065 | 0,075 | 0,080 | 35 (25 – 44) |
| | | 0,060 | 1,4 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 0,0032 | 115 (83 – 140) |
| S3 | E | 0,060 | 1,4 | 0,042 | 0,050 | 0,065 | 0,075 | 0,080 | 30 (20 – 39) |
| | | 0,060 | 1,4 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 0,0032 | 100 (66 – 120) |
| S11 | E | 0,10 | 1,4 | 0,060 | 0,070 | 0,090 | 0,10 | 0,11 | 105 (78 – 120) |
| | | 0,10 | 1,4 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0044 | 345 (260 – 390) |
| S12 | E | 0,10 | 1,4 | 0,060 | 0,070 | 0,090 | 0,10 | 0,11 | 80 (60 – 99) |
| | | 0,10 | 1,4 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0044 | 260 (200 – 320) |
| S13 | E | 0,10 | 1,4 | 0,050 | 0,060 | 0,075 | 0,090 | 0,10 | 65 (48 – 79) |
| | | 0,10 | 1,4 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 215 (160 – 250) |

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – XSE720 dynamisches Fräsen

| SMG |  | a _p /DC | f _z | | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------|-----------------|
| | | | 10 | 12 | 16 | 20 | 25 | |
| P1 | E/M/A/D | 1,4 | 0,10 | 0,12 | 0,15 | 0,17 | 0,19 | 245 (190 – 300) |
| | | 1,4 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 800 (630 – 980) |
| P2 | E/M/A/D | 1,4 | 0,10 | 0,12 | 0,15 | 0,18 | 0,20 | 240 (190 – 290) |
| | | 1,4 | 0,0040 | 0,0048 | 0,0060 | 0,0070 | 0,0080 | 790 (630 – 950) |
| P3 | E/M/A/D | 1,4 | 0,10 | 0,12 | 0,14 | 0,17 | 0,19 | 205 (160 – 250) |
| | | 1,4 | 0,0040 | 0,0048 | 0,0055 | 0,0065 | 0,0075 | 670 (530 – 820) |
| P4 | E/M/A/D | 1,4 | 0,095 | 0,11 | 0,14 | 0,16 | 0,18 | 185 (140 – 220) |
| | | 1,4 | 0,0038 | 0,0044 | 0,0055 | 0,0065 | 0,0070 | 610 (460 – 720) |
| P5 | E/M/A/D | 1,4 | 0,075 | 0,090 | 0,11 | 0,13 | 0,15 | 140 (110 – 180) |
| | | 1,4 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 460 (370 – 590) |
| P6 | E/M/A/D | 1,4 | 0,075 | 0,090 | 0,11 | 0,13 | 0,15 | 155 (130 – 200) |
| | | 1,4 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 510 (430 – 650) |
| P7 | E/M/A/D | 1,4 | 0,075 | 0,090 | 0,11 | 0,13 | 0,15 | 150 (120 – 190) |
| | | 1,4 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 490 (400 – 620) |
| P8 | E/M/A/D | 1,4 | 0,080 | 0,095 | 0,12 | 0,14 | 0,15 | 140 (110 – 180) |
| | | 1,4 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0060 | 460 (370 – 590) |
| P11 | E/M/A/D | 1,4 | 0,090 | 0,11 | 0,13 | 0,15 | 0,17 | 140 (110 – 180) |
| | | 1,4 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 460 (370 – 590) |
| P12 | E/M/A/D | 1,4 | 0,060 | 0,070 | 0,090 | 0,10 | 0,12 | 100 (86 – 110) |
| | | 1,4 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0048 | 330 (290 – 360) |
| M1 | E/M/A | 1,4 | 0,10 | 0,12 | 0,15 | 0,17 | 0,19 | 180 (160 – 200) |
| | | 1,4 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 590 (530 – 650) |
| M2 | E/M/A | 1,4 | 0,090 | 0,11 | 0,13 | 0,15 | 0,17 | 150 (130 – 170) |
| | | 1,4 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 490 (430 – 550) |
| M3 | E/M/A | 1,4 | 0,075 | 0,085 | 0,11 | 0,12 | 0,14 | 125 (110 – 140) |
| | | 1,4 | 0,0030 | 0,0034 | 0,0044 | 0,0048 | 0,0055 | 410 (370 – 450) |
| M4 | E/M/A | 1,4 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 95 (80 – 110) |
| | | 1,4 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 310 (270 – 360) |
| M5 | E/M/A | 1,4 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 80 (67 – 92) |
| | | 1,4 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 260 (220 – 300) |
| S1 | E | 1,4 | 0,044 | 0,050 | 0,065 | 0,075 | 0,085 | 44 (35 – 53) |
| | | 1,4 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 0,0034 | 145 (120 – 170) |
| S2 | E | 1,4 | 0,040 | 0,048 | 0,060 | 0,070 | 0,075 | 34 (25 – 43) |
| | | 1,4 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 0,0030 | 110 (83 – 140) |
| S3 | E | 1,4 | 0,040 | 0,048 | 0,060 | 0,070 | 0,075 | 29 (20 – 39) |
| | | 1,4 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 0,0030 | 95 (66 – 120) |
| S11 | E | 1,4 | 0,070 | 0,085 | 0,10 | 0,12 | 0,14 | 110 (82 – 130) |
| | | 1,4 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0055 | 360 (270 – 420) |
| S12 | E | 1,4 | 0,070 | 0,085 | 0,10 | 0,12 | 0,14 | 85 (63 – 100) |
| | | 1,4 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0055 | 280 (210 – 320) |
| S13 | E | 1,4 | 0,060 | 0,075 | 0,090 | 0,10 | 0,12 | 65 (50 – 83) |
| | | 1,4 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 0,0048 | 215 (170 – 270) |

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte


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 Stahl und Guss
 Stahl und Guss
 Rostfrei und ISO-S-Werkstoffe
 Rostfrei und ISO-S-Werkstoffe
 NE-Metalle
 NE-Metalle
 Harter
 Harter
 Kunststoffe und Composite
 Graphit
 X-Heads
 Minimaster Plus
 Minimaster

Schnittdaten – XSE720 Eckfräsen – Zoll

| SMG | | a _e /DC | a _p /DC | f _z | | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|--------|--------|--------|--------|------------------|
| | | | | 3/8 | 1/2 | 5/8 | 3/4 | 1 | |
| P1 | E/M/A/D | 0,12 | 1,4 | 0,080 | 0,095 | 0,12 | 0,13 | 0,15 | 265 (200 – 320) |
| | | 0,12 | 1,4 | 0,0032 | 0,0038 | 0,0048 | 0,0050 | 0,0060 | 870 (660 – 1000) |
| P2 | E/M/A/D | 0,12 | 1,4 | 0,080 | 0,095 | 0,12 | 0,14 | 0,15 | 255 (200 – 320) |
| | | 0,12 | 1,4 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0060 | 840 (660 – 1000) |
| P3 | E/M/A/D | 0,12 | 1,4 | 0,075 | 0,090 | 0,11 | 0,13 | 0,15 | 225 (170 – 270) |
| | | 0,12 | 1,4 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 740 (560 – 880) |
| P4 | E/M/A/D | 0,12 | 1,4 | 0,075 | 0,090 | 0,11 | 0,13 | 0,14 | 195 (150 – 240) |
| | | 0,12 | 1,4 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0055 | 640 (500 – 780) |
| P5 | E/M/A/D | 0,12 | 1,4 | 0,060 | 0,070 | 0,090 | 0,10 | 0,11 | 160 (120 – 190) |
| | | 0,12 | 1,4 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0044 | 520 (400 – 620) |
| P6 | E/M/A/D | 0,12 | 1,4 | 0,060 | 0,070 | 0,085 | 0,10 | 0,11 | 180 (140 – 220) |
| | | 0,12 | 1,4 | 0,0024 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 590 (460 – 720) |
| P7 | E/M/A/D | 0,12 | 1,4 | 0,060 | 0,070 | 0,085 | 0,10 | 0,11 | 170 (130 – 210) |
| | | 0,12 | 1,4 | 0,0024 | 0,0028 | 0,0034 | 0,0040 | 0,0044 | 560 (430 – 680) |
| P8 | E/M/A/D | 0,12 | 1,4 | 0,060 | 0,075 | 0,090 | 0,11 | 0,12 | 160 (120 – 190) |
| | | 0,12 | 1,4 | 0,0024 | 0,0030 | 0,0036 | 0,0044 | 0,0048 | 520 (400 – 620) |
| P11 | E/M/A/D | 0,12 | 1,4 | 0,070 | 0,080 | 0,10 | 0,12 | 0,13 | 160 (130 – 200) |
| | | 0,12 | 1,4 | 0,0028 | 0,0032 | 0,0040 | 0,0048 | 0,0050 | 520 (430 – 650) |
| P12 | E/M/A/D | 0,12 | 1,4 | 0,048 | 0,055 | 0,070 | 0,080 | 0,090 | 95 (80 – 100) |
| | | 0,12 | 1,4 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 0,0036 | 310 (270 – 320) |
| M1 | E/M/A | 0,12 | 1,4 | 0,075 | 0,090 | 0,11 | 0,13 | 0,15 | 170 (150 – 190) |
| | | 0,12 | 1,4 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 560 (500 – 620) |
| M2 | E/M/A | 0,12 | 1,4 | 0,070 | 0,085 | 0,10 | 0,12 | 0,13 | 140 (120 – 150) |
| | | 0,12 | 1,4 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0050 | 460 (400 – 490) |
| M3 | E/M/A | 0,10 | 1,4 | 0,060 | 0,075 | 0,090 | 0,10 | 0,12 | 120 (100 – 110) |
| | | 0,10 | 1,4 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 0,0048 | 395 (330 – 360) |
| M4 | E/M/A | 0,10 | 1,4 | 0,055 | 0,065 | 0,080 | 0,090 | 0,10 | 90 (77 – 91) |
| | | 0,10 | 1,4 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 0,0040 | 295 (260 – 290) |
| M5 | E/M/A | 0,10 | 1,4 | 0,055 | 0,065 | 0,080 | 0,090 | 0,10 | 75 (64 – 76) |
| | | 0,10 | 1,4 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 0,0040 | 245 (210 – 240) |
| S1 | E | 0,060 | 1,4 | 0,046 | 0,055 | 0,070 | 0,080 | 0,090 | 45 (35 – 54) |
| | | 0,060 | 1,4 | 0,0018 | 0,0022 | 0,0028 | 0,0032 | 0,0036 | 150 (120 – 170) |
| S2 | E | 0,060 | 1,4 | 0,042 | 0,050 | 0,065 | 0,075 | 0,080 | 35 (25 – 44) |
| | | 0,060 | 1,4 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 0,0032 | 115 (83 – 140) |
| S3 | E | 0,060 | 1,4 | 0,042 | 0,050 | 0,065 | 0,075 | 0,080 | 30 (20 – 39) |
| | | 0,060 | 1,4 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 0,0032 | 100 (66 – 120) |
| S11 | E | 0,10 | 1,4 | 0,060 | 0,070 | 0,090 | 0,10 | 0,11 | 105 (78 – 120) |
| | | 0,10 | 1,4 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0044 | 345 (260 – 390) |
| S12 | E | 0,10 | 1,4 | 0,060 | 0,070 | 0,090 | 0,10 | 0,11 | 80 (60 – 99) |
| | | 0,10 | 1,4 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0044 | 260 (200 – 320) |
| S13 | E | 0,10 | 1,4 | 0,050 | 0,060 | 0,075 | 0,090 | 0,10 | 65 (48 – 79) |
| | | 0,10 | 1,4 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 215 (160 – 250) |

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – XSE720 dynamisches Fräsen – Zoll

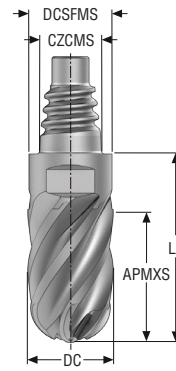
| SMG |  | a _p /DC | f _z | | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------|------------------|
| | | | 3/8 | 1/2 | 5/8 | 3/4 | 1 | |
| P1 | E/M/A/D | 1,4 | 0,10 | 0,12 | 0,15 | 0,17 | 0,19 | 285 (220 – 350) |
| | | 1,4 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 940 (730 – 1100) |
| P2 | E/M/A/D | 1,4 | 0,10 | 0,12 | 0,15 | 0,18 | 0,20 | 275 (210 – 340) |
| | | 1,4 | 0,0040 | 0,0048 | 0,0060 | 0,0070 | 0,0080 | 900 (690 – 1100) |
| P3 | E/M/A/D | 1,4 | 0,10 | 0,12 | 0,14 | 0,17 | 0,19 | 240 (180 – 290) |
| | | 1,4 | 0,0040 | 0,0048 | 0,0055 | 0,0065 | 0,0075 | 790 (600 – 950) |
| P4 | E/M/A/D | 1,4 | 0,095 | 0,11 | 0,14 | 0,16 | 0,18 | 210 (160 – 260) |
| | | 1,4 | 0,0038 | 0,0044 | 0,0055 | 0,0065 | 0,0070 | 690 (530 – 850) |
| P5 | E/M/A/D | 1,4 | 0,075 | 0,090 | 0,11 | 0,13 | 0,15 | 175 (130 – 210) |
| | | 1,4 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 570 (430 – 680) |
| P6 | E/M/A/D | 1,4 | 0,075 | 0,090 | 0,11 | 0,13 | 0,15 | 195 (150 – 240) |
| | | 1,4 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 640 (500 – 780) |
| P7 | E/M/A/D | 1,4 | 0,075 | 0,090 | 0,11 | 0,13 | 0,15 | 185 (140 – 220) |
| | | 1,4 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 610 (460 – 720) |
| P8 | E/M/A/D | 1,4 | 0,080 | 0,095 | 0,12 | 0,14 | 0,15 | 170 (130 – 210) |
| | | 1,4 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 0,0060 | 560 (430 – 680) |
| P11 | E/M/A/D | 1,4 | 0,090 | 0,11 | 0,13 | 0,15 | 0,17 | 170 (130 – 210) |
| | | 1,4 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 560 (430 – 680) |
| P12 | E/M/A/D | 1,4 | 0,060 | 0,070 | 0,090 | 0,10 | 0,12 | 100 (86 – 110) |
| | | 1,4 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 0,0048 | 330 (290 – 360) |
| M1 | E/M/A | 1,4 | 0,10 | 0,12 | 0,15 | 0,17 | 0,19 | 180 (160 – 200) |
| | | 1,4 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 0,0075 | 590 (530 – 650) |
| M2 | E/M/A | 1,4 | 0,090 | 0,11 | 0,13 | 0,15 | 0,17 | 150 (130 – 170) |
| | | 1,4 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 0,0065 | 490 (430 – 550) |
| M3 | E/M/A | 1,4 | 0,075 | 0,085 | 0,11 | 0,12 | 0,14 | 125 (110 – 120) |
| | | 1,4 | 0,0030 | 0,0034 | 0,0044 | 0,0048 | 0,0055 | 410 (370 – 390) |
| M4 | E/M/A | 1,4 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 95 (80 – 95) |
| | | 1,4 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 310 (270 – 310) |
| M5 | E/M/A | 1,4 | 0,065 | 0,075 | 0,095 | 0,11 | 0,12 | 80 (67 – 79) |
| | | 1,4 | 0,0026 | 0,0030 | 0,0038 | 0,0044 | 0,0048 | 260 (220 – 250) |
| S1 | E | 1,4 | 0,044 | 0,050 | 0,065 | 0,075 | 0,085 | 44 (35 – 53) |
| | | 1,4 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 0,0034 | 145 (120 – 170) |
| S2 | E | 1,4 | 0,040 | 0,048 | 0,060 | 0,070 | 0,075 | 34 (25 – 43) |
| | | 1,4 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 0,0030 | 110 (83 – 140) |
| S3 | E | 1,4 | 0,040 | 0,048 | 0,060 | 0,070 | 0,075 | 29 (20 – 39) |
| | | 1,4 | 0,0016 | 0,0019 | 0,0024 | 0,0028 | 0,0030 | 95 (66 – 120) |
| S11 | E | 1,4 | 0,070 | 0,085 | 0,10 | 0,12 | 0,14 | 110 (82 – 130) |
| | | 1,4 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0055 | 360 (270 – 420) |
| S12 | E | 1,4 | 0,070 | 0,085 | 0,10 | 0,12 | 0,14 | 85 (63 – 100) |
| | | 1,4 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 0,0055 | 280 (210 – 320) |
| S13 | E | 1,4 | 0,060 | 0,075 | 0,090 | 0,10 | 0,12 | 65 (50 – 83) |
| | | 1,4 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 0,0048 | 215 (170 – 270) |

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Unversell
 Stahl und Guss
 Stahl und Guss
 Rostfrei und ISO-S-Werkstoffe
 Rostfrei und ISO-S-Werkstoffe
 NE-Metalle
 NE-Metalle
 Harter
 Harter
 Kunststoffe und Composite
 Graphit
 X-Heads
 Minimaster Plus
 Minimaster

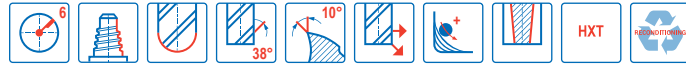
XSB720

Hochleistungsfräser – Superlegierung – Kugelkopf – 6 Schneiden



D

- Toleranzen:
- DC= e7
- RE= ±0,02 mm
- Nachschleifen möglich, wenn DC ≥ Ø12 ist mm



| Bezeichnung | Produktnummer | Längenindex | Werkzeugform | CZCMS | DC | DCSFMS | APMXS | LF | PCEDC | SW | Beschichtung |
|-------------------|---------------|-------------|--------------|-------|------|--------|-------|------|-------|----|--------------|
| | | | | | mm | mm | mm | mm | | | HXT |
| XSB720E10100D3BZ6 | 10138222 | 3 | D | E10 | 10,0 | 9,7 | 15,0 | 21,8 | 6 | 8 | ■ |
| XSB720E12120D3BZ6 | 10138223 | 3 | D | E12 | 12,0 | 11,7 | 18,0 | 25,9 | 6 | 10 | ■ |
| XSB720E16160D3BZ6 | 10138224 | 3 | D | E16 | 16,0 | 15,5 | 24,0 | 34,1 | 6 | 12 | ■ |
| XSB720E20200D3BZ6 | 10138225 | 3 | D | E20 | 20,0 | 19,3 | 30,0 | 40,2 | 6 | 16 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

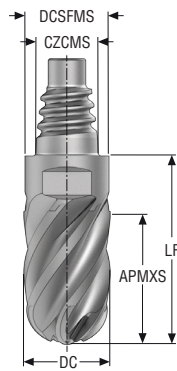
X-Heads

Minimaster Plus

Minimaster

XSB720

Hochleistungsfräser – Superlegierung – Kugelkopf – 6 Schneiden – Zoll



D



- Toleranzen:
- DC= e7
- RE= ±.0008 Zoll
- Nachschleifen möglich, wenn DC ≥ Ø.500 ist Zoll

| Bezeichnung | Produktnummer | Längenindex | Werkzeugform | CZCMS | DC | DCSFMS | APMXS | LF | PCEDC | SW | Beschichtung |
|--------------------|---------------|-------------|--------------|-------|-------|--------|-------|-------|-------|----|--------------|
| | | | | | Zoll | Zoll | Zoll | Zoll | | | HXT |
| XSB720E10.375D3BZ6 | 10138226 | 3 | D | E10 | 0.375 | 0.364 | 0.563 | 0.827 | 6 | 8 | ■ |
| XSB720E12.500D3BZ6 | 10138227 | 3 | D | E12 | 0.500 | 0.484 | 0.750 | 1.055 | 6 | 10 | ■ |
| XSB720E16.625D3BZ6 | 10138228 | 3 | D | E16 | 0.625 | 0.610 | 0.938 | 1.343 | 6 | 12 | ■ |
| XSB720E20.750D3BZ6 | 10138229 | 3 | D | E20 | 0.750 | 0.728 | 1.125 | 1.524 | 6 | 16 | ■ |
| XSB720E25.100D3BZ6 | 10138230 | 3 | D | E25 | 1.000 | 0.965 | 1.500 | 1.980 | 6 | 20 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus


Minimaster

Schnittdaten – XSB720 Eckfräsen

| SMG | | a _e /DC | a _p /DC | f _z | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|--------|--------|--------|-----------------|
| | | | | 10 | 12 | 16 | 20 | |
| P1 | E/M/A/D | 0,12 | 1,2 | 0,095 | 0,11 | 0,14 | 0,16 | 185 (150 – 140) |
| | | 0,12 | 1,2 | 0,0038 | 0,0044 | 0,0055 | 0,0065 | 610 (500 – 450) |
| P2 | E/M/A/D | 0,12 | 1,2 | 0,10 | 0,12 | 0,15 | 0,17 | 175 (140 – 130) |
| | | 0,12 | 1,2 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 570 (460 – 420) |
| P3 | E/M/A/D | 0,12 | 1,2 | 0,095 | 0,11 | 0,14 | 0,16 | 155 (120 – 110) |
| | | 0,12 | 1,2 | 0,0038 | 0,0044 | 0,0055 | 0,0065 | 510 (400 – 360) |
| P4 | E/M/A/D | 0,12 | 1,2 | 0,090 | 0,11 | 0,13 | 0,16 | 135 (110 – 100) |
| | | 0,12 | 1,2 | 0,0036 | 0,0044 | 0,0050 | 0,0065 | 445 (370 – 320) |
| P5 | E/M/A/D | 0,12 | 1,2 | 0,090 | 0,11 | 0,13 | 0,15 | 130 (110 – 100) |
| | | 0,12 | 1,2 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 425 (370 – 320) |
| P6 | E/M/A/D | 0,12 | 1,2 | 0,090 | 0,11 | 0,13 | 0,15 | 145 (120 – 110) |
| | | 0,12 | 1,2 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 475 (400 – 360) |
| P7 | E/M/A/D | 0,12 | 1,2 | 0,090 | 0,11 | 0,13 | 0,15 | 140 (110 – 100) |
| | | 0,12 | 1,2 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 460 (370 – 320) |
| P8 | E/M/A/D | 0,12 | 1,2 | 0,095 | 0,11 | 0,14 | 0,16 | 130 (99 – 98) |
| | | 0,12 | 1,2 | 0,0038 | 0,0044 | 0,0055 | 0,0065 | 425 (330 – 320) |
| P11 | E/M/A/D | 0,12 | 1,2 | 0,070 | 0,080 | 0,10 | 0,12 | 140 (110 – 100) |
| | | 0,12 | 1,2 | 0,0028 | 0,0032 | 0,0040 | 0,0048 | 460 (370 – 320) |
| P12 | E/M/A/D | 0,12 | 1,2 | 0,048 | 0,055 | 0,070 | 0,080 | 85 (68 – 67) |
| | | 0,12 | 1,2 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 280 (230 – 210) |
| M1 | E/M/A | 0,12 | 1,2 | 0,075 | 0,090 | 0,11 | 0,13 | 170 (150 – 190) |
| | | 0,12 | 1,2 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 560 (500 – 620) |
| M2 | E/M/A | 0,12 | 1,2 | 0,070 | 0,085 | 0,10 | 0,12 | 140 (120 – 160) |
| | | 0,12 | 1,2 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 460 (400 – 520) |
| M3 | E/M/A | 0,10 | 1,2 | 0,060 | 0,070 | 0,090 | 0,10 | 120 (110 – 140) |
| | | 0,10 | 1,2 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 395 (370 – 450) |
| M4 | E/M/A | 0,10 | 1,2 | 0,050 | 0,060 | 0,075 | 0,090 | 90 (77 – 100) |
| | | 0,10 | 1,2 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 295 (260 – 320) |
| M5 | E/M/A | 0,10 | 1,2 | 0,050 | 0,060 | 0,075 | 0,090 | 75 (65 – 89) |
| | | 0,10 | 1,2 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 245 (220 – 290) |
| S1 | E | 0,070 | 1,2 | 0,048 | 0,055 | 0,070 | 0,080 | 45 (35 – 54) |
| | | 0,070 | 1,2 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 150 (120 – 170) |
| S2 | E | 0,070 | 1,2 | 0,048 | 0,055 | 0,070 | 0,080 | 35 (5 – 45) |
| | | 0,070 | 1,2 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 115 (17 – 140) |
| S3 | E | 0,070 | 1,2 | 0,048 | 0,055 | 0,070 | 0,080 | 30 (20 – 40) |
| | | 0,070 | 1,2 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 100 (66 – 130) |
| S11 | E | 0,10 | 1,2 | 0,060 | 0,070 | 0,090 | 0,10 | 105 (79 – 130) |
| | | 0,10 | 1,2 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 345 (260 – 420) |
| S12 | E | 0,10 | 1,2 | 0,060 | 0,070 | 0,090 | 0,10 | 80 (61 – 100) |
| | | 0,10 | 1,2 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 260 (210 – 320) |
| S13 | E | 0,10 | 1,2 | 0,060 | 0,070 | 0,090 | 0,10 | 60 (47 – 77) |
| | | 0,10 | 1,2 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 195 (160 – 250) |

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – XSB720 Eckfräsen dynamisches Fräsen $a_p/DC=0,07$

| SMG |  | a_p/DC | f_z | | | | v_c |
|-----|---|----------|--------|--------|--------|--------|-----------------|
| | | | 10 | 12 | 16 | 20 | |
| P1 | E/M/A/D | 1,2 | 0,12 | 0,14 | 0,18 | 0,22 | 195 (160 – 150) |
| | | 1,2 | 0,0048 | 0,0055 | 0,0070 | 0,0085 | 640 (530 – 490) |
| P2 | E/M/A/D | 1,2 | 0,12 | 0,14 | 0,19 | 0,22 | 190 (150 – 140) |
| | | 1,2 | 0,0048 | 0,0055 | 0,0075 | 0,0085 | 620 (500 – 450) |
| P3 | E/M/A/D | 1,2 | 0,12 | 0,14 | 0,18 | 0,20 | 165 (130 – 120) |
| | | 1,2 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 540 (430 – 390) |
| P4 | E/M/A/D | 1,2 | 0,12 | 0,14 | 0,17 | 0,20 | 145 (120 – 110) |
| | | 1,2 | 0,0048 | 0,0055 | 0,0065 | 0,0080 | 475 (400 – 360) |
| P5 | E/M/A/D | 1,2 | 0,12 | 0,14 | 0,17 | 0,20 | 140 (110 – 100) |
| | | 1,2 | 0,0048 | 0,0055 | 0,0065 | 0,0080 | 460 (370 – 320) |
| P6 | E/M/A/D | 1,2 | 0,11 | 0,14 | 0,17 | 0,19 | 160 (130 – 120) |
| | | 1,2 | 0,0044 | 0,0055 | 0,0065 | 0,0075 | 520 (430 – 390) |
| P7 | E/M/A/D | 1,2 | 0,11 | 0,14 | 0,17 | 0,19 | 150 (120 – 110) |
| | | 1,2 | 0,0044 | 0,0055 | 0,0065 | 0,0075 | 490 (400 – 360) |
| P8 | E/M/A/D | 1,2 | 0,12 | 0,14 | 0,18 | 0,20 | 140 (110 – 100) |
| | | 1,2 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 460 (370 – 320) |
| P11 | E/M/A/D | 1,2 | 0,090 | 0,11 | 0,13 | 0,15 | 150 (120 – 110) |
| | | 1,2 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 490 (400 – 360) |
| P12 | E/M/A/D | 1,2 | 0,060 | 0,070 | 0,090 | 0,10 | 95 (73 – 72) |
| | | 1,2 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 310 (240 – 230) |
| M1 | E/M/A | 1,2 | 0,10 | 0,12 | 0,15 | 0,17 | 185 (160 – 200) |
| | | 1,2 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 610 (530 – 650) |
| M2 | E/M/A | 1,2 | 0,090 | 0,11 | 0,13 | 0,15 | 150 (130 – 170) |
| | | 1,2 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 490 (430 – 550) |
| M3 | E/M/A | 1,2 | 0,070 | 0,085 | 0,10 | 0,12 | 125 (110 – 140) |
| | | 1,2 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 410 (370 – 450) |
| M4 | E/M/A | 1,2 | 0,060 | 0,075 | 0,090 | 0,10 | 95 (81 – 110) |
| | | 1,2 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 310 (270 – 360) |
| M5 | E/M/A | 1,2 | 0,060 | 0,075 | 0,090 | 0,10 | 80 (68 – 93) |
| | | 1,2 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 260 (230 – 300) |
| S1 | E | 1,2 | 0,048 | 0,055 | 0,070 | 0,080 | 45 (35 – 54) |
| | | 1,2 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 150 (120 – 170) |
| S2 | E | 1,2 | 0,048 | 0,055 | 0,070 | 0,080 | 35 (5 – 45) |
| | | 1,2 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 115 (17 – 140) |
| S3 | E | 1,2 | 0,048 | 0,055 | 0,070 | 0,080 | 30 (20 – 40) |
| | | 1,2 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 100 (66 – 130) |
| S11 | E | 1,2 | 0,070 | 0,085 | 0,10 | 0,12 | 110 (82 – 130) |
| | | 1,2 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 360 (270 – 420) |
| S12 | E | 1,2 | 0,070 | 0,085 | 0,10 | 0,12 | 85 (63 – 100) |
| | | 1,2 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 280 (210 – 320) |
| S13 | E | 1,2 | 0,070 | 0,085 | 0,10 | 0,12 | 65 (49 – 81) |
| | | 1,2 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 215 (170 – 260) |

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte


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 Harter
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 Graphit
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 Minimaster

Schnittdaten – XSB720 Eckfräsen – Zoll

| SMG | | a _e /DC | a _p /DC | f _z | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|--------|--------|--------|-----------------|
| | | | | 3/8 | 1/2 | 5/8 | 3/4 | |
| P1 | E/M/A/D | 0,12 | 1,2 | 0,095 | 0,11 | 0,14 | 0,16 | 195 (170 – 220) |
| | | 0,12 | 1,2 | 0,0038 | 0,0044 | 0,0055 | 0,0065 | 640 (560 – 720) |
| P2 | E/M/A/D | 0,12 | 1,2 | 0,10 | 0,12 | 0,15 | 0,17 | 190 (170 – 210) |
| | | 0,12 | 1,2 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 620 (560 – 680) |
| P3 | E/M/A/D | 0,12 | 1,2 | 0,095 | 0,11 | 0,14 | 0,16 | 165 (150 – 180) |
| | | 0,12 | 1,2 | 0,0038 | 0,0044 | 0,0055 | 0,0065 | 540 (500 – 590) |
| P4 | E/M/A/D | 0,12 | 1,2 | 0,090 | 0,11 | 0,13 | 0,16 | 145 (130 – 160) |
| | | 0,12 | 1,2 | 0,0036 | 0,0044 | 0,0050 | 0,0065 | 475 (430 – 520) |
| P5 | E/M/A/D | 0,12 | 1,2 | 0,090 | 0,11 | 0,13 | 0,15 | 140 (130 – 160) |
| | | 0,12 | 1,2 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 460 (430 – 520) |
| P6 | E/M/A/D | 0,12 | 1,2 | 0,090 | 0,11 | 0,13 | 0,15 | 155 (140 – 170) |
| | | 0,12 | 1,2 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 510 (460 – 550) |
| P7 | E/M/A/D | 0,12 | 1,2 | 0,090 | 0,11 | 0,13 | 0,15 | 150 (130 – 160) |
| | | 0,12 | 1,2 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 490 (430 – 520) |
| P8 | E/M/A/D | 0,12 | 1,2 | 0,095 | 0,11 | 0,14 | 0,16 | 140 (120 – 150) |
| | | 0,12 | 1,2 | 0,0038 | 0,0044 | 0,0055 | 0,0065 | 460 (400 – 490) |
| P11 | E/M/A/D | 0,12 | 1,2 | 0,070 | 0,080 | 0,10 | 0,12 | 150 (130 – 170) |
| | | 0,12 | 1,2 | 0,0028 | 0,0032 | 0,0040 | 0,0048 | 490 (430 – 550) |
| P12 | E/M/A/D | 0,12 | 1,2 | 0,048 | 0,055 | 0,070 | 0,080 | 95 (81 – 100) |
| | | 0,12 | 1,2 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 310 (270 – 320) |
| M1 | E/M/A | 0,12 | 1,2 | 0,075 | 0,090 | 0,11 | 0,13 | 220 (180 – 260) |
| | | 0,12 | 1,2 | 0,0030 | 0,0036 | 0,0044 | 0,0050 | 720 (600 – 850) |
| M2 | E/M/A | 0,12 | 1,2 | 0,070 | 0,085 | 0,10 | 0,12 | 180 (140 – 220) |
| | | 0,12 | 1,2 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 590 (460 – 720) |
| M3 | E/M/A | 0,10 | 1,2 | 0,060 | 0,070 | 0,090 | 0,10 | 160 (120 – 200) |
| | | 0,10 | 1,2 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 520 (400 – 650) |
| M4 | E/M/A | 0,10 | 1,2 | 0,050 | 0,060 | 0,075 | 0,090 | 125 (93 – 150) |
| | | 0,10 | 1,2 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 410 (310 – 490) |
| M5 | E/M/A | 0,10 | 1,2 | 0,050 | 0,060 | 0,075 | 0,090 | 105 (77 – 120) |
| | | 0,10 | 1,2 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 345 (260 – 390) |
| S1 | E | 0,070 | 1,2 | 0,048 | 0,055 | 0,070 | 0,080 | 45 (35 – 54) |
| | | 0,070 | 1,2 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 150 (120 – 170) |
| S2 | E | 0,070 | 1,2 | 0,048 | 0,055 | 0,070 | 0,080 | 37 (27 – 47) |
| | | 0,070 | 1,2 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 120 (89 – 150) |
| S3 | E | 0,070 | 1,2 | 0,048 | 0,055 | 0,070 | 0,080 | 30 (20 – 40) |
| | | 0,070 | 1,2 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 100 (66 – 130) |
| S11 | E | 0,10 | 1,2 | 0,060 | 0,070 | 0,090 | 0,10 | 80 (61 – 100) |
| | | 0,10 | 1,2 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 260 (210 – 320) |
| S12 | E | 0,10 | 1,2 | 0,060 | 0,070 | 0,090 | 0,10 | 80 (61 – 100) |
| | | 0,10 | 1,2 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 260 (210 – 320) |
| S13 | E | 0,10 | 1,2 | 0,060 | 0,070 | 0,090 | 0,10 | 80 (61 – 100) |
| | | 0,10 | 1,2 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 260 (210 – 320) |

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – XSB720 Eckfräsen dynamisches Fräsen $a_p/DC=0,07$ – Zoll

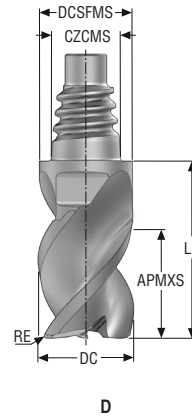
| SMG |  | a_p/DC | f_z | | | | v_c |
|-----|---|----------|--------|--------|--------|--------|-----------------|
| | | | 3/8 | 1/2 | 5/8 | 3/4 | |
| P1 | E/M/A/D | 1,2 | 0,12 | 0,14 | 0,18 | 0,22 | 210 (190 – 240) |
| | | 1,2 | 0,0048 | 0,0055 | 0,0070 | 0,0085 | 690 (630 – 780) |
| P2 | E/M/A/D | 1,2 | 0,12 | 0,14 | 0,19 | 0,22 | 205 (180 – 230) |
| | | 1,2 | 0,0048 | 0,0055 | 0,0075 | 0,0085 | 670 (600 – 750) |
| P3 | E/M/A/D | 1,2 | 0,12 | 0,14 | 0,18 | 0,20 | 180 (160 – 200) |
| | | 1,2 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 590 (530 – 650) |
| P4 | E/M/A/D | 1,2 | 0,12 | 0,14 | 0,17 | 0,20 | 155 (140 – 170) |
| | | 1,2 | 0,0048 | 0,0055 | 0,0065 | 0,0080 | 510 (460 – 550) |
| P5 | E/M/A/D | 1,2 | 0,12 | 0,14 | 0,17 | 0,20 | 150 (130 – 170) |
| | | 1,2 | 0,0048 | 0,0055 | 0,0065 | 0,0080 | 490 (430 – 550) |
| P6 | E/M/A/D | 1,2 | 0,11 | 0,14 | 0,17 | 0,19 | 170 (150 – 190) |
| | | 1,2 | 0,0044 | 0,0055 | 0,0065 | 0,0075 | 560 (500 – 620) |
| P7 | E/M/A/D | 1,2 | 0,11 | 0,14 | 0,17 | 0,19 | 160 (140 – 180) |
| | | 1,2 | 0,0044 | 0,0055 | 0,0065 | 0,0075 | 520 (460 – 590) |
| P8 | E/M/A/D | 1,2 | 0,12 | 0,14 | 0,18 | 0,20 | 150 (130 – 170) |
| | | 1,2 | 0,0048 | 0,0055 | 0,0070 | 0,0080 | 490 (430 – 550) |
| P11 | E/M/A/D | 1,2 | 0,090 | 0,11 | 0,13 | 0,15 | 160 (140 – 180) |
| | | 1,2 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 520 (460 – 590) |
| P12 | E/M/A/D | 1,2 | 0,060 | 0,070 | 0,090 | 0,10 | 100 (87 – 110) |
| | | 1,2 | 0,0024 | 0,0028 | 0,0036 | 0,0040 | 330 (290 – 360) |
| M1 | E/M/A | 1,2 | 0,10 | 0,12 | 0,15 | 0,17 | 235 (190 – 280) |
| | | 1,2 | 0,0040 | 0,0048 | 0,0060 | 0,0065 | 770 (630 – 910) |
| M2 | E/M/A | 1,2 | 0,090 | 0,11 | 0,13 | 0,15 | 195 (160 – 230) |
| | | 1,2 | 0,0036 | 0,0044 | 0,0050 | 0,0060 | 640 (530 – 750) |
| M3 | E/M/A | 1,2 | 0,070 | 0,085 | 0,10 | 0,12 | 170 (130 – 200) |
| | | 1,2 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 560 (430 – 650) |
| M4 | E/M/A | 1,2 | 0,060 | 0,075 | 0,090 | 0,10 | 130 (97 – 160) |
| | | 1,2 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 425 (320 – 520) |
| M5 | E/M/A | 1,2 | 0,060 | 0,075 | 0,090 | 0,10 | 105 (81 – 130) |
| | | 1,2 | 0,0024 | 0,0030 | 0,0036 | 0,0040 | 345 (270 – 420) |
| S1 | E | 1,2 | 0,048 | 0,055 | 0,070 | 0,080 | 45 (35 – 54) |
| | | 1,2 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 150 (120 – 170) |
| S2 | E | 1,2 | 0,048 | 0,055 | 0,070 | 0,080 | 37 (27 – 47) |
| | | 1,2 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 120 (89 – 150) |
| S3 | E | 1,2 | 0,048 | 0,055 | 0,070 | 0,080 | 30 (20 – 40) |
| | | 1,2 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 100 (66 – 130) |
| S11 | E | 1,2 | 0,070 | 0,085 | 0,10 | 0,12 | 85 (63 – 100) |
| | | 1,2 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 280 (210 – 320) |
| S12 | E | 1,2 | 0,070 | 0,085 | 0,10 | 0,12 | 85 (63 – 100) |
| | | 1,2 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 280 (210 – 320) |
| S13 | E | 1,2 | 0,070 | 0,085 | 0,10 | 0,12 | 85 (63 – 100) |
| | | 1,2 | 0,0028 | 0,0034 | 0,0040 | 0,0048 | 280 (210 – 320) |

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_g = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

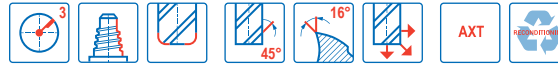
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XSE450

Hochleistungsfräser – Aluminium – Eckfräser – 3 Schneiden – Eckenradius



- Toleranzen:
- DC= 0/-0,0508 mm
- RE= ±0,0254 mm
- Nachschleifen möglich, wenn DC ≥ Ø12 ist mm



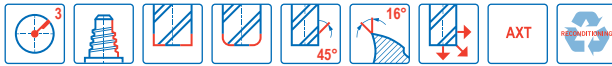
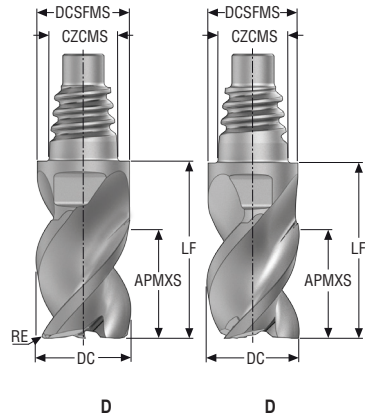
| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | CZCMS | DC | DCSFMS | APMXS | LF | RE | PCEDC | SW | Beschichtung |
|----------------------|----------------|--------------|---------------|-------|------|--------|-------|------|-----|-------|----|--------------|
| | | | | | mm | mm | mm | mm | mm | | | AXT |
| XSE450E10100D2R050Z3 | 10138362 | 2 | D | E10 | 10,0 | 9,7 | 12,0 | 18,7 | 0,5 | 3 | 8 | ■ |
| XSE450E12120D2R050Z3 | 10138363 | 2 | D | E12 | 12,0 | 11,7 | 14,4 | 22,1 | 0,5 | 3 | 10 | ■ |
| XSE450E12120D2R100Z3 | 10138364 | 2 | D | E12 | 12,0 | 11,7 | 14,4 | 22,1 | 1,0 | 3 | 10 | ■ |
| XSE450E16160D2R050Z3 | 10138365 | 2 | D | E16 | 16,0 | 15,5 | 19,2 | 29,2 | 0,5 | 3 | 12 | ■ |
| XSE450E16160D2R100Z3 | 10138366 | 2 | D | E16 | 16,0 | 15,5 | 19,2 | 29,2 | 1,0 | 3 | 12 | ■ |
| XSE450E20200D2R050Z3 | 10138367 | 2 | D | E20 | 20,0 | 19,3 | 24,0 | 34,3 | 0,5 | 3 | 16 | ■ |
| XSE450E20200D2R100Z3 | 10138369 | 2 | D | E20 | 20,0 | 19,3 | 24,0 | 34,3 | 1,0 | 3 | 16 | ■ |

■ Lagerstandard.

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 Harter
 Kunststoffe und Composite
 Graphit
 X-Heads
 Minimaster Plus
 Minimaster

XSE450

Hochleistungsfräser – Aluminium – Eckfräser – 3 Schneiden – Eckenradius – Zoll



- Toleranzen:
- DC= 0/-0.002 Zoll
- RE= ±.001 Zoll
- Nachschleifen möglich, wenn DC ≥ Ø.500 ist Zoll

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | CZCMS | DC | DCSFMS | APMXS | LF | RE | PCEDC | SW | Beschichtung |
|-----------------------|--------------------|------------------|-------------------|-------|-------|--------|-------|-------|-------|-------|----|--------------|
| | | | | | Zoll | Zoll | Zoll | Zoll | Zoll | | | |
| XSE450E10.375D2SZ3 | 10138370 | 2 | D | E10 | 0.375 | 0.364 | 0.450 | 0.720 | - | 3 | 8 | ■ AXT |
| XSE450E12.500D2SZ3 | 10138371 | 2 | D | E12 | 0.500 | 0.484 | 0.600 | 0.906 | - | 3 | 10 | ■ |
| XSE450E16.625D2SZ3 | 10138372 | 2 | D | E16 | 0.625 | 0.610 | 0.750 | 1.150 | - | 3 | 12 | ■ |
| XSE450E20.750D2SZ3 | 10138373 | 2 | D | E20 | 0.750 | 0.728 | 0.900 | 1.295 | - | 3 | 16 | ■ |
| XSE450E25.00D2SZ3 | 10138374 | 2 | D | E25 | 1.000 | 0.965 | 1.200 | 1.673 | - | 3 | 20 | ■ |
| XSE450E10.375D2R030Z3 | 10138375 | 2 | D | E10 | 0.375 | 0.364 | 0.450 | 0.720 | 0.030 | 3 | 8 | ■ |
| XSE450E12.500D2R030Z3 | 10138376 | 2 | D | E12 | 0.500 | 0.484 | 0.600 | 0.906 | 0.030 | 3 | 10 | ■ |
| XSE450E12.500D2R060Z3 | 10138377 | 2 | D | E12 | 0.500 | 0.484 | 0.600 | 0.906 | 0.060 | 3 | 10 | ■ |
| XSE450E16.625D2R030Z3 | 10138378 | 2 | D | E16 | 0.625 | 0.610 | 0.750 | 1.150 | 0.030 | 3 | 12 | ■ |
| XSE450E16.625D2R060Z3 | 10138379 | 2 | D | E16 | 0.625 | 0.610 | 0.750 | 1.150 | 0.060 | 3 | 12 | ■ |
| XSE450E16.625D2R120Z3 | 10138380 | 2 | D | E16 | 0.625 | 0.610 | 0.750 | 1.150 | 0.120 | 3 | 12 | ■ |
| XSE450E20.750D2R030Z3 | 10138381 | 2 | D | E20 | 0.750 | 0.728 | 0.900 | 1.295 | 0.030 | 3 | 16 | ■ |
| XSE450E20.750D2R060Z3 | 10138382 | 2 | D | E20 | 0.750 | 0.728 | 0.900 | 1.295 | 0.060 | 3 | 16 | ■ |
| XSE450E20.750D2R120Z3 | 10138383 | 2 | D | E20 | 0.750 | 0.728 | 0.900 | 1.295 | 0.120 | 3 | 16 | ■ |
| XSE450E25.00D2R030Z3 | 10138384 | 2 | D | E25 | 1.000 | 0.965 | 1.200 | 1.673 | 0.030 | 3 | 20 | ■ |
| XSE450E25.00D2R060Z3 | 10138385 | 2 | D | E25 | 1.000 | 0.965 | 1.200 | 1.673 | 0.060 | 3 | 20 | ■ |
| XSE450E25.00D2R120Z3 | 10138386 | 2 | D | E25 | 1.000 | 0.965 | 1.200 | 1.673 | 0.120 | 3 | 20 | ■ |

■ Lagerstandard.

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Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – XSE450 Eckfräsen

| SMG | | a _e /DC | a _p /DC | f _z | | | | v _c | |
|-----|-------|--------------------|--------------------|----------------|--------|--------|--------|----------------|---------------------------------------|
| | | | | 10 | 12 | 16 | 20 | | |
| N1 | E/M/A | 0,40 | 1,1 | 0,15 | 0,18 | 0,22 | 0,26 | 0,30 | 405 (340 – 450) 1325 (1200 – 1400) |
| | | 0,40 | 1,1 | 0,0060 | 0,0070 | 0,0085 | 0,010 | 0,012 | |
| N2 | E/M/A | 0,40 | 1,1 | 0,13 | 0,16 | 0,20 | 0,22 | 0,25 | 275 (230 – 330) 900 (760 – 1000) |
| | | 0,40 | 1,1 | 0,0050 | 0,0065 | 0,0080 | 0,0085 | 0,010 | |
| N3 | E/M/A | 0,40 | 1,1 | 0,13 | 0,16 | 0,20 | 0,22 | 0,25 | 185 (150 – 220) 610 (500 – 720) |
| | | 0,40 | 1,1 | 0,0050 | 0,0065 | 0,0080 | 0,0085 | 0,010 | |
| N11 | E/M/A | 0,40 | 1,1 | 0,13 | 0,16 | 0,20 | 0,22 | 0,25 | 245 (200 – 290) 800 (660 – 950) |
| | | 0,40 | 1,1 | 0,0050 | 0,0065 | 0,0080 | 0,0085 | 0,010 | |
| TS1 | A/D | 0,40 | 1,1 | 0,15 | 0,18 | 0,22 | 0,26 | 0,30 | 280 (170 – 390) 920 (560 – 1200) |
| | | 0,40 | 1,1 | 0,0060 | 0,0070 | 0,0085 | 0,010 | 0,012 | |
| TP1 | A/D | 0,40 | 1,1 | 0,15 | 0,18 | 0,22 | 0,26 | 0,30 | 280 (170 – 390) 920 (560 – 1200) |
| | | 0,40 | 1,1 | 0,0060 | 0,0070 | 0,0085 | 0,010 | 0,012 | |

Schnittdaten – XSE450 Nutfräsen

| SMG | | a _p /DC | f _z | | | | v _c | |
|-----|-------|--------------------|----------------|--------|--------|--------|----------------|---------------------------------------|
| | | | 10 | 12 | 16 | 20 | | |
| N1 | E/M/A | 0,90 | 0,10 | 0,12 | 0,16 | 0,20 | 0,25 | 360 (310 – 410) 1175 (1100 – 1300) |
| | | 0,90 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,010 | |
| N2 | E/M/A | 0,90 | 0,080 | 0,095 | 0,13 | 0,16 | 0,20 | 250 (200 – 300) 820 (660 – 980) |
| | | 0,90 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 0,0080 | |
| N3 | E/M/A | 0,90 | 0,080 | 0,095 | 0,13 | 0,16 | 0,20 | 165 (140 – 200) 540 (460 – 650) |
| | | 0,90 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 0,0080 | |
| N11 | E/M/A | 0,90 | 0,080 | 0,095 | 0,13 | 0,16 | 0,20 | 220 (180 – 260) 720 (600 – 850) |
| | | 0,90 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 0,0080 | |
| TS1 | A/D | 0,90 | 0,10 | 0,12 | 0,16 | 0,20 | 0,25 | 250 (150 – 340) 820 (500 – 1100) |
| | | 0,90 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,010 | |
| TP1 | A/D | 0,90 | 0,10 | 0,12 | 0,16 | 0,20 | 0,25 | 250 (150 – 340) 820 (500 – 1100) |
| | | 0,90 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,010 | |

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)


f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor


a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

Schnittdaten – XSE450 Eckfräsen – Zoll

| SMG |  | a _p /DC | a _p /DC | f _z | | | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------|-------|--------------------|
| | | | | 3/8 | 1/2 | 5/8 | 3/4 | 1 | |
| N1 | E/M/A | 0,40 | 1,1 | 0,15 | 0,18 | 0,22 | 0,26 | 0,30 | 560 (450 – 670) |
| | | 0,40 | 1,1 | 0,0060 | 0,0070 | 0,0085 | 0,010 | 0,012 | 1825 (1500 – 2100) |
| N2 | E/M/A | 0,40 | 1,1 | 0,13 | 0,16 | 0,20 | 0,22 | 0,25 | 445 (340 – 550) |
| | | 0,40 | 1,1 | 0,0050 | 0,0065 | 0,0080 | 0,0085 | 0,010 | 1450 (1200 – 1800) |
| N3 | E/M/A | 0,40 | 1,1 | 0,13 | 0,16 | 0,20 | 0,22 | 0,25 | 295 (230 – 360) |
| | | 0,40 | 1,1 | 0,0050 | 0,0065 | 0,0080 | 0,0085 | 0,010 | 970 (760 – 1100) |
| N11 | E/M/A | 0,40 | 1,1 | 0,13 | 0,16 | 0,20 | 0,22 | 0,25 | 395 (300 – 490) |
| | | 0,40 | 1,1 | 0,0050 | 0,0065 | 0,0080 | 0,0085 | 0,010 | 1300 (990 – 1600) |
| TS1 | A/D | 0,40 | 1,1 | 0,15 | 0,18 | 0,22 | 0,26 | 0,30 | 280 (170 – 390) |
| | | 0,40 | 1,1 | 0,0060 | 0,0070 | 0,0085 | 0,010 | 0,012 | 920 (560 – 1200) |
| TP1 | A/D | 0,40 | 1,1 | 0,15 | 0,18 | 0,22 | 0,26 | 0,30 | 280 (170 – 390) |
| | | 0,40 | 1,1 | 0,0060 | 0,0070 | 0,0085 | 0,010 | 0,012 | 920 (560 – 1200) |

Schnittdaten – XSE450 Nutfräsen – Zoll

| SMG |  | a _p /DC | f _z | | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------|--------------------|
| | | | 3/8 | 1/2 | 5/8 | 3/4 | 1 | |
| N1 | E/M/A | 1,1 | 0,10 | 0,12 | 0,16 | 0,20 | 0,25 | 500 (400 – 590) |
| | | 1,1 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,010 | 1650 (1400 – 1900) |
| N2 | E/M/A | 1,1 | 0,080 | 0,095 | 0,13 | 0,16 | 0,20 | 400 (300 – 490) |
| | | 1,1 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 0,0080 | 1300 (990 – 1600) |
| N3 | E/M/A | 1,1 | 0,080 | 0,095 | 0,13 | 0,16 | 0,20 | 265 (200 – 330) |
| | | 1,1 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 0,0080 | 870 (660 – 1000) |
| N11 | E/M/A | 1,1 | 0,080 | 0,095 | 0,13 | 0,16 | 0,20 | 355 (270 – 440) |
| | | 1,1 | 0,0032 | 0,0038 | 0,0050 | 0,0065 | 0,0080 | 1175 (890 – 1400) |
| TS1 | A/D | 1,1 | 0,10 | 0,12 | 0,16 | 0,20 | 0,25 | 250 (150 – 340) |
| | | 1,1 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,010 | 820 (500 – 1100) |
| TP1 | A/D | 1,1 | 0,10 | 0,12 | 0,16 | 0,20 | 0,25 | 250 (150 – 340) |
| | | 1,1 | 0,0040 | 0,0048 | 0,0065 | 0,0080 | 0,010 | 820 (500 – 1100) |

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

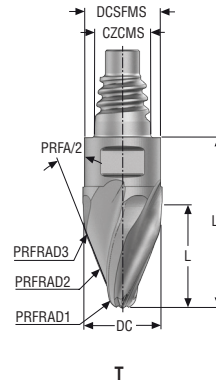
a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

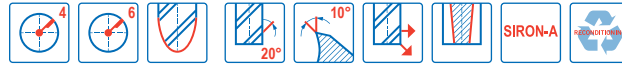
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XHT740

Hochgeschwindigkeitsfräsen – ISO– M und ISO– S – Konische Form – 4-6 Schneiden



- Toleranzen:
- PRFRAD1= $\pm 0,03$ mm
- Formtoleranz PRFRAD2= 0,02 mm
- Nachschleifen möglich, wenn DC $\geq \varnothing 12$ mm und PRFRAD1 $\geq 1,5$ mm ist



| Bezeichnung | Produktnum- mer | Längen- index | Werkzeug- form | CZCMS | DC | DCSFMS | L | LF | PRFRAD1 | PRFRAD2 | PRFRAD3 | PRFA/2° | PCEDC | SW | Beschich- tung |
|--------------------------|--------------------|------------------|-------------------|-------|------|--------|------|------|---------|---------|---------|---------|-------|----|-------------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | | | | SIRA |
| XHT740E10100T2R1.5R250Z4 | 10138388 | 2 | T | E10 | 10,0 | 9,7 | 5,4 | 18,7 | 1,5 | 250,0 | 2,0 | 65,0 | 4 | 8 | ■ |
| XHT740E12120T2R3R250Z4 | 10138389 | 2 | T | E12 | 12,0 | 11,7 | 10,5 | 22,1 | 3,0 | 250,0 | 6,0 | 32,5 | 4 | 10 | ■ |
| XHT740E16160T2R4R500Z4 | 10138390 | 2 | T | E16 | 16,0 | 15,5 | 14,6 | 29,2 | 4,0 | 500,0 | 8,0 | 27,5 | 4 | 12 | ■ |
| XHT740E10100T3R2R250Z4 | 10138391 | 3 | T | E10 | 10,0 | 9,7 | 12,7 | 21,8 | 2,0 | 250,0 | 5,0 | 20,0 | 4 | 8 | ■ |
| XHT740E12120T3R3R250Z4 | 10138392 | 3 | T | E12 | 12,0 | 11,7 | 13,7 | 25,9 | 3,0 | 250,0 | 6,0 | 20,0 | 4 | 10 | ■ |
| XHT740E16160T3R4R1000Z4 | 10138394 | 3 | T | E16 | 16,0 | 15,5 | 24,0 | 34,1 | 4,0 | 1000,0 | 5,0 | 20,0 | 4 | 12 | ■ |
| XHT740E16160T3R4R500Z4 | 10138393 | 3 | T | E16 | 16,0 | 15,5 | 17,6 | 34,1 | 4,0 | 500,0 | 8,0 | 20,0 | 4 | 12 | ■ |
| XHT740E10100T3R2R250Z6 | 10138395 | 3 | T | E10 | 10,0 | 9,7 | 12,7 | 21,8 | 2,0 | 250,0 | 5,0 | 20,0 | 6 | 8 | ■ |
| XHT740E12120T3R3R250Z6 | 10138396 | 3 | T | E12 | 12,0 | 11,7 | 13,7 | 25,9 | 3,0 | 250,0 | 6,0 | 20,0 | 6 | 10 | ■ |
| XHT740E16160T3R4R500Z6 | 10138397 | 3 | T | E16 | 16,0 | 15,5 | 17,6 | 34,1 | 4,0 | 500,0 | 8,0 | 20,0 | 6 | 12 | ■ |

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Schnittdaten – XHT740 – Kopierfräser PCEDC 4

| SMG |  | a _p /DC | f _z | | | v _c |
|-----|---|--------------------|----------------|--------|--------|-----------------|
| | | | 10 | 12 | 16 | |
| P8 | E/M/A/D | 0,010 | 0,05 | 0,06 | 0,08 | 170 (150 - 195) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 560 (490 - 640) |
| P12 | E/M/A/D | 0,010 | 0,05 | 0,06 | 0,08 | 120 (95 - 135) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 400 (310 - 445) |
| M1 | E/M/A | 0,010 | 0,05 | 0,06 | 0,08 | 150 (125 - 155) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 490 (410 - 510) |
| M2 | E/M/A | 0,010 | 0,05 | 0,06 | 0,08 | 145 (120 - 150) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 475 (400 - 490) |
| M3 | E/M/A | 0,010 | 0,05 | 0,06 | 0,08 | 130 (90 - 140) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 425 (295 - 460) |
| S2 | E | 0,010 | 0,05 | 0,06 | 0,08 | 60 (50 - 70) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 195 (165 - 230) |
| S11 | E | 0,010 | 0,05 | 0,06 | 0,08 | 100 (85 - 105) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 320 (280 - 345) |
| S12 | E | 0,010 | 0,05 | 0,06 | 0,08 | 95 (80 - 100) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 310 (260 - 320) |
| S13 | E | 0,010 | 0,05 | 0,06 | 0,08 | 90 (75 - 95) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 295 (245 - 310) |

Schnittdaten – XHT740 – Kopierfräser PCEDC 6

| SMG |  | a _p /DC | f _z | | | v _c |
|-----|---|--------------------|----------------|--------|--------|-----------------|
| | | | 10 | 12 | 16 | |
| P8 | E/M/A/D | 0,010 | 0,05 | 0,06 | 0,08 | 170 (150 - 195) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 560 (490 - 640) |
| P12 | E/M/A/D | 0,010 | 0,05 | 0,06 | 0,08 | 120 (95 - 135) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 400 (310 - 445) |
| M1 | E/M/A | 0,010 | 0,05 | 0,06 | 0,08 | 150 (125 - 155) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 490 (410 - 510) |
| M2 | E/M/A | 0,010 | 0,05 | 0,06 | 0,08 | 145 (120 - 150) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 475 (400 - 490) |
| M3 | E/M/A | 0,010 | 0,05 | 0,06 | 0,08 | 130 (90 - 140) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 425 (295 - 460) |
| S2 | E | 0,010 | 0,05 | 0,06 | 0,08 | 60 (50 - 70) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 195 (165 - 230) |
| S11 | E | 0,010 | 0,05 | 0,06 | 0,08 | 100 (85 - 105) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 320 (280 - 345) |
| S12 | E | 0,010 | 0,05 | 0,06 | 0,08 | 95 (80 - 100) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 310 (260 - 320) |
| S13 | E | 0,010 | 0,05 | 0,06 | 0,08 | 90 (75 - 95) |
| | | 0,010 | 0,0022 | 0,0024 | 0,0032 | 295 (245 - 310) |

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_g = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

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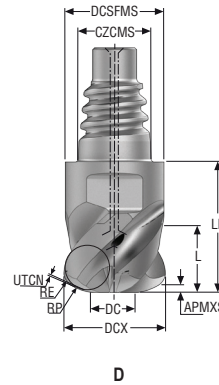
XHF580

Hochvorschubfräser – Universell – 4 Schneiden – Eckenradius – ICC

Stahl und Guss

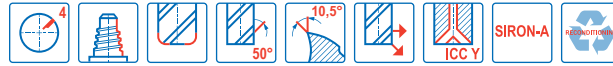


Rostfrei und ISO-S-Werkstoffe



NE-Metalle

- Toleranzen:
- DCX= h9
- RE= ±0,03 mm
- Nachschleifen möglich, wenn DCX ≥ Ø12 ist mm



Harter

| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | CSP | CZCMS | DCX | DC | DCSFMS | APMXS | L | LF | RE | RP | UTCN | PCEDC | SW | Be-schich-tung |
|--------------------|----------------|--------------|---------------|-----|-------|------|-----|--------|-------|------|------|-----|-------|-------|-------|----|----------------|
| | | | | | | mm | mm | mm | mm | mm | mm | mm | mm | mm | | | SIRA |
| XHF580E10100D1HZ4A | 10137971 | 1 | D | ✓ | E10 | 10,0 | 3,4 | 9,7 | 0,7 | 6,0 | 12,4 | 1,5 | 1,99 | 0,27 | 4 | 8 | ■ |
| XHF580E12120D1HZ4A | 10137972 | 1 | D | ✓ | E12 | 12,0 | 4,5 | 11,7 | 0,8 | 7,5 | 14,5 | 1,5 | 2,1 | 0,323 | 4 | 10 | ■ |
| XHF580E16160D1HZ4A | 10137973 | 1 | D | ✓ | E16 | 16,0 | 6,2 | 15,5 | 1,0 | 10,0 | 18,7 | 2,0 | 2,747 | 0,426 | 4 | 12 | ■ |

■ Lagerstandard.

Kunststoffe und Composite

Graphit

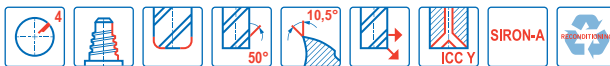
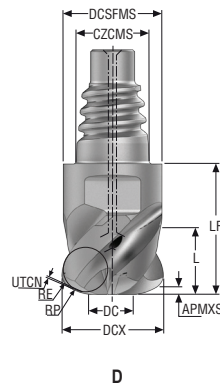
X-Heads

Minimaster Plus

Minimaster

XHF580

Hochvorschubfräser – Universell – 4 Schneiden – Eckenradius – ICC – Zoll



- Toleranzen:
- DCX= h9
- RE= ±.0012 Zoll
- Nachschleifen möglich, wenn DCX ≥ Ø.500 ist Zoll

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | CSP | CZCMS | DCX | DC | DCS- FMS | APMXS | L | LF | RE | RP | UTCN | PCEDC | SW | Beschich- tung |
|---------------------|--------------------|------------------|-------------------|-----|-------|-------|-------|-------------|-------|-------|-------|-------|-------|-------|-------|----|-------------------|
| | | | | | | Zoll | Zoll | Zoll | Zoll | Zoll | Zoll | Zoll | Zoll | Zoll | | | SIRA |
| XHF580E10.375D1HZ4A | 10137974 | 1 | D | ✓ | E10 | 0.375 | 0.134 | 0.364 | 0.024 | 0.236 | 0.488 | 0.060 | 0.076 | 0.008 | 4 | 8 | ■ |
| XHF580E12.500D1HZ4A | 10137975 | 1 | D | ✓ | E12 | 0.500 | 0.197 | 0.484 | 0.033 | 0.315 | 0.571 | 0.060 | 0.086 | 0.014 | 4 | 10 | ■ |
| XHF580E16.625D1HZ4A | 10137976 | 1 | D | ✓ | E16 | 0.614 | 0.236 | 0.610 | 0.039 | 0.394 | 0.736 | 0.080 | 0.110 | 0.016 | 4 | 12 | ■ |

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Schnittdaten – XHF580 Eckfräsen

| SMG | | a _p /DCX | a _r /DCX | f _z | | | v _c |
|-----|---------|---------------------|---------------------|----------------|-------|-------|--------------------|
| | | | | 10 | 12 | 16 | |
| P1 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 350 (330 – 400) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 1150 (1100 – 1300) |
| P2 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 340 (320 – 390) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 1125 (1100 – 1200) |
| P3 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 295 (280 – 340) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 970 (920 – 1100) |
| P4 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 260 (250 – 300) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 850 (830 – 980) |
| P5 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 260 (250 – 300) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 850 (830 – 980) |
| P6 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 190 (180 – 230) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 620 (600 – 750) |
| P7 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 180 (170 – 220) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 590 (560 – 720) |
| P8 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 170 (160 – 200) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 560 (530 – 650) |
| P11 | E/M/A/D | 0,30 | 0,060 | 0,40 | 0,48 | 0,65 | 145 (150 – 170) |
| | | 0,30 | 0,060 | 0,016 | 0,019 | 0,026 | 475 (500 – 550) |
| P12 | E/M/A/D | 0,30 | 0,060 | 0,40 | 0,48 | 0,65 | 85 (83 – 100) |
| | | 0,30 | 0,060 | 0,016 | 0,019 | 0,026 | 280 (280 – 320) |
| M1 | E/M/A | 0,30 | 0,060 | 0,40 | 0,48 | 0,65 | 170 (170 – 200) |
| | | 0,30 | 0,060 | 0,016 | 0,019 | 0,026 | 560 (560 – 650) |
| M2 | E/M/A | 0,30 | 0,060 | 0,40 | 0,48 | 0,65 | 140 (140 – 160) |
| | | 0,30 | 0,060 | 0,016 | 0,019 | 0,026 | 460 (460 – 520) |
| M3 | E/M/A | 0,30 | 0,060 | 0,40 | 0,48 | 0,65 | 105 (97 – 130) |
| | | 0,30 | 0,060 | 0,016 | 0,019 | 0,026 | 345 (320 – 420) |
| M4 | E/M/A | 0,30 | 0,060 | 0,40 | 0,48 | 0,65 | 75 (73 – 99) |
| | | 0,30 | 0,060 | 0,016 | 0,019 | 0,026 | 245 (240 – 320) |
| M5 | E/M/A | 0,30 | 0,060 | 0,40 | 0,48 | 0,65 | 65 (61 – 83) |
| | | 0,30 | 0,060 | 0,016 | 0,019 | 0,026 | 215 (210 – 270) |
| K1 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 345 (330 – 400) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 1125 (1100 – 1300) |
| K2 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 300 (280 – 340) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 980 (920 – 1100) |
| K3 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 250 (240 – 290) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 820 (790 – 950) |
| K4 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 240 (230 – 280) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 790 (760 – 910) |
| K5 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 145 (140 – 160) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 475 (460 – 520) |
| K6 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 210 (200 – 240) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 690 (660 – 780) |
| K7 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 185 (180 – 210) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 610 (600 – 680) |
| S1 | E | 0,30 | 0,034 | 0,24 | 0,28 | 0,38 | 45 (36 – 71) |
| | | 0,30 | 0,034 | 0,0095 | 0,011 | 0,015 | 150 (120 – 230) |
| S2 | E | 0,30 | 0,034 | 0,24 | 0,28 | 0,38 | 36 (29 – 57) |
| | | 0,30 | 0,034 | 0,0095 | 0,011 | 0,015 | 120 (96 – 180) |
| S3 | E | 0,30 | 0,034 | 0,24 | 0,28 | 0,38 | 31 (25 – 49) |
| | | 0,30 | 0,034 | 0,0095 | 0,011 | 0,015 | 100 (83 – 160) |
| S11 | E | 0,30 | 0,060 | 0,36 | 0,42 | 0,55 | 160 (160 – 190) |
| | | 0,30 | 0,060 | 0,014 | 0,017 | 0,022 | 520 (530 – 620) |
| S12 | E | 0,30 | 0,060 | 0,36 | 0,42 | 0,55 | 125 (120 – 150) |
| | | 0,30 | 0,060 | 0,014 | 0,017 | 0,022 | 410 (400 – 490) |
| S13 | E | 0,30 | 0,060 | 0,36 | 0,42 | 0,55 | 95 (91 – 110) |
| | | 0,30 | 0,060 | 0,014 | 0,017 | 0,022 | 310 (300 – 360) |
| H5 | M/A | 0,30 | 0,060 | 0,40 | 0,48 | 0,65 | 105 (98 – 130) |
| | | 0,30 | 0,060 | 0,016 | 0,019 | 0,026 | 345 (330 – 420) |
| H8 | M/A | 0,30 | 0,060 | 0,40 | 0,48 | 0,65 | 105 (98 – 130) |
| | | 0,30 | 0,060 | 0,016 | 0,019 | 0,026 | 345 (330 – 420) |
| H21 | M/A | 0,30 | 0,060 | 0,40 | 0,48 | 0,65 | 105 (98 – 130) |
| | | 0,30 | 0,060 | 0,016 | 0,019 | 0,026 | 345 (330 – 420) |
| H31 | M/A | 0,30 | 0,060 | 0,40 | 0,48 | 0,65 | 80 (74 – 100) |
| | | 0,30 | 0,060 | 0,016 | 0,019 | 0,026 | 260 (250 – 320) |

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_r = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – XHF580 Nutfräsen

| SMG |  | a _p /DCX | f _z | | | v _c |
|-----|---|---------------------|----------------|----------------|---------------|--------------------------------------|
| | | | 10 | 12 | 16 | |
| P1 | E/M/A/D | 0,060 0,060 | 0,30 0,012 | 0,36 0,014 | 0,48 0,019 | 320 (300 – 360) 1050 (990 – 1100) |
| P2 | E/M/A/D | 0,060 0,060 | 0,30 0,012 | 0,36 0,014 | 0,48 0,019 | 310 (290 – 350) 1025 (960 – 1100) |
| P3 | E/M/A/D | 0,060 0,060 | 0,30 0,012 | 0,36 0,014 | 0,48 0,019 | 265 (250 – 300) 870 (830 – 980) |
| P4 | E/M/A/D | 0,060 0,060 | 0,30 0,012 | 0,36 0,014 | 0,48 0,019 | 235 (220 – 270) 770 (730 – 880) |
| P5 | E/M/A/D | 0,060 0,060 | 0,30 0,012 | 0,36 0,014 | 0,48 0,019 | 235 (220 – 270) 770 (730 – 880) |
| P6 | E/M/A/D | 0,060 0,060 | 0,30 0,012 | 0,36 0,014 | 0,48 0,019 | 175 (160 – 210) 570 (530 – 680) |
| P7 | E/M/A/D | 0,060 0,060 | 0,30 0,012 | 0,36 0,014 | 0,48 0,019 | 165 (150 – 200) 540 (500 – 650) |
| P8 | E/M/A/D | 0,060 0,060 | 0,30 0,012 | 0,36 0,014 | 0,48 0,019 | 155 (150 – 180) 510 (500 – 590) |
| P11 | E/M/A/D | 0,060 0,060 | 0,24 0,0095 | 0,28 0,011 | 0,38 0,015 | 130 (130 – 160) 425 (430 – 520) |
| P12 | E/M/A/D | 0,060 0,060 | 0,24 0,0095 | 0,28 0,011 | 0,38 0,015 | 80 (75 – 94) 260 (250 – 300) |
| M1 | E/M/A | 0,060 0,060 | 0,24 0,0095 | 0,28 0,011 | 0,38 0,015 | 155 (150 – 180) 510 (500 – 590) |
| M2 | E/M/A | 0,060 0,060 | 0,24 0,0095 | 0,28 0,011 | 0,38 0,015 | 125 (120 – 150) 410 (400 – 490) |
| M3 | E/M/A | 0,060 0,060 | 0,24 0,0095 | 0,28 0,011 | 0,38 0,015 | 95 (88 – 110) 310 (290 – 360) |
| M4 | E/M/A | 0,060 0,060 | 0,24 0,0095 | 0,28 0,011 | 0,38 0,015 | 70 (66 – 89) 230 (220 – 290) |
| M5 | E/M/A | 0,060 0,060 | 0,24 0,0095 | 0,28 0,011 | 0,38 0,015 | 60 (55 – 74) 195 (190 – 240) |
| K1 | E/M/A/D | 0,060 0,060 | 0,30 0,012 | 0,36 0,014 | 0,48 0,019 | 310 (300 – 360) 1025 (990 – 1100) |
| K2 | E/M/A/D | 0,060 0,060 | 0,30 0,012 | 0,36 0,014 | 0,48 0,019 | 270 (260 – 310) 890 (860 – 1000) |
| K3 | E/M/A/D | 0,060 0,060 | 0,30 0,012 | 0,36 0,014 | 0,48 0,019 | 230 (220 – 260) 750 (730 – 850) |
| K4 | E/M/A/D | 0,060 0,060 | 0,30 0,012 | 0,36 0,014 | 0,48 0,019 | 220 (210 – 250) 720 (690 – 820) |
| K5 | E/M/A/D | 0,060 0,060 | 0,30 0,012 | 0,36 0,014 | 0,48 0,019 | 130 (130 – 150) 425 (430 – 490) |
| K6 | E/M/A/D | 0,060 0,060 | 0,30 0,012 | 0,36 0,014 | 0,48 0,019 | 190 (180 – 220) 620 (600 – 720) |
| K7 | E/M/A/D | 0,060 0,060 | 0,30 0,012 | 0,36 0,014 | 0,48 0,019 | 165 (160 – 190) 540 (530 – 620) |
| S1 | E | 0,034 0,034 | 0,18 0,0070 | 0,22 0,0085 | 0,28 0,011 | 39 (32 – 62) 130 (110 – 200) |
| S2 | E | 0,034 0,034 | 0,18 0,0070 | 0,22 0,0085 | 0,28 0,011 | 31 (26 – 50) 100 (86 – 160) |
| S3 | E | 0,034 0,034 | 0,18 0,0070 | 0,22 0,0085 | 0,28 0,011 | 27 (22 – 43) 90 (73 – 140) |
| S11 | E | 0,060 0,060 | 0,18 0,0070 | 0,22 0,0085 | 0,28 0,011 | 150 (150 – 180) 490 (500 – 590) |
| S12 | E | 0,060 0,060 | 0,18 0,0070 | 0,22 0,0085 | 0,28 0,011 | 115 (110 – 140) 375 (370 – 450) |
| S13 | E | 0,060 0,060 | 0,18 0,0070 | 0,22 0,0085 | 0,28 0,011 | 90 (85 – 100) 295 (280 – 320) |
| H5 | M/A | 0,060 0,060 | 0,24 0,0095 | 0,28 0,011 | 0,38 0,015 | 95 (88 – 120) 310 (290 – 390) |
| H8 | M/A | 0,060 0,060 | 0,24 0,0095 | 0,28 0,011 | 0,38 0,015 | 95 (88 – 120) 310 (290 – 390) |
| H21 | M/A | 0,060 0,060 | 0,24 0,0095 | 0,28 0,011 | 0,38 0,015 | 95 (88 – 120) 310 (290 – 390) |
| H31 | M/A | 0,060 0,060 | 0,24 0,0095 | 0,28 0,011 | 0,38 0,015 | 70 (67 – 91) 230 (220 – 290) |

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte


Unversell
 Stahl und Guss
 Stahl und Guss
 Rostfrei und ISO-S-Werkstoffe
 NE-Metalle
 Harter
 Kunststoffe und Composite
 Graphit
 X-Heads
 Minmaster Plus
 Minmaster

Schnittdaten – XHF580 Eckfräsen – Zoll

| SMG | | a _p /DCX | a _s /DCX | f _z | | | v _c |
|-----|---------|---------------------|---------------------|----------------|-------|-------|--------------------|
| | | | | 3/8 | 1/2 | 5/8 | |
| P1 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 485 (440 – 530) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 1600 (1500 – 1700) |
| P2 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 475 (430 – 520) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 1550 (1500 – 1700) |
| P3 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 405 (370 – 450) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 1325 (1300 – 1400) |
| P4 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 360 (320 – 390) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 1175 (1100 – 1200) |
| P5 | E/M/A/D | 0,34 | 0,060 | 0,50 | 0,60 | 0,80 | 260 (240 – 290) |
| | | 0,34 | 0,060 | 0,020 | 0,024 | 0,032 | 850 (790 – 950) |
| P6 | E/M/A/D | 0,34 | 0,060 | 0,50 | 0,60 | 0,80 | 295 (270 – 320) |
| | | 0,34 | 0,060 | 0,020 | 0,024 | 0,032 | 970 (890 – 1000) |
| P7 | E/M/A/D | 0,34 | 0,060 | 0,50 | 0,60 | 0,80 | 280 (250 – 300) |
| | | 0,34 | 0,060 | 0,020 | 0,024 | 0,032 | 920 (830 – 980) |
| P8 | E/M/A/D | 0,34 | 0,060 | 0,50 | 0,60 | 0,80 | 260 (240 – 290) |
| | | 0,34 | 0,060 | 0,020 | 0,024 | 0,032 | 850 (790 – 950) |
| P11 | E/M/A/D | 0,30 | 0,055 | 0,40 | 0,48 | 0,65 | 160 (140 – 170) |
| | | 0,30 | 0,055 | 0,016 | 0,019 | 0,026 | 520 (460 – 550) |
| P12 | E/M/A/D | 0,30 | 0,055 | 0,40 | 0,48 | 0,65 | 95 (83 – 100) |
| | | 0,30 | 0,055 | 0,016 | 0,019 | 0,026 | 310 (280 – 320) |
| M1 | E/M/A | 0,30 | 0,055 | 0,40 | 0,48 | 0,65 | 185 (170 – 200) |
| | | 0,30 | 0,055 | 0,016 | 0,019 | 0,026 | 610 (560 – 650) |
| M2 | E/M/A | 0,30 | 0,055 | 0,40 | 0,48 | 0,65 | 150 (140 – 160) |
| | | 0,30 | 0,055 | 0,016 | 0,019 | 0,026 | 490 (460 – 520) |
| M3 | E/M/A | 0,30 | 0,055 | 0,40 | 0,48 | 0,65 | 115 (97 – 130) |
| | | 0,30 | 0,055 | 0,016 | 0,019 | 0,026 | 375 (320 – 420) |
| M4 | E/M/A | 0,30 | 0,055 | 0,40 | 0,48 | 0,65 | 85 (73 – 99) |
| | | 0,30 | 0,055 | 0,016 | 0,019 | 0,026 | 280 (240 – 320) |
| M5 | E/M/A | 0,30 | 0,055 | 0,40 | 0,48 | 0,65 | 70 (61 – 82) |
| | | 0,30 | 0,055 | 0,016 | 0,019 | 0,026 | 230 (210 – 260) |
| K1 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 475 (430 – 520) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 1550 (1500 – 1700) |
| K2 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 415 (370 – 450) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 1350 (1300 – 1400) |
| K3 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 350 (320 – 380) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 1150 (1100 – 1200) |
| K4 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 335 (300 – 370) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 1100 (990 – 1200) |
| K5 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 200 (180 – 220) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 660 (600 – 720) |
| K6 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 295 (270 – 320) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 970 (890 – 1000) |
| K7 | E/M/A/D | 0,30 | 0,060 | 0,50 | 0,60 | 0,80 | 255 (230 – 280) |
| | | 0,30 | 0,060 | 0,020 | 0,024 | 0,032 | 840 (760 – 910) |
| S1 | E | 0,30 | 0,034 | 0,24 | 0,28 | 0,38 | 55 (36 – 71) |
| | | 0,30 | 0,034 | 0,0095 | 0,011 | 0,015 | 180 (120 – 230) |
| S2 | E | 0,30 | 0,034 | 0,24 | 0,28 | 0,38 | 43 (29 – 57) |
| | | 0,30 | 0,034 | 0,0095 | 0,011 | 0,015 | 140 (96 – 180) |
| S3 | E | 0,30 | 0,034 | 0,24 | 0,28 | 0,38 | 37 (25 – 49) |
| | | 0,30 | 0,034 | 0,0095 | 0,011 | 0,015 | 120 (83 – 160) |
| S11 | E | 0,30 | 0,034 | 0,36 | 0,42 | 0,55 | 170 (150 – 190) |
| | | 0,30 | 0,034 | 0,014 | 0,017 | 0,022 | 560 (500 – 620) |
| S12 | E | 0,30 | 0,034 | 0,36 | 0,42 | 0,55 | 130 (120 – 140) |
| | | 0,30 | 0,034 | 0,014 | 0,017 | 0,022 | 425 (400 – 450) |
| S13 | E | 0,30 | 0,034 | 0,36 | 0,42 | 0,55 | 100 (89 – 110) |
| | | 0,30 | 0,034 | 0,014 | 0,017 | 0,022 | 330 (300 – 360) |
| H5 | M/A | 0,30 | 0,060 | 0,40 | 0,48 | 0,65 | 115 (98 – 130) |
| | | 0,30 | 0,060 | 0,016 | 0,019 | 0,026 | 375 (330 – 420) |
| H8 | M/A | 0,30 | 0,060 | 0,40 | 0,48 | 0,65 | 115 (98 – 130) |
| | | 0,30 | 0,060 | 0,016 | 0,019 | 0,026 | 375 (330 – 420) |
| H21 | M/A | 0,30 | 0,060 | 0,40 | 0,48 | 0,65 | 115 (98 – 130) |
| | | 0,30 | 0,060 | 0,016 | 0,019 | 0,026 | 375 (330 – 420) |
| H31 | M/A | 0,30 | 0,060 | 0,40 | 0,48 | 0,65 | 90 (74 – 100) |
| | | 0,30 | 0,060 | 0,016 | 0,019 | 0,026 | 295 (250 – 320) |

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_s = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – XHF580 Nutfräsen – Zoll

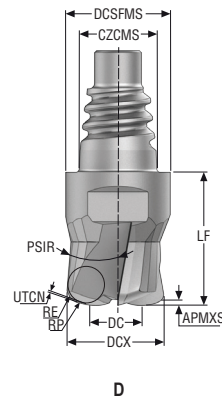
| SMG |  | a _p /DCX | f _z | | | v _c |
|-----|---|---------------------|----------------|--------|-------|--------------------|
| | | | 3/8 | 1/2 | 5/8 | |
| P1 | E/M/A/D | 0,060 | 0,30 | 0,36 | 0,48 | 440 (400 – 480) |
| | | 0,060 | 0,012 | 0,014 | 0,019 | 1450 (1400 – 1500) |
| P2 | E/M/A/D | 0,060 | 0,30 | 0,36 | 0,48 | 430 (390 – 470) |
| | | 0,060 | 0,012 | 0,014 | 0,019 | 1400 (1300 – 1500) |
| P3 | E/M/A/D | 0,060 | 0,30 | 0,36 | 0,48 | 370 (330 – 400) |
| | | 0,060 | 0,012 | 0,014 | 0,019 | 1225 (1100 – 1300) |
| P4 | E/M/A/D | 0,060 | 0,30 | 0,36 | 0,48 | 325 (290 – 360) |
| | | 0,060 | 0,012 | 0,014 | 0,019 | 1075 (960 – 1100) |
| P5 | E/M/A/D | 0,060 | 0,30 | 0,36 | 0,48 | 245 (220 – 270) |
| | | 0,060 | 0,012 | 0,014 | 0,019 | 800 (730 – 880) |
| P6 | E/M/A/D | 0,060 | 0,30 | 0,36 | 0,48 | 275 (250 – 300) |
| | | 0,060 | 0,012 | 0,014 | 0,019 | 900 (830 – 980) |
| P7 | E/M/A/D | 0,060 | 0,30 | 0,36 | 0,48 | 260 (240 – 280) |
| | | 0,060 | 0,012 | 0,014 | 0,019 | 850 (790 – 910) |
| P8 | E/M/A/D | 0,060 | 0,30 | 0,36 | 0,48 | 245 (220 – 270) |
| | | 0,060 | 0,012 | 0,014 | 0,019 | 800 (730 – 880) |
| P11 | E/M/A/D | 0,055 | 0,24 | 0,28 | 0,38 | 145 (130 – 160) |
| | | 0,055 | 0,0095 | 0,011 | 0,015 | 475 (430 – 520) |
| P12 | E/M/A/D | 0,055 | 0,24 | 0,28 | 0,38 | 85 (75 – 94) |
| | | 0,055 | 0,0095 | 0,011 | 0,015 | 280 (250 – 300) |
| M1 | E/M/A | 0,055 | 0,24 | 0,28 | 0,38 | 170 (150 – 180) |
| | | 0,055 | 0,0095 | 0,011 | 0,015 | 560 (500 – 590) |
| M2 | E/M/A | 0,055 | 0,24 | 0,28 | 0,38 | 135 (120 – 150) |
| | | 0,055 | 0,0095 | 0,011 | 0,015 | 445 (400 – 490) |
| M3 | E/M/A | 0,055 | 0,24 | 0,28 | 0,38 | 105 (88 – 110) |
| | | 0,055 | 0,0095 | 0,011 | 0,015 | 345 (290 – 360) |
| M4 | E/M/A | 0,055 | 0,24 | 0,28 | 0,38 | 80 (66 – 89) |
| | | 0,055 | 0,0095 | 0,011 | 0,015 | 260 (220 – 290) |
| M5 | E/M/A | 0,055 | 0,24 | 0,28 | 0,38 | 65 (55 – 74) |
| | | 0,055 | 0,0095 | 0,011 | 0,015 | 215 (190 – 240) |
| K1 | E/M/A/D | 0,060 | 0,30 | 0,36 | 0,48 | 430 (390 – 480) |
| | | 0,060 | 0,012 | 0,014 | 0,019 | 1400 (1300 – 1500) |
| K2 | E/M/A/D | 0,060 | 0,30 | 0,36 | 0,48 | 375 (340 – 410) |
| | | 0,060 | 0,012 | 0,014 | 0,019 | 1225 (1200 – 1300) |
| K3 | E/M/A/D | 0,060 | 0,30 | 0,36 | 0,48 | 315 (290 – 350) |
| | | 0,060 | 0,012 | 0,014 | 0,019 | 1025 (960 – 1100) |
| K4 | E/M/A/D | 0,060 | 0,30 | 0,36 | 0,48 | 305 (270 – 330) |
| | | 0,060 | 0,012 | 0,014 | 0,019 | 1000 (890 – 1000) |
| K5 | E/M/A/D | 0,060 | 0,30 | 0,36 | 0,48 | 180 (170 – 200) |
| | | 0,060 | 0,012 | 0,014 | 0,019 | 590 (560 – 650) |
| K6 | E/M/A/D | 0,060 | 0,30 | 0,36 | 0,48 | 265 (240 – 290) |
| | | 0,060 | 0,012 | 0,014 | 0,019 | 870 (790 – 950) |
| K7 | E/M/A/D | 0,060 | 0,30 | 0,36 | 0,48 | 230 (210 – 250) |
| | | 0,060 | 0,012 | 0,014 | 0,019 | 750 (690 – 820) |
| S1 | E | 0,034 | 0,18 | 0,22 | 0,28 | 47 (32 – 62) |
| | | 0,034 | 0,0070 | 0,0085 | 0,011 | 155 (110 – 200) |
| S2 | E | 0,034 | 0,18 | 0,22 | 0,28 | 38 (26 – 50) |
| | | 0,034 | 0,0070 | 0,0085 | 0,011 | 125 (86 – 160) |
| S3 | E | 0,034 | 0,18 | 0,22 | 0,28 | 32 (22 – 43) |
| | | 0,034 | 0,0070 | 0,0085 | 0,011 | 105 (73 – 140) |
| S11 | E | 0,034 | 0,18 | 0,22 | 0,28 | 160 (150 – 180) |
| | | 0,034 | 0,0070 | 0,0085 | 0,011 | 520 (500 – 590) |
| S12 | E | 0,034 | 0,18 | 0,22 | 0,28 | 125 (110 – 140) |
| | | 0,034 | 0,0070 | 0,0085 | 0,011 | 410 (370 – 450) |
| S13 | E | 0,034 | 0,18 | 0,22 | 0,28 | 95 (84 – 100) |
| | | 0,034 | 0,0070 | 0,0085 | 0,011 | 310 (280 – 320) |
| H5 | M/A | 0,060 | 0,24 | 0,28 | 0,38 | 105 (88 – 120) |
| | | 0,060 | 0,0095 | 0,011 | 0,015 | 345 (290 – 390) |
| H8 | M/A | 0,060 | 0,24 | 0,28 | 0,38 | 105 (88 – 120) |
| | | 0,060 | 0,0095 | 0,011 | 0,015 | 345 (290 – 390) |
| H21 | M/A | 0,060 | 0,24 | 0,28 | 0,38 | 105 (88 – 120) |
| | | 0,060 | 0,0095 | 0,011 | 0,015 | 345 (290 – 390) |
| H31 | M/A | 0,060 | 0,24 | 0,28 | 0,38 | 80 (67 – 91) |
| | | 0,060 | 0,0095 | 0,011 | 0,015 | 260 (220 – 290) |

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

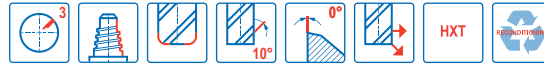
Unversell
 Stahl und Guss
 Stahl und Guss
 Rostfrei und ISO-S-Werkstoffe
 NE-Metalle
 Harter
 Kunststoffe und Composite
 Graphit
 X-Heads
 Minmaster Plus
 Minmaster

XHF780

Hochvorschubfräser – ISO– M und ISO– S – 3 Schneiden – Eckenradius



- Toleranzen:
- DCX= -0,02/-0,04 mm
- RE= ±0,05 mm
- Nachschleifen möglich, wenn DCX ≥ Ø12 ist mm



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | CZCMS | DCX | DC | DCSFMS | APMXS | LF | RE | RP | UTCN | PSIR° | PCEDC | SW | Beschich- tung |
|-------------------|--------------------|------------------|-------------------|-------|------|-----|--------|-------|------|-----|-------|-------|-------|-------|----|-------------------|
| | | | | | mm | mm | mm | mm | mm | mm | mm | mm | | | | HXT |
| XHF780E10100D1HZ3 | 10137957 | 1 | D | E10 | 10,0 | 5,0 | 9,7 | 0,45 | 12,3 | 0,8 | 1,175 | 0,232 | -5,0 | 3 | 8 | ■ |
| XHF780E12120D1HZ3 | 10137958 | 1 | D | E12 | 12,0 | 6,0 | 11,7 | 0,5 | 14,4 | 1,0 | 1,416 | 0,262 | -5,0 | 3 | 10 | ■ |
| XHF780E16160D1HZ3 | 10137959 | 1 | D | E16 | 16,0 | 8,0 | 15,5 | 0,6 | 18,6 | 1,5 | 1,989 | 0,32 | -5,0 | 3 | 12 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

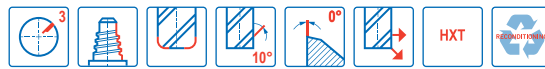
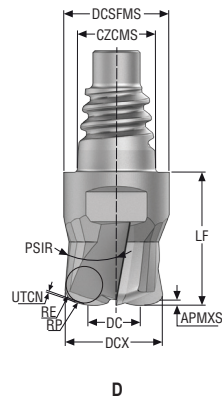
X-Heads

Minimaster Plus

Minimaster

XHF780

Hochvorschubfräser – ISO– M und ISO– S – 3 Schneiden – Eckenradius – Zoll



- Toleranzen:
- DCX= -0.0008/-0.0016 Zoll
- RE= ±.002 Zoll
- Nachschleifen möglich, wenn DCX ≥ Ø.500 ist Zoll

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | CZCMS | DCX | DC | DCSFMS | APMXS | LF | RE | RP | UTCN | PSIR° | PCEDC | SW | Beschichtung |
|--------------------|--------------------|------------------|-------------------|-------|-------|-------|--------|-------|-------|-------|-------|-------|-------|-------|----|--------------|
| | | | | | Zoll | Zoll | Zoll | Zoll | Zoll | Zoll | Zoll | Zoll | | | | HXT |
| XHF780E10.375D1HZ3 | 10137960 | 1 | D | E10 | 0.375 | 0.188 | 0.364 | 0.018 | 0.484 | 0.028 | 0.043 | 0.009 | -5,0 | 3 | 8 | ■ |
| XHF780E12.500D1HZ3 | 10137961 | 1 | D | E12 | 0.461 | 0.250 | 0.484 | 0.020 | 0.567 | 0.045 | 0.061 | 0.010 | -5,0 | 3 | 10 | ■ |
| XHF780E16.625D1HZ3 | 10137962 | 1 | D | E16 | 0.625 | 0.313 | 0.610 | 0.024 | 0.732 | 0.061 | 0.080 | 0.012 | -5,0 | 3 | 12 | ■ |

■ Lagerstandard.

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Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

X-Heads

Minimaster Plus


Minimaster

Schnittdaten – XHF780 Eckfräsen

| SMG | | a _e /DCX | a _p /DCX | f _z | | | v _c |
|-----|---------|---------------------|---------------------|----------------|-------|-------|--------------------|
| | | | | 10 | 12 | 16 | |
| P1 | E/M/A/D | 0,30 | 0,040 | 0,50 | 0,60 | 0,80 | 355 (330 – 410) |
| | | 0,30 | 0,040 | 0,020 | 0,024 | 0,032 | 1175 (1100 – 1300) |
| P2 | E/M/A/D | 0,30 | 0,040 | 0,50 | 0,60 | 0,80 | 345 (320 – 390) |
| | | 0,30 | 0,040 | 0,020 | 0,024 | 0,032 | 1125 (1100 – 1200) |
| P3 | E/M/A/D | 0,30 | 0,040 | 0,50 | 0,60 | 0,80 | 295 (280 – 340) |
| | | 0,30 | 0,040 | 0,020 | 0,024 | 0,032 | 970 (920 – 1100) |
| P4 | E/M/A/D | 0,30 | 0,040 | 0,50 | 0,60 | 0,80 | 260 (250 – 300) |
| | | 0,30 | 0,040 | 0,020 | 0,024 | 0,032 | 850 (830 – 980) |
| P5 | E/M/A/D | 0,30 | 0,040 | 0,50 | 0,60 | 0,80 | 260 (250 – 300) |
| | | 0,30 | 0,040 | 0,020 | 0,024 | 0,032 | 850 (830 – 980) |
| P6 | E/M/A/D | 0,30 | 0,040 | 0,50 | 0,60 | 0,80 | 195 (180 – 230) |
| | | 0,30 | 0,040 | 0,020 | 0,024 | 0,032 | 640 (600 – 750) |
| P7 | E/M/A/D | 0,30 | 0,040 | 0,50 | 0,60 | 0,80 | 185 (170 – 220) |
| | | 0,30 | 0,040 | 0,020 | 0,024 | 0,032 | 610 (560 – 720) |
| P8 | E/M/A/D | 0,30 | 0,040 | 0,50 | 0,60 | 0,80 | 175 (160 – 210) |
| | | 0,30 | 0,040 | 0,020 | 0,024 | 0,032 | 570 (530 – 680) |
| P11 | E/M/A/D | 0,30 | 0,040 | 0,50 | 0,60 | 0,80 | 180 (170 – 210) |
| | | 0,30 | 0,040 | 0,020 | 0,024 | 0,032 | 590 (560 – 680) |
| P12 | E/M/A/D | 0,30 | 0,036 | 0,40 | 0,48 | 0,65 | 85 (83 – 100) |
| | | 0,30 | 0,036 | 0,016 | 0,019 | 0,026 | 280 (280 – 320) |
| M1 | E/M/A | 0,30 | 0,036 | 0,40 | 0,48 | 0,65 | 175 (170 – 210) |
| | | 0,30 | 0,036 | 0,016 | 0,019 | 0,026 | 570 (560 – 680) |
| M2 | E/M/A | 0,30 | 0,036 | 0,40 | 0,48 | 0,65 | 140 (140 – 160) |
| | | 0,30 | 0,036 | 0,016 | 0,019 | 0,026 | 460 (460 – 520) |
| M3 | E/M/A | 0,30 | 0,036 | 0,40 | 0,48 | 0,65 | 105 (97 – 130) |
| | | 0,30 | 0,036 | 0,016 | 0,019 | 0,026 | 345 (320 – 420) |
| M4 | E/M/A | 0,30 | 0,036 | 0,40 | 0,48 | 0,65 | 75 (73 – 100) |
| | | 0,30 | 0,036 | 0,016 | 0,019 | 0,026 | 245 (240 – 320) |
| M5 | E/M/A | 0,30 | 0,036 | 0,40 | 0,48 | 0,65 | 65 (61 – 83) |
| | | 0,30 | 0,036 | 0,016 | 0,019 | 0,026 | 215 (210 – 270) |
| S1 | E | 0,30 | 0,022 | 0,24 | 0,28 | 0,38 | 45 (36 – 71) |
| | | 0,30 | 0,022 | 0,0095 | 0,011 | 0,015 | 150 (120 – 230) |
| S2 | E | 0,30 | 0,022 | 0,24 | 0,28 | 0,38 | 36 (29 – 57) |
| | | 0,30 | 0,022 | 0,0095 | 0,011 | 0,015 | 120 (96 – 180) |
| S3 | E | 0,30 | 0,022 | 0,24 | 0,28 | 0,38 | 31 (25 – 49) |
| | | 0,30 | 0,022 | 0,0095 | 0,011 | 0,015 | 100 (83 – 160) |
| S11 | E | 0,30 | 0,022 | 0,36 | 0,42 | 0,55 | 160 (160 – 190) |
| | | 0,30 | 0,022 | 0,014 | 0,017 | 0,022 | 520 (530 – 620) |
| S12 | E | 0,30 | 0,022 | 0,36 | 0,42 | 0,55 | 120 (120 – 150) |
| | | 0,30 | 0,022 | 0,014 | 0,017 | 0,022 | 395 (400 – 490) |
| S13 | E | 0,30 | 0,022 | 0,36 | 0,42 | 0,55 | 95 (90 – 110) |
| | | 0,30 | 0,022 | 0,014 | 0,017 | 0,022 | 310 (300 – 360) |
| H5 | M/A | 0,30 | 0,040 | 0,40 | 0,48 | 0,65 | 105 (99 – 130) |
| | | 0,30 | 0,040 | 0,016 | 0,019 | 0,026 | 345 (330 – 420) |
| H8 | M/A | 0,30 | 0,040 | 0,40 | 0,48 | 0,65 | 105 (99 – 130) |
| | | 0,30 | 0,040 | 0,016 | 0,019 | 0,026 | 345 (330 – 420) |
| H11 | M/A | 0,30 | 0,040 | 0,40 | 0,48 | 0,65 | 135 (130 – 170) |
| | | 0,30 | 0,040 | 0,016 | 0,019 | 0,026 | 445 (430 – 550) |
| H21 | M/A | 0,30 | 0,040 | 0,40 | 0,48 | 0,65 | 105 (99 – 130) |
| | | 0,30 | 0,040 | 0,016 | 0,019 | 0,026 | 345 (330 – 420) |
| H31 | M/A | 0,30 | 0,040 | 0,40 | 0,48 | 0,65 | 80 (75 – 100) |
| | | 0,30 | 0,040 | 0,016 | 0,019 | 0,026 | 260 (250 – 320) |

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – XHF780 Nutfräsen

| SMG |  | a _p /DCX | f _z | | | v _c |
|-----|---|---------------------|----------------|--------|-------|-------------------|
| | | | 10 | 12 | 16 | |
| P1 | E/M/A/D | 0,040 | 0,30 | 0,36 | 0,48 | 310 (290 – 350) |
| | | 0,040 | 0,012 | 0,014 | 0,019 | 1025 (960 – 1100) |
| P2 | E/M/A/D | 0,040 | 0,30 | 0,36 | 0,48 | 300 (290 – 350) |
| | | 0,040 | 0,012 | 0,014 | 0,019 | 980 (960 – 1100) |
| P3 | E/M/A/D | 0,040 | 0,30 | 0,36 | 0,48 | 260 (250 – 300) |
| | | 0,040 | 0,012 | 0,014 | 0,019 | 850 (830 – 980) |
| P4 | E/M/A/D | 0,040 | 0,30 | 0,36 | 0,48 | 230 (220 – 260) |
| | | 0,040 | 0,012 | 0,014 | 0,019 | 750 (730 – 850) |
| P5 | E/M/A/D | 0,040 | 0,30 | 0,36 | 0,48 | 230 (220 – 260) |
| | | 0,040 | 0,012 | 0,014 | 0,019 | 750 (730 – 850) |
| P6 | E/M/A/D | 0,040 | 0,30 | 0,36 | 0,48 | 170 (160 – 200) |
| | | 0,040 | 0,012 | 0,014 | 0,019 | 560 (530 – 650) |
| P7 | E/M/A/D | 0,040 | 0,30 | 0,36 | 0,48 | 160 (150 – 190) |
| | | 0,040 | 0,012 | 0,014 | 0,019 | 520 (500 – 620) |
| P8 | E/M/A/D | 0,040 | 0,30 | 0,36 | 0,48 | 150 (140 – 180) |
| | | 0,040 | 0,012 | 0,014 | 0,019 | 490 (460 – 590) |
| P11 | E/M/A/D | 0,040 | 0,30 | 0,36 | 0,48 | 155 (150 – 180) |
| | | 0,040 | 0,012 | 0,014 | 0,019 | 510 (500 – 590) |
| P12 | E/M/A/D | 0,036 | 0,24 | 0,28 | 0,38 | 75 (73 – 92) |
| | | 0,036 | 0,0095 | 0,011 | 0,015 | 245 (240 – 300) |
| M1 | E/M/A | 0,036 | 0,24 | 0,28 | 0,38 | 150 (150 – 180) |
| | | 0,036 | 0,0095 | 0,011 | 0,015 | 490 (500 – 590) |
| M2 | E/M/A | 0,036 | 0,24 | 0,28 | 0,38 | 120 (120 – 140) |
| | | 0,036 | 0,0095 | 0,011 | 0,015 | 395 (400 – 450) |
| M3 | E/M/A | 0,036 | 0,24 | 0,28 | 0,38 | 90 (85 – 110) |
| | | 0,036 | 0,0095 | 0,011 | 0,015 | 295 (280 – 360) |
| M4 | E/M/A | 0,036 | 0,24 | 0,28 | 0,38 | 65 (64 – 87) |
| | | 0,036 | 0,0095 | 0,011 | 0,015 | 215 (210 – 280) |
| M5 | E/M/A | 0,036 | 0,24 | 0,28 | 0,38 | 55 (53 – 72) |
| | | 0,036 | 0,0095 | 0,011 | 0,015 | 180 (180 – 230) |
| S1 | E | 0,022 | 0,18 | 0,22 | 0,28 | 38 (31 – 60) |
| | | 0,022 | 0,0070 | 0,0085 | 0,011 | 125 (110 – 190) |
| S2 | E | 0,022 | 0,18 | 0,22 | 0,28 | 30 (25 – 48) |
| | | 0,022 | 0,0070 | 0,0085 | 0,011 | 100 (83 – 150) |
| S3 | E | 0,022 | 0,18 | 0,22 | 0,28 | 26 (21 – 41) |
| | | 0,022 | 0,0070 | 0,0085 | 0,011 | 85 (69 – 130) |
| S11 | E | 0,022 | 0,18 | 0,22 | 0,28 | 145 (140 – 170) |
| | | 0,022 | 0,0070 | 0,0085 | 0,011 | 475 (460 – 550) |
| S12 | E | 0,022 | 0,18 | 0,22 | 0,28 | 110 (110 – 130) |
| | | 0,022 | 0,0070 | 0,0085 | 0,011 | 360 (370 – 420) |
| S13 | E | 0,022 | 0,18 | 0,22 | 0,28 | 85 (82 – 100) |
| | | 0,022 | 0,0070 | 0,0085 | 0,011 | 280 (270 – 320) |
| H5 | M/A | 0,040 | 0,24 | 0,28 | 0,38 | 90 (86 – 110) |
| | | 0,040 | 0,0095 | 0,011 | 0,015 | 295 (290 – 360) |
| H8 | M/A | 0,040 | 0,24 | 0,28 | 0,38 | 90 (86 – 110) |
| | | 0,040 | 0,0095 | 0,011 | 0,015 | 295 (290 – 360) |
| H11 | M/A | 0,040 | 0,24 | 0,28 | 0,38 | 115 (110 – 140) |
| | | 0,040 | 0,0095 | 0,011 | 0,015 | 375 (370 – 450) |
| H21 | M/A | 0,040 | 0,24 | 0,28 | 0,38 | 90 (86 – 110) |
| | | 0,040 | 0,0095 | 0,011 | 0,015 | 295 (290 – 360) |
| H31 | M/A | 0,040 | 0,24 | 0,28 | 0,38 | 70 (65 – 88) |
| | | 0,040 | 0,0095 | 0,011 | 0,015 | 230 (220 – 280) |

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte


Universell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

Schnittdaten – XHF780 Eckfräsen – Zoll

| SMG | | a _e /DCX | a _p /DCX | f _z | | | v _c |
|-----|---------|---------------------|---------------------|----------------|-------|-------|--------------------|
| | | | | 3/8 | 1/2 | 5/8 | |
| P1 | E/M/A/D | 0,30 | 0,040 | 0,50 | 0,60 | 0,80 | 370 (330 – 410) |
| | | 0,30 | 0,040 | 0,020 | 0,024 | 0,032 | 1225 (1100 – 1300) |
| P2 | E/M/A/D | 0,30 | 0,040 | 0,50 | 0,60 | 0,80 | 360 (320 – 390) |
| | | 0,30 | 0,040 | 0,020 | 0,024 | 0,032 | 1175 (1100 – 1200) |
| P3 | E/M/A/D | 0,30 | 0,040 | 0,50 | 0,60 | 0,80 | 310 (280 – 340) |
| | | 0,30 | 0,040 | 0,020 | 0,024 | 0,032 | 1025 (920 – 1100) |
| P4 | E/M/A/D | 0,30 | 0,040 | 0,50 | 0,60 | 0,80 | 270 (250 – 300) |
| | | 0,30 | 0,040 | 0,020 | 0,024 | 0,032 | 890 (830 – 980) |
| P5 | E/M/A/D | 0,30 | 0,040 | 0,50 | 0,60 | 0,80 | 270 (250 – 300) |
| | | 0,30 | 0,040 | 0,020 | 0,024 | 0,032 | 890 (830 – 980) |
| P6 | E/M/A/D | 0,30 | 0,040 | 0,50 | 0,60 | 0,80 | 305 (280 – 330) |
| | | 0,30 | 0,040 | 0,020 | 0,024 | 0,032 | 1000 (920 – 1000) |
| P7 | E/M/A/D | 0,30 | 0,040 | 0,50 | 0,60 | 0,80 | 290 (260 – 320) |
| | | 0,30 | 0,040 | 0,020 | 0,024 | 0,032 | 950 (860 – 1000) |
| P8 | E/M/A/D | 0,30 | 0,040 | 0,50 | 0,60 | 0,80 | 270 (250 – 300) |
| | | 0,30 | 0,040 | 0,020 | 0,024 | 0,032 | 890 (830 – 980) |
| P11 | E/M/A/D | 0,30 | 0,036 | 0,40 | 0,48 | 0,65 | 160 (150 – 170) |
| | | 0,30 | 0,036 | 0,016 | 0,019 | 0,026 | 520 (500 – 550) |
| P12 | E/M/A/D | 0,30 | 0,036 | 0,40 | 0,48 | 0,65 | 95 (83 – 100) |
| | | 0,30 | 0,036 | 0,016 | 0,019 | 0,026 | 310 (280 – 320) |
| M1 | E/M/A | 0,30 | 0,036 | 0,40 | 0,48 | 0,65 | 190 (170 – 210) |
| | | 0,30 | 0,036 | 0,016 | 0,019 | 0,026 | 620 (560 – 680) |
| M2 | E/M/A | 0,30 | 0,036 | 0,40 | 0,48 | 0,65 | 150 (140 – 160) |
| | | 0,30 | 0,036 | 0,016 | 0,019 | 0,026 | 490 (460 – 520) |
| M3 | E/M/A | 0,30 | 0,036 | 0,40 | 0,48 | 0,65 | 115 (97 – 130) |
| | | 0,30 | 0,036 | 0,016 | 0,019 | 0,026 | 375 (320 – 420) |
| M4 | E/M/A | 0,30 | 0,036 | 0,40 | 0,48 | 0,65 | 85 (73 – 100) |
| | | 0,30 | 0,036 | 0,016 | 0,019 | 0,026 | 280 (240 – 320) |
| M5 | E/M/A | 0,30 | 0,036 | 0,40 | 0,48 | 0,65 | 70 (61 – 83) |
| | | 0,30 | 0,036 | 0,016 | 0,019 | 0,026 | 230 (210 – 270) |
| S1 | E | 0,30 | 0,022 | 0,24 | 0,28 | 0,38 | 55 (36 – 71) |
| | | 0,30 | 0,022 | 0,0095 | 0,011 | 0,015 | 180 (120 – 230) |
| S2 | E | 0,30 | 0,022 | 0,24 | 0,28 | 0,38 | 43 (29 – 57) |
| | | 0,30 | 0,022 | 0,0095 | 0,011 | 0,015 | 140 (96 – 180) |
| S3 | E | 0,30 | 0,022 | 0,24 | 0,28 | 0,38 | 37 (25 – 49) |
| | | 0,30 | 0,022 | 0,0095 | 0,011 | 0,015 | 120 (83 – 160) |
| S11 | E | 0,30 | 0,022 | 0,36 | 0,42 | 0,55 | 175 (160 – 190) |
| | | 0,30 | 0,022 | 0,014 | 0,017 | 0,022 | 570 (530 – 620) |
| S12 | E | 0,30 | 0,022 | 0,36 | 0,42 | 0,55 | 135 (120 – 150) |
| | | 0,30 | 0,022 | 0,014 | 0,017 | 0,022 | 445 (400 – 490) |
| S13 | E | 0,30 | 0,022 | 0,36 | 0,42 | 0,55 | 105 (90 – 110) |
| | | 0,30 | 0,022 | 0,014 | 0,017 | 0,022 | 345 (300 – 360) |
| H5 | M/A | 0,30 | 0,040 | 0,40 | 0,48 | 0,65 | 115 (99 – 130) |
| | | 0,30 | 0,040 | 0,016 | 0,019 | 0,026 | 375 (330 – 420) |
| H8 | M/A | 0,30 | 0,040 | 0,40 | 0,48 | 0,65 | 115 (99 – 130) |
| | | 0,30 | 0,040 | 0,016 | 0,019 | 0,026 | 375 (330 – 420) |
| H11 | M/A | 0,30 | 0,040 | 0,40 | 0,48 | 0,65 | 150 (130 – 170) |
| | | 0,30 | 0,040 | 0,016 | 0,019 | 0,026 | 490 (430 – 550) |
| H21 | M/A | 0,30 | 0,040 | 0,40 | 0,48 | 0,65 | 115 (99 – 130) |
| | | 0,30 | 0,040 | 0,016 | 0,019 | 0,026 | 375 (330 – 420) |
| H31 | M/A | 0,30 | 0,040 | 0,40 | 0,48 | 0,65 | 90 (75 – 100) |
| | | 0,30 | 0,040 | 0,016 | 0,019 | 0,026 | 295 (250 – 320) |

SMG = Seco Werkstoff-Gruppe
 Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge
 v_c = m/min (sf/min)
 f_z = mm/Zahn (Zoll/Zahn)
 a_p = mm/DC (Zoll/DC) = Faktor
 a_e = mm/DC (Zoll/DC) = Faktor
 Alle Schnittdaten sind Richtwerte

Schnittdaten – XHF780 Nutfräsen – Zoll

| SMG |  | a _p /DCX | f _z | | | v _c |
|-----|---|---------------------|----------------|--------|-------|-------------------|
| | | | 3/8 | 1/2 | 5/8 | |
| P1 | E/M/A/D | 0,040 | 0,30 | 0,36 | 0,48 | 325 (290 – 350) |
| | | 0,040 | 0,012 | 0,014 | 0,019 | 1075 (960 – 1100) |
| P2 | E/M/A/D | 0,040 | 0,30 | 0,36 | 0,48 | 315 (290 – 350) |
| | | 0,040 | 0,012 | 0,014 | 0,019 | 1025 (960 – 1100) |
| P3 | E/M/A/D | 0,040 | 0,30 | 0,36 | 0,48 | 270 (250 – 300) |
| | | 0,040 | 0,012 | 0,014 | 0,019 | 890 (830 – 980) |
| P4 | E/M/A/D | 0,040 | 0,30 | 0,36 | 0,48 | 240 (220 – 260) |
| | | 0,040 | 0,012 | 0,014 | 0,019 | 790 (730 – 850) |
| P5 | E/M/A/D | 0,040 | 0,30 | 0,36 | 0,48 | 240 (220 – 260) |
| | | 0,040 | 0,012 | 0,014 | 0,019 | 790 (730 – 850) |
| P6 | E/M/A/D | 0,040 | 0,30 | 0,36 | 0,48 | 270 (240 – 290) |
| | | 0,040 | 0,012 | 0,014 | 0,019 | 890 (790 – 950) |
| P7 | E/M/A/D | 0,040 | 0,30 | 0,36 | 0,48 | 255 (230 – 280) |
| | | 0,040 | 0,012 | 0,014 | 0,019 | 840 (760 – 910) |
| P8 | E/M/A/D | 0,040 | 0,30 | 0,36 | 0,48 | 240 (220 – 260) |
| | | 0,040 | 0,012 | 0,014 | 0,019 | 790 (730 – 850) |
| P11 | E/M/A/D | 0,036 | 0,24 | 0,28 | 0,38 | 140 (130 – 150) |
| | | 0,036 | 0,0095 | 0,011 | 0,015 | 460 (430 – 490) |
| P12 | E/M/A/D | 0,036 | 0,24 | 0,28 | 0,38 | 80 (73 – 92) |
| | | 0,036 | 0,0095 | 0,011 | 0,015 | 260 (240 – 300) |
| M1 | E/M/A | 0,036 | 0,24 | 0,28 | 0,38 | 165 (150 – 180) |
| | | 0,036 | 0,0095 | 0,011 | 0,015 | 540 (500 – 590) |
| M2 | E/M/A | 0,036 | 0,24 | 0,28 | 0,38 | 130 (120 – 140) |
| | | 0,036 | 0,0095 | 0,011 | 0,015 | 425 (400 – 450) |
| M3 | E/M/A | 0,036 | 0,24 | 0,28 | 0,38 | 100 (85 – 110) |
| | | 0,036 | 0,0095 | 0,011 | 0,015 | 330 (280 – 360) |
| M4 | E/M/A | 0,036 | 0,24 | 0,28 | 0,38 | 75 (64 – 87) |
| | | 0,036 | 0,0095 | 0,011 | 0,015 | 245 (210 – 280) |
| M5 | E/M/A | 0,036 | 0,24 | 0,28 | 0,38 | 65 (53 – 72) |
| | | 0,036 | 0,0095 | 0,011 | 0,015 | 215 (180 – 230) |
| S1 | E | 0,022 | 0,18 | 0,22 | 0,28 | 45 (31 – 60) |
| | | 0,022 | 0,0070 | 0,0085 | 0,011 | 150 (110 – 190) |
| S2 | E | 0,022 | 0,18 | 0,22 | 0,28 | 36 (25 – 48) |
| | | 0,022 | 0,0070 | 0,0085 | 0,011 | 120 (83 – 150) |
| S3 | E | 0,022 | 0,18 | 0,22 | 0,28 | 31 (21 – 41) |
| | | 0,022 | 0,0070 | 0,0085 | 0,011 | 100 (69 – 130) |
| S11 | E | 0,022 | 0,18 | 0,22 | 0,28 | 155 (140 – 170) |
| | | 0,022 | 0,0070 | 0,0085 | 0,011 | 510 (460 – 550) |
| S12 | E | 0,022 | 0,18 | 0,22 | 0,28 | 120 (110 – 130) |
| | | 0,022 | 0,0070 | 0,0085 | 0,011 | 395 (370 – 420) |
| S13 | E | 0,022 | 0,18 | 0,22 | 0,28 | 95 (82 – 100) |
| | | 0,022 | 0,0070 | 0,0085 | 0,011 | 310 (270 – 320) |
| H5 | M/A | 0,040 | 0,24 | 0,28 | 0,38 | 100 (86 – 110) |
| | | 0,040 | 0,0095 | 0,011 | 0,015 | 330 (290 – 360) |
| H8 | M/A | 0,040 | 0,24 | 0,28 | 0,38 | 100 (86 – 110) |
| | | 0,040 | 0,0095 | 0,011 | 0,015 | 330 (290 – 360) |
| H11 | M/A | 0,040 | 0,24 | 0,28 | 0,38 | 130 (110 – 140) |
| | | 0,040 | 0,0095 | 0,011 | 0,015 | 425 (370 – 450) |
| H21 | M/A | 0,040 | 0,24 | 0,28 | 0,38 | 100 (86 – 110) |
| | | 0,040 | 0,0095 | 0,011 | 0,015 | 330 (290 – 360) |
| H31 | M/A | 0,040 | 0,24 | 0,28 | 0,38 | 75 (65 – 88) |
| | | 0,040 | 0,0095 | 0,011 | 0,015 | 245 (220 – 280) |

SMG = Seco Werkstoff-Gruppe

Kühlung: A = Luft D = Trockenbearbeitung E = Emulsion M = Minimalmenge

v_c = m/min (sf/min)

f_z = mm/Zahn (Zoll/Zahn)

a_p = mm/DC (Zoll/DC) = Faktor

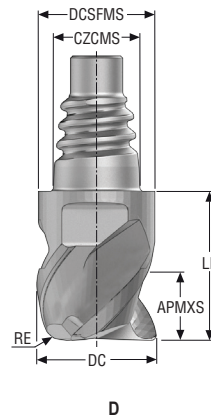
a_e = mm/DC (Zoll/DC) = Faktor

Alle Schnittdaten sind Richtwerte

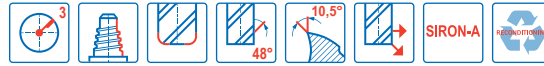
Unversell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

XVE540

Allgemeine Anwendung – Universell – Eckfräser – 3 Schneiden – Eckenradius



- Toleranzen:
- DC= h9
- RE= ±0,015 mm
- Nachschleifen möglich, wenn DC ≥ Ø12 ist mm



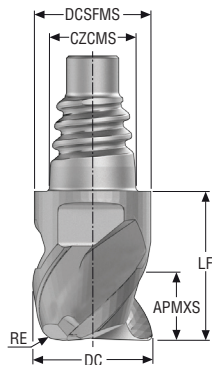
| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | CZCMS | DC | DCSFMS | APMXS | LF | RE | PCEDC | SW | Beschichtung |
|----------------------|--------------------|------------------|-------------------|-------|------|--------|-------|------|-----|-------|----|--------------|
| | | | | | mm | mm | mm | mm | mm | | | SIRA |
| XVE540E10100D1R050Z3 | 10137981 | 1 | D | E10 | 10,0 | 9,7 | 5,5 | 12,4 | 0,5 | 3 | 8 | ■ |
| XVE540E12120D1R050Z3 | 10137982 | 1 | D | E12 | 12,0 | 11,7 | 6,5 | 14,5 | 0,5 | 3 | 10 | ■ |
| XVE540E16160D1R050Z3 | 10137983 | 1 | D | E16 | 16,0 | 15,5 | 8,5 | 18,7 | 0,5 | 3 | 12 | ■ |
| XVE540E20200D1R050Z3 | 10137984 | 1 | D | E20 | 20,0 | 19,3 | 11,0 | 21,3 | 0,5 | 3 | 16 | ■ |

■ Lagerstandard.

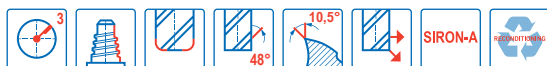
Universell
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

XVE540

Allgemeine Anwendung – Universell – Eckfräser – 3 Schneiden – Eckenradius



D



- Toleranzen:
- DC= h9
- RE= .015 Zoll= ±.0006 Zoll
- RE= .031 Zoll= ±.0012 Zoll
- Nachschleifen möglich, wenn DC ≥ Ø.500 ist Zoll



| Bezeichnung | Produkt-nummer | Längen-index | Werkzeug-form | CZCMS | DC | DCSFMS | APMXS | LF | RE | PCEDC | SW | Beschichtung |
|-----------------------|----------------|--------------|---------------|-------|-------|--------|-------|-------|-------|-------|----|--------------|
| | | | | | Zoll | Zoll | Zoll | Zoll | Zoll | | | SIRA |
| XVE540E10.375D1R015Z3 | 10137985 | 1 | D | E10 | 0.375 | 0.364 | 0.209 | 0.488 | 0.015 | 3 | 8 | ■ |
| XVE540E12.500D1R015Z3 | 10137986 | 1 | D | E12 | 0.500 | 0.484 | 0.276 | 0.575 | 0.015 | 3 | 10 | ■ |
| XVE540E16.625D1R015Z3 | 10137987 | 1 | D | E16 | 0.625 | 0.610 | 0.335 | 0.736 | 0.015 | 3 | 12 | ■ |
| XVE540E20.750D1R031Z3 | 10137988 | 1 | D | E20 | 0.750 | 0.728 | 0.413 | 0.839 | 0.031 | 3 | 16 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads


Minimaster Plus

Minimaster

Schnittdaten – XVE540 – Eckfräsen PCEDC 3

| SMG | | a _d /DC | a _p /DC | f _z | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|--------|--------|--------|--------------------|
| | | | | 10 | 12 | 16 | 20 | |
| P1 | E/M/A/D | 0,50 | 0,50 | 0,055 | 0,065 | 0,080 | 0,090 | 175 (140 – 220) |
| | | 0,50 | 0,50 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 570 (460 – 720) |
| P2 | E/M/A/D | 0,50 | 0,50 | 0,055 | 0,065 | 0,080 | 0,090 | 170 (130 – 210) |
| | | 0,50 | 0,50 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 560 (430 – 680) |
| P3 | E/M/A/D | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 150 (120 – 180) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 490 (400 – 590) |
| P4 | E/M/A/D | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 135 (100 – 160) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 445 (330 – 520) |
| P5 | E/M/A/D | 0,50 | 0,50 | 0,050 | 0,060 | 0,070 | 0,085 | 125 (96 – 150) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0028 | 0,0034 | 410 (320 – 490) |
| P6 | E/M/A/D | 0,50 | 0,50 | 0,048 | 0,055 | 0,070 | 0,080 | 145 (110 – 170) |
| | | 0,50 | 0,50 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 475 (370 – 550) |
| P7 | E/M/A/D | 0,50 | 0,50 | 0,048 | 0,055 | 0,070 | 0,080 | 135 (110 – 160) |
| | | 0,50 | 0,50 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 445 (370 – 520) |
| P8 | E/M/A/D | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 125 (96 – 150) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 410 (320 – 490) |
| P11 | E/M/A/D | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 80 (70 – 93) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 260 (230 – 300) |
| P12 | E/M/A/D | 0,50 | 0,50 | 0,034 | 0,040 | 0,050 | 0,060 | 50 (45 – 59) |
| | | 0,50 | 0,50 | 0,0013 | 0,0016 | 0,0020 | 0,0024 | 165 (150 – 190) |
| M1 | E/M/A | 0,50 | 0,50 | 0,055 | 0,065 | 0,080 | 0,095 | 95 (81 – 100) |
| | | 0,50 | 0,50 | 0,0022 | 0,0026 | 0,0032 | 0,0038 | 310 (270 – 320) |
| M2 | E/M/A | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 75 (67 – 88) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 245 (220 – 280) |
| M3 | E/M/A | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 50 (39 – 60) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 165 (130 – 190) |
| M4 | E/M/A | 0,50 | 0,50 | 0,044 | 0,050 | 0,065 | 0,075 | 38 (30 – 46) |
| | | 0,50 | 0,50 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 125 (99 – 150) |
| M5 | E/M/A | 0,50 | 0,50 | 0,044 | 0,050 | 0,065 | 0,075 | 32 (25 – 39) |
| | | 0,50 | 0,50 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 105 (83 – 120) |
| K1 | E/M/A/D | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 155 (140 – 170) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 510 (460 – 550) |
| K2 | E/M/A/D | 0,50 | 0,50 | 0,046 | 0,055 | 0,065 | 0,075 | 135 (120 – 150) |
| | | 0,50 | 0,50 | 0,0018 | 0,0022 | 0,0026 | 0,0030 | 445 (400 – 490) |
| K3 | E/M/A/D | 0,50 | 0,50 | 0,046 | 0,055 | 0,065 | 0,075 | 115 (99 – 130) |
| | | 0,50 | 0,50 | 0,0018 | 0,0022 | 0,0026 | 0,0030 | 375 (330 – 420) |
| K4 | E/M/A/D | 0,50 | 0,50 | 0,046 | 0,055 | 0,065 | 0,075 | 110 (95 – 120) |
| | | 0,50 | 0,50 | 0,0018 | 0,0022 | 0,0026 | 0,0030 | 360 (320 – 390) |
| K5 | E/M/A/D | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 140 (120 – 150) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 460 (400 – 490) |
| K6 | E/M/A/D | 0,50 | 0,50 | 0,055 | 0,065 | 0,080 | 0,095 | 200 (170 – 220) |
| | | 0,50 | 0,50 | 0,0022 | 0,0026 | 0,0032 | 0,0038 | 660 (560 – 720) |
| K7 | E/M/A/D | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 175 (150 – 190) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 570 (500 – 620) |
| N1 | E/M/A | 0,40 | 0,50 | 0,080 | 0,095 | 0,12 | 0,14 | 550 (510 – 710) |
| | | 0,40 | 0,50 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 1800 (1700 – 2300) |
| N2 | E/M/A | 0,40 | 0,50 | 0,080 | 0,095 | 0,12 | 0,14 | 355 (330 – 450) |
| | | 0,40 | 0,50 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 1175 (1100 – 1400) |
| N3 | E/M/A | 0,40 | 0,50 | 0,080 | 0,095 | 0,12 | 0,14 | 235 (220 – 300) |
| | | 0,40 | 0,50 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 770 (730 – 980) |
| N11 | E/M/A | 0,50 | 0,50 | 0,070 | 0,080 | 0,11 | 0,13 | 300 (250 – 340) |
| | | 0,50 | 0,50 | 0,0028 | 0,0032 | 0,0044 | 0,0050 | 980 (830 – 1100) |
| S1 | E | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 30 (24 – 37) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 100 (79 – 120) |
| S2 | E | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 25 (19 – 32) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 80 (63 – 100) |
| S3 | E | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 22 (17 – 27) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 70 (56 – 88) |
| S11 | E | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 100 (72 – 120) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 330 (240 – 390) |
| S12 | E | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 75 (56 – 99) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 245 (190 – 320) |
| S13 | E | 0,50 | 0,50 | 0,044 | 0,050 | 0,065 | 0,075 | 60 (44 – 79) |
| | | 0,50 | 0,50 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 195 (150 – 250) |
| TS1 | A/D | 0,40 | 0,50 | 0,080 | 0,095 | 0,12 | 0,14 | 255 (160 – 350) |
| | | 0,40 | 0,50 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 840 (530 – 1100) |
| TP1 | A/D | 0,40 | 0,50 | 0,080 | 0,095 | 0,12 | 0,14 | 255 (160 – 350) |
| | | 0,40 | 0,50 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 840 (530 – 1100) |
| GR1 | A/D | 0,40 | 0,50 | 0,080 | 0,095 | 0,12 | 0,14 | 610 (510 – 710) |
| | | 0,40 | 0,50 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 2000 (1700 – 2300) |

Schnittdaten – XVE540 – Nutfräsen PCEDC 3


| SMG |  | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------------------|
| | | | 10 | 12 | 16 | 20 | |
| P1 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 165 (130 – 200) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 540 (430 – 650) |
| P2 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 160 (120 – 190) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 520 (400 – 620) |
| P3 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 135 (110 – 170) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 445 (370 – 550) |
| P4 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 120 (90 – 140) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 395 (300 – 450) |
| P5 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 115 (86 – 140) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 375 (290 – 450) |
| P6 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 130 (97 – 160) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 425 (320 – 520) |
| P7 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 120 (92 – 150) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 395 (310 – 490) |
| P8 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 115 (86 – 140) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 375 (290 – 450) |
| P11 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 75 (64 – 84) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 245 (210 – 270) |
| P12 | E/M/A/D | 0,50 | 0,034 | 0,040 | 0,050 | 0,060 | 44 (38 – 49) |
| | | 0,50 | 0,0013 | 0,0016 | 0,0020 | 0,0024 | 145 (130 – 160) |
| M1 | E/M/A | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 85 (75 – 99) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 280 (250 – 320) |
| M2 | E/M/A | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 70 (60 – 79) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 230 (200 – 250) |
| M3 | E/M/A | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 45 (35 – 55) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 150 (120 – 180) |
| M4 | E/M/A | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 34 (27 – 41) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 110 (89 – 130) |
| M5 | E/M/A | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 28 (22 – 34) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 90 (73 – 110) |
| K1 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 140 (120 – 150) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 460 (400 – 490) |
| K2 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 120 (110 – 130) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 395 (370 – 420) |
| K3 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 105 (89 – 110) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 345 (300 – 360) |
| K4 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 100 (85 – 110) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 330 (280 – 360) |
| K5 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 125 (110 – 140) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 410 (370 – 450) |
| K6 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 185 (150 – 200) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 610 (500 – 650) |
| K7 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 160 (130 – 170) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 520 (430 – 550) |
| N1 | E/M/A | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 540 (510 – 700) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 1775 (1700 – 2200) |
| N2 | E/M/A | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 345 (330 – 450) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 1125 (1100 – 1400) |
| N3 | E/M/A | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 230 (220 – 300) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 750 (730 – 980) |
| N11 | E/M/A | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 300 (260 – 350) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 980 (860 – 1100) |
| S1 | E | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 27 (22 – 34) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 90 (73 – 110) |
| S2 | E | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 23 (18 – 29) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 75 (60 – 95) |
| S3 | E | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 20 (15 – 24) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 65 (50 – 78) |
| S11 | E | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 90 (66 – 110) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 295 (220 – 360) |
| S12 | E | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 70 (51 – 90) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 230 (170 – 290) |
| S13 | E | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 55 (39 – 69) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 180 (130 – 220) |
| TS1 | A/D | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 250 (150 – 350) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 820 (500 – 1100) |
| TP1 | A/D | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 250 (150 – 350) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 820 (500 – 1100) |
| GR1 | A/D | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 600 (500 – 700) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 1975 (1700 – 2200) |

Unversell
Stahl und Guss
Stahlfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

Schnittdaten – XVE540 – Eckfräsen PCEDC 3 – Zoll

| SMG | | a _g /DC | a _p /DC | f _z | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|--------|--------|--------|--------------------|
| | | | | 3/8 | 1/2 | 5/8 | 3/4 | |
| P1 | E/M/A/D | 0,50 | 0,50 | 0,055 | 0,065 | 0,080 | 0,090 | 185 (150 – 210) |
| | | 0,50 | 0,50 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 610 (500 – 680) |
| P2 | E/M/A/D | 0,50 | 0,50 | 0,055 | 0,065 | 0,080 | 0,090 | 180 (150 – 200) |
| | | 0,50 | 0,50 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 590 (500 – 650) |
| P3 | E/M/A/D | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 155 (130 – 180) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 510 (430 – 590) |
| P4 | E/M/A/D | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 140 (120 – 160) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 460 (400 – 520) |
| P5 | E/M/A/D | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 110 (89 – 130) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 360 (300 – 420) |
| P6 | E/M/A/D | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 125 (100 – 140) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 410 (330 – 450) |
| P7 | E/M/A/D | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 115 (94 – 140) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 375 (310 – 450) |
| P8 | E/M/A/D | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,090 | 110 (89 – 130) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 360 (300 – 420) |
| P11 | E/M/A/D | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 95 (70 – 110) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 310 (230 – 360) |
| P12 | E/M/A/D | 0,50 | 0,50 | 0,034 | 0,040 | 0,050 | 0,060 | 60 (45 – 73) |
| | | 0,50 | 0,50 | 0,0013 | 0,0016 | 0,0020 | 0,0024 | 195 (150 – 230) |
| M1 | E/M/A | 0,50 | 0,50 | 0,055 | 0,065 | 0,080 | 0,095 | 105 (81 – 130) |
| | | 0,50 | 0,50 | 0,0022 | 0,0026 | 0,0032 | 0,0038 | 345 (270 – 420) |
| M2 | E/M/A | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 90 (67 – 110) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 295 (220 – 360) |
| M3 | E/M/A | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 75 (56 – 99) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 245 (190 – 320) |
| M4 | E/M/A | 0,50 | 0,50 | 0,044 | 0,050 | 0,065 | 0,075 | 60 (43 – 76) |
| | | 0,50 | 0,50 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 195 (150 – 240) |
| M5 | E/M/A | 0,50 | 0,50 | 0,044 | 0,050 | 0,065 | 0,075 | 50 (36 – 63) |
| | | 0,50 | 0,50 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 165 (120 – 200) |
| K1 | E/M/A/D | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 140 (120 – 160) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 460 (400 – 520) |
| K2 | E/M/A/D | 0,50 | 0,50 | 0,046 | 0,055 | 0,065 | 0,075 | 120 (110 – 140) |
| | | 0,50 | 0,50 | 0,0018 | 0,0022 | 0,0026 | 0,0030 | 395 (370 – 450) |
| K3 | E/M/A/D | 0,50 | 0,50 | 0,046 | 0,055 | 0,065 | 0,075 | 105 (87 – 110) |
| | | 0,50 | 0,50 | 0,0018 | 0,0022 | 0,0026 | 0,0030 | 345 (290 – 360) |
| K4 | E/M/A/D | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 110 (89 – 130) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 360 (300 – 420) |
| K5 | E/M/A/D | 0,50 | 0,50 | 0,046 | 0,055 | 0,065 | 0,075 | 65 (54 – 80) |
| | | 0,50 | 0,50 | 0,0018 | 0,0022 | 0,0026 | 0,0030 | 215 (180 – 260) |
| K6 | E/M/A/D | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 95 (78 – 110) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 310 (260 – 360) |
| K7 | E/M/A/D | 0,50 | 0,50 | 0,046 | 0,055 | 0,065 | 0,075 | 85 (69 – 100) |
| | | 0,50 | 0,50 | 0,0018 | 0,0022 | 0,0026 | 0,0030 | 280 (230 – 320) |
| N1 | E/M/A | 0,40 | 0,50 | 0,080 | 0,095 | 0,12 | 0,14 | 610 (510 – 710) |
| | | 0,40 | 0,50 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 2000 (1700 – 2300) |
| N2 | E/M/A | 0,40 | 0,50 | 0,080 | 0,095 | 0,12 | 0,14 | 395 (330 – 450) |
| | | 0,40 | 0,50 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 1300 (1100 – 1400) |
| N3 | E/M/A | 0,40 | 0,50 | 0,080 | 0,095 | 0,12 | 0,14 | 260 (220 – 300) |
| | | 0,40 | 0,50 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 850 (730 – 980) |
| N11 | E/M/A | 0,50 | 0,50 | 0,070 | 0,080 | 0,11 | 0,13 | 300 (250 – 340) |
| | | 0,50 | 0,30 | 0,0028 | 0,0032 | 0,0044 | 0,0055 | 1025 (860 – 1100) |
| S1 | E | 0,50 | 0,50 | 0,055 | 0,065 | 0,080 | 0,090 | 39 (32 – 46) |
| | | 0,50 | 0,50 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 130 (110 – 150) |
| S2 | E | 0,50 | 0,50 | 0,055 | 0,065 | 0,080 | 0,090 | 31 (26 – 37) |
| | | 0,50 | 0,50 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 100 (86 – 120) |
| S3 | E | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 28 (23 – 33) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 90 (76 – 100) |
| S11 | E | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 115 (87 – 140) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 375 (290 – 450) |
| S12 | E | 0,50 | 0,50 | 0,050 | 0,060 | 0,075 | 0,085 | 90 (67 – 110) |
| | | 0,50 | 0,50 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 295 (220 – 360) |
| S13 | E | 0,50 | 0,50 | 0,044 | 0,050 | 0,065 | 0,075 | 70 (53 – 87) |
| | | 0,50 | 0,50 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 230 (180 – 280) |
| TS1 | A/D | 0,40 | 0,50 | 0,080 | 0,095 | 0,12 | 0,14 | 255 (160 – 350) |
| | | 0,40 | 0,50 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 840 (530 – 1100) |
| TP1 | A/D | 0,40 | 0,50 | 0,080 | 0,095 | 0,12 | 0,14 | 255 (160 – 350) |
| | | 0,40 | 0,50 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 840 (530 – 1100) |
| GR1 | A/D | 0,40 | 0,50 | 0,080 | 0,095 | 0,12 | 0,14 | 610 (510 – 710) |
| | | 0,40 | 0,50 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 2000 (1700 – 2300) |

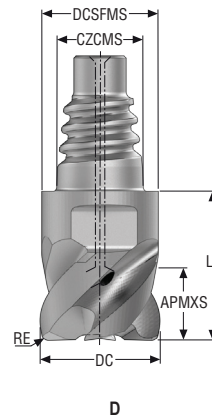
Schnittdaten – XVE540 – Nutfräsen PCEDC 3 – Zoll

| SMG |  | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------------------|
| | | | 3/8 | 1/2 | 5/8 | 3/4 | |
| P1 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 170 (140 – 190) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 560 (460 – 620) |
| P2 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 165 (140 – 190) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 540 (460 – 620) |
| P3 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 140 (120 – 160) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 460 (400 – 520) |
| P4 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 125 (100 – 140) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 410 (330 – 450) |
| P5 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 100 (81 – 120) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 330 (270 – 390) |
| P6 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 110 (90 – 130) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 360 (300 – 420) |
| P7 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 105 (85 – 120) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 345 (280 – 390) |
| P8 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 100 (81 – 120) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 330 (270 – 390) |
| P11 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 85 (64 – 100) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 280 (210 – 320) |
| P12 | E/M/A/D | 0,50 | 0,034 | 0,040 | 0,050 | 0,060 | 50 (38 – 62) |
| | | 0,50 | 0,0013 | 0,0016 | 0,0020 | 0,0024 | 165 (130 – 200) |
| M1 | E/M/A | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 100 (75 – 120) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 330 (250 – 390) |
| M2 | E/M/A | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 80 (61 – 100) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 260 (210 – 320) |
| M3 | E/M/A | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 70 (50 – 89) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 230 (170 – 290) |
| M4 | E/M/A | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 50 (38 – 67) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 165 (130 – 210) |
| M5 | E/M/A | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 44 (32 – 56) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 145 (110 – 180) |
| K1 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 125 (110 – 140) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 410 (370 – 450) |
| K2 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 110 (92 – 120) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 360 (310 – 390) |
| K3 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 90 (78 – 100) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 295 (260 – 320) |
| K4 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 100 (81 – 120) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 330 (270 – 390) |
| K5 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 60 (48 – 71) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 195 (160 – 230) |
| K6 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 90 (71 – 100) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 295 (240 – 320) |
| K7 | E/M/A/D | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 75 (61 – 91) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 245 (210 – 290) |
| N1 | E/M/A | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 600 (500 – 700) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 1975 (1700 – 2200) |
| N2 | E/M/A | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 385 (330 – 450) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 1275 (1100 – 1400) |
| N3 | E/M/A | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 255 (220 – 300) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 840 (730 – 980) |
| N11 | E/M/A | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 300 (260 – 340) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 980 (860 – 1100) |
| S1 | E | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 36 (29 – 43) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 120 (96 – 140) |
| S2 | E | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 29 (24 – 34) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 95 (79 – 110) |
| S3 | E | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 25 (20 – 30) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 80 (66 – 98) |
| S11 | E | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 105 (79 – 130) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 345 (260 – 420) |
| S12 | E | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 80 (61 – 100) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 260 (210 – 320) |
| S13 | E | 0,50 | 0,034 | 0,042 | 0,055 | 0,070 | 60 (47 – 77) |
| | | 0,50 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 195 (160 – 250) |
| TS1 | A/D | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 250 (150 – 350) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 820 (500 – 1100) |
| TP1 | A/D | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 250 (150 – 350) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 820 (500 – 1100) |
| GR1 | A/D | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 600 (500 – 700) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 1975 (1700 – 2200) |

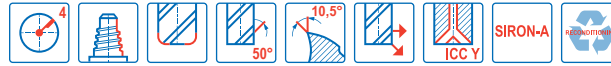
Unversell
Stahl und Guss
Stahlfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

XVE540

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Eckenradius – ICC



- Toleranzen:
- DC= h9
- RE= ±0,015 mm
- Nachschleifen möglich, wenn DC ≥ Ø12 ist mm



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | CSP | CZCMS | DC | DCSFMS | APMXS | LF | RE | PCEDC | SW | Beschichtung |
|-----------------------|--------------------|------------------|-------------------|-----|-------|------|--------|-------|------|-----|-------|----|--------------|
| | | | | | | mm | mm | mm | mm | mm | | | SIRA |
| XVE540E10100D1R050Z4A | 10137989 | 1 | D | ✓ | E10 | 10,0 | 9,7 | 6,0 | 12,4 | 0,5 | 4 | 8 | ■ |
| XVE540E12120D1R050Z4A | 10137990 | 1 | D | ✓ | E12 | 12,0 | 11,7 | 7,5 | 14,5 | 0,5 | 4 | 10 | ■ |
| XVE540E16160D1R050Z4A | 10137991 | 1 | D | ✓ | E16 | 16,0 | 15,5 | 10,0 | 18,7 | 0,5 | 4 | 12 | ■ |
| XVE540E20200D1R050Z4A | 10137992 | 1 | D | ✓ | E20 | 20,0 | 19,3 | 12,0 | 21,3 | 0,5 | 4 | 16 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

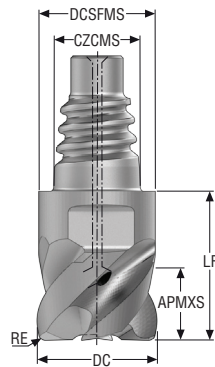
X-Heads

Minimaster Plus

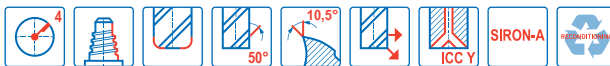
Minimaster

XVE540

Allgemeine Anwendung – Universell – Eckfräser – 4 Schneiden – Eckenradius – ICC – Zoll



D



- Toleranzen:
- DC= h9
- RE= .015 Zoll= ±.0006 Zoll
- RE= .031 Zoll= ±.0012 Zoll
- Nachschleifen möglich, wenn DC ≥ Ø.500 ist Zoll

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | CSP | CZCMS | DC | DCSFMS | APMXS | LF | RE | PCEDC | SW | Beschichtung |
|------------------------|--------------------|------------------|-------------------|-----|-------|-------|--------|-------|-------|-------|-------|----|--------------|
| | | | | | | Zoll | Zoll | Zoll | Zoll | Zoll | | | SIRA |
| XVE540E10.375D1R015Z4A | 10137993 | 1 | D | ✓ | E10 | 0.375 | 0.364 | 0.236 | 0.488 | 0.015 | 4 | 8 | ■ |
| XVE540E12.500D1R031Z4A | 10137994 | 1 | D | ✓ | E12 | 0.500 | 0.484 | 0.315 | 0.571 | 0.031 | 4 | 12 | ■ |
| XVE540E16.625D1R031Z4A | 10137995 | 1 | D | ✓ | E16 | 0.625 | 0.610 | 0.394 | 0.736 | 0.031 | 4 | 16 | ■ |
| XVE540E20.750D1R031Z4A | 10137996 | 1 | D | ✓ | E20 | 0.750 | 0.728 | 0.453 | 0.839 | 0.031 | 4 | 18 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

X-Heads


Minimaster Plus

Minimaster

Schnittdaten – XVE540 – Eckfräsen PCEDC 4

| SMG | | a _g /DC | a _p /DC | f _z | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|--------|--------|--------|--------------------|
| | | | | 10 | 12 | 16 | 20 | |
| P1 | E/M/A/D | 0,50 | 0,55 | 0,055 | 0,065 | 0,080 | 0,090 | 175 (140 – 210) |
| | | 0,50 | 0,55 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 570 (460 – 680) |
| P2 | E/M/A/D | 0,50 | 0,55 | 0,055 | 0,065 | 0,080 | 0,090 | 170 (130 – 210) |
| | | 0,50 | 0,55 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 560 (430 – 680) |
| P3 | E/M/A/D | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 150 (120 – 180) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 490 (400 – 590) |
| P4 | E/M/A/D | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 130 (99 – 160) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 425 (330 – 520) |
| P5 | E/M/A/D | 0,50 | 0,55 | 0,050 | 0,060 | 0,070 | 0,085 | 125 (95 – 150) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0028 | 0,0034 | 410 (320 – 490) |
| P6 | E/M/A/D | 0,50 | 0,55 | 0,048 | 0,055 | 0,070 | 0,080 | 140 (110 – 170) |
| | | 0,50 | 0,55 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 460 (370 – 550) |
| P7 | E/M/A/D | 0,50 | 0,55 | 0,048 | 0,055 | 0,070 | 0,080 | 135 (110 – 160) |
| | | 0,50 | 0,55 | 0,0019 | 0,0022 | 0,0028 | 0,0032 | 445 (370 – 520) |
| P8 | E/M/A/D | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 125 (95 – 150) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 410 (320 – 490) |
| P11 | E/M/A/D | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 80 (70 – 92) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 260 (230 – 300) |
| P12 | E/M/A/D | 0,50 | 0,55 | 0,034 | 0,040 | 0,050 | 0,060 | 50 (44 – 58) |
| | | 0,50 | 0,55 | 0,0013 | 0,0016 | 0,0020 | 0,0024 | 165 (150 – 190) |
| M1 | E/M/A | 0,50 | 0,55 | 0,055 | 0,065 | 0,080 | 0,095 | 95 (80 – 100) |
| | | 0,50 | 0,55 | 0,0022 | 0,0026 | 0,0032 | 0,0038 | 310 (270 – 320) |
| M2 | E/M/A | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 75 (66 – 87) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 245 (220 – 280) |
| M3 | E/M/A | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 49 (39 – 60) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 160 (130 – 190) |
| M4 | E/M/A | 0,50 | 0,55 | 0,044 | 0,050 | 0,065 | 0,075 | 38 (30 – 46) |
| | | 0,50 | 0,55 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 125 (99 – 150) |
| M5 | E/M/A | 0,50 | 0,55 | 0,044 | 0,050 | 0,065 | 0,075 | 32 (25 – 38) |
| | | 0,50 | 0,55 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 105 (83 – 120) |
| K1 | E/M/A/D | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 155 (140 – 170) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 510 (460 – 550) |
| K2 | E/M/A/D | 0,50 | 0,55 | 0,046 | 0,055 | 0,065 | 0,075 | 135 (120 – 150) |
| | | 0,50 | 0,55 | 0,0018 | 0,0022 | 0,0026 | 0,0030 | 445 (400 – 490) |
| K3 | E/M/A/D | 0,50 | 0,55 | 0,046 | 0,055 | 0,065 | 0,075 | 115 (99 – 130) |
| | | 0,50 | 0,55 | 0,0018 | 0,0022 | 0,0026 | 0,0030 | 375 (330 – 420) |
| K4 | E/M/A/D | 0,50 | 0,55 | 0,046 | 0,055 | 0,065 | 0,075 | 110 (94 – 120) |
| | | 0,50 | 0,55 | 0,0018 | 0,0022 | 0,0026 | 0,0030 | 360 (310 – 390) |
| K5 | E/M/A/D | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 135 (110 – 150) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 445 (370 – 490) |
| K6 | E/M/A/D | 0,50 | 0,55 | 0,055 | 0,065 | 0,080 | 0,095 | 200 (160 – 220) |
| | | 0,50 | 0,55 | 0,0022 | 0,0026 | 0,0032 | 0,0038 | 660 (530 – 720) |
| K7 | E/M/A/D | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 175 (150 – 190) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 570 (500 – 620) |
| N1 | E/M/A | 0,40 | 0,55 | 0,080 | 0,095 | 0,12 | 0,14 | 540 (510 – 700) |
| | | 0,40 | 0,55 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 1775 (1700 – 2200) |
| N2 | E/M/A | 0,40 | 0,55 | 0,080 | 0,095 | 0,12 | 0,14 | 350 (330 – 450) |
| | | 0,40 | 0,55 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 1150 (1100 – 1400) |
| N3 | E/M/A | 0,40 | 0,55 | 0,080 | 0,095 | 0,12 | 0,14 | 235 (220 – 300) |
| | | 0,40 | 0,55 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 770 (730 – 980) |
| N11 | E/M/A | 0,50 | 0,55 | 0,070 | 0,080 | 0,11 | 0,13 | 295 (250 – 340) |
| | | 0,50 | 0,55 | 0,0028 | 0,0032 | 0,0044 | 0,0050 | 970 (830 – 1100) |
| S1 | E | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 30 (24 – 37) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 100 (79 – 120) |
| S2 | E | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 25 (19 – 31) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 80 (63 – 100) |
| S3 | E | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 22 (17 – 27) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 70 (56 – 88) |
| S11 | E | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 100 (72 – 120) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 330 (240 – 390) |
| S12 | E | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 75 (55 – 98) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 245 (190 – 320) |
| S13 | E | 0,50 | 0,55 | 0,044 | 0,050 | 0,065 | 0,075 | 60 (44 – 78) |
| | | 0,50 | 0,55 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 195 (150 – 250) |
| TS1 | A/D | 0,40 | 0,55 | 0,080 | 0,095 | 0,12 | 0,14 | 250 (160 – 350) |
| | | 0,40 | 0,55 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 820 (530 – 1100) |
| TP1 | A/D | 0,40 | 0,55 | 0,080 | 0,095 | 0,12 | 0,14 | 250 (160 – 350) |
| | | 0,40 | 0,55 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 820 (530 – 1100) |
| GR1 | A/D | 0,40 | 0,55 | 0,080 | 0,095 | 0,12 | 0,14 | 610 (510 – 700) |
| | | 0,40 | 0,55 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 2000 (1700 – 2200) |

Schnittdaten – XVE540 – Nutfräsen PCEDC 4


| SMG |  | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------------------|
| | | | 10 | 12 | 16 | 20 | |
| P1 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 160 (130 – 200) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 520 (430 – 650) |
| P2 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 155 (120 – 190) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 510 (400 – 620) |
| P3 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 135 (110 – 160) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 445 (370 – 520) |
| P4 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 120 (90 – 140) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 395 (300 – 450) |
| P5 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 115 (86 – 140) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 375 (290 – 450) |
| P6 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 125 (96 – 150) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 410 (320 – 490) |
| P7 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 120 (91 – 150) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 395 (300 – 490) |
| P8 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 115 (86 – 140) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 375 (290 – 450) |
| P11 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 75 (63 – 83) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 245 (210 – 270) |
| P12 | E/M/A/D | 0,55 | 0,034 | 0,040 | 0,050 | 0,060 | 43 (37 – 49) |
| | | 0,55 | 0,0013 | 0,0016 | 0,0020 | 0,0024 | 140 (130 – 160) |
| M1 | E/M/A | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 85 (74 – 98) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 280 (250 – 320) |
| M2 | E/M/A | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 70 (60 – 79) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 230 (200 – 250) |
| M3 | E/M/A | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 45 (35 – 54) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 150 (120 – 170) |
| M4 | E/M/A | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 33 (26 – 40) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 110 (86 – 130) |
| M5 | E/M/A | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 28 (22 – 34) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 90 (73 – 110) |
| K1 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 140 (120 – 150) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 460 (400 – 490) |
| K2 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 120 (110 – 130) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 395 (370 – 420) |
| K3 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 100 (88 – 110) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 330 (290 – 360) |
| K4 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 95 (84 – 110) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 310 (280 – 360) |
| K5 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 125 (100 – 130) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 410 (330 – 420) |
| K6 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 185 (150 – 200) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 610 (500 – 650) |
| K7 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 160 (130 – 170) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 520 (430 – 550) |
| N1 | E/M/A | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 530 (500 – 690) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 1750 (1700 – 2200) |
| N2 | E/M/A | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 345 (320 – 440) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 1125 (1100 – 1400) |
| N3 | E/M/A | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 230 (220 – 290) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 750 (730 – 950) |
| N11 | E/M/A | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 295 (250 – 340) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 970 (830 – 1100) |
| S1 | E | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 27 (21 – 33) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 90 (69 – 100) |
| S2 | E | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 23 (17 – 28) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 75 (56 – 91) |
| S3 | E | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 20 (15 – 24) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 65 (50 – 78) |
| S11 | E | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 90 (65 – 110) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 295 (220 – 360) |
| S12 | E | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 70 (50 – 89) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 230 (170 – 290) |
| S13 | E | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 55 (39 – 69) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 180 (130 – 220) |
| TS1 | A/D | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 250 (150 – 340) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 820 (500 – 1100) |
| TP1 | A/D | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 250 (150 – 340) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 820 (500 – 1100) |
| GR1 | A/D | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 590 (500 – 690) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 1925 (1700 – 2200) |

Unversell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

Schnittdaten – XVE540 – Eckfräsen PCEDC 4 – Zoll

| SMG | | a _e /DC | a _p /DC | f _z | | | | v _c |
|-----|---------|--------------------|--------------------|----------------|--------|--------|--------|--------------------|
| | | | | 3/8 | 1/2 | 5/8 | 3/4 | |
| P1 | E/M/A/D | 0,50 | 0,55 | 0,055 | 0,065 | 0,080 | 0,090 | 180 (150 – 210) |
| | | 0,50 | 0,55 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 590 (500 – 680) |
| P2 | E/M/A/D | 0,50 | 0,55 | 0,055 | 0,065 | 0,080 | 0,090 | 175 (150 – 200) |
| | | 0,50 | 0,55 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 570 (500 – 650) |
| P3 | E/M/A/D | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 155 (130 – 180) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 510 (430 – 590) |
| P4 | E/M/A/D | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 135 (110 – 150) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 445 (370 – 490) |
| P5 | E/M/A/D | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 110 (88 – 130) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 360 (290 – 420) |
| P6 | E/M/A/D | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 125 (99 – 140) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 410 (330 – 450) |
| P7 | E/M/A/D | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 115 (93 – 130) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 375 (310 – 420) |
| P8 | E/M/A/D | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,090 | 110 (88 – 130) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0036 | 360 (290 – 420) |
| P11 | E/M/A/D | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 90 (70 – 110) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 295 (230 – 360) |
| P12 | E/M/A/D | 0,50 | 0,55 | 0,034 | 0,040 | 0,050 | 0,060 | 60 (44 – 73) |
| | | 0,50 | 0,55 | 0,0013 | 0,0016 | 0,0020 | 0,0024 | 195 (150 – 230) |
| M1 | E/M/A | 0,50 | 0,55 | 0,055 | 0,065 | 0,080 | 0,095 | 105 (80 – 130) |
| | | 0,50 | 0,55 | 0,0022 | 0,0026 | 0,0032 | 0,0038 | 345 (270 – 420) |
| M2 | E/M/A | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 90 (66 – 100) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 295 (220 – 320) |
| M3 | E/M/A | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 75 (55 – 98) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 245 (190 – 320) |
| M4 | E/M/A | 0,50 | 0,55 | 0,044 | 0,050 | 0,065 | 0,075 | 60 (43 – 75) |
| | | 0,50 | 0,55 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 195 (150 – 240) |
| M5 | E/M/A | 0,50 | 0,55 | 0,044 | 0,050 | 0,065 | 0,075 | 49 (36 – 63) |
| | | 0,50 | 0,55 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 160 (120 – 200) |
| K1 | E/M/A/D | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 135 (120 – 150) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 445 (400 – 490) |
| K2 | E/M/A/D | 0,50 | 0,55 | 0,046 | 0,055 | 0,065 | 0,075 | 120 (110 – 130) |
| | | 0,50 | 0,55 | 0,0018 | 0,0022 | 0,0026 | 0,0030 | 395 (370 – 420) |
| K3 | E/M/A/D | 0,50 | 0,55 | 0,046 | 0,055 | 0,065 | 0,075 | 100 (86 – 110) |
| | | 0,50 | 0,55 | 0,0018 | 0,0022 | 0,0026 | 0,0030 | 330 (290 – 360) |
| K4 | E/M/A/D | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 110 (88 – 130) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 360 (290 – 420) |
| K5 | E/M/A/D | 0,50 | 0,55 | 0,046 | 0,055 | 0,065 | 0,075 | 65 (54 – 79) |
| | | 0,50 | 0,55 | 0,0018 | 0,0022 | 0,0026 | 0,0030 | 215 (180 – 250) |
| K6 | E/M/A/D | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 95 (78 – 110) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 310 (260 – 360) |
| K7 | E/M/A/D | 0,50 | 0,55 | 0,046 | 0,055 | 0,065 | 0,075 | 85 (68 – 100) |
| | | 0,50 | 0,55 | 0,0018 | 0,0022 | 0,0026 | 0,0030 | 280 (230 – 320) |
| N1 | E/M/A | 0,40 | 0,55 | 0,080 | 0,095 | 0,12 | 0,14 | 610 (510 – 700) |
| | | 0,40 | 0,55 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 2000 (1700 – 2200) |
| N2 | E/M/A | 0,40 | 0,55 | 0,080 | 0,095 | 0,12 | 0,14 | 390 (330 – 450) |
| | | 0,40 | 0,55 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 1275 (1100 – 1400) |
| N3 | E/M/A | 0,40 | 0,55 | 0,080 | 0,095 | 0,12 | 0,14 | 260 (220 – 300) |
| | | 0,40 | 0,55 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 850 (730 – 980) |
| N11 | E/M/A | 0,50 | 0,55 | 0,070 | 0,080 | 0,11 | 0,13 | 295 (250 – 340) |
| | | 0,50 | 0,30 | 0,0028 | 0,0032 | 0,0044 | 0,0055 | 1000 (860 – 1100) |
| S1 | E | 0,50 | 0,55 | 0,055 | 0,065 | 0,080 | 0,090 | 39 (31 – 46) |
| | | 0,50 | 0,55 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 130 (110 – 150) |
| S2 | E | 0,50 | 0,55 | 0,055 | 0,065 | 0,080 | 0,090 | 31 (25 – 37) |
| | | 0,50 | 0,55 | 0,0022 | 0,0026 | 0,0032 | 0,0036 | 100 (83 – 120) |
| S3 | E | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 27 (22 – 32) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 90 (73 – 100) |
| S11 | E | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 115 (86 – 140) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 375 (290 – 450) |
| S12 | E | 0,50 | 0,55 | 0,050 | 0,060 | 0,075 | 0,085 | 90 (66 – 100) |
| | | 0,50 | 0,55 | 0,0020 | 0,0024 | 0,0030 | 0,0034 | 295 (220 – 320) |
| S13 | E | 0,50 | 0,55 | 0,044 | 0,050 | 0,065 | 0,075 | 70 (53 – 87) |
| | | 0,50 | 0,55 | 0,0017 | 0,0020 | 0,0026 | 0,0030 | 230 (180 – 280) |
| TS1 | A/D | 0,40 | 0,55 | 0,080 | 0,095 | 0,12 | 0,14 | 250 (160 – 350) |
| | | 0,40 | 0,55 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 820 (530 – 1100) |
| TP1 | A/D | 0,40 | 0,55 | 0,080 | 0,095 | 0,12 | 0,14 | 250 (160 – 350) |
| | | 0,40 | 0,55 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 820 (530 – 1100) |
| GR1 | A/D | 0,40 | 0,55 | 0,080 | 0,095 | 0,12 | 0,14 | 610 (510 – 700) |
| | | 0,40 | 0,55 | 0,0032 | 0,0038 | 0,0048 | 0,0055 | 2000 (1700 – 2200) |

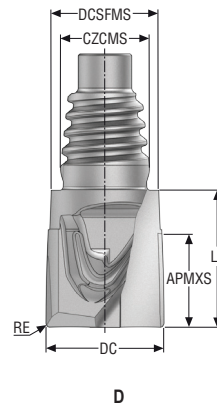
Schnittdaten – XVE540 – Nutfräsen PCEDC 4 Zoll

| SMG |  | a _p /DC | f _z | | | | v _c |
|-----|---|--------------------|----------------|--------|--------|--------|--------------------|
| | | | 3/8 | 1/2 | 5/8 | 3/4 | |
| P1 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 170 (140 – 190) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 560 (460 – 620) |
| P2 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 165 (140 – 180) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 540 (460 – 590) |
| P3 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 140 (120 – 160) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 460 (400 – 520) |
| P4 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 125 (100 – 140) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 410 (330 – 450) |
| P5 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 100 (80 – 110) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 330 (270 – 360) |
| P6 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 110 (89 – 130) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 360 (300 – 420) |
| P7 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 105 (84 – 120) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 345 (280 – 390) |
| P8 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 100 (80 – 110) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 330 (270 – 360) |
| P11 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 85 (63 – 100) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 280 (210 – 320) |
| P12 | E/M/A/D | 0,55 | 0,034 | 0,040 | 0,050 | 0,060 | 49 (37 – 61) |
| | | 0,55 | 0,0013 | 0,0016 | 0,0020 | 0,0024 | 160 (130 – 200) |
| M1 | E/M/A | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 100 (74 – 120) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 330 (250 – 390) |
| M2 | E/M/A | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 80 (60 – 99) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 260 (200 – 320) |
| M3 | E/M/A | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 70 (50 – 89) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 230 (170 – 290) |
| M4 | E/M/A | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 50 (38 – 66) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 165 (130 – 210) |
| M5 | E/M/A | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 43 (31 – 55) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 140 (110 – 180) |
| K1 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 125 (110 – 140) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 410 (370 – 450) |
| K2 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 105 (91 – 120) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 345 (300 – 390) |
| K3 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 90 (77 – 100) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 295 (260 – 320) |
| K4 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 100 (80 – 110) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 330 (270 – 360) |
| K5 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 60 (48 – 70) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 195 (160 – 220) |
| K6 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 85 (70 – 100) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 280 (230 – 320) |
| K7 | E/M/A/D | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 75 (61 – 90) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 245 (210 – 290) |
| N1 | E/M/A | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 590 (500 – 690) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 1925 (1700 – 2200) |
| N2 | E/M/A | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 380 (320 – 440) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 1250 (1100 – 1400) |
| N3 | E/M/A | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 255 (220 – 290) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 840 (730 – 950) |
| N11 | E/M/A | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 295 (250 – 340) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 970 (830 – 1100) |
| S1 | E | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 36 (29 – 42) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 120 (96 – 130) |
| S2 | E | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 29 (23 – 34) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 95 (76 – 110) |
| S3 | E | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 25 (20 – 29) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 80 (66 – 95) |
| S11 | E | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 105 (78 – 120) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 345 (260 – 390) |
| S12 | E | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 80 (60 – 99) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 260 (200 – 320) |
| S13 | E | 0,55 | 0,034 | 0,042 | 0,055 | 0,070 | 60 (47 – 76) |
| | | 0,55 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 195 (160 – 240) |
| TS1 | A/D | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 250 (150 – 340) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 820 (500 – 1100) |
| TP1 | A/D | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 250 (150 – 340) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 820 (500 – 1100) |
| GR1 | A/D | 0,30 | 0,034 | 0,042 | 0,055 | 0,070 | 590 (500 – 690) |
| | | 0,30 | 0,0013 | 0,0017 | 0,0022 | 0,0028 | 1925 (1700 – 2200) |

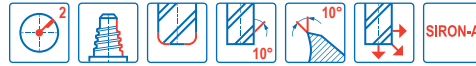
Unversell
Stahl und Guss
Stahlfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

XVE510

Allgemeine Anwendung – Universell – Eckfräser – 2 Schneiden – Eckenradius



- Toleranzen:
- DC= h10
- RE= ±0,015 mm



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | CZCMS | DC | DCSFMS | APMXS | LF | RE | PCEDC | SW | Beschichtung |
|----------------------|--------------------|------------------|-------------------|-------|------|--------|-------|------|-----|-------|----|--------------|
| | | | | | mm | mm | mm | mm | mm | | | SIRA |
| XVE510E10100D1R050Z2 | 10138003 | 1 | D | E10 | 10,0 | 9,7 | 8,0 | 11,8 | 0,5 | 2 | 6 | ■ |
| XVE510E12120D1R050Z2 | 10138004 | 1 | D | E12 | 12,0 | 11,7 | 10,0 | 14,0 | 0,5 | 2 | 8 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite


Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – XVE510 Eckfräsen

| SMG |  | a _d /DC | | a _p /DC | | f _z | | v _c |
|-----|---|--------------------|------|--------------------|--------|--------------------|-----------------|----------------|
| | | | | | | 10 | 12 | |
| P1 | E/M/A/D | 0,10 | 0,65 | 0,65 | 0,080 | 0,095 | 210 (170 – 250) | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 690 (560 – 820) | | |
| P2 | E/M/A/D | 0,10 | 0,65 | 0,080 | 0,095 | 205 (170 – 240) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 670 (560 – 780) | | |
| P3 | E/M/A/D | 0,10 | 0,65 | 0,080 | 0,095 | 175 (150 – 210) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 570 (500 – 680) | | |
| P4 | E/M/A/D | 0,10 | 0,65 | 0,080 | 0,095 | 155 (130 – 180) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 510 (430 – 590) | | |
| P5 | E/M/A/D | 0,10 | 0,65 | 0,080 | 0,095 | 155 (130 – 180) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 510 (430 – 590) | | |
| P6 | E/M/A/D | 0,10 | 0,65 | 0,080 | 0,095 | 175 (140 – 200) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 570 (460 – 650) | | |
| P7 | E/M/A/D | 0,10 | 0,65 | 0,080 | 0,095 | 165 (140 – 190) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 540 (460 – 620) | | |
| P8 | E/M/A/D | 0,10 | 0,65 | 0,080 | 0,095 | 155 (130 – 180) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 510 (430 – 590) | | |
| P11 | E/M/A/D | 0,10 | 0,65 | 0,080 | 0,095 | 115 (82 – 140) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 375 (270 – 450) | | |
| P12 | E/M/A/D | 0,10 | 0,65 | 0,070 | 0,080 | 70 (50 – 89) | | |
| | | 0,10 | 0,65 | 0,0028 | 0,0032 | 230 (170 – 290) | | |
| M1 | E/M/A | 0,10 | 0,65 | 0,080 | 0,095 | 135 (97 – 170) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 445 (320 – 550) | | |
| M2 | E/M/A | 0,10 | 0,65 | 0,080 | 0,095 | 110 (78 – 130) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 360 (260 – 420) | | |
| M3 | E/M/A | 0,10 | 0,65 | 0,080 | 0,095 | 70 (55 – 85) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 230 (190 – 270) | | |
| M4 | E/M/A | 0,10 | 0,65 | 0,080 | 0,095 | 50 (41 – 64) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 165 (140 – 200) | | |
| M5 | E/M/A | 0,10 | 0,65 | 0,080 | 0,095 | 44 (35 – 53) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 145 (120 – 170) | | |
| K1 | E/M/A/D | 0,10 | 0,65 | 0,080 | 0,095 | 185 (160 – 210) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 610 (530 – 680) | | |
| K2 | E/M/A/D | 0,10 | 0,65 | 0,080 | 0,095 | 160 (140 – 180) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 520 (460 – 590) | | |
| K3 | E/M/A/D | 0,10 | 0,65 | 0,080 | 0,095 | 135 (120 – 150) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 445 (400 – 490) | | |
| K4 | E/M/A/D | 0,10 | 0,65 | 0,080 | 0,095 | 130 (110 – 150) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 425 (370 – 490) | | |
| K5 | E/M/A/D | 0,10 | 0,65 | 0,080 | 0,095 | 155 (130 – 180) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 510 (430 – 590) | | |
| K6 | E/M/A/D | 0,10 | 0,65 | 0,080 | 0,095 | 230 (190 – 270) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 750 (630 – 880) | | |
| K7 | E/M/A/D | 0,10 | 0,65 | 0,080 | 0,095 | 100 (83 – 110) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 330 (280 – 380) | | |
| N1 | E/M/A | 0,20 | 0,65 | 0,075 | 0,090 | 470 (410 – 530) | | |
| | | 0,20 | 0,65 | 0,0030 | 0,0036 | 1550 (1400 – 1700) | | |
| N2 | E/M/A | 0,20 | 0,65 | 0,075 | 0,090 | 305 (270 – 340) | | |
| | | 0,20 | 0,65 | 0,0030 | 0,0036 | 1000 (890 – 1100) | | |
| N3 | E/M/A | 0,20 | 0,65 | 0,075 | 0,090 | 200 (180 – 230) | | |
| | | 0,20 | 0,65 | 0,0030 | 0,0036 | 660 (600 – 750) | | |
| N11 | E/M/A | 0,10 | 0,65 | 0,10 | 0,12 | 370 (300 – 440) | | |
| | | 0,10 | 0,65 | 0,0040 | 0,0048 | 1225 (990 – 1400) | | |
| S1 | E | 0,10 | 0,65 | 0,080 | 0,095 | 60 (39 – 85) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 195 (130 – 270) | | |
| S2 | E | 0,10 | 0,65 | 0,080 | 0,095 | 55 (32 – 77) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 180 (110 – 250) | | |
| S3 | E | 0,10 | 0,65 | 0,080 | 0,095 | 39 (24 – 54) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 130 (79 – 170) | | |
| S11 | E | 0,10 | 0,65 | 0,080 | 0,095 | 120 (110 – 140) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 395 (370 – 450) | | |
| S12 | E | 0,10 | 0,65 | 0,080 | 0,095 | 95 (78 – 100) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 310 (260 – 320) | | |
| S13 | E | 0,10 | 0,65 | 0,080 | 0,095 | 70 (61 – 84) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 230 (210 – 270) | | |
| TS1 | A/D | 0,10 | 0,65 | 0,080 | 0,095 | 540 (470 – 620) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 1775 (1600 – 2000) | | |
| TP1 | A/D | 0,10 | 0,65 | 0,080 | 0,095 | 540 (470 – 620) | | |
| | | 0,10 | 0,65 | 0,0032 | 0,0038 | 1775 (1600 – 2000) | | |
| GR1 | A/D | 0,20 | 0,65 | 0,10 | 0,12 | 570 (510 – 630) | | |
| | | 0,20 | 0,65 | 0,0040 | 0,0048 | 1875 (1700 – 2000) | | |

Unversell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

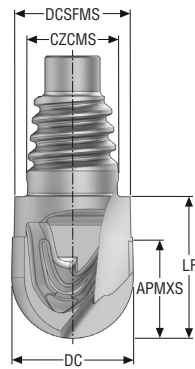
Minimaster

Schnittdaten – XVE510 Nutfräsen

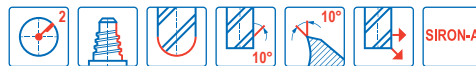
| SMG | | a _p /DC | f _z | | v _c |
|-----|---------|--------------------|----------------|--------|--------------------|
| | | | 10 | 12 | |
| P1 | E/M/A/D | 0,50 | 0,050 | 0,060 | 135 (110 – 160) |
| | | 0,50 | 0,0020 | 0,0024 | 445 (370 – 520) |
| P2 | E/M/A/D | 0,50 | 0,050 | 0,060 | 130 (110 – 150) |
| | | 0,50 | 0,0020 | 0,0024 | 425 (370 – 490) |
| P3 | E/M/A/D | 0,50 | 0,050 | 0,060 | 115 (91 – 130) |
| | | 0,50 | 0,0020 | 0,0024 | 375 (300 – 420) |
| P4 | E/M/A/D | 0,50 | 0,050 | 0,060 | 100 (80 – 110) |
| | | 0,50 | 0,0020 | 0,0024 | 330 (270 – 360) |
| P5 | E/M/A/D | 0,50 | 0,050 | 0,060 | 100 (81 – 120) |
| | | 0,50 | 0,0020 | 0,0024 | 330 (270 – 390) |
| P6 | E/M/A/D | 0,50 | 0,050 | 0,060 | 110 (90 – 130) |
| | | 0,50 | 0,0020 | 0,0024 | 360 (300 – 420) |
| P7 | E/M/A/D | 0,50 | 0,050 | 0,060 | 105 (85 – 120) |
| | | 0,50 | 0,0020 | 0,0024 | 345 (280 – 390) |
| P8 | E/M/A/D | 0,50 | 0,050 | 0,060 | 100 (81 – 120) |
| | | 0,50 | 0,0020 | 0,0024 | 330 (270 – 390) |
| P11 | E/M/A/D | 0,50 | 0,050 | 0,060 | 75 (53 – 94) |
| | | 0,50 | 0,0020 | 0,0024 | 245 (180 – 300) |
| P12 | E/M/A/D | 0,40 | 0,040 | 0,048 | 46 (33 – 58) |
| | | 0,40 | 0,0016 | 0,0019 | 150 (110 – 190) |
| M1 | E/M/A | 0,50 | 0,050 | 0,060 | 85 (62 – 110) |
| | | 0,50 | 0,0020 | 0,0024 | 280 (210 – 360) |
| M2 | E/M/A | 0,50 | 0,050 | 0,060 | 70 (50 – 89) |
| | | 0,50 | 0,0020 | 0,0024 | 230 (170 – 290) |
| M3 | E/M/A | 0,50 | 0,050 | 0,060 | 45 (35 – 54) |
| | | 0,50 | 0,0020 | 0,0024 | 150 (120 – 170) |
| M4 | E/M/A | 0,38 | 0,050 | 0,060 | 34 (27 – 41) |
| | | 0,38 | 0,0020 | 0,0024 | 110 (89 – 130) |
| M5 | E/M/A | 0,38 | 0,050 | 0,060 | 28 (23 – 34) |
| | | 0,38 | 0,0020 | 0,0024 | 90 (76 – 110) |
| K1 | E/M/A/D | 0,50 | 0,050 | 0,060 | 120 (100 – 130) |
| | | 0,50 | 0,0020 | 0,0024 | 395 (330 – 420) |
| K2 | E/M/A/D | 0,50 | 0,050 | 0,060 | 105 (87 – 120) |
| | | 0,50 | 0,0020 | 0,0024 | 345 (290 – 390) |
| K3 | E/M/A/D | 0,50 | 0,050 | 0,060 | 90 (74 – 100) |
| | | 0,50 | 0,0020 | 0,0024 | 295 (250 – 320) |
| K4 | E/M/A/D | 0,50 | 0,050 | 0,060 | 85 (70 – 97) |
| | | 0,50 | 0,0020 | 0,0024 | 280 (230 – 310) |
| K5 | E/M/A/D | 0,50 | 0,050 | 0,060 | 100 (80 – 120) |
| | | 0,50 | 0,0020 | 0,0024 | 330 (270 – 390) |
| K6 | E/M/A/D | 0,50 | 0,050 | 0,060 | 150 (120 – 170) |
| | | 0,50 | 0,0020 | 0,0024 | 490 (400 – 550) |
| K7 | E/M/A/D | 0,50 | 0,050 | 0,060 | 65 (54 – 74) |
| | | 0,50 | 0,0020 | 0,0024 | 215 (180 – 240) |
| N1 | E/M/A | 0,50 | 0,050 | 0,060 | 350 (300 – 390) |
| | | 0,50 | 0,0020 | 0,0024 | 1150 (990 – 1200) |
| N2 | E/M/A | 0,50 | 0,050 | 0,060 | 225 (200 – 250) |
| | | 0,50 | 0,0020 | 0,0024 | 740 (660 – 820) |
| N3 | E/M/A | 0,50 | 0,050 | 0,060 | 150 (130 – 170) |
| | | 0,50 | 0,0020 | 0,0024 | 490 (430 – 550) |
| N11 | E/M/A | 0,50 | 0,050 | 0,060 | 250 (200 – 290) |
| | | 0,50 | 0,0020 | 0,0024 | 820 (660 – 950) |
| S1 | E | 0,50 | 0,050 | 0,060 | 40 (25 – 54) |
| | | 0,50 | 0,0020 | 0,0024 | 130 (83 – 170) |
| S2 | E | 0,50 | 0,050 | 0,060 | 35 (20 – 49) |
| | | 0,50 | 0,0020 | 0,0024 | 115 (66 – 160) |
| S3 | E | 0,50 | 0,050 | 0,060 | 25 (15 – 34) |
| | | 0,50 | 0,0020 | 0,0024 | 80 (50 – 110) |
| S11 | E | 0,50 | 0,050 | 0,060 | 80 (65 – 90) |
| | | 0,50 | 0,0020 | 0,0024 | 260 (220 – 290) |
| S12 | E | 0,50 | 0,050 | 0,060 | 60 (50 – 69) |
| | | 0,50 | 0,0020 | 0,0024 | 195 (170 – 220) |
| S13 | E | 0,42 | 0,050 | 0,060 | 47 (39 – 54) |
| | | 0,42 | 0,0020 | 0,0024 | 155 (130 – 170) |
| TS1 | A/D | 0,50 | 0,050 | 0,060 | 350 (300 – 390) |
| | | 0,50 | 0,0020 | 0,0024 | 1150 (990 – 1200) |
| TP1 | A/D | 0,50 | 0,050 | 0,060 | 350 (300 – 390) |
| | | 0,50 | 0,0020 | 0,0024 | 1150 (990 – 1200) |
| GR1 | A/D | 0,50 | 0,050 | 0,060 | 450 (400 – 490) |
| | | 0,50 | 0,0020 | 0,0024 | 1475 (1400 – 1600) |

XVB510

Allgemeine Anwendung – Universell – Kugelkopf – 2 Schneiden



D



- Toleranzen:
- DC= h9
- RE= ±0,01 mm



| Bezeichnung | Produktnummer | Längenindex | Werkzeugform | CZCMS | DC | DCSFMS | APMXS | LF | PCEDC | SW | Beschichtung |
|-------------------|---------------|-------------|--------------|-------|------|--------|-------|------|-------|----|--------------|
| | | | | | mm | mm | mm | mm | | | SIRA |
| XVB510E10100D1BZ2 | 10138005 | 1 | D | E10 | 10,0 | 9,7 | 8,0 | 11,8 | 2 | 6 | ■ |
| XVB510E12120D1BZ2 | 10138006 | 1 | D | E12 | 12,0 | 11,7 | 10,0 | 14,0 | 2 | 8 | ■ |
| XVB510E16160D1BZ2 | 10138007 | 1 | D | E16 | 16,0 | 15,5 | 13,0 | 18,1 | 2 | 10 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

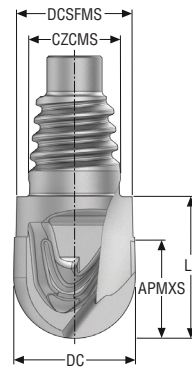
X-Heads

Minimaster Plus

Minimaster

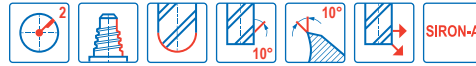
XVB510

Allgemeine Anwendung – Universell – Kugelkopf – 2 Schneiden – Zoll



D

- Toleranzen:
- DC= h9
- RE= ±.0004 Zoll



| Bezeichnung | Produktnummer | Längenindex | Werkzeugform | CZCMS | DC | DCSFMS | APMXS | LF | PCEDC | SW | Beschichtung |
|--------------------|---------------|-------------|--------------|-------|-------|--------|-------|-------|-------|----|--------------|
| | | | | | Zoll | Zoll | Zoll | Zoll | | | SIRA |
| XVB510E10.375D1BZ2 | 10138008 | 1 | D | E10 | 0.375 | 0.364 | 0.315 | 0.465 | 2 | 6 | ■ |
| XVB510E12.500D1BZ2 | 10138009 | 1 | D | E12 | 0.500 | 0.484 | 0.413 | 0.551 | 2 | 8 | ■ |
| XVB510E16.625D1BZ2 | 10138010 | 1 | D | E16 | 0.624 | 0.610 | 0.512 | 0.713 | 2 | 10 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite


Graphit

X-Heads

Minimaster Plus

Minimaster

Schnittdaten – XVB510 Kopierfräsen/Schruppen

| SMG |  | a _d /DC | a _p /DC | f _z | | | v _c |
|-----|---|--------------------|--------------------|-----------------|-----------------|-----------------|---------------------------------------|
| | | | | 10 | 12 | 16 | |
| P1 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 185 (150 – 210) 610 (500 – 680) |
| P2 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 180 (150 – 210) 590 (500 – 680) |
| P3 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 155 (130 – 180) 510 (430 – 590) |
| P4 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 135 (110 – 160) 445 (370 – 520) |
| P5 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 135 (110 – 160) 445 (370 – 520) |
| P6 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 150 (130 – 180) 490 (430 – 590) |
| P7 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 145 (120 – 170) 475 (400 – 550) |
| P8 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 135 (110 – 160) 445 (370 – 520) |
| P11 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 65 (50 – 78) 215 (170 – 250) |
| P12 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,060 0,0024 | 0,075 0,0030 | 0,090 0,0036 | 39 (30 – 47) 130 (99 – 150) |
| M1 | E/M/A | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 75 (59 – 91) 245 (200 – 290) |
| M2 | E/M/A | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 60 (48 – 74) 195 (160 – 240) |
| M3 | E/M/A | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 60 (48 – 74) 195 (160 – 240) |
| M4 | E/M/A | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 46 (36 – 55) 150 (120 – 180) |
| M5 | E/M/A | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 38 (30 – 46) 125 (99 – 150) |
| K1 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 180 (150 – 210) 590 (500 – 680) |
| K2 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 155 (130 – 180) 510 (430 – 590) |
| K3 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 130 (110 – 150) 425 (370 – 490) |
| K4 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 125 (110 – 150) 410 (370 – 490) |
| K5 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 80 (63 – 94) 260 (210 – 300) |
| K6 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 115 (93 – 130) 375 (310 – 420) |
| K7 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 100 (81 – 120) 330 (270 – 390) |
| N1 | E/M/A | 0,10 0,10 | 0,65 0,65 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 445 (390 – 500) 1450 (1300 – 1600) |
| N2 | E/M/A | 0,10 0,10 | 0,65 0,65 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 285 (250 – 320) 940 (830 – 1000) |
| N3 | E/M/A | 0,10 0,10 | 0,65 0,65 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 190 (170 – 210) 620 (560 – 680) |
| N11 | E/M/A | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 335 (270 – 400) 1100 (890 – 1300) |
| S1 | E | 0,050 0,050 | 0,65 0,65 | 0,060 0,0024 | 0,070 0,0028 | 0,095 0,0038 | 55 (33 – 76) 180 (110 – 240) |
| S2 | E | 0,050 0,050 | 0,65 0,65 | 0,060 0,0024 | 0,070 0,0028 | 0,095 0,0038 | 44 (27 – 61) 145 (89 – 200) |
| S3 | E | 0,050 0,050 | 0,65 0,65 | 0,060 0,0024 | 0,070 0,0028 | 0,095 0,0038 | 38 (23 – 52) 125 (76 – 170) |
| S11 | E | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 105 (88 – 120) 345 (290 – 390) |
| S12 | E | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 80 (68 – 94) 260 (230 – 300) |
| S13 | E | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 65 (53 – 73) 215 (180 – 230) |
| TS1 | A/D | 0,10 0,10 | 0,65 0,65 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 445 (390 – 500) 1450 (1300 – 1600) |
| TP1 | A/D | 0,10 0,10 | 0,65 0,65 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 445 (390 – 500) 1450 (1300 – 1600) |
| GR1 | A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 630 (570 – 700) 2075 (1900 – 2200) |

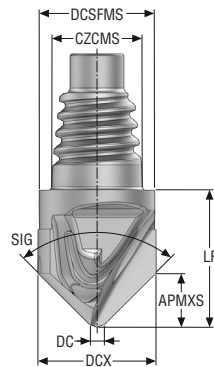
Unversell
Stahl und Guss
Stahl und Guss
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Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

Schnittdaten – XVB510 Kopierfräsen/Schruppen – Zoll

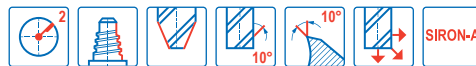
| SMG | | a _e /DC | a _p /DC | f _z | | | v _c |
|-----|---------|--------------------|--------------------|-----------------|-----------------|-----------------|---------------------------------------|
| | | | | 3/8 | 1/2 | 5/8 | |
| | | | | 3/8 | 1/2 | 5/8 | |
| P1 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 365 (320 – 420) 1200 (1100 – 1300) |
| P2 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 355 (310 – 400) 1175 (1100 – 1300) |
| P3 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 305 (270 – 350) 1000 (890 – 1100) |
| P4 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 270 (230 – 310) 890 (760 – 1000) |
| P5 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 175 (140 – 210) 570 (460 – 680) |
| P6 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 195 (160 – 240) 640 (530 – 780) |
| P7 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 185 (150 – 220) 610 (500 – 720) |
| P8 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 175 (140 – 210) 570 (460 – 680) |
| P11 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 155 (130 – 180) 510 (430 – 590) |
| P12 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,060 0,0024 | 0,075 0,0030 | 0,090 0,0036 | 95 (78 – 110) 310 (260 – 360) |
| M1 | E/M/A | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 185 (160 – 210) 610 (530 – 680) |
| M2 | E/M/A | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 150 (130 – 170) 490 (430 – 550) |
| M3 | E/M/A | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 120 (95 – 140) 395 (320 – 450) |
| M4 | E/M/A | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 90 (71 – 110) 295 (240 – 360) |
| M5 | E/M/A | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 75 (59 – 92) 245 (200 – 300) |
| K1 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 360 (310 – 410) 1175 (1100 – 1300) |
| K2 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 310 (270 – 350) 1025 (890 – 1100) |
| K3 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 265 (230 – 300) 870 (760 – 980) |
| K4 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 250 (220 – 280) 820 (730 – 910) |
| K5 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 100 (79 – 120) 330 (260 – 390) |
| K6 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 150 (120 – 180) 490 (400 – 590) |
| K7 | E/M/A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 130 (110 – 160) 425 (370 – 520) |
| N1 | E/M/A | 0,10 0,10 | 0,65 0,65 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 510 (390 – 630) 1675 (1300 – 2000) |
| N2 | E/M/A | 0,10 0,10 | 0,65 0,65 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 330 (250 – 400) 1075 (830 – 1300) |
| N3 | E/M/A | 0,10 0,10 | 0,65 0,65 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 220 (170 – 270) 720 (560 – 880) |
| N11 | E/M/A | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 405 (270 – 530) 1325 (890 – 1700) |
| S1 | E | 0,050 0,050 | 0,65 0,65 | 0,060 0,0024 | 0,070 0,0028 | 0,095 0,0038 | 110 (66 – 150) 360 (220 – 490) |
| S2 | E | 0,050 0,050 | 0,65 0,65 | 0,060 0,0024 | 0,070 0,0028 | 0,095 0,0038 | 90 (53 – 120) 295 (180 – 390) |
| S3 | E | 0,050 0,050 | 0,65 0,65 | 0,060 0,0024 | 0,070 0,0028 | 0,095 0,0038 | 75 (46 – 100) 245 (160 – 320) |
| S11 | E | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 175 (130 – 220) 570 (430 – 720) |
| S12 | E | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 135 (95 – 170) 445 (320 – 550) |
| S13 | E | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 105 (74 – 130) 345 (250 – 420) |
| TS1 | A/D | 0,10 0,10 | 0,65 0,65 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 320 (200 – 440) 1050 (660 – 1400) |
| TP1 | A/D | 0,10 0,10 | 0,65 0,65 | 0,10 0,0040 | 0,12 0,0048 | 0,15 0,0060 | 320 (200 – 440) 1050 (660 – 1400) |
| GR1 | A/D | 0,10 0,10 | 0,65 0,65 | 0,070 0,0028 | 0,085 0,0034 | 0,11 0,0044 | 850 (710 – 980) 2800 (2400 – 3200) |

XVC506/509/512

Allgemeine Anwendung – Universell – Fase – 2 Schneiden



N



- Toleranzen:
- SIG= ±1°



| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | CZCMS | DCX | DC | DCSFMS | APMXS | LF | SIG° | PCEDC | SW | Beschichtung |
|-------------------|--------------------|------------------|-------------------|-------|------|-----|--------|-------|------|-------|-------|----|--------------|
| | | | | | mm | mm | mm | mm | mm | | | | SIRA |
| XVC506E10100N1SZ2 | 10138012 | 1 | N | E10 | 10,0 | 1,5 | 9,7 | 7,23 | 11,8 | 60,0 | 2 | 6 | ■ |
| XVC506E12120N1SZ2 | 10138013 | 1 | N | E12 | 12,0 | 1,5 | 11,7 | 7,73 | 14,0 | 60,0 | 2 | 8 | ■ |
| XVC509E10100N1SZ2 | 10138014 | 1 | N | E10 | 10,0 | 1,5 | 9,7 | 4,23 | 11,8 | 90,0 | 2 | 6 | ■ |
| XVC509E12120N1SZ2 | 10138015 | 1 | N | E12 | 12,0 | 1,5 | 11,7 | 5,23 | 14,0 | 90,0 | 2 | 8 | ■ |
| XVC509E16160N1SZ2 | 10138016 | 1 | N | E16 | 16,0 | 1,5 | 15,5 | 7,23 | 18,1 | 90,0 | 2 | 10 | ■ |
| XVC512E12120N1SZ2 | 10138017 | 1 | N | E12 | 12,0 | 1,5 | 11,7 | 3,03 | 14,0 | 120,0 | 2 | 8 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

X-Heads


Minimaster Plus

Minimaster

Schnittdaten – XVC506 Anfasen

| SMG | | a _e /DC | a _p /DC | f _z | | v _c | |
|-------------------------------|---------------------------|-------------------------|-----------------------|---------------------|-----------------|---------------------------------------|-------------------------------------|
| | | | | 10 | 12 | | |
| Universell | P1 | E/M/A/D 0,10 0.10 | 2,0 2.0 | 0,25 0.010 | 0,26 0.010 | 200 (180 – 220) 660 (600 – 720) | |
| | P2 | E/M/A/D 0,10 0.10 | 2,0 2.0 | 0,25 0.010 | 0,26 0.010 | 195 (180 – 220) 640 (600 – 720) | |
| | P3 | E/M/A/D 0,10 0.10 | 2,0 2.0 | 0,24 0.0095 | 0,25 0.010 | 170 (150 – 190) 560 (500 – 620) | |
| | P4 | E/M/A/D 0,10 0.10 | 2,0 2.0 | 0,24 0.0095 | 0,25 0.010 | 150 (130 – 160) 490 (430 – 520) | |
| | P5 | E/M/A/D 0,10 0.10 | 2,0 2.0 | 0,24 0.0095 | 0,25 0.010 | 150 (140 – 170) 490 (460 – 550) | |
| | P6 | E/M/A/D 0,10 0.10 | 2,0 2.0 | 0,24 0.0095 | 0,24 0.0095 | 170 (150 – 190) 560 (500 – 620) | |
| | P7 | E/M/A/D 0,10 0.10 | 2,0 2.0 | 0,24 0.0095 | 0,24 0.0095 | 160 (140 – 180) 520 (460 – 590) | |
| | P8 | E/M/A/D 0,10 0.10 | 2,0 2.0 | 0,24 0.0095 | 0,26 0.010 | 150 (140 – 170) 490 (460 – 550) | |
| | P11 | E/M/A/D 0,10 0.10 | 2,0 2.0 | 0,24 0.0095 | 0,24 0.0095 | 105 (86 – 120) 345 (290 – 390) | |
| | P12 | E/M/A/D 0,10 0.10 | 1,6 1.6 | 0,15 0.0060 | 0,16 0.0065 | 65 (52 – 76) 215 (180 – 240) | |
| | Stahl und Guss | M1 | E/M/A 0,10 0.10 | 2,0 2.0 | 0,26 0.010 | 0,28 0.011 | 125 (99 – 140) 410 (330 – 450) |
| | | M2 | E/M/A 0,10 0.10 | 2,0 2.0 | 0,24 0.0095 | 0,25 0.010 | 100 (80 – 120) 330 (270 – 390) |
| M3 | | E/M/A 0,10 0.10 | 2,0 2.0 | 0,24 0.0095 | 0,25 0.010 | 65 (45 – 84) 215 (150 – 270) | |
| M4 | | E/M/A 0,10 0.10 | 1,5 1.5 | 0,19 0.0075 | 0,20 0.0080 | 47 (33 – 60) 155 (110 – 190) | |
| M5 | | E/M/A 0,10 0.10 | 1,5 1.5 | 0,19 0.0075 | 0,20 0.0080 | 39 (27 – 50) 130 (89 – 160) | |
| Rostfrei und ISO-S-Werkstoffe | K1 | E/M/A/D 0,10 0.10 | 2,0 2.0 | 0,25 0.010 | 0,26 0.010 | 200 (180 – 220) 660 (600 – 720) | |
| | K2 | E/M/A/D 0,10 0.10 | 2,0 2.0 | 0,22 0.0085 | 0,24 0.0095 | 175 (160 – 190) 570 (530 – 620) | |
| | K3 | E/M/A/D 0,10 0.10 | 2,0 2.0 | 0,22 0.0085 | 0,24 0.0095 | 150 (130 – 160) 490 (430 – 520) | |
| | K4 | E/M/A/D 0,10 0.10 | 2,0 2.0 | 0,22 0.0085 | 0,24 0.0095 | 140 (130 – 150) 460 (430 – 490) | |
| | K5 | E/M/A/D 0,10 0.10 | 2,0 2.0 | 0,20 0.0080 | 0,22 0.0085 | 85 (74 – 95) 280 (250 – 310) | |
| | K6 | E/M/A/D 0,10 0.10 | 2,0 2.0 | 0,22 0.0085 | 0,24 0.0095 | 125 (110 – 140) 410 (370 – 450) | |
| | K7 | E/M/A/D 0,10 0.10 | 2,0 2.0 | 0,20 0.0080 | 0,22 0.0085 | 110 (94 – 120) 360 (310 – 390) | |
| NE-Metalle | N1 | E/M/A 0,10 0.10 | 2,0 2.0 | 0,24 0.0095 | 0,25 0.010 | 600 (500 – 690) 1975 (1700 – 2200) | |
| | N2 | E/M/A 0,10 0.10 | 2,0 2.0 | 0,24 0.0095 | 0,25 0.010 | 385 (330 – 440) 1275 (1100 – 1400) | |
| | N3 | E/M/A 0,10 0.10 | 2,0 2.0 | 0,24 0.0095 | 0,25 0.010 | 255 (220 – 290) 840 (730 – 950) | |
| | N11 | E/M/A 0,10 0.10 | 2,0 2.0 | 0,24 0.0095 | 0,25 0.010 | 400 (350 – 450) 1300 (1200 – 1400) | |
| Harter | S1 | E 0,10 0.10 | 2,0 2.0 | 0,12 0.0048 | 0,13 0.0050 | 43 (15 – 71) 140 (50 – 230) | |
| | S2 | E 0,10 0.10 | 2,0 2.0 | 0,12 0.0048 | 0,13 0.0050 | 35 (12 – 57) 115 (40 – 180) | |
| | S3 | E 0,10 0.10 | 2,0 2.0 | 0,12 0.0048 | 0,12 0.0048 | 30 (10 – 49) 100 (33 – 160) | |
| | S11 | E 0,10 0.10 | 2,0 2.0 | 0,24 0.0095 | 0,25 0.010 | 95 (72 – 120) 310 (240 – 390) | |
| | S12 | E 0,10 0.10 | 2,0 2.0 | 0,24 0.0095 | 0,25 0.010 | 75 (55 – 94) 245 (190 – 300) | |
| | S13 | E 0,10 0.10 | 1,7 1.7 | 0,19 0.0075 | 0,20 0.0080 | 55 (43 – 72) 180 (150 – 230) | |
| | Kunststoffe und Composite | H5 | M/A 0,050 0.050 | 2,0 2.0 | 0,11 0.0044 | 0,12 0.0048 | 120 (110 – 140) 395 (370 – 450) |
| | | H8 | M/A 0,050 0.050 | 1,8 1.8 | 0,080 0.0032 | 0,085 0.0034 | 120 (99 – 130) 395 (330 – 420) |
| | | H21 | M/A 0,050 0.050 | 1,8 1.8 | 0,080 0.0032 | 0,085 0.0034 | 120 (99 – 130) 395 (330 – 420) |
| | | H31 | M/A 0,050 0.050 | 1,8 1.8 | 0,070 0.0028 | 0,075 0.0030 | 90 (75 – 100) 295 (250 – 320) |
| | | TS1 | A/D 0,10 0.10 | 2,0 2.0 | 0,17 0.0065 | 0,18 0.0070 | 260 (160 – 360) 850 (530 – 1100) |
| | | TP1 | A/D 0,10 0.10 | 2,0 2.0 | 0,17 0.0065 | 0,18 0.0070 | 260 (160 – 360) 850 (530 – 1100) |
| | | Minimaster Plus | GR1 | A/D 0,10 0.10 | 2,0 2.0 | 0,24 0.0095 | 0,25 0.010 |

Schnittdaten – XVC509 Anfasen

| SMG |  | a _d /DC | a _p /DC | f _z | | | v _c |
|-----|---|--------------------|--------------------|----------------|--------|--------|--------------------|
| | | | | 10 | 12 | 16 | |
| P1 | E/M/A/D | 0,10 | 2,0 | 0,24 | 0,25 | 0,28 | 200 (180 – 220) |
| | | 0,10 | 2,0 | 0,0095 | 0,010 | 0,011 | 660 (600 – 720) |
| P2 | E/M/A/D | 0,10 | 2,0 | 0,24 | 0,26 | 0,28 | 195 (180 – 220) |
| | | 0,10 | 2,0 | 0,0095 | 0,010 | 0,011 | 640 (600 – 720) |
| P3 | E/M/A/D | 0,10 | 2,0 | 0,24 | 0,24 | 0,26 | 170 (150 – 190) |
| | | 0,10 | 2,0 | 0,0095 | 0,0095 | 0,010 | 560 (500 – 620) |
| P4 | E/M/A/D | 0,10 | 2,0 | 0,22 | 0,24 | 0,26 | 150 (130 – 160) |
| | | 0,10 | 2,0 | 0,0085 | 0,0095 | 0,010 | 490 (430 – 520) |
| P5 | E/M/A/D | 0,10 | 2,0 | 0,22 | 0,24 | 0,26 | 150 (140 – 170) |
| | | 0,10 | 2,0 | 0,0085 | 0,0095 | 0,010 | 490 (460 – 550) |
| P6 | E/M/A/D | 0,10 | 2,0 | 0,22 | 0,24 | 0,26 | 170 (150 – 190) |
| | | 0,10 | 2,0 | 0,0085 | 0,0095 | 0,010 | 560 (500 – 620) |
| P7 | E/M/A/D | 0,10 | 2,0 | 0,22 | 0,24 | 0,26 | 160 (140 – 180) |
| | | 0,10 | 2,0 | 0,0085 | 0,0095 | 0,010 | 520 (460 – 590) |
| P8 | E/M/A/D | 0,10 | 2,0 | 0,24 | 0,25 | 0,28 | 150 (130 – 160) |
| | | 0,10 | 2,0 | 0,0095 | 0,010 | 0,011 | 490 (430 – 520) |
| P11 | E/M/A/D | 0,10 | 2,0 | 0,22 | 0,24 | 0,26 | 105 (85 – 120) |
| | | 0,10 | 2,0 | 0,0085 | 0,0095 | 0,010 | 345 (280 – 390) |
| P12 | E/M/A/D | 0,10 | 1,6 | 0,14 | 0,15 | 0,17 | 60 (50 – 74) |
| | | 0,10 | 1,6 | 0,0055 | 0,0060 | 0,0065 | 195 (170 – 240) |
| M1 | E/M/A | 0,10 | 2,0 | 0,25 | 0,26 | 0,28 | 120 (98 – 140) |
| | | 0,10 | 2,0 | 0,010 | 0,010 | 0,011 | 395 (330 – 450) |
| M2 | E/M/A | 0,10 | 2,0 | 0,22 | 0,24 | 0,26 | 100 (80 – 120) |
| | | 0,10 | 2,0 | 0,0085 | 0,0095 | 0,010 | 330 (270 – 390) |
| M3 | E/M/A | 0,10 | 2,0 | 0,22 | 0,24 | 0,26 | 65 (45 – 84) |
| | | 0,10 | 2,0 | 0,0085 | 0,0095 | 0,010 | 215 (150 – 270) |
| M4 | E/M/A | 0,10 | 1,5 | 0,18 | 0,19 | 0,20 | 46 (33 – 60) |
| | | 0,10 | 1,5 | 0,0070 | 0,0075 | 0,0080 | 150 (110 – 190) |
| M5 | E/M/A | 0,10 | 1,5 | 0,18 | 0,19 | 0,20 | 39 (27 – 50) |
| | | 0,10 | 1,5 | 0,0070 | 0,0075 | 0,0080 | 130 (89 – 160) |
| K1 | E/M/A/D | 0,10 | 2,0 | 0,24 | 0,26 | 0,28 | 200 (180 – 220) |
| | | 0,10 | 2,0 | 0,0095 | 0,010 | 0,011 | 660 (600 – 720) |
| K2 | E/M/A/D | 0,10 | 2,0 | 0,22 | 0,24 | 0,26 | 175 (160 – 190) |
| | | 0,10 | 2,0 | 0,0085 | 0,0095 | 0,010 | 570 (530 – 620) |
| K3 | E/M/A/D | 0,10 | 2,0 | 0,22 | 0,24 | 0,26 | 145 (130 – 160) |
| | | 0,10 | 2,0 | 0,0085 | 0,0095 | 0,010 | 475 (430 – 520) |
| K4 | E/M/A/D | 0,10 | 2,0 | 0,22 | 0,24 | 0,26 | 140 (130 – 150) |
| | | 0,10 | 2,0 | 0,0085 | 0,0095 | 0,010 | 460 (430 – 490) |
| K5 | E/M/A/D | 0,10 | 2,0 | 0,20 | 0,22 | 0,24 | 85 (74 – 95) |
| | | 0,10 | 2,0 | 0,0080 | 0,0085 | 0,0095 | 280 (250 – 310) |
| K6 | E/M/A/D | 0,10 | 2,0 | 0,22 | 0,24 | 0,26 | 125 (110 – 130) |
| | | 0,10 | 2,0 | 0,0085 | 0,0095 | 0,010 | 410 (370 – 420) |
| K7 | E/M/A/D | 0,10 | 2,0 | 0,20 | 0,22 | 0,24 | 110 (94 – 120) |
| | | 0,10 | 2,0 | 0,0080 | 0,0085 | 0,0095 | 360 (310 – 390) |
| N1 | E/M/A | 0,10 | 2,0 | 0,22 | 0,24 | 0,26 | 600 (500 – 700) |
| | | 0,10 | 2,0 | 0,0085 | 0,0095 | 0,010 | 1975 (1700 – 2200) |
| N2 | E/M/A | 0,10 | 2,0 | 0,22 | 0,24 | 0,26 | 385 (330 – 450) |
| | | 0,10 | 2,0 | 0,0085 | 0,0095 | 0,010 | 1275 (1100 – 1400) |
| N3 | E/M/A | 0,10 | 2,0 | 0,22 | 0,24 | 0,26 | 255 (220 – 300) |
| | | 0,10 | 2,0 | 0,0085 | 0,0095 | 0,010 | 840 (730 – 980) |
| N11 | E/M/A | 0,10 | 2,0 | 0,22 | 0,24 | 0,26 | 400 (350 – 450) |
| | | 0,10 | 2,0 | 0,0085 | 0,0095 | 0,010 | 1300 (1200 – 1400) |
| S1 | E | 0,10 | 2,0 | 0,13 | 0,13 | 0,15 | 43 (15 – 71) |
| | | 0,10 | 2,0 | 0,0050 | 0,0050 | 0,0060 | 140 (50 – 230) |
| S2 | E | 0,10 | 2,0 | 0,13 | 0,13 | 0,15 | 35 (12 – 57) |
| | | 0,10 | 2,0 | 0,0050 | 0,0050 | 0,0060 | 115 (40 – 180) |
| S3 | E | 0,10 | 2,0 | 0,12 | 0,12 | 0,14 | 30 (10 – 50) |
| | | 0,10 | 2,0 | 0,0048 | 0,0048 | 0,0055 | 100 (33 – 160) |
| S11 | E | 0,10 | 2,0 | 0,22 | 0,24 | 0,26 | 100 (72 – 120) |
| | | 0,10 | 2,0 | 0,0085 | 0,0095 | 0,010 | 330 (240 – 390) |
| S12 | E | 0,10 | 2,0 | 0,22 | 0,24 | 0,26 | 75 (55 – 94) |
| | | 0,10 | 2,0 | 0,0085 | 0,0095 | 0,010 | 245 (190 – 300) |
| S13 | E | 0,10 | 1,7 | 0,19 | 0,20 | 0,22 | 55 (42 – 72) |
| | | 0,10 | 1,7 | 0,0075 | 0,0080 | 0,0085 | 180 (140 – 230) |
| H5 | M/A | 0,10 | 2,0 | 0,12 | 0,12 | 0,14 | 120 (110 – 140) |
| | | 0,10 | 2,0 | 0,0048 | 0,0048 | 0,0055 | 395 (370 – 450) |
| H8 | M/A | 0,10 | 1,8 | 0,085 | 0,090 | 0,10 | 120 (99 – 130) |
| | | 0,10 | 1,8 | 0,0034 | 0,0036 | 0,0040 | 395 (330 – 420) |
| H21 | M/A | 0,10 | 1,8 | 0,085 | 0,090 | 0,10 | 120 (99 – 130) |
| | | 0,10 | 1,8 | 0,0034 | 0,0036 | 0,0040 | 395 (330 – 420) |
| H31 | M/A | 0,10 | 1,8 | 0,075 | 0,080 | 0,085 | 90 (75 – 100) |
| | | 0,10 | 1,8 | 0,0030 | 0,0032 | 0,0034 | 295 (250 – 320) |
| TS1 | A/D | 0,10 | 2,0 | 0,22 | 0,24 | 0,26 | 250 (150 – 350) |
| | | 0,10 | 2,0 | 0,0085 | 0,0095 | 0,010 | 820 (500 – 1100) |
| TP1 | A/D | 0,10 | 2,0 | 0,22 | 0,24 | 0,26 | 250 (150 – 350) |
| | | 0,10 | 2,0 | 0,0085 | 0,0095 | 0,010 | 820 (500 – 1100) |
| GR1 | A/D | 0,10 | 2,0 | 0,22 | 0,24 | 0,26 | 600 (500 – 700) |
| | | 0,10 | 2,0 | 0,0085 | 0,0095 | 0,010 | 1975 (1700 – 2200) |

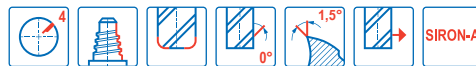
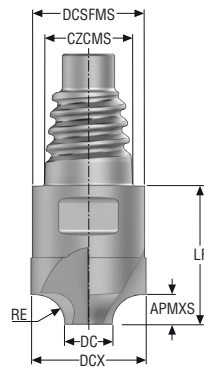
Unversell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Kunststoffe und Composite
Graphit
X-Heads
Minimaster Plus
Minimaster

Schnittdaten – XVC512 Anfasen

| SMG | | a _e /DC | | f _z | v _c |
|-----|---------|--------------------|------------|----------------|---------------------------------------|
| | | | | | |
| | | | | 12 | |
| P1 | E/M/A/D | 0,10 0,10 | 1,3 1,3 | 0,36 0,014 | 165 (150 – 180) 540 (500 – 590) |
| P2 | E/M/A/D | 0,10 0,10 | 1,3 1,3 | 0,36 0,014 | 160 (140 – 170) 520 (460 – 550) |
| P3 | E/M/A/D | 0,10 0,10 | 1,3 1,3 | 0,34 0,013 | 135 (120 – 150) 445 (400 – 490) |
| P4 | E/M/A/D | 0,10 0,10 | 1,3 1,3 | 0,34 0,013 | 120 (110 – 130) 395 (370 – 420) |
| P5 | E/M/A/D | 0,10 0,10 | 1,3 1,3 | 0,34 0,013 | 120 (110 – 130) 395 (370 – 420) |
| P6 | E/M/A/D | 0,10 0,10 | 1,3 1,3 | 0,32 0,013 | 135 (120 – 150) 445 (400 – 490) |
| P7 | E/M/A/D | 0,10 0,10 | 1,3 1,3 | 0,32 0,013 | 125 (120 – 140) 410 (400 – 450) |
| P8 | E/M/A/D | 0,10 0,10 | 1,3 1,3 | 0,34 0,013 | 120 (110 – 130) 395 (370 – 420) |
| P11 | E/M/A/D | 0,10 0,10 | 1,3 1,3 | 0,32 0,013 | 85 (68 – 100) 280 (230 – 320) |
| P12 | E/M/A/D | 0,10 0,10 | 1,3 1,3 | 0,22 0,0085 | 50 (41 – 61) 165 (140 – 200) |
| M1 | E/M/A | 0,10 0,10 | 1,3 1,3 | 0,36 0,014 | 100 (80 – 110) 330 (270 – 360) |
| M2 | E/M/A | 0,10 0,10 | 1,3 1,3 | 0,34 0,013 | 80 (65 – 96) 260 (220 – 310) |
| M3 | E/M/A | 0,10 0,10 | 1,3 1,3 | 0,34 0,013 | 50 (37 – 68) 165 (130 – 220) |
| M4 | E/M/A | 0,10 0,10 | 1,3 1,3 | 0,30 0,012 | 39 (28 – 51) 130 (92 – 160) |
| M5 | E/M/A | 0,10 0,10 | 1,3 1,3 | 0,30 0,012 | 33 (23 – 42) 110 (76 – 130) |
| K1 | E/M/A/D | 0,10 0,10 | 1,3 1,3 | 0,36 0,014 | 160 (140 – 180) 520 (460 – 590) |
| K2 | E/M/A/D | 0,10 0,10 | 1,3 1,3 | 0,32 0,013 | 140 (130 – 150) 460 (430 – 490) |
| K3 | E/M/A/D | 0,10 0,10 | 1,3 1,3 | 0,32 0,013 | 115 (110 – 130) 375 (370 – 420) |
| K4 | E/M/A/D | 0,10 0,10 | 1,3 1,3 | 0,32 0,013 | 110 (98 – 120) 360 (330 – 390) |
| K5 | E/M/A/D | 0,10 0,10 | 1,3 1,3 | 0,30 0,012 | 65 (58 – 75) 215 (200 – 240) |
| K6 | E/M/A/D | 0,10 0,10 | 1,3 1,3 | 0,32 0,013 | 100 (86 – 110) 330 (290 – 360) |
| K7 | E/M/A/D | 0,10 0,10 | 1,3 1,3 | 0,30 0,012 | 85 (74 – 96) 280 (250 – 310) |
| N1 | E/M/A | 0,10 0,10 | 1,3 1,3 | 0,34 0,013 | 480 (410 – 560) 1575 (1400 – 1800) |
| N2 | E/M/A | 0,10 0,10 | 1,3 1,3 | 0,34 0,013 | 310 (260 – 360) 1025 (860 – 1100) |
| N3 | E/M/A | 0,10 0,10 | 1,3 1,3 | 0,34 0,013 | 205 (180 – 240) 670 (600 – 780) |
| N11 | E/M/A | 0,10 0,10 | 1,3 1,3 | 0,34 0,013 | 320 (290 – 360) 1050 (960 – 1100) |
| S1 | E | 0,10 0,10 | 1,3 1,3 | 0,19 0,0075 | 35 (12 – 58) 115 (40 – 190) |
| S2 | E | 0,10 0,10 | 1,3 1,3 | 0,19 0,0075 | 29 (9,6 – 47) 95 (32 – 150) |
| S3 | E | 0,10 0,10 | 1,3 1,3 | 0,17 0,0065 | 25 (8,3 – 41) 80 (28 – 130) |
| S11 | E | 0,10 0,10 | 1,3 1,3 | 0,34 0,013 | 80 (58 – 98) 260 (200 – 320) |
| S12 | E | 0,10 0,10 | 1,3 1,3 | 0,34 0,013 | 60 (45 – 76) 195 (150 – 240) |
| S13 | E | 0,10 0,10 | 1,3 1,3 | 0,30 0,012 | 47 (35 – 59) 155 (120 – 190) |
| H5 | M/A | 0,10 0,10 | 1,3 1,3 | 0,17 0,0065 | 100 (83 – 110) 330 (280 – 360) |
| H8 | M/A | 0,10 0,10 | 1,3 1,3 | 0,13 0,0050 | 100 (84 – 110) 330 (280 – 360) |
| H21 | M/A | 0,10 0,10 | 1,3 1,3 | 0,13 0,0050 | 100 (84 – 110) 330 (280 – 360) |
| H31 | M/A | 0,10 0,10 | 1,3 1,3 | 0,11 0,0044 | 75 (64 – 88) 245 (210 – 280) |
| TS1 | A/D | 0,10 0,10 | 1,3 1,3 | 0,34 0,013 | 200 (130 – 280) 660 (430 – 910) |
| TP1 | A/D | 0,10 0,10 | 1,3 1,3 | 0,34 0,013 | 200 (130 – 280) 660 (430 – 910) |
| GR1 | A/D | 0,10 0,10 | 1,3 1,3 | 0,34 0,013 | 480 (410 – 560) 1575 (1400 – 1800) |

XVK310

Allgemeine Anwendung – Universell – Konkav – 4 Schneiden



- Toleranzen:
- RE= ≤5= ±0,05 mm
- RE= >5= ±0,01 mm

| Bezeichnung | Produkt- nummer | Längen- index | Werkzeug- form | CZCMS | DCX | DC | DCSFMS | APMXS | LF | RE | PCEDC | SW | Beschichtung |
|----------------------|--------------------|------------------|-------------------|-------|------|-----|--------|-------|------|-----|-------|----|--------------|
| | | | | | mm | mm | mm | mm | mm | mm | | | SIRA |
| XVK310E12120D1K300Z4 | 10137998 | 1 | D | E12 | 12,0 | 5,0 | 11,7 | 3,0 | 14,5 | 3,0 | 4 | 10 | ■ |
| XVK310E12120D1K400Z4 | 10137999 | 1 | D | E12 | 12,0 | 4,0 | 11,7 | 4,0 | 14,5 | 4,0 | 4 | 10 | ■ |
| XVK310E16160D1K500Z4 | 10138000 | 1 | D | E16 | 16,0 | 6,0 | 15,5 | 5,0 | 18,7 | 5,0 | 4 | 12 | ■ |
| XVK310E20200D1K600Z4 | 10138001 | 1 | D | E20 | 20,0 | 8,0 | 19,3 | 6,0 | 21,3 | 6,0 | 4 | 16 | ■ |

■ Lagerstandard.

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

X-Heads



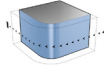
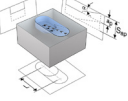


Minimaster Plus

Minimaster

Schnittdaten – XVK310 Eckfräsen/Schruppen

| | SMG | a _p /D _c | | f _z | | | v _c |
|-------------------------------|-----|--------------------------------|------|----------------|--------|--------|-------------------|
| | | | | 12 | 16 | 20 | |
| Universell | P1 | E/M/A/D | 0,24 | 0,048 | 0,065 | 0,080 | 290 (195 – 310) |
| | | | 0,24 | 0,0019 | 0,0026 | 0,0032 | 950 (640 – 1100) |
| | P2 | E/M/A/D | 0,24 | 0,050 | 0,065 | 0,080 | 280 (190 – 305) |
| | | | 0,24 | 0,0022 | 0,0026 | 0,0032 | 910 (620 – 1000) |
| Stahl und Guss | P3 | E/M/A/D | 0,24 | 0,046 | 0,060 | 0,075 | 240 (165 – 260) |
| | | | 0,24 | 0,0018 | 0,0024 | 0,003 | 790 (540 – 850) |
| | P4 | E/M/A/D | 0,24 | 0,046 | 0,060 | 0,075 | 210 (145 – 230) |
| | | | 0,24 | 0,0018 | 0,0024 | 0,003 | 680 (475 – 760) |
| | P5 | E/M/A/D | 0,24 | 0,046 | 0,060 | 0,075 | 205 (135 – 220) |
| | | | 0,24 | 0,0018 | 0,0024 | 0,003 | 670 (445 – 730) |
| | P6 | E/M/A/D | 0,24 | 0,044 | 0,060 | 0,075 | 230 (155 – 245) |
| | | | 0,24 | 0,0017 | 0,0024 | 0,003 | 760 (510 – 800) |
| Rostfrei und ISO-S-Werkstoffe | P7 | E/M/A/D | 0,24 | 0,044 | 0,060 | 0,075 | 215 (145 – 230) |
| | | | 0,24 | 0,0017 | 0,0024 | 0,003 | 710 (475 – 760) |
| | P8 | E/M/A/D | 0,24 | 0,046 | 0,060 | 0,075 | 205 (140 – 220) |
| | | | 0,24 | 0,0018 | 0,0024 | 0,003 | 670 (460 – 730) |
| | P11 | E/M/A/D | 0,24 | 0,044 | 0,060 | 0,075 | 210 (140 – 225) |
| | | | 0,24 | 0,0017 | 0,0024 | 0,003 | 680 (460 – 740) |
| | M1 | E/M/A | 0,24 | 0,050 | 0,065 | 0,080 | 255 (170 – 270) |
| | | | 0,24 | 0,0022 | 0,0026 | 0,0032 | 840 (560 – 890) |
| NE-Metalle | M2 | E/M/A | 0,24 | 0,046 | 0,060 | 0,075 | 205 (135 – 220) |
| | | | 0,24 | 0,0018 | 0,0024 | 0,003 | 670 (445 – 730) |
| | M3 | E/M/A | 0,24 | 0,036 | 0,048 | 0,060 | 150 (105 – 165) |
| | | | 0,24 | 0,0014 | 0,0019 | 0,0024 | 490 (345 – 540) |
| | M4 | E/M/A | 0,24 | 0,032 | 0,042 | 0,050 | 110 (75 – 120) |
| | | | 0,24 | 0,0013 | 0,0017 | 0,0022 | 360 (250 – 400) |
| | M5 | E/M/A | 0,24 | 0,032 | 0,042 | 0,050 | 95 (65 – 100) |
| | | | 0,24 | 0,0013 | 0,0017 | 0,0022 | 310 (220 – 320) |
| Harter | K1 | E/M/A/D | 0,24 | 0,046 | 0,060 | 0,075 | 205 (135 – 220) |
| | | | 0,24 | 0,0018 | 0,0024 | 0,003 | 670 (445 – 730) |
| | K2 | E/M/A/D | 0,24 | 0,040 | 0,055 | 0,065 | 175 (120 – 190) |
| | | | 0,24 | 0,0016 | 0,0022 | 0,0026 | 570 (400 – 620) |
| | K3 | E/M/A/D | 0,24 | 0,040 | 0,055 | 0,065 | 150 (100 – 160) |
| | | | 0,24 | 0,0016 | 0,0022 | 0,0026 | 490 (320 – 530) |
| | K4 | E/M/A/D | 0,24 | 0,040 | 0,055 | 0,065 | 140 (95 – 150) |
| | | | 0,24 | 0,0016 | 0,0022 | 0,0026 | 460 (310 – 490) |
| Kunststoffe und Composite | K5 | E/M/A/D | 0,24 | 0,036 | 0,050 | 0,060 | 85 (55 – 90) |
| | | | 0,24 | 0,0014 | 0,0022 | 0,0024 | 280 (180 – 300) |
| | K6 | E/M/A/D | 0,24 | 0,040 | 0,055 | 0,065 | 125 (85 – 135) |
| | | | 0,24 | 0,0016 | 0,0022 | 0,0026 | 410 (280 – 445) |
| | K7 | E/M/A/D | 0,24 | 0,036 | 0,050 | 0,060 | 105 (70 – 115) |
| | | | 0,24 | 0,0014 | 0,0022 | 0,0024 | 345 (220 – 375) |
| Graphit | N1 | E/M/A | 0,24 | 0,046 | 0,060 | 0,075 | 315 (215 – 340) |
| | | | 0,24 | 0,0018 | 0,0024 | 0,003 | 1025 (710 – 1125) |
| | N2 | E/M/A | 0,24 | 0,046 | 0,060 | 0,075 | 205 (135 – 220) |
| | | | 0,24 | 0,0018 | 0,0024 | 0,003 | 670 (445 – 730) |
| | N3 | E/M/A | 0,24 | 0,046 | 0,060 | 0,075 | 135 (90 – 145) |
| | | | 0,24 | 0,0018 | 0,0024 | 0,003 | 445 (300 – 475) |
| | N11 | E/M/A | 0,24 | 0,046 | 0,060 | 0,075 | 205 (135 – 220) |
| | | | 0,24 | 0,0018 | 0,0024 | 0,003 | 670 (445 – 730) |
| X-Heads | S1 | E | 0,24 | 0,048 | 0,065 | 0,080 | 205 (140 – 220) |
| | | | 0,24 | 0,0019 | 0,0026 | 0,0032 | 670 (460 – 730) |
| | S2 | E | 0,24 | 0,048 | 0,065 | 0,080 | 205 (140 – 220) |
| | | | 0,24 | 0,0019 | 0,0026 | 0,0032 | 670 (460 – 730) |
| | S3 | E | 0,24 | 0,046 | 0,060 | 0,075 | 205 (135 – 220) |
| | | | 0,24 | 0,0018 | 0,0024 | 0,003 | 670 (445 – 730) |
| | S11 | E | 0,24 | 0,046 | 0,060 | 0,075 | 265 (180 – 285) |
| | | | 0,24 | 0,0018 | 0,0024 | 0,003 | 870 (590 – 940) |
| | S12 | E | 0,24 | 0,046 | 0,060 | 0,075 | 205 (135 – 220) |
| | | | 0,24 | 0,0018 | 0,0024 | 0,003 | 670 (445 – 730) |
| Minimaster Plus | S13 | E | 0,24 | 0,040 | 0,050 | 0,065 | 155 (105 – 165) |
| | | | 0,24 | 0,0016 | 0,0022 | 0,0026 | 510 (345 – 540) |
| | TS1 | A/D | 0,24 | 0,046 | 0,060 | 0,075 | 205 (135 – 220) |
| | | | 0,24 | 0,0018 | 0,0024 | 0,003 | 670 (445 – 730) |
| | TP1 | A/D | 0,24 | 0,046 | 0,060 | 0,075 | 205 (135 – 220) |
| | | | 0,24 | 0,0018 | 0,0024 | 0,003 | 670 (445 – 730) |
| Minimaster | GR1 | A/D | 0,24 | 0,046 | 0,060 | 0,075 | 205 (135 – 220) |
| | | | 0,24 | 0,0018 | 0,0024 | 0,003 | 670 (445 – 730) |

Berechnungen

| Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen. | | | | | | | | | | Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen. | | | | | | | | | | | | | | |
|--|---|---|---|--|---|---|-------|-------|-------|--|-------------------|-------------------|--------------|-------|--------|-------|-------|--------------|-------|--------------|-------|--------------|-------|--------------|
| Gerade | Nutfräsen | | Eckfräsen/Schruppen | | | Eckfräsen/Schlichten | | | | Einwärtskopieren | | Walzenstirnfräsen | | | Bohren | | | | | | | | | |
| |  |  |  |  |  |  | a_p | f_z | a_e | f_z | a_p | v_c | a_e (% DC) | f_z | a_p | a_p | f_z | a_p (% DC) | f_z | a_p (% DC) | f_z | a_p (% DC) | f_z | a_p (% DC) |
| JS412 | | | | | | | | | | | $\leq 30^\circ$ * | | | | | | | | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 140 | 3 | 40 | 120 | 80 | 100 | 50 | 10 | 130 | 50 | 100 | | | | | | | | |
| JS413 | | | | | | | | | | | $\leq 10^\circ$ * | | | | | | | | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 150 | 3 | 40 | 120 | 70 | 50 | 50 | 10 | 130 | X | X | | | | | | | | |
| LV3 | X | X | 25 | 60 | 240 | 120 | 3 | 40 | 230 | 70 | 50 | 50 | 10 | 130 | X | X | | | | | | | | |
| JS452 | | | | | | | | | | | $\leq 30^\circ$ * | | | | | | | | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 140 | 3 | 35 | 120 | 70 | 100 | 50 | 10 | 130 | 50 | 100 | | | | | | | | |
| LV3 | 50 | 60 | 75 | 60 | 50 | 120 | 3 | 40 | 100 | 70 | 70 | 50 | 10 | 130 | 20 | 10 | | | | | | | | |
| JS453 | | | | | | | | | | | $\leq 10^\circ$ * | | | | | | | | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 140 | 3 | 35 | 120 | 70 | 50 | 50 | 10 | 130 | 20 | 10 | | | | | | | | |
| LV3 | X | X | 25 | 60 | 240 | 120 | 3 | 40 | 230 | 70 | 70 | 50 | 10 | 130 | 20 | 10 | | | | | | | | |
| JSE512 | | | | | | | | | | | $\leq 30^\circ$ * | | | | | | | | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 110 | 3 | 65 | 125 | 40 | 40 | 100 | 5 | 130 | 40 | 40 | | | | | | | | |
| JSE513 | | | | | | | | | | | $\leq 5^\circ$ * | | | | | | | | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 110 | 3 | 85 | 150 | 100 | 100 | 100 | 5 | 130 | 50 | 40 | | | | | | | | |
| LV3 | 30 | 100 | 30 | 50 | 200 | 110 | 3 | 85 | 250 | X | X | X | X | X | X | X | | | | | | | | |
| LV4 | X | X | X | X | X | 60 | 3 | 80 | 350 | X | X | X | X | X | X | X | X | | | | | | | |
| JSE514 | | | | | | | | | | | $\leq 5^\circ$ * | | | | | | | | | | | | | |
| LV1 | 100 | 100 | 100 | 100 | 100 | 110 | 3 | 60 | 150 | 100 | 100 | 100 | 5 | 130 | X | X | | | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 110 | 3 | 60 | 150 | 100 | 100 | 100 | 5 | 130 | X | X | | | | | | | | |
| LV3 | X | X | 25 | 50 | 200 | 110 | 3 | 60 | 250 | X | X | X | X | X | X | X | | | | | | | | |
| LV4 | X | X | X | X | X | 60 | 3 | 80 | 350 | X | X | X | X | X | X | X | X | | | | | | | |
| JS553 | | | | | | | | | | | $\leq 45^\circ$ * | | | | | | | | | | | | | |
| LV1 | 100 | 100 | 100 | 100 | 100 | 110 | 3 | 55 | 150 | 50 | 55 | 35 | 3 | 130 | 35 | 50 | | | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 110 | 3 | 55 | 150 | 50 | 55 | 35 | 3 | 130 | 35 | 50 | | | | | | | | |
| LV3 | 40 | 60 | 40 | 105 | 200 | 110 | 3 | 55 | 250 | 50 | 15 | 35 | 3 | 130 | 35 | 50 | | | | | | | | |
| JS554 | | | | | | | | | | | $\leq 5^\circ$ * | | | | | | | | | | | | | |
| LV1 | 100 | 100 | 100 | 100 | 100 | 110 | 3 | 53 | 150 | 100 | 100 | 100 | 3 | 130 | X | X | | | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 110 | 3 | 53 | 150 | 100 | 100 | 100 | 3 | 130 | X | X | | | | | | | | |
| LV3 | 40 | 60 | 38 | 105 | 200 | 110 | 3 | 53 | 250 | 50 | 50 | 60 | 3 | 130 | X | X | | | | | | | | |
| JS564 | | | | | | | | | | | $\leq 5^\circ$ * | | | | | | | | | | | | | |
| LV2 | X | X | 100 | 100 | 100 | 110 | 3 | 55 | 100 | X | X | 100 | 2 | 130 | X | X | | | | | | | | |
| LV3 | X | X | 38 | 105 | 140 | 110 | 3 | 55 | 140 | X | X | 60 | 1,5 | 130 | X | X | | | | | | | | |
| JS565 | | | | | | | | | | | $\leq 5^\circ$ * | | | | | | | | | | | | | |
| LV2 | X | X | 100 | 100 | 100 | 110 | 3 | 55 | 100 | X | X | 100 | 2 | 130 | X | X | | | | | | | | |
| LV3 | X | X | 38 | 105 | 140 | 110 | 3 | 55 | 140 | X | X | 60 | 1,5 | 130 | X | X | | | | | | | | |

* Max. Einwärtskopierwinkel
 Prozentuale Werte, bezogen auf die Original-Schnittdaten.




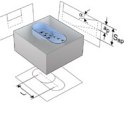


Berechnungen

| Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen. | | | | | | | | | | Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen. | | | | | | | |
|--|-----------|-----|---------------------|-----|-----|----------------------|-------|-------|-------|--|-------|-------------------|--------------|-------|--------|-------|--------------|
| Gerade | Nutfräsen | | Eckfräsen/Schruppen | | | Eckfräsen/Schlichten | | | | Einwärtskopieren | | Walzenstirnfräsen | | | Bohren | | |
| | | | | | | | a_p | f_z | a_e | f_z | a_p | v_c | a_e (% DC) | f_z | a_p | f_z | a_p (% DC) |
| J28 | | | | | | | | | | | | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 140 | 3 | 100 | 135 | | | | | | | | |
| J36 | | | | | | | | | | | | | | | | | |
| LV2 | X | X | 100 | 100 | 100 | 120 | 3 | 85 | 150 | X | X | X | X | X | X | X | X |
| J93F | | | | | | | | | | | | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 133 | 3 | 40 | 100 | 100 | 100 | 100 | 3 | 130 | 25 | 30 | |
| JH120 | | | | | | | | | | | | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 120 | 3 | 120 | 80 | 17 | 100 | 100 | 2 | 130 | X | X | |
| JH130 | | | | | | | | | | | | | | | | | |
| LV2 | X | X | 100 | 100 | 100 | 120 | 3 | 120 | 80 | X | X | X | X | X | X | X | X |
| JH142 | | | | | | | | | | | | | | | | | |
| LV2 | X | X | 100 | 100 | 100 | 110 | 3 | 80 | 70 | X | X | 30 | 2 | 130 | X | X | |
| LV3 | X | X | 100 | 100 | 100 | 110 | 3 | 80 | 70 | X | X | 20 | 1 | 130 | X | X | |
| LV6 | X | X | 100 | 100 | 100 | 110 | 3 | 80 | 70 | X | X | 10 | 1 | 130 | X | X | |
| JH830 | | | | | | | | | | | | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 110 | 3 | 110 | 80 | 9 | 135 | 135 | 3 | 130 | X | X | |
| JH910 | | | | | | | | | | | | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 125 | 4 | 100 | 80 | 15 | 140 | 140 | 3 | 130 | X | X | |
| LV3 | 80 | 80 | 100 | 80 | 80 | 125 | 4 | 80 | 65 | 10 | 110 | 110 | 3 | 130 | X | X | |
| JH930 | | | | | | | | | | | | | | | | | |
| LV2 | X | X | 100 | 100 | 100 | 125 | 2 | 30 | 100 | X | X | X | X | X | X | X | X |

* Max. Einwärtskopierwinkel

Prozentuale Werte, bezogen auf die Original-Schnittdaten.

Berechnungen

| Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen. | | | | | | | | | | Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen. | | | | | | | | | |
|--|---|---|---|--|---|---|-------|-------|-------|--|-------------------|-------------------|-------|-------|---------------------------|---|-------|-----------------|--|
| Gerade | Nutfräsen | | Eckfräsen/Schruppen | | | Eckfräsen/Schlichten | | | | Einwärtskopieren | | Walzenstirnfräsen | | | Bohren | | | | |
| |  |  |  |  |  |  | a_p | f_z | a_e | f_z | a_p | a_p | f_z | f_z | $a_p/360^\circ$ (% DC) | Bohrung \varnothing (\geq % DC) | f_z | a_p (% DC) | |
| | | | | | | | | | | $\leq 5^\circ$ * | | | | | | | | | |
| JH40 | 100 | 100 | 100 | 100 | 100 | 100 | 3 | 35 | 100 | 83 | 55 | 55 | 25 | 130 | 55 | 80 | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 100 | 3 | 35 | 100 | 83 | 55 | 55 | 25 | 130 | 55 | 80 | | | |
| JH410 | | | | | | | | | | | $\leq 45^\circ$ * | | | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 125 | 2 | 25 | 100 | 100 | 67 | 67 | 40 | 130 | 67 | 80 | | | |
| LV2 (ML) | 75 | 60 | 80 | 60 | 100 | 125 | 2 | 25 | 100 | 60 | 40 | 40 | 40 | 130 | 40 | 50 | | | |
| LV2 (TL) | 125 | 100 | 100 | 100 | 100 | 100 | 2 | 100 | 100 | 100 | 50 | 100 | 40 | 130 | 150 | 80 | | | |
| LV2 (RS) | 125 | 100 | 100 | 100 | 100 | 100 | 2 | 100 | 100 | 100 | 50 | 100 | 40 | 130 | 150 | 80 | | | |
| LV3 (RS) | 95 | 95 | 80 | 100 | 100 | 100 | 2 | 100 | 100 | 50 | 50 | 50 | 40 | 130 | 75 | 40 | | | |
| JH421 | | | | | | | | | | | $\leq 45^\circ$ * | | | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 100 | 4 | 35 | 100 | 100 | 100 | 100 | 25 | 130 | 45 | 80 | | | |
| JH440 | | | | | | | | | | | $\leq 30^\circ$ * | | | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 125 | 3 | 40 | 100 | 100 | 100 | 100 | 5 | 130 | X | X | | | |
| JHP750 | | | | | | | | | | | $\leq 5^\circ$ * | | | | | | | | |
| LV1 | 115 | 120 | 115 | 115 | 100 | 100 | 2 | 145 | 100 | 100 | 120 | 120 | 3 | 130 | 10 | 70 | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 100 | 2 | 145 | 100 | 100 | 100 | 100 | 3 | 130 | 10 | 60 | | | |
| JHP951 | | | | | | | | | | | $\leq 5^\circ$ * | | | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 158 | 2 | 50 | 113 | 20 | 100 | 125 | 3 | 130 | 6 | 20 | | | |
| JHP993 | | | | | | | | | | | $\leq 10^\circ$ * | | | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | X | X | X | X | 30 | 100 | 100 | 3 | 130 | 4 | 40 | | | |
| LV3 | 80 | 80 | 80 | 80 | 80 | X | X | X | X | 20 | 80 | 80 | 3 | 130 | 3 | 30 | | | |
| JS520 | | | | | | | | | | | $\leq X^\circ$ * | | | | | | | | |
| LV2 | X | X | 100 | 100 | 100 | 133 | 2 | 65 | 100 | X | X | X | X | X | X | X | X | X | |
| LV3 | X | X | X | X | X | 133 | 2 | 65 | 175 | X | X | X | X | X | X | X | X | X | |
| JS522 | | | | | | | | | | | $\leq X^\circ$ * | | | | | | | | |
| LV4 | X | X | 100 | 100 | 100 | 129 | 2 | 140 | 100 | X | X | X | X | X | X | X | X | X | |
| JS720 | | | | | | | | | | | $\leq X^\circ$ * | | | | | | | | |
| LV2 | X | X | 100 | 100 | 100 | 110 | 2 | 65 | 100 | X | X | 100 | 2 | 130 | X | X | X | X | |
| LV3 | X | X | 100 | 100 | 100 | 110 | 2 | 65 | 100 | X | X | 100 | 2 | 130 | X | X | X | X | |
| JS754 | | | | | | | | | | | $\leq X^\circ$ * | | | | | | | | |
| LV1 | 100 | 100 | 100 | 100 | 100 | 110 | 3 | 55 | 150 | 100 | 100 | 100 | 3 | 130 | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 110 | 3 | 55 | 150 | 100 | 100 | 100 | 3 | 130 | X | X | | | |
| LV3 | 40 | 60 | 38 | 105 | 200 | 110 | 3 | 55 | 250 | 50 | 50 | 60 | 3 | 130 | | | | | |
| JS755 | | | | | | | | | | | $\leq X^\circ$ * | | | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 110 | 3 | 55 | 150 | 100 | 100 | 100 | 3 | 130 | X | X | | | |
| LV3 | 40 | 60 | 38 | 105 | 100 | 110 | 3 | 55 | 250 | 50 | 50 | 60 | 3 | 130 | X | X | | | |

* Max. Einwärtskopierwinkel

Prozentuale Werte, bezogen auf die Original-Schnittdaten.







Berechnungen

| Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen. | | | | | | | | | | Original-Schnittdaten zum Eckfräsen einsetzen, danach Parameter neu berechnen. | | | | | | | | |
|--|-----------|-----|---------------------|-----|-----|----------------------|-------|-------|-------|--|-------|-------------------|-------|---------|---------------------------|--|-------|-----------------|
| Gerade | Nutfräsen | | Eckfräsen/Schruppen | | | Eckfräsen/Schlichten | | | | Einwärtskopieren | | Walzenstirnfräsen | | | Bohren | | | |
| | | | | | | | a_p | f_z | a_e | f_z | a_p | a_p | f_z | f_z | $a_p/360^\circ$ (% DC) | Bohrung \varnothing (\geq % DC) | f_z | a_p (% DC) |
| | | | | | | | | | | $\leq X^\circ$ | | | | | | | | |
| JME542-JME562-JME564 | | | | | | | | | | | | | | | | | | |
| LV1 | 100 | 100 | 100 | 100 | 100 | 125 | 2 | 150 | 5 | X | X | X | X | X | X | X | X | X |
| LV2 | 63 | 100 | 100 | 100 | 65 | 125 | 2 | 150 | 3 | X | X | X | X | X | X | X | X | X |
| LV3 | 25 | 100 | 100 | 100 | 25 | 125 | 2 | 150 | 1 | X | X | X | X | X | X | X | X | X |
| LV4 (TL) | 18 | 100 | 100 | 100 | 20 | 125 | 2 | 150 | 1 | X | X | X | X | X | X | X | X | X |
| LV4 (XL) | 12 | 100 | 100 | 100 | 10 | 125 | 2 | 150 | 1 | X | X | X | X | X | X | X | X | X |
| LV5 | 10 | 100 | 100 | 100 | 10 | 125 | 2 | 150 | 1 | X | X | X | X | X | X | X | X | X |
| LV6 | 4 | 100 | 100 | 100 | 5 | 125 | 2 | 150 | 1 | X | X | X | X | X | X | X | X | X |
| LV7 | 2 | 100 | 100 | 100 | 2 | 125 | 2 | 150 | 1 | X | X | X | X | X | X | X | X | X |
| | | | | | | | | | | $\leq X^\circ$ | | | | | | | | |
| JME142-JME144 | | | | | | | | | | | | | | | | | | |
| LV1 | 100 | 100 | 100 | 100 | 100 | 100 | 2 | 150 | 5 | X | X | X | X | X | X | X | X | X |
| LV2 | 85 | 85 | 100 | 100 | 63 | 100 | 2 | 150 | 3 | X | X | X | X | X | X | X | X | X |
| LV3 | 75 | 75 | 100 | 100 | 25 | 100 | 2 | 150 | 1 | X | X | X | X | X | X | X | X | X |
| LV4 | 60 | 60 | 100 | 100 | 20 | 100 | 2 | 150 | 1 | X | X | X | X | X | X | X | X | X |
| LV5 | 50 | 50 | 100 | 100 | 10 | 100 | 2 | 150 | 1 | X | X | X | X | X | X | X | X | X |
| LV6 | 40 | 40 | 100 | 100 | 5 | 100 | 2 | 150 | 1 | X | X | X | X | X | X | X | X | X |
| | | | | | | | | | | $\leq X^\circ$ | | | | | | | | |
| JM403-JM404-JM406 | | | | | | | | | | | | | | | | | | |
| LV1 | 100 | 100 | 100 | 100 | 100 | X | X | X | X | X | X | X | X | X | X | X | X | X |
| LV2 | 100 | 75 | 100 | 75 | 100 | X | X | X | X | X | X | X | X | X | X | X | X | X |
| LV3 (L) | 100 | 75 | 100 | 75 | 90 | X | X | X | X | X | X | X | X | X | X | X | X | X |
| LV3 (TL) | 90 | 75 | 100 | 75 | 70 | X | X | X | X | X | X | X | X | X | X | X | X | X |
| LV4 (XL) | 75 | 75 | 100 | 75 | 70 | X | X | X | X | X | X | X | X | X | X | X | X | X |
| LV4 (SL) | 75 | 75 | 100 | 75 | 45 | X | X | X | X | X | X | X | X | X | X | X | X | X |
| LV5 | 50 | 50 | 100 | 50 | 30 | X | X | X | X | X | X | X | X | X | X | X | X | X |
| | | | | | | | | | | ≤ 2 | | | | | | | | |
| JC898 | | | | | | | | | | | | | | | | | | |
| LV3 | X | X | 100 | 100 | 100 | X | X | X | X | X | 50 | 80 | 3 | 130-160 | X | X | X | X |
| | | | | | | | | | | $\leq 5^\circ$ | | | | | | | | |
| JC899 | | | | | | | | | | | | | | | | | | |
| LV3 | X | X | 100 | 100 | 100 | 100 | 3 | 50 | 100 | X | X | X | X | X | X | X | X | X |

* Max. Einwärtskopierwinkel

Prozentuale Werte, bezogen auf die Original-Schnittdaten.

Berechnungen

| Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen. | | | | | | | | | | Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen. | | | | | | | |
|--|---|-------|---|-------|-------|---|--------------|-------|-------|--|-----------------|---|------------------------|--------------------------------------|---|--------------|--|
| Gerade | Nutfräsen | | Eckfräsen/Schruppen | | | Eckfräsen/Schlichten | | | | Einwärtskopieren | | Walzenstirnfräsen | | | Bohren | | |
| |  | |  | | |  | | | |  | |  | | |  | | |
| | a_p | f_z | a_e | f_z | a_p | v_c | a_e (% DC) | f_z | a_p | a_p | f_z | f_z | $a_p/360^\circ$ (% DC) | Bohrung \varnothing (\geq % DC) | f_z | a_p (% DC) | |
| JHP170 | | | | | | | | | | | $\leq 1^\circ$ | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 130 | 3 | 175 | 80 | 100 | 100 | 100 | 2 | 130 | X | X | |
| JHP490 | | | | | | | | | | | $\leq 30^\circ$ | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | X | X | X | X | 50 | 50 | 35 | 5 | 130 | 30 | 50 | |
| LV2 (E-Form) | 100 | 75 | 100 | 100 | 100 | X | X | X | X | 50 | 50 | 35 | 5 | 130 | 30 | 50 | |
| LV3 | 100 | 75 | 80 | 100 | 100 | X | X | X | X | 50 | 50 | 35 | 5 | 130 | 30 | 50 | |
| LV4 | 150 | 75 | 80 | 100 | 100 | X | X | X | X | 50 | 50 | 35 | 5 | 130 | 30 | 50 | |
| JHP760 | | | | | | | | | | | $\leq 5^\circ$ | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 140 | 2 | 125 | 15 | 30 | 100 | 100 | 3 | 130 | 10 | 50 | |
| LV3 | 50 | 50 | 100 | 50 | 50 | 140 | 2 | 125 | 15 | 15 | 50 | 50 | 3 | 130 | 5 | 25 | |
| JHP770 | | | | | | | | | | | $\leq 15^\circ$ | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 170 | 3 | 125 | 100 | 100 | 40 | 40 | 3 | 130 | X | X | |
| JHP780 | | | | | | | | | | | $\leq 5^\circ$ | | | | | | |
| LV1 | 100 | 100 | 100 | 100 | 100 | 160 | 2 | 135 | 140 | 100 | 100 | 35 | 3 | 130 | 35 | 50 | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 160 | 2 | 135 | 140 | 100 | 100 | 35 | 3 | 130 | 35 | 50 | |
| JD620 | | | | | | | | | | | $\leq X^\circ$ | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 100 | 2 | 110 | 4 | X | X | X | X | X | X | X | |
| LV3 | 100 | 100 | 100 | 100 | 100 | 100 | 2 | 110 | 4 | X | X | X | X | X | X | X | |
| LV4 | 20 | 100 | 60 | 100 | 60 | 100 | 2 | 110 | 4 | X | X | X | X | X | X | X | |
| JD630 | | | | | | | | | | | $\leq X^\circ$ | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 100 | 2 | 110 | 4 | X | X | X | X | X | X | X | |
| LV3 | 100 | 100 | 100 | 100 | 100 | 100 | 2 | 110 | 4 | X | X | X | X | X | X | X | |
| LV4 | 100 | 100 | 100 | 100 | 100 | 100 | 2 | 110 | 4 | X | X | X | X | X | X | X | |
| JD640 | | | | | | | | | | | $\leq X^\circ$ | | | | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | 100 | 2 | 110 | 4 | X | X | X | X | X | X | X | |
| LV3 | 100 | 100 | 100 | 100 | 100 | 100 | 2 | 110 | 4 | X | X | X | X | X | X | X | |
| LV4 | 100 | 100 | 100 | 100 | 100 | 100 | 2 | 110 | 4 | X | X | X | X | X | X | X | |

* Max. Einwärtskopierwinkel

Prozentuale Werte, bezogen auf die Original-Schnittdaten.



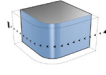
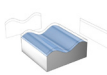
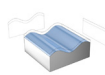
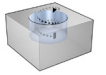
Berechnungen

| Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen. | | | | | | | | | | Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen. | | | | | | | | | | | |
|--|----------------|----------------|---------------------|----------------|----------------|----------------------|-----------------------|----------------|----------------|--|----------------|-------------------|-----------------------------|--------------------|----------------|-----------------------|----------------|---------------------------|--|--|--|
| Gerade | Nutfräsen | | Eckfräsen/Schruppen | | | Eckfräsen/Schlichten | | | | Einwärtskopieren | | Walzenstirnfräsen | | | Tauchfräsen | | | | | | |
| | | | | | | | | | | | | | | | | | | | | | |
| | a _p | f _z | a _e | f _z | a _p | v _c | a _e (% DC) | f _z | a _p | a _p | f _z | f _z | a _p /360° (% DC) | Bohrung Ø (≥ % DC) | v _c | a _e (% DC) | f _z | a _e -sd (% DC) | | | |
| JHF181 | | | | | | | | | | | | | | | | | | | | | |
| LV1 | 100 | 100 | 100 | 100 | 100 | X | X | X | X | X | X | 100 | 3,4 | 130 | X | X | X | X | | | |
| LV2 | 80 | 85 | 100 | 85 | 80 | X | X | X | X | X | X | 85 | 3,0 | 130 | X | X | X | X | | | |
| LV3 | 60 | 70 | 100 | 70 | 60 | X | X | X | X | X | X | 70 | 2,5 | 130 | X | X | X | X | | | |
| | | | | | | | | | | ≤ 1,5° * | | | | | | | | | | | |
| JHF980 | | | | | | | | | | | | | | | | | | | | | |
| LV1 | 100 | 100 | 100 | 100 | 100 | X | X | X | X | 100 | 100 | 100 | 3 | 130 | 70 | 30 | 33 | 200 | | | |
| LV2 | 100 | 100 | 100 | 100 | 100 | X | X | X | X | 100 | 100 | 100 | 3 | 130 | 70 | 30 | 33 | 200 | | | |
| LV3 | 80 | 85 | 80 | 85 | 80 | X | X | X | X | 80 | 85 | 85 | 3 | 130 | 70 | 30 | 33 | 200 | | | |
| LV4 | 50 | 70 | 50 | 70 | 60 | X | X | X | X | 60 | 70 | 70 | 3 | 130 | 70 | 30 | 33 | 200 | | | |

* Max. Einwärtskopierwinkel

Prozentuale Werte, bezogen auf die Original-Schnittdaten.

Berechnungen

| Original-Schnittdaten einsetzen, danach Parameter neu berechnen. | | | | | | | | | | Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen. | | | | | | | | | | |
|--|---|---|---|--|---|---|--------------|-------|-------|--|------------------------|-------|-------|-------------------------------|--------------|-------|-------|-------------------|------------------------|-----|
| KUGELKOPF | Nutfräsen | | Eckfräsen/Schruppen | | | Eckfräsen/Schichten | | | | | Kopierfräsen/Schruppen | | | Kopierfräsen/ Feinbearbeitung | | | | Walzenstirnfräsen | | |
| |  |  |  |  |  |  | | | | | | | | | | | | | | |
| | a_p | f_z | a_e | f_z | a_p | v_c | a_e (% DC) | f_z | a_p | | a_e | f_z | a_p | v_c | a_e (% DC) | f_z | a_p | f_z | $a_p/360^\circ$ (% DC) | |
| JSB512 LV2 | X | X | 100 | 100 | 100 | 125 | 3 | 125 | 10 | X | X | X | X | X | X | X | X | 100 | 5 | 130 |
| JS532 LV1 | X | X | 100 | 100 | 100 | 125 | 3 | 125 | 10 | X | X | X | X | X | X | X | X | 75 | 5 | 130 |
| LV2 | X | X | 70 | 100 | 70 | 125 | 3 | 125 | 10 | X | X | X | X | X | X | X | X | 75 | 5 | 130 |
| LV3 | X | X | X | X | X | 125 | 3 | 125 | 10 | X | X | X | X | X | X | X | X | X | X | X |
| JS533 LV1 | X | X | 100 | 100 | 100 | 125 | 3 | 125 | 15 | X | X | X | X | X | X | X | X | 75 | 5 | 130 |
| LV2 | X | X | 75 | 75 | 75 | 125 | 3 | 125 | 15 | X | X | X | X | X | X | X | X | 75 | 5 | 130 |
| JS534 LV1 | X | X | 100 | 100 | 100 | 125 | 3 | 170 | 20 | X | X | X | X | X | X | X | X | 100 | 3 | 130 |
| LV2 | X | X | 70 | 100 | 70 | 125 | 3 | 170 | 20 | X | X | X | X | X | X | X | X | 100 | 3 | 130 |
| LV3 | X | X | 70 | 100 | 70 | 125 | 3 | 170 | 20 | X | X | X | X | X | X | X | X | 100 | 3 | 130 |
| JHB970 LV1 | X | X | 100 | 100 | 100 | 155 | 2 | 30 | 15 | X | X | X | X | X | X | X | X | 40 | 3 | 130 |
| LV2 | X | X | 100 | 100 | 100 | 155 | 2 | 30 | 15 | X | X | X | X | X | X | X | X | 40 | 3 | 130 |
| LV3 | X | X | 100 | 100 | 100 | 155 | 2 | 30 | 15 | X | X | X | X | X | X | X | X | 40 | 3 | 130 |
| JHB720 LV2 | X | X | 100 | 100 | 100 | 125 | 2 | 90 | 75 | X | X | X | X | X | X | X | X | 40 | 3 | 130 |
| JH112 LV1 | X | X | 100 | 100 | 100 | 110 | 2 | 70 | 100 | X | X | X | X | X | X | X | X | 20 | 2 | 130 |
| LV2 | X | X | 100 | 100 | 100 | 110 | 2 | 70 | 100 | X | X | X | X | X | X | X | X | 20 | 2 | 130 |
| LV3 | X | X | 100 | 100 | 100 | 110 | 1,6 | 55 | 100 | X | X | X | X | X | X | X | X | X | X | X |
| LV4 | X | X | 100 | 100 | 100 | 130 | 1,4 | 55 | 100 | X | X | X | X | X | X | X | X | X | X | X |
| LV5 | X | X | 100 | 100 | 100 | 130 | 1,4 | 50 | 100 | X | X | X | X | X | X | X | X | X | X | X |
| LV6 | X | X | 100 | 100 | 100 | 130 | 1 | 35 | 100 | X | X | X | X | X | X | X | X | X | X | X |
| JH150 LV2 | X | X | 100 | 100 | 100 | 165 | 1 | 90 | 35 | X | X | X | X | X | X | X | X | 30 | 2 | 130 |

* Max. Einwärtskopierwinkel

Prozentuale Werte, bezogen auf die Original-Schnittdaten.

Berechnungen

| Original-Schnittdaten zum Eckfräsen/Schruppen einsetzen, danach Parameter neu berechnen. | | | | | | | | | | Original-Schnittdaten zum Nutfräsen einsetzen, danach Parameter neu berechnen. | | | | | | | | | | |
|--|-----------|-------|---------------------|-------|-------|---------------------|--------------|-------|-------|--|------------------------|-------|-------|-------------------------------|--------------|-------|-------|-------------------|------------------------|-----|
| KUGELKOPF | Nutfräsen | | Eckfräsen/Schruppen | | | Eckfräsen/Schichten | | | | | Kopierfräsen/Schruppen | | | Kopierfräsen/ Feinbearbeitung | | | | Walzenstirnfräsen | | |
| | | | | | | | | | | | | | | | | | | | | |
| | a_p | f_z | a_e | f_z | a_p | v_c | a_e (% DC) | f_z | a_p | | a_e | f_z | a_p | v_c | a_e (% DC) | f_z | a_p | f_z | $a_p/360^\circ$ (% DC) | |
| JH160 Standard (2) | X | X | X | X | X | X | X | X | X | X | X | X | X | X | X | X | X | X | X | X |
| JH450 Standard (2) | X | X | 100 | 100 | 100 | 120 | 5 | 90 | 25 | X | X | X | X | X | X | X | X | 45 | 5 | 130 |
| JH460 Standard (2) | X | X | 100 | 100 | 100 | 120 | 5 | 90 | 25 | X | X | X | X | X | X | X | X | X | X | X |
| JMB542-JMB562-JMB563 | | | | | | | | | | | | | | | | | | | | |
| LV1 | 100 | 100 | X | X | X | X | X | X | X | 100 | 100 | 100 | 125 | 2 | 150 | 5 | X | X | X | X |
| LV2 | 65 | 100 | X | X | X | X | X | X | X | 100 | 100 | 63 | 125 | 2 | 150 | 3 | X | X | X | X |
| LV3 | 26 | 100 | X | X | X | X | X | X | X | 100 | 100 | 25 | 125 | 2 | 150 | 1 | X | X | X | X |
| LV4 (TL) | 20 | 100 | X | X | X | X | X | X | X | 100 | 100 | 19 | 125 | 2 | 150 | 1 | X | X | X | X |
| LV4 (XL) | 12 | 100 | X | X | X | X | X | X | X | 100 | 100 | 12 | 125 | 2 | 150 | 1 | X | X | X | X |
| LV5 | 10 | 100 | X | X | X | X | X | X | X | 100 | 100 | 10 | 125 | 2 | 150 | 1 | X | X | X | X |
| LV6 | 4 | 100 | X | X | X | X | X | X | X | 100 | 100 | 4 | 125 | 2 | 150 | 1 | X | X | X | X |
| LV7 | 2 | 100 | X | X | X | X | X | X | X | 100 | 100 | 2 | 125 | 2 | 150 | 1 | X | X | X | X |
| JMB112 | | | | | | | | | | | | | | | | | | | | |
| LV1 | 100 | 100 | X | X | X | X | X | X | X | 100 | 100 | 100 | 118 | 2 | 120 | 5 | X | X | X | X |
| LV2 | 65 | 100 | X | X | X | X | X | X | X | 64 | 85 | 85 | 118 | 2 | 120 | 3 | X | X | X | X |
| LV3 | 26 | 100 | X | X | X | X | X | X | X | 56 | 75 | 75 | 118 | 2 | 120 | 1 | X | X | X | X |
| LV4 | 20 | 100 | X | X | X | X | X | X | X | 45 | 60 | 60 | 118 | 2 | 120 | 1 | X | X | X | X |
| LV5 | 10 | 100 | X | X | X | X | X | X | X | 38 | 50 | 50 | 118 | 2 | 120 | 1 | X | X | X | X |
| LV6 | 4 | 100 | X | X | X | X | X | X | X | 30 | 40 | 40 | 118 | 2 | 120 | 1 | X | X | X | X |
| JM413-JM416 | | | | | | | | | | | | | | | | | | | | |
| LV1 | X | X | 100 | 100 | 100 | 100 | 5 | 40 | 35 | X | X | X | X | X | X | X | X | X | X | X |
| LV2 | X | X | 100 | 60 | 100 | 100 | 5 | 40 | 15 | X | X | X | X | X | X | X | X | X | X | X |
| LV3 | X | X | 100 | 80 | 100 | 100 | 5 | 40 | 15 | X | X | X | X | X | X | X | X | X | X | X |
| LV4 | X | X | 100 | 60 | 75 | 100 | 5 | 40 | 10 | X | X | X | X | X | X | X | X | X | X | X |
| JMB642 | | | | | | | | | | | | | | | | | | | | |
| LV1 | 100 | 100 | 100 | 100 | 100 | 100 | 2 | 85 | 200 | X | X | X | X | X | X | X | X | X | X | X |
| LV3 | 100 | 100 | 100 | 100 | 100 | 100 | 2 | 85 | 200 | X | X | X | X | X | X | X | X | X | X | X |
| LV5 | 30 | 100 | 60 | 100 | 100 | 100 | 2 | 85 | 200 | X | X | X | X | X | X | X | X | X | X | X |
| LV6 | 30 | 100 | 60 | 100 | 100 | 100 | 2 | 85 | 200 | X | X | X | X | X | X | X | X | X | X | X |
| LV7 | 30 | 100 | 60 | 100 | 100 | 100 | 2 | 85 | 200 | X | X | X | X | X | X | X | X | X | X | X |
| JD660 | | | | | | | | | | ≤2 | | | | | | | | | | |
| LV1 | X | X | 100 | 100 | 100 | 100 | 2 | 100 | 100 | X | X | X | X | X | X | X | X | X | X | X |
| LV2 | X | X | 100 | 100 | 100 | 100 | 2 | 100 | 100 | X | X | X | X | X | X | X | X | X | X | X |
| LV3 | X | X | 100 | 100 | 100 | 100 | 2 | 100 | 100 | X | X | X | X | X | X | X | X | X | X | X |
| LV4 | X | X | 100 | 100 | 100 | 100 | 2 | 100 | 100 | X | X | X | X | X | X | X | X | X | X | X |
| LV5 | X | X | 100 | 100 | 100 | 100 | 2 | 100 | 100 | X | X | X | X | X | X | X | X | X | X | X |

* Max. Einwärtskopierwinkel
 Prozentuale Werte, bezogen auf die Original-Schnittdaten.

Nomenklatur und Formeln

| Drehzahl | |
|--|------------------------|
| $n = \frac{v_c \cdot 1000}{\pi \cdot D_c}$ | (U/min) |
| Schnittgeschwindigkeit | |
| $v_c = \frac{n \cdot \pi \cdot D_c}{1000}$ | (m/min) |
| Vorschubgeschwindigkeit | |
| $v_f = n \cdot z_n \cdot f_z$ | (mm/min) |
| Vorschub pro Umdrehung | |
| $f = z_n \cdot f_z$ | (mm/U) |
| Zeitspanvolumen | |
| $Q = \frac{a_e \cdot a_p \cdot v_f}{1000}$ | (cm ³ /min) |
| Schnittgeschwindigkeit und Drehzahl zum Kopierfräsen | |
| $v_c = \frac{n \cdot \pi \cdot D_w}{1000}$ | (m/min) |
| $n = \frac{v_c \cdot 1000}{\pi \cdot D_w}$ | (Drehzahl) |
| $D_w = 2 \cdot \sqrt{a_p (D_c - a_p)}$ | (mm) |

Berechnung von a_p abhängig von Auskräglänge:

Bei Auskräglänge länger als 4 x DC und Einsatz zylindrischer Schäfte muss die Schnitttiefe (a_p) neu berechnet werden.

Die neue Schnitttiefe ist nach folgender Formel zu berechnen: a_p (neu)

$$a_{p,neu} = a_p \times (4 \times DC / XS)^2$$

| Profilhöhe | |
|--|------|
| $H = \frac{D_c}{2} - \sqrt{\frac{D_c^2 - a_e^2}{2}}$ | |
| $D_w = 2 \cdot \sqrt{a_p (D_c - a_p)}$ | (mm) |

Profilhöhe H (um)

| DC | Teilung a_e (um) | | | | | | |
|----|--------------------|------|------|------|------|------|------|
| | 0,06 | 0,08 | 0,11 | 0,15 | 0,20 | 0,3 | 0,45 |
| 1 | 0,90 | 1,60 | 3,00 | 5,70 | 10,0 | 23,0 | 53,0 |
| 2 | 0,45 | 0,80 | 1,50 | 2,80 | 5,0 | 11,0 | 26,0 |
| 4 | 0,23 | 0,40 | 0,76 | 1,40 | 2,5 | 5,60 | 13,0 |
| 6 | 0,15 | 0,27 | 0,50 | 0,94 | 1,7 | 3,80 | 8,40 |
| 8 | 0,11 | 0,20 | 0,38 | 0,70 | 1,3 | 2,80 | 6,30 |
| 10 | 0,09 | 0,16 | 0,30 | 0,56 | 1,0 | 2,30 | 5,10 |
| 12 | 0,08 | 0,13 | 0,25 | 0,47 | 0,83 | 1,90 | 4,20 |

- a_p = Axiale Schnitttiefe (mm)
- a_e = Radiale Schnitttiefe (Eingriffsbreite) (mm)
- DC = Fräserdurchmesser
- f = Vorschub/U (mm/U)
- f_z = Vorschub/Zahn (mm/Zahn)
- z_n = Zähnezahl
- n = Drehzahl (U/min)
- Q = Zeitspanvolumen (cm³/min)
- v_c = Schnittgeschwindigkeit (m/min)
- v_f = Vorschubgeschwindigkeit (mm/min)
- D_w = Werkstückdurchmesser

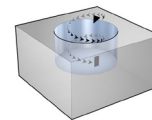
Zerspanungsempfehlungen

Einwärtskopieren

In nachstehender Tabelle finden Sie die Vorschubraten zu den entsprechenden Winkeln.

Empfohlene Bohrungsdurchmesser zum Bohrzirkularfräsen

| Werkzeugdiameter DC | Bohrungsdiameter |
|---------------------|------------------|
| 1-2,5 | 1,4 x DC |
| 3-6 | 1,3 x DC |
| 8-12 | 1,2 x DC |
| 16-32 | 1,15 x DC |

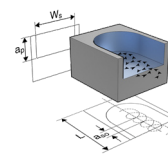


Trochoides Verfahren

Nachstehende Abbildung zeigt das sogenannte Trochoide Verfahren

Empfohlene Nutbreite

| Werkzeugdiameter DC | Nutbreite |
|---------------------|-----------|
| 1-2,5 | 1,8 x DC |
| 3-6 | 1,6 x DC |
| 8-12 | 1,4 x DC |
| 16-32 | 1,2 x DC |





MINIMASTER™ PLUS

Minimaster™ Plus ist ein Wechselkopfsystem zum Fräsen.

Der Schneidkopfwechsel erfolgt rasch, ohne dass der Schaft aus dem Halter bzw. aus der Maschine entnommen oder die gesamte Anordnung neu eingemessen werden muss

. Nach dem Wechsel des Schneidkopfes bleibt die axiale und radiale Position unverändert – für maximale Präzision.

- Schaftfräser: 10 bis 16 mm (.375 - .625")
- Kugelkopffräser: 10 bis 16 mm (.375 - .625")
- Zentrier-/Anfasfräser: 10 bis 16 mm (.375 - .625")
- Hochvorschubfräser: 10 bis 16 mm (.375 - .625")

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Rostfrei und
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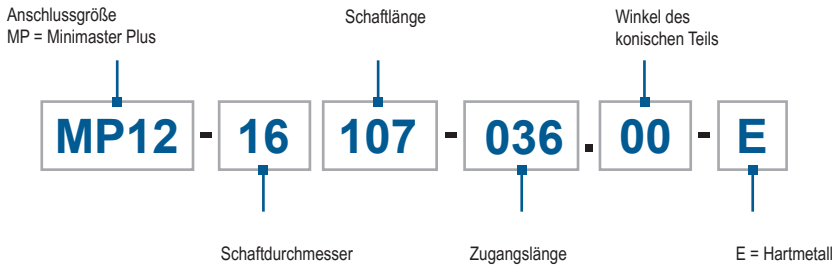
X-Heads

Minimaster Plus

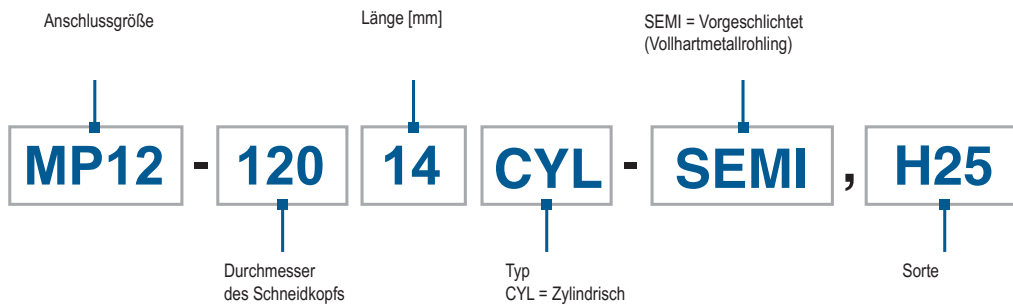
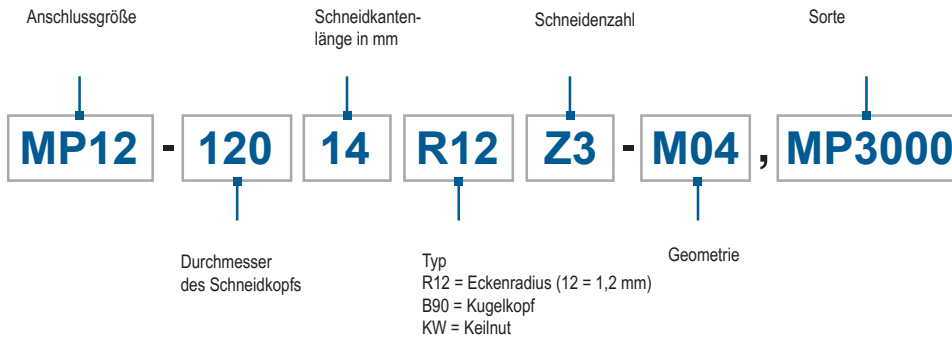
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Code-Schlüssel

Code-Schlüssel – Aufnahmen



Code-Schlüssel – Wendeschneidplatten



Innenkühlung



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Auswahl

1. Anschlussgröße wählen

Die Ausführung des Werkstückes und die Bearbeitung entscheiden über die Anschlussgröße. Je größer der Anschlussdurchmesser, desto höher ist die Stabilität.

2. Schneidkopf wählen

- Werkstoff anhand der Seco Werkstoff-Gruppen ab Seite 728 klassifizieren
- Die gewählte Anschlussgröße den Katalogseiten entnehmen und den geeigneten Schneidkopf in der Auswahltable wählen.

3. Aufnahme wählen

- Auf den Katalogseiten die geeignete Aufnahme auswählen.
- Schneidkopf und Aufnahme müssen die gleiche Anschlussgröße haben. Je kürzer die Aufnahme, desto größer ist die Stabilität.

Hinweis! Hartmetallschäfte eignen sich nur zum Schlichten und Vorschlichten.

4. Schnittdaten wählen

- Die maximale axiale Schnitttiefe ist in der Tabelle Abmessungen angegeben. Die Schnittdatenempfehlungen basieren auf stabilen Arbeitsbedingungen und müssen daher je nach Stabilität der Bearbeitung (Werkzeugsystem, Maschine und Aufspannung) angepasst werden. Eine allgemeine Regel für die max. Schnitttiefe beim Nutfräsen ist $DC \cdot 0.3 = \text{Max APMXS}$. (Siehe Abb. 1).
- Empfehlungen zu Vorschub und Schnittgeschwindigkeit finden Sie ebenfalls in der Tabelle Abmessungen.
- Die empfohlene Maximaldrehzahl, die aus Sicherheitsgründen nie überschritten werden darf, ist auf Seite N/A angegeben
- Wenn die radiale Schnitttiefe (Eingriffsbreite) geringer ist als der volle Schneiddurchmesser, müssen Vorschub/Zahn und Schnittgeschwindigkeit erhöht werden, um die Mittenspanndicke und die Arbeitstemperatur im Schneidbereich konstant zu halten.
- Den Prozentsatz des Werkzeugeingriffs ermitteln: radiale Schnitttiefe durch den Werkzeugdurchmesser dividieren ($ae/DC\%$), bei Kugelkopffräsern den effektiven Wirk-Durchmesser D_w anstatt DC (siehe Abb. 2 und 6) verwenden.
- Mit dem Prozentsatz erhalten Sie den korrekten Vorschub pro Zahn sowie eine Empfehlung für die Schnittgeschwindigkeit beim tatsächlichen Werkzeugeingriff.

5. Allgemein

- Beim Fräsen an Ecken und Taschenboden vergrößert sich die Eingriffsbreite dramatisch. Der Vorschub muss reduziert werden, weil sonst die Mittenspanndicke enorm zunimmt. Setzen Sie deshalb die Vorschubwerte für volle Eingriffsbreite ein.
- Beim Bohrfräsen mit einem Kopierwinkel von 40° oder beim Ziehfräsen mit einem Kopierwinkel von 30° in Kombination mit einer geringen Schnitttiefe wird der Wirkdurchmesser D_w immer größer sein als die genannten Werte in der Tabelle. In diesem Falle für die Vorschubberechnung den Fräserdurchmesser DC als Wirkdurchmesser D_w einsetzen.
- Nutzen Sie zur Berechnung von Vorschub/U stets den ZEFP-Faktor. Der ZEFP-Faktor ist die effektive Zähnezahl zur Berechnung von Vorschub und Vorschubgeschwindigkeit. Den ZEFP-Faktor finden Sie in der Tabelle Abmessungen.

Hinweis! Bei höheren Vorschubwerten nimmt die Qualität der Werkstück-Oberfläche ab (siehe Abb. 3& 5)


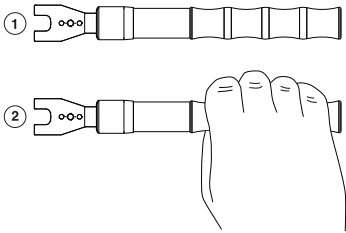
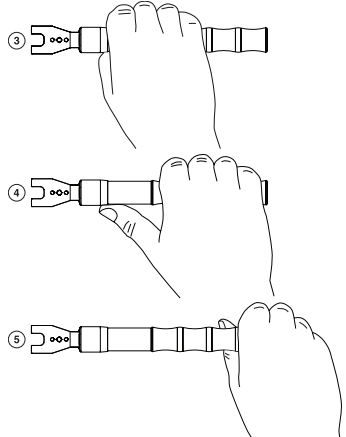
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| | | |
|-------------------------------|--------|--------|
| Universell | Abb. 1 | Abb. 2 |
| Stahl und Guss | | |
| Rostfrei und ISO-S-Werkstoffe | Abb. 3 | Abb. 4 |
| NE-Metalle | | |
| Harter | Abb. 5 | Abb. 6 |
| Kunststoffe und Composite | | |

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Minimaster

Informationen zum Drehmomentschlüssel und Bedienungsanweisung

| Drehmomentschlüssel | |
|---|--|
|  | <p>Zum Spannen des Schneidkopfes empfehlen wir einen Drehmomentschlüssel für höchste Präzision und höhere Lebensdauer. Unterschiedliche Drehmomente für Montage: □ MP10: 11 Nm □ MP12: 15Nm □ MP16: 19 Nm Keine verschlissenen Schlüssel verwenden. Hinweis: Drehmoment- und Standard-Schlüssel bitte separat bestellen.</p> |
|  | <p>Nehmen Sie den Schlüsselgriff wie dargestellt (Abb. 1) in die Hand (Abb. 2).</p> |
|  | <p>Beachten Sie den korrekten Ansatz des Schlüssels. Verwenden Sie den Schlüssel nicht wie auf Abb. 3-5, da ein falsches Drehmoment einen nicht ordnungsgemäßen Einsatz des Schneidkopfes verursachen kann.</p> |

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Rostfrei und ISO-S-Werkstoffe

Rostfrei und ISO-S-Werkstoffe

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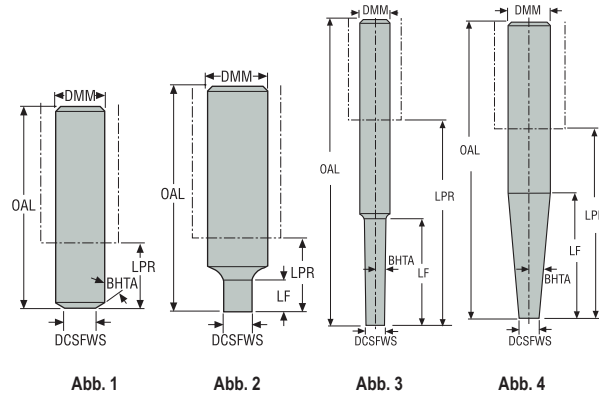
Graphit

X-Heads

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MP10 Schaft – Metrisch



- Zylindrischer Schaft DMM mit Toleranz h5 kompatibel mit Schrupfaufnahmen

| Bezeichnung | Aufnahme | DCSFWS | DMM | OAL | LPR | LF | RPMX | BHTA° | Abb. | | Gewicht |
|---------------------|-------------|--------|------|-------|-------|-------|-------|-------|------|---|---------|
| | | mm | mm | mm | mm | mm | mm | | | | kg |
| MP10-10055-010.00 | Zylindrisch | 9,8 | 10,0 | 55,0 | 15,0 | 10,0 | 80000 | 0,0 | 2 | ✓ | 0,1 |
| MP10-16068-000.60 | Zylindrisch | 9,5 | 16,0 | 68,0 | 20,0 | 0,0 | 80000 | 60,0 | 1 | ✓ | 0,2 |
| MP10-16073-015.00 | Zylindrisch | 9,8 | 16,0 | 73,0 | 25,0 | 15,0 | 80000 | 0,0 | 2 | ✓ | 0,1 |
| MP10-16118-035.01 | Zylindrisch | 9,5 | 16,0 | 118,0 | 70,0 | 35,0 | 80000 | 1,0 | 3 | ✓ | 0,2 |
| MP10-16158-060.01 | Zylindrisch | 9,5 | 16,0 | 158,0 | 110,0 | 60,0 | 80000 | 1,0 | 3 | ✓ | 0,2 |
| MP10-20100-045.03 | Zylindrisch | 9,5 | 20,0 | 100,0 | 50,0 | 45,0 | 80000 | 3,0 | 3 | ✓ | 0,2 |
| MP10-20140-085.03 | Zylindrisch | 9,5 | 20,0 | 140,0 | 90,0 | 85,0 | 80000 | 3,0 | 3 | ✓ | 0,3 |
| MP10-20140-090.05 | Zylindrisch | 9,5 | 20,0 | 140,0 | 90,0 | 60,0 | 80000 | 5,0 | 4 | ✓ | 0,3 |
| MP10-12095-030.00-E | Zylindrisch | 9,8 | 12,0 | 95,0 | 50,0 | 30,0 | 80000 | 0,0 | 2 | ✓ | 0,2 |
| MP10-12105-040.00-E | Zylindrisch | 9,8 | 12,0 | 105,0 | 60,0 | 40,0 | 80000 | 0,0 | 2 | ✓ | 0,2 |
| MP10-12125-060.00-E | Zylindrisch | 9,8 | 12,0 | 125,0 | 80,0 | 60,0 | 80000 | 0,0 | 2 | ✓ | 0,2 |
| MP10-16120-050.01-E | Zylindrisch | 9,5 | 16,0 | 120,0 | 72,0 | 50,0 | 80000 | 1,0 | 3 | ✓ | 0,3 |
| MP10-16150-080.01-E | Zylindrisch | 9,5 | 16,0 | 150,0 | 102,0 | 80,0 | 80000 | 1,0 | 3 | ✓ | 0,3 |
| MP10-16170-100.01-E | Zylindrisch | 9,5 | 16,0 | 170,0 | 122,0 | 100,0 | 80000 | 1,0 | 3 | ✓ | 0,4 |
| MP10-16140-092.03-E | Zylindrisch | 9,5 | 16,0 | 140,0 | 92,0 | 62,0 | 80000 | 3,0 | 4 | ✓ | 0,4 |
| MP10-16170-122.03-E | Zylindrisch | 9,5 | 16,0 | 170,0 | 122,0 | 62,0 | 80000 | 3,0 | 4 | ✓ | 0,4 |

Zubehör

| Schlüssel | Ersatzklinge | Drehmoment-schlüssel |
|-----------|--------------|----------------------|
| | | |
| MP1016 | MP00-10M | MP00-10.110 |

Die Klingen sind im Lieferumfang des Drehmomentschlüssels enthalten

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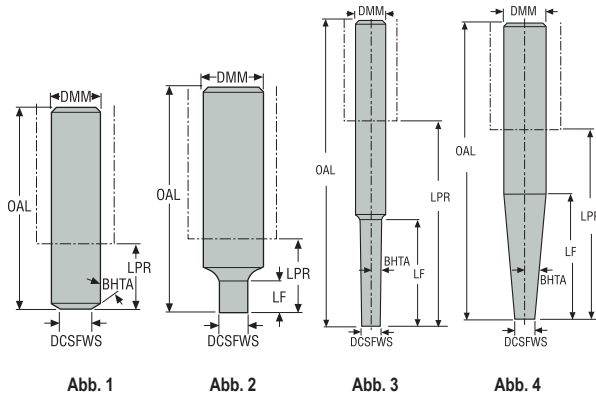
Graphit

X-Heads

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MP10 Schaft – Zoll



• Zylindrischer Schaft DMM mit Toleranz h5 kompatibel mit Schrumpfaufnahmen

| Bezeichnung | Aufnahme | DCSFMS | DMM | OAL | LPR | LF | RPMX | BHTA° | Abb. | | Gewicht |
|-----------------------|-------------|--------|-------|-------|-------|-------|-------|-------|------|---|---------|
| | | Zoll | Zoll | Zoll | Zoll | Zoll | | | | | lbs |
| MP10-0372.1-0.39.00 | Zylindrisch | 0.370 | 0.375 | 2.122 | 0.591 | 0.394 | 80000 | 0,0 | 2 | ✓ | 0.220 |
| MP10-0622.6-0.00.60 | Zylindrisch | 0.374 | 0.625 | 2.662 | 0.787 | 0 | 80000 | 60,0 | 1 | ✓ | 0.220 |
| MP10-0622.8-0.59.00 | Zylindrisch | 0.370 | 0.625 | 2.859 | 0.984 | 0.591 | 80000 | 0,0 | 2 | ✓ | 0.220 |
| MP10-0624.6-1.37.01 | Zylindrisch | 0.374 | 0.625 | 4.631 | 2.756 | 1.378 | 80000 | 1,0 | 3 | ✓ | 0.440 |
| MP10-0626.2-2.36.01 | Zylindrisch | 0.374 | 0.625 | 6.206 | 4.331 | 2.362 | 80000 | 1,0 | 3 | ✓ | 0.440 |
| MP10-0753.9-1.80.03 | Zylindrisch | 0.374 | 0.750 | 3.969 | 1.969 | 1.799 | 80000 | 3,0 | 3 | ✓ | 0.440 |
| MP10-0755.5-3.40.03 | Zylindrisch | 0.374 | 0.750 | 5.543 | 3.543 | 3.402 | 80000 | 3,0 | 4 | ✓ | 0.660 |
| MP10-0755.5-3.54.05 | Zylindrisch | 0.374 | 0.750 | 5.543 | 3.543 | 2.150 | 80000 | 5,0 | 4 | ✓ | 0.660 |
| MP10-0504.8-2.36.00-E | Zylindrisch | 0.370 | 0.500 | 4.900 | 3.150 | 2.362 | 80000 | 0,0 | 2 | ✓ | 0.440 |

Zubehör

| Schlüssel | Ersatzklinge | Drehmoment-schlüssel |
|-----------|--------------|----------------------|
| | | |
| MP1016 | MP00-10M | MP00-10.110 |

Die Klingen sind im Lieferumfang des Drehmomentschlüssels enthalten

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

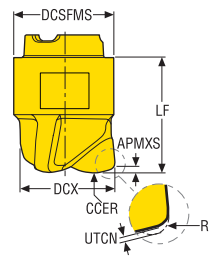
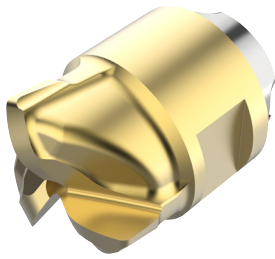
Graphit

X-Heads

Minimaster Plus

Minimaster

MP10 Hochvorschubfräser



• Auswahl der Wendschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 586-587

Z3



| Bezeichnung | DCX | DC | APMXS | DCSFMS | CCER | RP | LF | UTCN | RMPX° | C min | C max | ZEFP | Beschichtung | | |
|----------------------|----------------|---------------|--------------|--------------|--------------|---------------|---------------|---------------|-------|-------|-------|------|--------------|-------------|------|
| | | | | | | | | | | | | | Beschichtet | Beschichtet | |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | | | MP3000 | F40M |
| MP10-0950.6HFZ3-MD08 | 9,525 0.375 | 4,55 0.179 | 0,6 0.024 | 9,4 0.370 | 6,2 0.244 | 1,13 0.044 | 11,0 0.433 | 0,32 0.013 | 5,0 | 10,4 | 13,4 | 3 | | ■ | |
| MP10-1000.6HFZ3-MD08 | 10,0 0.394 | 5,0 0.197 | 0,6 0.024 | 9,6 0.378 | 6,2 0.244 | 1,13 0.044 | 11,0 0.433 | 0,32 0.013 | 5,0 | 10,9 | 14,8 | 3 | | ■ | |

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Rostfrei und ISO-S-Werkstoffe

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Kunststoffe und Composite

Graphit

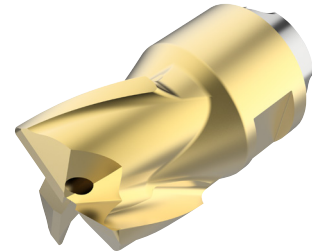
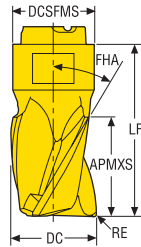
X-Heads

Minimaster Plus

Minimaster

MP10 Eckfräser

Nut- und Konturfräsen



• Auswahl der Wandeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 588-589

Z3



| Bezeichnung | DC | APMXS | RE | DCSFMS | LF | FHA | RMPX° | C min | C max | ZEFP | Beschichtung | | |
|---------------------|---------------|--------------|--------------|--------------|---------------|-----|-------|-------|-------|------|--------------|--------|------|
| | | | | | | | | | | | Beschichtet | | |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | | | | MP3000 | F40M |
| MP10-09807KWZ3-E03 | 9,8 0.386 | 7,0 0.276 | 0,3 0.012 | 9,6 0.378 | 16,0 0.630 | 30 | 15,0 | 12,0 | 18,8 | 3 | | | ■ |
| MP10-10007R04Z3-E03 | 10,0 0.394 | 7,0 0.276 | 0,4 0.016 | 9,6 0.378 | 16,0 0.630 | 30 | 15,0 | 12,2 | 19,0 | 3 | | | ■ |
| MP10-10007R04Z3-M03 | 10,0 0.394 | 7,0 0.276 | 0,4 0.016 | 9,6 0.378 | 16,0 0.630 | 30 | 15,0 | 12,2 | 19,0 | 3 | ■ | | |
| MP10-10007R05Z3-E03 | 10,0 0.394 | 7,0 0.276 | 0,5 0.020 | 9,6 0.378 | 16,0 0.630 | 30 | 15,0 | 12,2 | 18,8 | 3 | | | ■ |
| MP10-10007R08Z3-E03 | 10,0 0.394 | 7,0 0.276 | 0,8 0.031 | 9,6 0.378 | 16,0 0.630 | 30 | 15,0 | 12,2 | 18,2 | 3 | | | ■ |
| MP10-10007R08Z3-M03 | 10,0 0.394 | 7,0 0.276 | 0,8 0.031 | 9,6 0.378 | 16,0 0.630 | 30 | 15,0 | 12,2 | 18,2 | 3 | ■ | | |
| MP10-10007R20Z3-E03 | 10,0 0.394 | 7,0 0.276 | 2,0 0.079 | 9,6 0.378 | 16,0 0.630 | 30 | 15,0 | 12,2 | 15,8 | 3 | | | ■ |
| MP10-10007R31Z3-E03 | 10,0 0.394 | 7,0 0.276 | 3,1 0.122 | 9,6 0.378 | 16,0 0.630 | 30 | 15,0 | 12,2 | 13,6 | 3 | | | ■ |

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Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

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Harter

Graphit

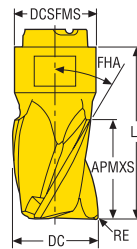
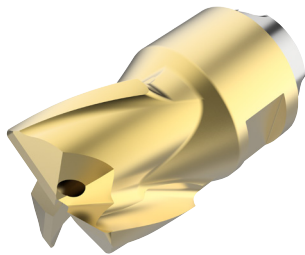
X-Heads

Minimaster Plus

Minimaster

MP10 Eckfräser

Nut- und Konturfräsen



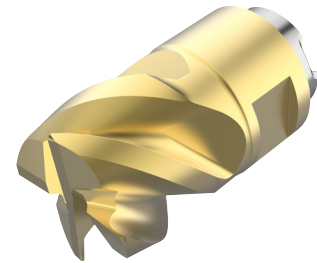
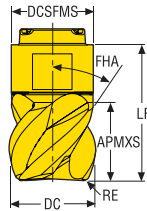
• Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 588-589

Z3



| Bezeichnung | DC | APMXS | RE | DCSFMS | LF | FHA | RMPX° | C min | C max | ZEFP | Beschichtung | |
|---------------------|----------------|---------------|--------------|--------------|---------------|-----|-------|-------|-------|------|--------------|------------|
| | | | | | | | | | | | mm Zoll | mm Zoll |
| MP10-09812KWZ3-E03 | 9,8 0.386 | 12,0 0.472 | 0,3 0.012 | 9,6 0.378 | 21,0 0.827 | 30 | 15,0 | 12,0 | 18,8 | 3 | | ■ |
| MP10-09512R04Z3-E03 | 9,525 0.375 | 12,0 0.472 | 0,4 0.016 | 9,6 0.378 | 21,0 0.827 | 30 | 15,0 | 11,6 | 18,0 | 3 | | ■ |
| MP10-09512R04Z3-M03 | 9,525 0.375 | 12,0 0.472 | 0,4 0.016 | 9,6 0.378 | 21,0 0.827 | 30 | 15,0 | 11,6 | 18,0 | 3 | ■ | |
| MP10-09512R08Z3-E03 | 9,525 0.375 | 12,0 0.472 | 0,8 0.031 | 9,6 0.378 | 21,0 0.827 | 30 | 15,0 | 11,6 | 17,2 | 3 | | ■ |
| MP10-09512R08Z3-M03 | 9,525 0.375 | 12,0 0.472 | 0,8 0.031 | 9,6 0.378 | 21,0 0.827 | 30 | 15,0 | 11,6 | 17,2 | 3 | ■ | |
| MP10-09512R16Z3-E03 | 9,525 0.375 | 12,0 0.472 | 1,6 0.063 | 9,6 0.378 | 21,0 0.827 | 30 | 15,0 | 11,6 | 15,6 | 3 | | ■ |
| MP10-09512R31Z3-E03 | 9,525 0.375 | 12,0 0.472 | 3,1 0.122 | 9,6 0.378 | 21,0 0.827 | 30 | 15,0 | 11,6 | 12,6 | 3 | | ■ |
| MP10-10012R04Z3-E03 | 10,0 0.394 | 12,0 0.472 | 0,4 0.016 | 9,6 0.378 | 21,0 0.827 | 30 | 15,0 | 12,2 | 19,0 | 3 | | ■ |
| MP10-10012R04Z3-M03 | 10,0 0.394 | 12,0 0.472 | 0,4 0.016 | 9,6 0.378 | 21,0 0.827 | 30 | 15,0 | 12,2 | 19,0 | 3 | ■ | |
| MP10-10012R05Z3-E03 | 10,0 0.394 | 12,0 0.472 | 0,5 0.020 | 9,6 0.378 | 21,0 0.827 | 30 | 15,0 | 12,2 | 18,8 | 3 | | ■ |
| MP10-10012R08Z3-E03 | 10,0 0.394 | 12,0 0.472 | 0,8 0.031 | 9,6 0.378 | 21,0 0.827 | 30 | 15,0 | 12,2 | 18,2 | 3 | | ■ |
| MP10-10012R08Z3-M03 | 10,0 0.394 | 12,0 0.472 | 0,8 0.031 | 9,6 0.378 | 21,0 0.827 | 30 | 15,0 | 12,2 | 18,2 | 3 | ■ | |
| MP10-10012R16Z3-E03 | 10,0 0.394 | 12,0 0.472 | 1,6 0.063 | 9,6 0.378 | 21,0 0.827 | 30 | 15,0 | 12,2 | 16,6 | 3 | | |
| MP10-10012R20Z3-E03 | 10,0 0.394 | 12,0 0.472 | 2,0 0.079 | 9,6 0.378 | 21,0 0.827 | 30 | 15,0 | 12,2 | 15,8 | 3 | | ■ |
| MP10-10012R31Z3-E03 | 10,0 0.394 | 12,0 0.472 | 3,1 0.122 | 9,6 0.378 | 21,0 0.827 | 30 | 15,0 | 12,2 | 13,6 | 3 | | ■ |

MP10 Eckfräser
Nut- und Konturfräsen



• Auswahl der Wandeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 588-589

Z4



| Bezeichnung | DC | APMXS | RE | DCSFMS | LF | FHA | RMPX° | ZEFP | Beschichtung | |
|---------------------|----------------|---------------|--------------|--------------|---------------|-----|-------|------|--------------|-------------|
| | | | | | | | | | Beschichtet | Beschichtet |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | MP3000 | F40M |
| MP10-10007R04Z4-M02 | 10,0 0.394 | 7,0 0.276 | 0,4 0.016 | 9,6 0.378 | 16,0 0.630 | 50 | 15,0 | 4 | ■ | |
| MP10-10007R05Z4-E02 | 10,0 0.394 | 7,0 0.276 | 0,5 0.020 | 9,6 0.378 | 16,0 0.630 | 50 | 15,0 | 4 | | ■ |
| MP10-10007R08Z4-E02 | 10,0 0.394 | 7,0 0.276 | 0,8 0.031 | 9,6 0.378 | 16,0 0.630 | 50 | 15,0 | 4 | | ■ |
| MP10-10007R08Z4-M02 | 10,0 0.394 | 7,0 0.276 | 0,8 0.031 | 9,6 0.378 | 16,0 0.630 | 50 | 15,0 | 4 | ■ | |
| MP10-10007R16Z4-E02 | 10,0 0.394 | 7,0 0.276 | 1,6 0.063 | 9,6 0.378 | 16,0 0.630 | 50 | 15,0 | 4 | | ■ |
| MP10-10012R04Z4-E02 | 10,0 0.394 | 12,0 0.472 | 0,4 0.016 | 9,6 0.378 | 21,0 0.827 | 50 | 15,0 | 4 | | ■ |
| MP10-10012R04Z4-M02 | 10,0 0.394 | 12,0 0.472 | 0,4 0.016 | 9,6 0.378 | 21,0 0.827 | 50 | 15,0 | 4 | ■ | |
| MP10-10012R05Z4-E02 | 10,0 0.394 | 12,0 0.472 | 0,5 0.020 | 9,6 0.378 | 21,0 0.827 | 50 | 15,0 | 4 | | ■ |
| MP10-10012R08Z4-E02 | 10,0 0.394 | 12,0 0.472 | 0,8 0.031 | 9,6 0.378 | 21,0 0.827 | 50 | 15,0 | 4 | | ■ |
| MP10-10012R08Z4-M02 | 10,0 0.394 | 12,0 0.472 | 0,8 0.031 | 9,6 0.378 | 21,0 0.827 | 50 | 15,0 | 4 | ■ | |
| MP10-10012R16Z4-E02 | 10,0 0.394 | 12,0 0.472 | 1,6 0.063 | 9,6 0.378 | 21,0 0.827 | 50 | 15,0 | 4 | | ■ |
| MP10-09512R04Z4-E02 | 9,525 0.375 | 12,0 0.472 | 0,4 0.016 | 9,6 0.378 | 21,0 0.827 | 50 | 15,0 | 4 | | ■ |
| MP10-09512R04Z4-M02 | 9,525 0.375 | 12,0 0.472 | 0,4 0.016 | 9,6 0.378 | 21,0 0.827 | 50 | 15,0 | 4 | ■ | |
| MP10-09512R08Z4-E02 | 9,525 0.375 | 12,0 0.472 | 0,8 0.031 | 9,6 0.378 | 21,0 0.827 | 50 | 15,0 | 4 | | ■ |
| MP10-09512R08Z4-M02 | 9,525 0.375 | 12,0 0.472 | 0,8 0.031 | 9,6 0.378 | 21,0 0.827 | 50 | 15,0 | 4 | ■ | |

Unversell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Graphit

X-Heads

Minimaster Plus

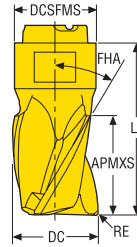
Minimaster

Universell

MP10 Eckfräser

Nur Konturfräsen

Stahl und Guss



Rostfrei und ISO-S-Werkstoffe

- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 588-589

Z5



NE-Metalle

| Bezeichnung | DC | APMXS | RE | DCSFMS | LF | FHA | ZEFP | Beschichtung | |
|---------------------|----------------|---------------|--------------|--------------|---------------|-----|------|--------------|--------------|
| | | | | | | | | Beschichtet | Beschichtung |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | MP3000 | F40M |
| MP10-10012R04Z5-M02 | 10,0 0.394 | 12,0 0.472 | 0,4 0.016 | 9,6 0.378 | 21,0 0.827 | 40 | 5 | ■ | |
| MP10-09512R04Z5-M02 | 9,525 0.375 | 12,0 0.472 | 0,4 0.016 | 9,6 0.378 | 21,0 0.827 | 40 | 5 | ■ | |

Harter

Kunststoffe und Composite

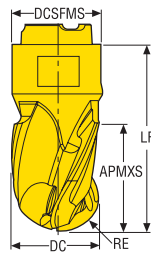
Graphit

X-Heads

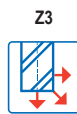
Minimaster Plus

Minimaster

MP10 Kugelkopffräser



• Auswahl der Wandeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 590-591



| Bezeichnung | DC | APMXS | RE | DCSFMS | LF | FHA | RMPX° | ZEFP | Beschichtung | |
|---------------------|----------------|---------------|-----------------|--------------|---------------|-----|-------|------|--------------|------|
| | | | | | | | | | MP3000 | F40M |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | | |
| MP10-10007B90Z3-E03 | 10,0 0.394 | 7,0 0.276 | 5,0 0.197 | 9,6 0.378 | 16,0 0.630 | 30 | 15,0 | 3 | | ■ |
| MP10-10007B90Z3-M03 | 10,0 0.394 | 7,0 0.276 | 5,0 0.197 | 9,6 0.378 | 16,0 0.630 | 30 | 15,0 | 3 | ■ | |
| MP10-10007B90Z4-E02 | 10,0 0.394 | 7,0 0.276 | 5,0 0.197 | 9,6 0.378 | 16,0 0.630 | 20 | 15,0 | 4 | | ■ |
| MP10-10007B90Z4-M02 | 10,0 0.394 | 7,0 0.276 | 5,0 0.197 | 9,6 0.378 | 16,0 0.630 | 20 | 15,0 | 4 | ■ | |
| MP10-10012B90Z3-E03 | 10,0 0.394 | 12,0 0.472 | 5,0 0.197 | 9,6 0.378 | 21,0 0.827 | 30 | 15,0 | 3 | | ■ |
| MP10-10012B90Z3-M03 | 10,0 0.394 | 12,0 0.472 | 5,0 0.197 | 9,6 0.378 | 21,0 0.827 | 30 | 15,0 | 3 | ■ | |
| MP10-09507B90Z3-E03 | 9,525 0.375 | 7,0 0.276 | 4,7625 0.188 | 9,4 0.370 | 16,0 0.630 | 30 | 15,0 | 3 | | ■ |
| MP10-09507B90Z3-M03 | 9,525 0.375 | 7,0 0.276 | 4,7625 0.188 | 9,4 0.370 | 16,0 0.630 | 30 | 15,0 | 3 | ■ | |
| MP10-09507B90Z4-E02 | 9,525 0.375 | 7,0 0.276 | 4,7625 0.188 | 9,4 0.370 | 16,0 0.630 | 20 | 15,0 | 4 | | ■ |
| MP10-09507B90Z4-M02 | 9,525 0.375 | 7,0 0.276 | 4,7625 0.188 | 9,4 0.370 | 16,0 0.630 | 20 | 15,0 | 4 | ■ | |
| MP10-09512B90Z3-E03 | 9,525 0.375 | 12,0 0.472 | 4,7625 0.188 | 9,6 0.378 | 21,0 0.827 | 30 | 15,0 | 3 | | ■ |
| MP10-09512B90Z3-M03 | 9,525 0.375 | 12,0 0.472 | 4,7625 0.188 | 9,6 0.378 | 21,0 0.827 | 30 | 15,0 | 3 | ■ | |

Unversell

Stahl und Guss

Rostfrei und
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Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

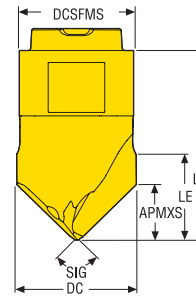
Graphit

X-Heads

Minimaster Plus

Minimaster

MP10 Zentrierbohren/Anfasen



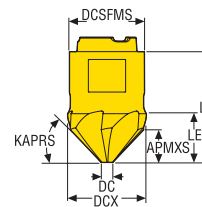
• Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 592-593

Z2



| Bezeichnung | DC | APMXS | DCSFMS | LE | LF | SIG° | ZEFP | | Beschichtung | |
|---------------------|---------------|--------------|--------------|--------------|---------------|------|------|--|--------------|-------------|
| | | | | | | | | | Beschichtet | Beschichtet |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | MP3000 | F40M |
| MP10-10006C90Z2-M03 | 10,0 0.394 | 4,6 0.181 | 9,6 0.378 | 7,1 0.280 | 16,0 0.630 | 90,0 | 2 | | | ■ |

MP10 Anfasen



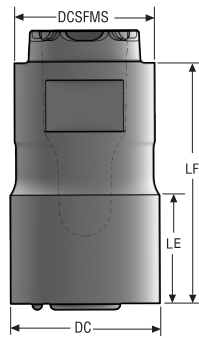
• Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 594-595

Z6




| Bezeichnung | DCX | DC | APMXS | DCSFMS | LE | LF | KAPRS° | ZEFP | | Beschichtung | |
|---------------------|---------------|---------------|--------------|--------------|--------------|---------------|--------|------|--|--------------|-------------|
| | | | | | | | | | | Beschichtet | Beschichtet |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | MP3000 | F40M |
| MP10-10006C90Z6-M03 | 10,1 0.398 | 1,95 0.077 | 4,0 0.157 | 9,6 0.378 | 5,9 0.232 | 14,5 0.571 | 45,0 | 6 | | | ■ |

MP10 Zylindrische Rohlinge



• Zylindrische Hartmetall-Rohlinge zur Herstellung eigener Geometrien



| Bezeichnung | DC | DCSFMS | LE | LF | Beschichtung | |
|--------------------|----------------|--------------|---------------|---------------|---|---------------|
| | | | | |  | Unbeschichtet |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | H25 |
| MP10-10007CYL-SEMI | 10,15 0.400 | 9,6 0.378 | 7,3 0.287 | 16,3 0.642 | | ■ |
| MP10-10012CYL-SEMI | 10,15 0.400 | 9,6 0.378 | 12,4 0.488 | 21,3 0.839 | | ■ |

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Graphit

X-Heads

Minimaster Plus

Minimaster

MP10 Hochvorschubfräsen – Auswahl der Wendeschneidplatten – mm/Zoll

| SMG | | a _p | f _z | | | |
|-----|-----------------------------|----------------|----------------|--------|-------|-------|
| | | | 100% | 70% | 30% | 20% |
| P1 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,46 | 0,46 | 0,60 | 0,75 |
| | | 0,017 | 0,018 | 0,018 | 0,024 | 0,030 |
| P2 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,46 | 0,48 | 0,60 | 0,75 |
| | | 0,017 | 0,018 | 0,019 | 0,024 | 0,030 |
| P3 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,44 | 0,44 | 0,60 | 0,70 |
| | | 0,017 | 0,017 | 0,017 | 0,024 | 0,028 |
| P4 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,44 | 0,44 | 0,55 | 0,70 |
| | | 0,017 | 0,017 | 0,017 | 0,022 | 0,028 |
| P5 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,42 | 0,42 | 0,55 | 0,70 |
| | | 0,017 | 0,017 | 0,017 | 0,022 | 0,028 |
| P6 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,42 | 0,42 | 0,55 | 0,70 |
| | | 0,017 | 0,017 | 0,017 | 0,022 | 0,028 |
| P7 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,42 | 0,42 | 0,55 | 0,70 |
| | | 0,017 | 0,017 | 0,017 | 0,022 | 0,028 |
| P8 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,44 | 0,44 | 0,60 | 0,70 |
| | | 0,017 | 0,017 | 0,017 | 0,024 | 0,028 |
| P11 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,42 | 0,42 | 0,55 | 0,70 |
| | | 0,017 | 0,017 | 0,017 | 0,022 | 0,028 |
| P12 | MP10-0950.6HFZ3-MD08 MP3000 | 0,34 | 0,30 | 0,30 | 0,38 | 0,46 |
| | | 0,013 | 0,012 | 0,012 | 0,015 | 0,018 |
| M1 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,46 | 0,48 | 0,60 | 0,75 |
| | | 0,017 | 0,018 | 0,019 | 0,024 | 0,030 |
| M2 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,42 | 0,42 | 0,55 | 0,70 |
| | | 0,017 | 0,017 | 0,017 | 0,022 | 0,028 |
| M3 | MP10-1000.6HFZ3-MD08 MP3000 | 0,34 | 0,36 | 0,34 | 0,44 | 0,55 |
| | | 0,013 | 0,014 | 0,013 | 0,017 | 0,022 |
| M4 | MP10-1000.6HFZ3-MD08 MP3000 | 0,25 | 0,32 | 0,30 | 0,38 | 0,46 |
| | | 0,010 | 0,013 | 0,012 | 0,015 | 0,018 |
| M5 | MP10-1000.6HFZ3-MD08 MP3000 | 0,25 | 0,32 | 0,30 | 0,38 | 0,46 |
| | | 0,010 | 0,013 | 0,012 | 0,015 | 0,018 |
| K1 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,46 | 0,48 | 0,60 | 0,75 |
| | | 0,017 | 0,018 | 0,019 | 0,024 | 0,030 |
| K2 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,42 | 0,42 | 0,55 | 0,70 |
| | | 0,017 | 0,017 | 0,017 | 0,022 | 0,028 |
| K3 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,42 | 0,42 | 0,55 | 0,70 |
| | | 0,017 | 0,017 | 0,017 | 0,022 | 0,028 |
| K4 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,42 | 0,42 | 0,55 | 0,70 |
| | | 0,017 | 0,017 | 0,017 | 0,022 | 0,028 |
| K5 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,38 | 0,38 | 0,50 | 0,60 |
| | | 0,017 | 0,015 | 0,015 | 0,020 | 0,024 |
| K6 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,42 | 0,42 | 0,55 | 0,70 |
| | | 0,017 | 0,017 | 0,017 | 0,022 | 0,028 |
| K7 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,38 | 0,38 | 0,50 | 0,60 |
| | | 0,017 | 0,015 | 0,015 | 0,020 | 0,024 |
| N1 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,60 | 0,60 | 0,80 | 1,0 |
| | | 0,017 | 0,024 | 0,024 | 0,032 | 0,040 |
| N2 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,60 | 0,60 | 0,80 | 1,0 |
| | | 0,017 | 0,024 | 0,024 | 0,032 | 0,040 |
| N3 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,60 | 0,60 | 0,80 | 1,0 |
| | | 0,017 | 0,024 | 0,024 | 0,032 | 0,040 |
| N11 | MP10-1000.6HFZ3-MD08 MP3000 | 0,42 | 0,60 | 0,60 | 0,80 | 1,0 |
| | | 0,017 | 0,024 | 0,024 | 0,032 | 0,040 |
| S1 | MP10-1000.6HFZ3-MD08 MP3000 | 0,25 | 0,32 | 0,30 | 0,38 | 0,46 |
| | | 0,010 | 0,013 | 0,012 | 0,015 | 0,018 |
| S2 | MP10-1000.6HFZ3-MD08 MP3000 | 0,25 | 0,32 | 0,30 | 0,38 | 0,46 |
| | | 0,010 | 0,013 | 0,012 | 0,015 | 0,018 |
| S3 | MP10-1000.6HFZ3-MD08 MP3000 | 0,25 | 0,30 | 0,28 | 0,36 | 0,44 |
| | | 0,010 | 0,012 | 0,011 | 0,014 | 0,017 |
| S11 | MP10-1000.6HFZ3-MD08 MP3000 | 0,30 | 0,36 | 0,34 | 0,44 | 0,55 |
| | | 0,012 | 0,014 | 0,013 | 0,017 | 0,022 |
| S12 | MP10-1000.6HFZ3-MD08 MP3000 | 0,30 | 0,36 | 0,34 | 0,44 | 0,55 |
| | | 0,012 | 0,014 | 0,013 | 0,017 | 0,022 |
| S13 | MP10-1000.6HFZ3-MD08 MP3000 | 0,25 | 0,32 | 0,30 | 0,38 | 0,46 |
| | | 0,010 | 0,013 | 0,012 | 0,015 | 0,018 |
| H5 | MP10-1000.6HFZ3-MD08 MP3000 | 0,34 | 0,30 | 0,30 | 0,38 | 0,46 |
| | | 0,013 | 0,012 | 0,012 | 0,015 | 0,018 |
| H8 | MP10-1000.6HFZ3-MD08 MP3000 | 0,30 | 0,24 | 0,22 | 0,28 | 0,34 |
| | | 0,012 | 0,0095 | 0,0085 | 0,011 | 0,013 |
| H11 | MP10-1000.6HFZ3-MD08 MP3000 | 0,34 | 0,30 | 0,30 | 0,38 | 0,46 |
| | | 0,013 | 0,012 | 0,012 | 0,015 | 0,018 |
| H12 | MP10-1000.6HFZ3-MD08 MP3000 | 0,30 | 0,24 | 0,22 | 0,28 | 0,34 |
| | | 0,012 | 0,0095 | 0,0085 | 0,011 | 0,013 |
| H21 | MP10-1000.6HFZ3-MD08 MP3000 | 0,30 | 0,24 | 0,22 | 0,28 | 0,34 |
| | | 0,012 | 0,0095 | 0,0085 | 0,011 | 0,013 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MP10 Hochvorschubfräsen – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | MP3000 | | | |
|-----|--------|------|------|------|
| | 100% | 70% | 30% | 20% |
| P1 | 250 | 305 | 355 | 370 |
| | 820 | 1000 | 1175 | 1225 |
| P2 | 245 | 295 | 345 | 360 |
| | 800 | 970 | 1125 | 1175 |
| P3 | 215 | 260 | 295 | 315 |
| | 710 | 850 | 970 | 1025 |
| P4 | 190 | 230 | 265 | 275 |
| | 620 | 750 | 870 | 900 |
| P5 | 180 | 220 | 255 | 265 |
| | 590 | 720 | 840 | 870 |
| P6 | 205 | 245 | 285 | 295 |
| | 670 | 800 | 940 | 970 |
| P7 | 190 | 235 | 270 | 280 |
| | 620 | 770 | 890 | 920 |
| P8 | 180 | 220 | 250 | 265 |
| | 590 | 720 | 820 | 870 |
| P11 | 185 | 225 | 260 | 275 |
| | 610 | 740 | 850 | 900 |
| P12 | 120 | 145 | 165 | 175 |
| | 395 | 475 | 540 | 570 |
| M1 | 185 | 220 | 255 | 270 |
| | 610 | 720 | 840 | 890 |
| M2 | 150 | 185 | 210 | 220 |
| | 490 | 610 | 690 | 720 |
| M3 | 120 | 145 | 170 | 180 |
| | 395 | 475 | 560 | 590 |
| M4 | 95 | 115 | 130 | 140 |
| | 310 | 375 | 425 | 460 |
| M5 | 80 | 95 | 110 | 115 |
| | 260 | 310 | 360 | 375 |
| K1 | 195 | 235 | 275 | 285 |
| | 640 | 770 | 900 | 940 |
| K2 | 170 | 210 | 240 | 250 |
| | 560 | 690 | 790 | 820 |
| K3 | 145 | 175 | 205 | 215 |
| | 475 | 570 | 670 | 710 |
| K4 | 140 | 170 | 195 | 205 |
| | 460 | 560 | 640 | 670 |
| K5 | 85 | 105 | 120 | 125 |
| | 280 | 345 | 395 | 410 |
| K6 | 120 | 150 | 170 | 180 |
| | 395 | 490 | 560 | 590 |
| K7 | 110 | 130 | 150 | 160 |
| | 360 | 425 | 490 | 520 |
| N1 | 1450 | 1750 | 2025 | 2100 |
| | 4750 | 5750 | 6650 | 6900 |
| N2 | 580 | 710 | 810 | 850 |
| | 1900 | 2325 | 2650 | 2800 |
| N3 | 390 | 470 | 540 | 570 |
| | 1275 | 1550 | 1775 | 1875 |
| N11 | 445 | 540 | 620 | 650 |
| | 1450 | 1775 | 2025 | 2125 |
| S1 | 45 | 55 | 60 | 65 |
| | 150 | 180 | 195 | 215 |
| S2 | 36 | 42 | 49 | 50 |
| | 120 | 140 | 160 | 165 |
| S3 | 31 | 37 | 43 | 45 |
| | 100 | 120 | 140 | 150 |
| S11 | 60 | 75 | 85 | 90 |
| | 195 | 245 | 280 | 295 |
| S12 | 43 | 50 | 60 | 60 |
| | 140 | 165 | 195 | 195 |
| S13 | 25 | 30 | 34 | 36 |
| | 80 | 100 | 110 | 120 |
| H5 | 37 | 45 | 50 | 55 |
| | 120 | 150 | 165 | 180 |
| H8 | 39 | 47 | 55 | 60 |
| | 130 | 155 | 180 | 195 |
| H11 | 48 | 55 | 65 | 70 |
| | 155 | 180 | 215 | 230 |
| H12 | 75 | 90 | 105 | 110 |
| | 245 | 295 | 345 | 360 |
| H21 | 39 | 47 | 55 | 60 |
| | 130 | 155 | 180 | 195 |

Universell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MP10 Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|----------------------------|----------------|----------------|---------|--------|--------|
| | | | 100% | 30% | 10% | 5% |
| P1 | MP10-10007R04Z3-M03 MP3000 | 3,5 | 0,042 | 0,046 | 0,070 | 0,10 |
| | | 0,14 | 0,0017 | 0,0018 | 0,0028 | 0,0040 |
| P2 | MP10-10007R04Z3-M03 MP3000 | 3,5 | 0,044 | 0,048 | 0,070 | 0,10 |
| | | 0,14 | 0,0017 | 0,0019 | 0,0028 | 0,0040 |
| P3 | MP10-10007R04Z3-M03 MP3000 | 3,5 | 0,040 | 0,044 | 0,070 | 0,095 |
| | | 0,14 | 0,0016 | 0,0017 | 0,0028 | 0,0038 |
| P4 | MP10-10007R04Z3-M03 MP3000 | 3,5 | 0,040 | 0,044 | 0,065 | 0,095 |
| | | 0,14 | 0,0016 | 0,0017 | 0,0026 | 0,0038 |
| P5 | MP10-10007R04Z3-M03 MP3000 | 3,5 | 0,040 | 0,042 | 0,065 | 0,090 |
| | | 0,14 | 0,0016 | 0,0017 | 0,0026 | 0,0036 |
| P6 | MP10-10007R04Z3-M03 MP3000 | 3,5 | 0,038 | 0,042 | 0,065 | 0,090 |
| | | 0,14 | 0,0015 | 0,0017 | 0,0026 | 0,0036 |
| P7 | MP10-10007R04Z3-M03 MP3000 | 3,5 | 0,038 | 0,042 | 0,065 | 0,090 |
| | | 0,14 | 0,0015 | 0,0017 | 0,0026 | 0,0036 |
| P8 | MP10-10007R04Z3-M03 MP3000 | 3,5 | 0,040 | 0,044 | 0,070 | 0,095 |
| | | 0,14 | 0,0016 | 0,0017 | 0,0028 | 0,0038 |
| P11 | MP10-10007R04Z3-M03 MP3000 | 3,5 | 0,038 | 0,042 | 0,065 | 0,090 |
| | | 0,14 | 0,0015 | 0,0017 | 0,0026 | 0,0036 |
| P12 | MP10-10007R04Z3-M03 MP3000 | 2,5 | 0,026 | 0,030 | 0,044 | 0,060 |
| | | 0,10 | 0,0010 | 0,0012 | 0,0017 | 0,0024 |
| M1 | MP10-10007R04Z3-E03 F40M | 3,5 | 0,044 | 0,048 | 0,070 | 0,10 |
| | | 0,14 | 0,0017 | 0,0019 | 0,0028 | 0,0040 |
| M2 | MP10-10007R04Z3-E03 F40M | 3,5 | 0,040 | 0,042 | 0,065 | 0,090 |
| | | 0,14 | 0,0016 | 0,0017 | 0,0026 | 0,0036 |
| M3 | MP10-10007R04Z3-E03 F40M | 2,5 | 0,032 | 0,034 | 0,055 | 0,075 |
| | | 0,10 | 0,0013 | 0,0013 | 0,0022 | 0,0030 |
| M4 | MP10-10007R04Z3-E03 F40M | 2,0 | 0,028 | 0,030 | 0,046 | 0,065 |
| | | 0,080 | 0,0011 | 0,0012 | 0,0018 | 0,0026 |
| M5 | MP10-10007R04Z3-E03 F40M | 2,0 | 0,028 | 0,030 | 0,046 | 0,065 |
| | | 0,080 | 0,0011 | 0,0012 | 0,0018 | 0,0026 |
| K1 | MP10-10007R04Z3-M03 MP3000 | 3,5 | 0,044 | 0,048 | 0,070 | 0,10 |
| | | 0,14 | 0,0017 | 0,0019 | 0,0028 | 0,0040 |
| K2 | MP10-10007R04Z3-M03 MP3000 | 3,5 | 0,040 | 0,042 | 0,065 | 0,090 |
| | | 0,14 | 0,0016 | 0,0017 | 0,0026 | 0,0036 |
| K3 | MP10-10007R04Z3-M03 MP3000 | 3,5 | 0,040 | 0,042 | 0,065 | 0,090 |
| | | 0,14 | 0,0016 | 0,0017 | 0,0026 | 0,0036 |
| K4 | MP10-10007R04Z3-M03 MP3000 | 3,5 | 0,040 | 0,042 | 0,065 | 0,090 |
| | | 0,14 | 0,0016 | 0,0017 | 0,0026 | 0,0036 |
| K5 | MP10-10007R04Z3-M03 MP3000 | 3,5 | 0,036 | 0,038 | 0,060 | 0,080 |
| | | 0,14 | 0,0014 | 0,0015 | 0,0024 | 0,0032 |
| K6 | MP10-10007R04Z3-M03 MP3000 | 3,5 | 0,040 | 0,042 | 0,065 | 0,090 |
| | | 0,14 | 0,0016 | 0,0017 | 0,0026 | 0,0036 |
| K7 | MP10-10007R04Z3-M03 MP3000 | 3,5 | 0,036 | 0,038 | 0,060 | 0,080 |
| | | 0,14 | 0,0014 | 0,0015 | 0,0024 | 0,0032 |
| N1 | MP10-10007R04Z3-E03 F40M | 3,5 | 0,055 | 0,060 | 0,090 | 0,13 |
| | | 0,14 | 0,0022 | 0,0024 | 0,0036 | 0,0050 |
| N2 | MP10-10007R04Z3-E03 F40M | 3,5 | 0,055 | 0,060 | 0,090 | 0,13 |
| | | 0,14 | 0,0022 | 0,0024 | 0,0036 | 0,0050 |
| N3 | MP10-10007R04Z3-E03 F40M | 3,5 | 0,055 | 0,060 | 0,090 | 0,13 |
| | | 0,14 | 0,0022 | 0,0024 | 0,0036 | 0,0050 |
| N11 | MP10-10007R04Z3-E03 F40M | 3,5 | 0,055 | 0,060 | 0,090 | 0,13 |
| | | 0,14 | 0,0022 | 0,0024 | 0,0036 | 0,0050 |
| S1 | MP10-10007R04Z3-E03 F40M | 2,0 | 0,028 | 0,030 | 0,046 | 0,065 |
| | | 0,080 | 0,0011 | 0,0012 | 0,0018 | 0,0026 |
| S2 | MP10-10007R04Z3-E03 F40M | 2,0 | 0,028 | 0,030 | 0,046 | 0,065 |
| | | 0,080 | 0,0011 | 0,0012 | 0,0018 | 0,0026 |
| S3 | MP10-10007R04Z3-E03 F40M | 2,0 | 0,026 | 0,028 | 0,042 | 0,060 |
| | | 0,080 | 0,0010 | 0,0011 | 0,0017 | 0,0024 |
| S11 | MP10-10007R04Z3-E03 F40M | 2,5 | 0,032 | 0,034 | 0,055 | 0,075 |
| | | 0,10 | 0,0013 | 0,0013 | 0,0022 | 0,0030 |
| S12 | MP10-10007R04Z3-E03 F40M | 2,5 | 0,032 | 0,034 | 0,055 | 0,075 |
| | | 0,10 | 0,0013 | 0,0013 | 0,0022 | 0,0030 |
| S13 | MP10-10007R04Z3-E03 F40M | 2,0 | 0,028 | 0,030 | 0,046 | 0,065 |
| | | 0,080 | 0,0011 | 0,0012 | 0,0018 | 0,0026 |
| H5 | MP10-10007R04Z3-M03 MP3000 | 2,5 | 0,026 | 0,030 | 0,044 | 0,060 |
| | | 0,10 | 0,0010 | 0,0012 | 0,0017 | 0,0024 |
| H8 | MP10-10007R04Z3-M03 MP3000 | 2,5 | 0,020 | 0,022 | 0,034 | 0,048 |
| | | 0,10 | 0,00080 | 0,00085 | 0,0013 | 0,0019 |
| H11 | MP10-10007R04Z3-M03 MP3000 | 2,5 | 0,026 | 0,030 | 0,044 | 0,060 |
| | | 0,10 | 0,0010 | 0,0012 | 0,0017 | 0,0024 |
| H12 | MP10-10007R04Z3-M03 MP3000 | 2,5 | 0,020 | 0,022 | 0,034 | 0,048 |
| | | 0,10 | 0,00080 | 0,00085 | 0,0013 | 0,0019 |
| H21 | MP10-10007R04Z3-M03 MP3000 | 2,5 | 0,020 | 0,022 | 0,034 | 0,048 |
| | | 0,10 | 0,00080 | 0,00085 | 0,0013 | 0,0019 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MP10 Nut- und Eckfräsen – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | MP3000 | | | | F40M | | | |
|-----|--------|------|------|------|------|------|------|------|
| | 100% | 30% | 10% | 5% | 100% | 30% | 10% | 5% |
| P1 | 265 | 345 | 405 | 435 | 250 | 325 | 380 | 410 |
| | 870 | 1125 | 1325 | 1425 | 820 | 1075 | 1250 | 1350 |
| P2 | 255 | 335 | 395 | 425 | 240 | 315 | 370 | 400 |
| | 840 | 1100 | 1300 | 1400 | 790 | 1025 | 1225 | 1300 |
| P3 | 225 | 290 | 340 | 365 | 210 | 275 | 320 | 345 |
| | 740 | 950 | 1125 | 1200 | 690 | 900 | 1050 | 1125 |
| P4 | 195 | 255 | 300 | 325 | 185 | 240 | 285 | 305 |
| | 640 | 840 | 980 | 1075 | 610 | 790 | 940 | 1000 |
| P5 | 190 | 245 | 290 | 310 | 175 | 235 | 270 | 295 |
| | 620 | 800 | 950 | 1025 | 570 | 770 | 890 | 970 |
| P6 | 215 | 275 | 325 | 350 | 200 | 260 | 305 | 330 |
| | 710 | 900 | 1075 | 1150 | 660 | 850 | 1000 | 1075 |
| P7 | 200 | 260 | 305 | 330 | 190 | 245 | 290 | 310 |
| | 660 | 850 | 1000 | 1075 | 620 | 800 | 950 | 1025 |
| P8 | 190 | 245 | 285 | 310 | 175 | 230 | 270 | 290 |
| | 620 | 800 | 940 | 1025 | 570 | 750 | 890 | 950 |
| P11 | 195 | 255 | 295 | 320 | 185 | 240 | 280 | 305 |
| | 640 | 840 | 970 | 1050 | 610 | 790 | 920 | 1000 |
| P12 | 125 | 160 | 185 | 200 | 115 | 150 | 175 | 190 |
| | 410 | 520 | 610 | 660 | 375 | 490 | 570 | 620 |
| M1 | 190 | 250 | 295 | 315 | 195 | 255 | 300 | 320 |
| | 620 | 820 | 970 | 1025 | 640 | 840 | 980 | 1050 |
| M2 | 155 | 205 | 240 | 260 | 160 | 210 | 245 | 265 |
| | 510 | 670 | 790 | 850 | 520 | 690 | 800 | 870 |
| M3 | 125 | 165 | 190 | 205 | 125 | 165 | 195 | 210 |
| | 410 | 540 | 620 | 670 | 410 | 540 | 640 | 690 |
| M4 | 95 | 125 | 145 | 155 | 100 | 125 | 145 | 160 |
| | 310 | 410 | 475 | 510 | 330 | 410 | 475 | 520 |
| M5 | 80 | 105 | 120 | 130 | 80 | 105 | 125 | 135 |
| | 260 | 345 | 395 | 425 | 260 | 345 | 410 | 445 |
| K1 | 200 | 265 | 310 | 335 | 190 | 250 | 295 | 315 |
| | 660 | 870 | 1025 | 1100 | 620 | 820 | 970 | 1025 |
| K2 | 180 | 235 | 275 | 295 | 170 | 220 | 260 | 280 |
| | 590 | 770 | 900 | 970 | 560 | 720 | 850 | 920 |
| K3 | 150 | 200 | 230 | 250 | 140 | 185 | 220 | 235 |
| | 490 | 660 | 750 | 820 | 460 | 610 | 720 | 770 |
| K4 | 145 | 190 | 220 | 240 | 135 | 180 | 210 | 225 |
| | 475 | 620 | 720 | 790 | 445 | 590 | 690 | 740 |
| K5 | 85 | 115 | 135 | 145 | 80 | 110 | 125 | 135 |
| | 280 | 375 | 445 | 475 | 260 | 360 | 410 | 445 |
| K6 | 125 | 165 | 195 | 210 | 120 | 155 | 185 | 200 |
| | 410 | 540 | 640 | 690 | 395 | 510 | 610 | 660 |
| K7 | 110 | 145 | 170 | 185 | 105 | 140 | 160 | 175 |
| | 360 | 475 | 560 | 610 | 345 | 460 | 520 | 570 |
| N1 | 1525 | 2000 | 2350 | 2525 | 1450 | 1875 | 2225 | 2375 |
| | 5000 | 6550 | 7700 | 8275 | 4750 | 6150 | 7300 | 7800 |
| N2 | 620 | 810 | 950 | 1025 | 580 | 760 | 900 | 960 |
| | 2025 | 2650 | 3125 | 3375 | 1900 | 2500 | 2950 | 3150 |
| N3 | 410 | 540 | 630 | 680 | 390 | 510 | 600 | 640 |
| | 1350 | 1775 | 2075 | 2225 | 1275 | 1675 | 1975 | 2100 |
| N11 | 470 | 610 | 720 | 780 | 445 | 580 | 680 | 730 |
| | 1550 | 2000 | 2350 | 2550 | 1450 | 1900 | 2225 | 2400 |
| S1 | 45 | 60 | 70 | 75 | 46 | 60 | 70 | 75 |
| | 150 | 195 | 230 | 245 | 150 | 195 | 230 | 245 |
| S2 | 36 | 47 | 55 | 60 | 37 | 48 | 55 | 60 |
| | 120 | 155 | 180 | 195 | 120 | 155 | 180 | 195 |
| S3 | 31 | 41 | 47 | 50 | 32 | 42 | 48 | 50 |
| | 100 | 135 | 155 | 165 | 105 | 140 | 155 | 165 |
| S11 | 65 | 80 | 95 | 105 | 65 | 85 | 100 | 105 |
| | 215 | 260 | 310 | 345 | 215 | 280 | 330 | 345 |
| S12 | 44 | 55 | 65 | 70 | 45 | 60 | 70 | 75 |
| | 145 | 180 | 215 | 230 | 150 | 195 | 230 | 245 |
| S13 | 25 | 33 | 38 | 41 | 26 | 33 | 39 | 42 |
| | 80 | 110 | 125 | 135 | 85 | 110 | 130 | 140 |
| H5 | 38 | 49 | 60 | 60 | 39 | 50 | 60 | 65 |
| | 125 | 160 | 195 | 195 | 130 | 165 | 195 | 215 |
| H8 | 40 | 50 | 60 | 65 | 40 | 50 | 60 | 65 |
| | 130 | 165 | 195 | 215 | 130 | 165 | 195 | 215 |
| H11 | 49 | 65 | 75 | 80 | 49 | 65 | 75 | 80 |
| | 160 | 215 | 245 | 260 | 160 | 215 | 245 | 260 |
| H12 | 75 | 100 | 115 | 125 | 70 | 95 | 110 | 115 |
| | 245 | 330 | 375 | 410 | 230 | 310 | 360 | 375 |
| H21 | 40 | 50 | 60 | 65 | 40 | 50 | 60 | 65 |
| | 130 | 165 | 195 | 215 | 130 | 165 | 195 | 215 |

Universell
Stahl und Guss
Stahl und Guss
Rostrfrei und ISO-S-Werkstoffe
Rostrfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MP10 Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | | | | |
|-------------------------------|----------------|----------------------------|----------------------------|-----------------|-----------------|-----------------|-----------------|-----------------|----------------|
| | | | 100% | 30% | 10% | 5% | 2% | | |
| Univerrseil | P1 | MP10-10007B90Z3-M03 MP3000 | 3,5 0,14 | 0,048 0,0019 | 0,050 0,0020 | 0,075 0,0030 | 0,10 0,0040 | 0,17 0,0065 | |
| | P2 | MP10-10007B90Z3-M03 MP3000 | 3,5 0,14 | 0,048 0,0019 | 0,050 0,0020 | 0,075 0,0030 | 0,11 0,0044 | 0,17 0,0065 | |
| | P3 | MP10-10007B90Z3-M03 MP3000 | 3,5 0,14 | 0,046 0,0018 | 0,048 0,0019 | 0,070 0,0028 | 0,10 0,0040 | 0,16 0,0065 | |
| | P4 | MP10-10007B90Z3-M03 MP3000 | 3,5 0,14 | 0,046 0,0018 | 0,048 0,0019 | 0,070 0,0028 | 0,10 0,0040 | 0,16 0,0065 | |
| | P5 | MP10-10007B90Z3-M03 MP3000 | 3,5 0,14 | 0,044 0,0017 | 0,046 0,0018 | 0,070 0,0028 | 0,095 0,0038 | 0,15 0,0060 | |
| | P6 | MP10-10007B90Z3-M03 MP3000 | 3,5 0,14 | 0,044 0,0017 | 0,046 0,0018 | 0,070 0,0028 | 0,095 0,0038 | 0,15 0,0060 | |
| | P7 | MP10-10007B90Z3-M03 MP3000 | 3,5 0,14 | 0,044 0,0017 | 0,046 0,0018 | 0,070 0,0028 | 0,095 0,0038 | 0,15 0,0060 | |
| | P8 | MP10-10007B90Z3-M03 MP3000 | 3,5 0,14 | 0,046 0,0018 | 0,048 0,0019 | 0,070 0,0028 | 0,10 0,0040 | 0,16 0,0065 | |
| | P11 | MP10-10007B90Z3-M03 MP3000 | 3,5 0,14 | 0,044 0,0017 | 0,046 0,0018 | 0,070 0,0028 | 0,095 0,0038 | 0,15 0,0060 | |
| | P12 | MP10-10007B90Z3-M03 MP3000 | 2,5 0,10 | 0,032 0,0013 | 0,032 0,0013 | 0,046 0,0018 | 0,065 0,0026 | 0,10 0,0040 | |
| | Stahl und Guss | M1 | MP10-10007B90Z3-E03 F40M | 3,5 0,14 | 0,048 0,0019 | 0,050 0,0020 | 0,075 0,0030 | 0,11 0,0044 | 0,17 0,0065 |
| | | M2 | MP10-10007B90Z3-E03 F40M | 3,5 0,14 | 0,044 0,0017 | 0,046 0,0018 | 0,070 0,0028 | 0,095 0,0038 | 0,15 0,0060 |
| M3 | | MP10-10007B90Z3-E03 F40M | 2,5 0,10 | 0,038 0,0015 | 0,038 0,0015 | 0,055 0,0022 | 0,075 0,0030 | 0,12 0,0048 | |
| M4 | | MP10-10007B90Z3-E03 F40M | 2,0 0,080 | 0,034 0,0013 | 0,036 0,0014 | 0,048 0,0019 | 0,065 0,0026 | 0,11 0,0044 | |
| M5 | | MP10-10007B90Z3-E03 F40M | 2,0 0,080 | 0,034 0,0013 | 0,036 0,0014 | 0,048 0,0019 | 0,065 0,0026 | 0,11 0,0044 | |
| Rostfrei und ISO-S-Werkstoffe | K1 | MP10-10007B90Z3-M03 MP3000 | 3,5 0,14 | 0,048 0,0019 | 0,050 0,0020 | 0,075 0,0030 | 0,11 0,0044 | 0,17 0,0065 | |
| | K2 | MP10-10007B90Z3-M03 MP3000 | 3,5 0,14 | 0,044 0,0017 | 0,046 0,0018 | 0,070 0,0028 | 0,095 0,0038 | 0,15 0,0060 | |
| | K3 | MP10-10007B90Z3-M03 MP3000 | 3,5 0,14 | 0,044 0,0017 | 0,046 0,0018 | 0,070 0,0028 | 0,095 0,0038 | 0,15 0,0060 | |
| | K4 | MP10-10007B90Z3-M03 MP3000 | 3,5 0,14 | 0,044 0,0017 | 0,046 0,0018 | 0,070 0,0028 | 0,095 0,0038 | 0,15 0,0060 | |
| | K5 | MP10-10007B90Z3-M03 MP3000 | 3,5 0,14 | 0,040 0,0016 | 0,042 0,0017 | 0,060 0,0024 | 0,085 0,0034 | 0,14 0,0055 | |
| | K6 | MP10-10007B90Z3-M03 MP3000 | 3,5 0,14 | 0,044 0,0017 | 0,046 0,0018 | 0,070 0,0028 | 0,095 0,0038 | 0,15 0,0060 | |
| | K7 | MP10-10007B90Z3-M03 MP3000 | 3,5 0,14 | 0,040 0,0016 | 0,042 0,0017 | 0,060 0,0024 | 0,085 0,0034 | 0,14 0,0055 | |
| NE-Metalle | N1 | MP10-10007B90Z3-E03 F40M | 3,5 0,14 | 0,060 0,0024 | 0,065 0,0026 | 0,095 0,0038 | 0,13 0,0050 | 0,22 0,0085 | |
| | N2 | MP10-10007B90Z3-E03 F40M | 3,5 0,14 | 0,060 0,0024 | 0,065 0,0026 | 0,095 0,0038 | 0,13 0,0050 | 0,22 0,0085 | |
| | N3 | MP10-10007B90Z3-E03 F40M | 3,5 0,14 | 0,060 0,0024 | 0,065 0,0026 | 0,095 0,0038 | 0,13 0,0050 | 0,22 0,0085 | |
| | N11 | MP10-10007B90Z3-E03 F40M | 3,5 0,14 | 0,060 0,0024 | 0,065 0,0026 | 0,095 0,0038 | 0,13 0,0050 | 0,22 0,0085 | |
| | Harter | S1 | MP10-10007B90Z3-E03 F40M | 2,0 0,080 | 0,034 0,0013 | 0,036 0,0014 | 0,048 0,0019 | 0,065 0,0026 | 0,11 0,0044 |
| S2 | | MP10-10007B90Z3-E03 F40M | 2,0 0,080 | 0,034 0,0013 | 0,036 0,0014 | 0,048 0,0019 | 0,065 0,0026 | 0,11 0,0044 | |
| S3 | | MP10-10007B90Z3-E03 F40M | 2,0 0,080 | 0,032 0,0013 | 0,032 0,0013 | 0,044 0,0017 | 0,060 0,0024 | 0,10 0,0040 | |
| S11 | | MP10-10007B90Z3-E03 F40M | 2,5 0,10 | 0,038 0,0015 | 0,038 0,0015 | 0,055 0,0022 | 0,075 0,0030 | 0,12 0,0048 | |
| S12 | | MP10-10007B90Z3-E03 F40M | 2,5 0,10 | 0,038 0,0015 | 0,038 0,0015 | 0,055 0,0022 | 0,075 0,0030 | 0,12 0,0048 | |
| S13 | | MP10-10007B90Z3-E03 F40M | 2,0 0,080 | 0,034 0,0013 | 0,036 0,0014 | 0,048 0,0019 | 0,065 0,0026 | 0,11 0,0044 | |
| Kunststoffe und Composite | | H5 | MP10-10007B90Z3-M03 MP3000 | 2,5 0,10 | 0,032 0,0013 | 0,032 0,0013 | 0,046 0,0018 | 0,065 0,0026 | 0,10 0,0040 |
| | H8 | MP10-10007B90Z3-M03 MP3000 | 2,5 0,10 | 0,025 0,0010 | 0,025 0,0010 | 0,036 0,0014 | 0,050 0,0020 | 0,080 0,0032 | |
| | H11 | MP10-10007B90Z3-M03 MP3000 | 2,5 0,10 | 0,032 0,0013 | 0,032 0,0013 | 0,046 0,0018 | 0,065 0,0026 | 0,10 0,0040 | |
| | H12 | MP10-10007B90Z3-M03 MP3000 | 2,5 0,10 | 0,025 0,0010 | 0,025 0,0010 | 0,036 0,0014 | 0,050 0,0020 | 0,080 0,0032 | |
| | H21 | MP10-10007B90Z3-M03 MP3000 | 2,5 0,10 | 0,025 0,0010 | 0,025 0,0010 | 0,036 0,0014 | 0,050 0,0020 | 0,080 0,0032 | |
| | Graphit | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| X-Heads | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |
| Minimaster Plus | | | | | | | | | |
| | | | | | | | | | |
| | | | | | | | | | |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MP10 Kopierfräser – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | MP3000 | | | | | F40M | | | | |
|-----|--------|------|------|------|------|------|------|------|------|------|
| | 100% | 30% | 10% | 5% | 2% | 100% | 30% | 10% | 5% | 2% |
| P1 | 275 | 330 | 360 | 385 | 385 | 260 | 310 | 340 | 365 | 365 |
| | 900 | 1075 | 1175 | 1275 | 1275 | 850 | 1025 | 1125 | 1200 | 1200 |
| P2 | 265 | 320 | 345 | 375 | 375 | 250 | 300 | 325 | 355 | 355 |
| | 870 | 1050 | 1125 | 1225 | 1225 | 820 | 980 | 1075 | 1175 | 1175 |
| P3 | 230 | 280 | 300 | 325 | 325 | 220 | 265 | 285 | 310 | 305 |
| | 750 | 920 | 980 | 1075 | 1075 | 720 | 870 | 940 | 1025 | 1000 |
| P4 | 205 | 245 | 265 | 290 | 290 | 195 | 230 | 250 | 270 | 270 |
| | 670 | 800 | 870 | 950 | 950 | 640 | 750 | 820 | 890 | 890 |
| P5 | 195 | 235 | 255 | 275 | 275 | 185 | 220 | 240 | 260 | 260 |
| | 640 | 770 | 840 | 900 | 900 | 610 | 720 | 790 | 850 | 850 |
| P6 | 220 | 265 | 285 | 310 | 310 | 205 | 250 | 270 | 295 | 290 |
| | 720 | 870 | 940 | 1025 | 1025 | 670 | 820 | 890 | 970 | 950 |
| P7 | 205 | 250 | 270 | 295 | 290 | 195 | 235 | 255 | 275 | 275 |
| | 670 | 820 | 890 | 970 | 950 | 640 | 770 | 840 | 900 | 900 |
| P8 | 195 | 235 | 255 | 275 | 270 | 185 | 220 | 240 | 260 | 255 |
| | 640 | 770 | 840 | 900 | 890 | 610 | 720 | 790 | 850 | 840 |
| P11 | 200 | 245 | 265 | 285 | 285 | 190 | 230 | 250 | 270 | 265 |
| | 660 | 800 | 870 | 940 | 940 | 620 | 750 | 820 | 890 | 870 |
| P12 | 125 | 155 | 160 | 175 | 175 | 120 | 145 | 155 | 165 | 165 |
| | 410 | 510 | 520 | 570 | 570 | 395 | 475 | 510 | 540 | 540 |
| M1 | 200 | 240 | 260 | 280 | 280 | 205 | 245 | 265 | 285 | 285 |
| | 660 | 790 | 850 | 920 | 920 | 670 | 800 | 870 | 940 | 940 |
| M2 | 165 | 195 | 215 | 230 | 230 | 165 | 200 | 215 | 235 | 235 |
| | 540 | 640 | 710 | 750 | 750 | 540 | 660 | 710 | 770 | 770 |
| M3 | 130 | 160 | 165 | 180 | 180 | 135 | 160 | 170 | 185 | 185 |
| | 425 | 520 | 540 | 590 | 590 | 445 | 520 | 560 | 610 | 610 |
| M4 | 100 | 125 | 125 | 140 | 140 | 105 | 125 | 130 | 140 | 140 |
| | 330 | 410 | 410 | 460 | 460 | 345 | 410 | 425 | 460 | 460 |
| M5 | 85 | 100 | 105 | 115 | 115 | 85 | 105 | 110 | 115 | 115 |
| | 280 | 330 | 345 | 375 | 375 | 280 | 345 | 360 | 375 | 375 |
| K1 | 210 | 255 | 275 | 300 | 300 | 200 | 240 | 260 | 280 | 280 |
| | 690 | 840 | 900 | 980 | 980 | 660 | 790 | 850 | 920 | 920 |
| K2 | 185 | 220 | 245 | 260 | 260 | 175 | 210 | 230 | 245 | 245 |
| | 610 | 720 | 800 | 850 | 850 | 570 | 690 | 750 | 800 | 800 |
| K3 | 155 | 190 | 205 | 220 | 220 | 150 | 180 | 195 | 210 | 210 |
| | 510 | 620 | 670 | 720 | 720 | 490 | 590 | 640 | 690 | 690 |
| K4 | 150 | 180 | 195 | 210 | 210 | 140 | 170 | 185 | 200 | 200 |
| | 490 | 590 | 640 | 690 | 690 | 460 | 560 | 610 | 660 | 660 |
| K5 | 90 | 110 | 120 | 125 | 130 | 85 | 105 | 110 | 120 | 120 |
| | 295 | 360 | 395 | 410 | 425 | 280 | 345 | 360 | 395 | 395 |
| K6 | 130 | 160 | 175 | 185 | 185 | 125 | 150 | 165 | 175 | 175 |
| | 425 | 520 | 570 | 610 | 610 | 410 | 490 | 540 | 570 | 570 |
| K7 | 115 | 140 | 150 | 165 | 165 | 110 | 130 | 145 | 155 | 155 |
| | 375 | 460 | 490 | 540 | 540 | 360 | 425 | 475 | 510 | 510 |
| N1 | 1600 | 1925 | 2100 | 2275 | 2250 | 1500 | 1825 | 1975 | 2150 | 2125 |
| | 5250 | 6325 | 6900 | 7475 | 7375 | 4925 | 6000 | 6475 | 7050 | 6975 |
| N2 | 650 | 780 | 840 | 920 | 900 | 610 | 730 | 800 | 860 | 850 |
| | 2125 | 2550 | 2750 | 3025 | 2950 | 2000 | 2400 | 2625 | 2825 | 2800 |
| N3 | 430 | 520 | 560 | 610 | 600 | 405 | 490 | 530 | 580 | 570 |
| | 1400 | 1700 | 1825 | 2000 | 1975 | 1325 | 1600 | 1750 | 1900 | 1875 |
| N11 | 490 | 590 | 640 | 700 | 690 | 465 | 560 | 610 | 660 | 650 |
| | 1600 | 1925 | 2100 | 2300 | 2275 | 1525 | 1825 | 2000 | 2175 | 2125 |
| S1 | 47 | 55 | 60 | 65 | 65 | 48 | 60 | 60 | 65 | 65 |
| | 155 | 180 | 195 | 215 | 215 | 155 | 195 | 195 | 215 | 215 |
| S2 | 38 | 46 | 48 | 50 | 50 | 39 | 47 | 49 | 55 | 55 |
| | 125 | 150 | 155 | 165 | 165 | 130 | 155 | 160 | 180 | 180 |
| S3 | 33 | 40 | 41 | 45 | 45 | 34 | 41 | 42 | 46 | 46 |
| | 110 | 130 | 135 | 150 | 150 | 110 | 135 | 140 | 150 | 150 |
| S11 | 65 | 80 | 85 | 90 | 90 | 70 | 85 | 85 | 95 | 95 |
| | 215 | 260 | 280 | 295 | 295 | 230 | 280 | 280 | 310 | 310 |
| S12 | 46 | 55 | 60 | 65 | 65 | 47 | 55 | 60 | 65 | 65 |
| | 150 | 180 | 195 | 215 | 215 | 155 | 180 | 195 | 215 | 215 |
| S13 | 27 | 32 | 33 | 36 | 36 | 27 | 33 | 34 | 37 | 37 |
| | 90 | 105 | 110 | 120 | 120 | 90 | 110 | 110 | 120 | 120 |
| H5 | 39 | 48 | 50 | 55 | 55 | 40 | 48 | 50 | 55 | 55 |
| | 130 | 155 | 165 | 180 | 180 | 130 | 155 | 165 | 180 | 180 |
| H8 | 41 | 50 | 50 | 55 | 55 | 41 | 50 | 50 | 55 | 55 |
| | 135 | 165 | 165 | 180 | 180 | 135 | 165 | 165 | 180 | 180 |
| H11 | 50 | 60 | 65 | 70 | 70 | 50 | 60 | 65 | 70 | 70 |
| | 165 | 195 | 215 | 230 | 230 | 165 | 195 | 215 | 230 | 230 |
| H12 | 80 | 95 | 100 | 110 | 110 | 75 | 90 | 95 | 100 | 100 |
| | 260 | 310 | 330 | 360 | 360 | 245 | 295 | 310 | 330 | 330 |
| H21 | 41 | 50 | 50 | 55 | 55 | 41 | 50 | 50 | 55 | 55 |
| | 135 | 165 | 165 | 180 | 180 | 135 | 165 | 165 | 180 | 180 |

Universell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MP10 Zentrierbohren – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | f_z | a_{so} |
|-----|--------------------------|------------------|--------------|
| | | | 100% |
| P1 | MP10-10006C90Z2-M03 F40M | 0,042 0,0017 | 3,0 0,12 |
| P2 | MP10-10006C90Z2-M03 F40M | 0,042 0,0017 | 3,0 0,12 |
| P3 | MP10-10006C90Z2-M03 F40M | 0,040 0,0016 | 3,0 0,12 |
| P4 | MP10-10006C90Z2-M03 F40M | 0,040 0,0016 | 3,0 0,12 |
| P5 | MP10-10006C90Z2-M03 F40M | 0,040 0,0016 | 3,0 0,12 |
| P6 | MP10-10006C90Z2-M03 F40M | 0,038 0,0015 | 3,0 0,12 |
| P7 | MP10-10006C90Z2-M03 F40M | 0,038 0,0015 | 3,0 0,12 |
| P8 | MP10-10006C90Z2-M03 F40M | 0,040 0,0016 | 3,0 0,12 |
| P11 | MP10-10006C90Z2-M03 F40M | 0,038 0,0015 | 3,0 0,12 |
| P12 | MP10-10006C90Z2-M03 F40M | 0,026 0,0010 | 2,0 0,080 |
| M1 | MP10-10006C90Z2-M03 F40M | 0,042 0,0017 | 3,0 0,12 |
| M2 | MP10-10006C90Z2-M03 F40M | 0,040 0,0016 | 3,0 0,12 |
| M3 | MP10-10006C90Z2-M03 F40M | 0,032 0,0013 | 2,0 0,080 |
| M4 | MP10-10006C90Z2-M03 F40M | 0,028 0,0011 | 1,7 0,065 |
| M5 | MP10-10006C90Z2-M03 F40M | 0,028 0,0011 | 1,7 0,065 |
| K1 | MP10-10006C90Z2-M03 F40M | 0,042 0,0017 | 3,0 0,12 |
| K2 | MP10-10006C90Z2-M03 F40M | 0,040 0,0016 | 3,0 0,12 |
| K3 | MP10-10006C90Z2-M03 F40M | 0,040 0,0016 | 3,0 0,12 |
| K4 | MP10-10006C90Z2-M03 F40M | 0,040 0,0016 | 3,0 0,12 |
| K5 | MP10-10006C90Z2-M03 F40M | 0,036 0,0014 | 3,0 0,12 |
| K6 | MP10-10006C90Z2-M03 F40M | 0,040 0,0016 | 3,0 0,12 |
| K7 | MP10-10006C90Z2-M03 F40M | 0,036 0,0014 | 3,0 0,12 |
| N1 | MP10-10006C90Z2-M03 F40M | 0,055 0,0022 | 3,0 0,12 |
| N2 | MP10-10006C90Z2-M03 F40M | 0,055 0,0022 | 3,0 0,12 |
| N3 | MP10-10006C90Z2-M03 F40M | 0,055 0,0022 | 3,0 0,12 |
| N11 | MP10-10006C90Z2-M03 F40M | 0,055 0,0022 | 3,0 0,12 |
| S1 | MP10-10006C90Z2-M03 F40M | 0,028 0,0011 | 1,7 0,065 |
| S2 | MP10-10006C90Z2-M03 F40M | 0,028 0,0011 | 1,7 0,065 |
| S3 | MP10-10006C90Z2-M03 F40M | 0,025 0,0010 | 1,7 0,065 |
| S11 | MP10-10006C90Z2-M03 F40M | 0,032 0,0013 | 1,9 0,075 |
| S12 | MP10-10006C90Z2-M03 F40M | 0,032 0,0013 | 1,9 0,075 |
| S13 | MP10-10006C90Z2-M03 F40M | 0,028 0,0011 | 1,7 0,065 |
| H5 | MP10-10006C90Z2-M03 F40M | 0,026 0,0010 | 2,0 0,080 |
| H8 | MP10-10006C90Z2-M03 F40M | 0,020 0,00080 | 1,9 0,075 |
| H11 | MP10-10006C90Z2-M03 F40M | 0,026 0,0010 | 2,0 0,080 |
| H12 | MP10-10006C90Z2-M03 F40M | 0,020 0,00080 | 1,9 0,075 |
| H21 | MP10-10006C90Z2-M03 F40M | 0,020 0,00080 | 1,9 0,075 |

SMG = Seco Werkstoff-Gruppe
 f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
 Alle Schnittdaten sind Startwerte

MP10 Zentrierbohren – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | F40M | | | |
|-----|--------------|-----|----------------------------------|-----------------|
| | v_c | f | | |
| | 100% | | Universell | |
| P1 | 305 1000 | | | |
| P2 | 295 970 | | Stahl und Guss | |
| P3 | 260 850 | | | |
| P4 | 225 740 | | | |
| P5 | 215 710 | | | |
| P6 | 245 800 | | | |
| P7 | 230 750 | | Rostfrei und ISO-S-Werkstoffe | |
| P8 | 215 710 | | | |
| P11 | 225 740 | | | |
| P12 | 135 445 | | | |
| M1 | 240 790 | | Rostfrei und ISO-S-Werkstoffe | |
| M2 | 195 640 | | | |
| M3 | 150 490 | | | |
| M4 | 110 360 | | | |
| M5 | 95 310 | | | |
| K1 | 235 770 | | NE-Metalle | |
| K2 | 205 670 | | | |
| K3 | 175 570 | | Harter | |
| K4 | 165 540 | | | |
| K5 | 100 330 | | | |
| K6 | 145 475 | | | |
| K7 | 130 425 | | | |
| N1 | 1775 5825 | | | Graphit |
| N2 | 710 2325 | | | |
| N3 | 475 1550 | | | |
| N11 | 540 1775 | | | |
| S1 | 50 165 | | X-Heads | |
| S2 | 42 140 | | | |
| S3 | 36 120 | | | |
| S11 | 75 245 | | | |
| S12 | 50 165 | | | |
| S13 | 29 95 | | | |
| H5 | 45 150 | | | Minimaster Plus |
| H8 | 46 150 | | | |
| H11 | 55 180 | | | |
| H12 | 85 280 | | | |
| H21 | 46 150 | | | |
| | | | Minimaster | |
| | | | | |

MP10 Anfasen – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | | |
|-----|--------------------------|----------------|----------------|--------|--------|--------|--------|
| | | | 100% | 50% | 30% | 20% | 10% |
| P1 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,060 | 0,060 | 0,060 | 0,060 | 0,075 |
| | | 0,080 | 0,0024 | 0,0024 | 0,0024 | 0,0024 | 0,0030 |
| P2 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,060 | 0,060 | 0,060 | 0,060 | 0,075 |
| | | 0,080 | 0,0024 | 0,0024 | 0,0024 | 0,0024 | 0,0030 |
| P3 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,055 | 0,055 | 0,055 | 0,055 | 0,070 |
| | | 0,080 | 0,0022 | 0,0022 | 0,0022 | 0,0022 | 0,0028 |
| P4 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,055 | 0,055 | 0,055 | 0,055 | 0,070 |
| | | 0,080 | 0,0022 | 0,0022 | 0,0022 | 0,0022 | 0,0028 |
| P5 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,055 | 0,055 | 0,055 | 0,055 | 0,065 |
| | | 0,080 | 0,0022 | 0,0022 | 0,0022 | 0,0022 | 0,0026 |
| P6 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,055 | 0,055 | 0,055 | 0,055 | 0,065 |
| | | 0,080 | 0,0022 | 0,0022 | 0,0022 | 0,0022 | 0,0026 |
| P7 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,055 | 0,055 | 0,055 | 0,055 | 0,065 |
| | | 0,080 | 0,0022 | 0,0022 | 0,0022 | 0,0022 | 0,0026 |
| P8 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,055 | 0,055 | 0,055 | 0,055 | 0,070 |
| | | 0,080 | 0,0022 | 0,0022 | 0,0022 | 0,0022 | 0,0028 |
| P11 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,055 | 0,055 | 0,055 | 0,055 | 0,065 |
| | | 0,080 | 0,0022 | 0,0022 | 0,0022 | 0,0022 | 0,0026 |
| P12 | MP10-10006C90Z2-M03 F40M | 1,8 | 0,038 | 0,038 | 0,038 | 0,038 | 0,046 |
| | | 0,070 | 0,0015 | 0,0015 | 0,0015 | 0,0015 | 0,0018 |
| M1 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,060 | 0,060 | 0,060 | 0,060 | 0,075 |
| | | 0,080 | 0,0024 | 0,0024 | 0,0024 | 0,0024 | 0,0030 |
| M2 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,055 | 0,055 | 0,055 | 0,055 | 0,065 |
| | | 0,080 | 0,0022 | 0,0022 | 0,0022 | 0,0022 | 0,0026 |
| M3 | MP10-10006C90Z2-M03 F40M | 1,8 | 0,044 | 0,044 | 0,044 | 0,044 | 0,055 |
| | | 0,070 | 0,0017 | 0,0017 | 0,0017 | 0,0017 | 0,0022 |
| M4 | MP10-10006C90Z2-M03 F40M | 1,3 | 0,038 | 0,038 | 0,038 | 0,038 | 0,048 |
| | | 0,050 | 0,0015 | 0,0015 | 0,0015 | 0,0015 | 0,0019 |
| M5 | MP10-10006C90Z2-M03 F40M | 1,3 | 0,038 | 0,038 | 0,038 | 0,038 | 0,048 |
| | | 0,050 | 0,0015 | 0,0015 | 0,0015 | 0,0015 | 0,0019 |
| K1 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,060 | 0,060 | 0,060 | 0,060 | 0,075 |
| | | 0,080 | 0,0024 | 0,0024 | 0,0024 | 0,0024 | 0,0030 |
| K2 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,055 | 0,055 | 0,055 | 0,055 | 0,065 |
| | | 0,080 | 0,0022 | 0,0022 | 0,0022 | 0,0022 | 0,0026 |
| K3 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,055 | 0,055 | 0,055 | 0,055 | 0,065 |
| | | 0,080 | 0,0022 | 0,0022 | 0,0022 | 0,0022 | 0,0026 |
| K4 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,055 | 0,055 | 0,055 | 0,055 | 0,065 |
| | | 0,080 | 0,0022 | 0,0022 | 0,0022 | 0,0022 | 0,0026 |
| K5 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,050 | 0,050 | 0,050 | 0,050 | 0,060 |
| | | 0,080 | 0,0020 | 0,0020 | 0,0020 | 0,0020 | 0,0024 |
| K6 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,055 | 0,055 | 0,055 | 0,055 | 0,065 |
| | | 0,080 | 0,0022 | 0,0022 | 0,0022 | 0,0022 | 0,0026 |
| K7 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,050 | 0,050 | 0,050 | 0,050 | 0,060 |
| | | 0,080 | 0,0020 | 0,0020 | 0,0020 | 0,0020 | 0,0024 |
| N1 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,075 | 0,075 | 0,075 | 0,075 | 0,095 |
| | | 0,080 | 0,0030 | 0,0030 | 0,0030 | 0,0030 | 0,0038 |
| N2 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,075 | 0,075 | 0,075 | 0,075 | 0,095 |
| | | 0,080 | 0,0030 | 0,0030 | 0,0030 | 0,0030 | 0,0038 |
| N3 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,075 | 0,075 | 0,075 | 0,075 | 0,095 |
| | | 0,080 | 0,0030 | 0,0030 | 0,0030 | 0,0030 | 0,0038 |
| N11 | MP10-10006C90Z2-M03 F40M | 2,0 | 0,075 | 0,075 | 0,075 | 0,075 | 0,095 |
| | | 0,080 | 0,0030 | 0,0030 | 0,0030 | 0,0030 | 0,0038 |
| S1 | MP10-10006C90Z2-M03 F40M | 1,3 | 0,038 | 0,038 | 0,038 | 0,038 | 0,048 |
| | | 0,050 | 0,0015 | 0,0015 | 0,0015 | 0,0015 | 0,0019 |
| S2 | MP10-10006C90Z2-M03 F40M | 1,3 | 0,038 | 0,038 | 0,038 | 0,038 | 0,048 |
| | | 0,050 | 0,0015 | 0,0015 | 0,0015 | 0,0015 | 0,0019 |
| S3 | MP10-10006C90Z2-M03 F40M | 1,3 | 0,036 | 0,036 | 0,036 | 0,036 | 0,044 |
| | | 0,050 | 0,0014 | 0,0014 | 0,0014 | 0,0014 | 0,0017 |
| S11 | MP10-10006C90Z2-M03 F40M | 1,5 | 0,044 | 0,044 | 0,044 | 0,044 | 0,055 |
| | | 0,060 | 0,0017 | 0,0017 | 0,0017 | 0,0017 | 0,0022 |
| S12 | MP10-10006C90Z2-M03 F40M | 1,5 | 0,044 | 0,044 | 0,044 | 0,044 | 0,055 |
| | | 0,060 | 0,0017 | 0,0017 | 0,0017 | 0,0017 | 0,0022 |
| S13 | MP10-10006C90Z2-M03 F40M | 1,3 | 0,038 | 0,038 | 0,038 | 0,038 | 0,048 |
| | | 0,050 | 0,0015 | 0,0015 | 0,0015 | 0,0015 | 0,0019 |
| H5 | MP10-10006C90Z2-M03 F40M | 1,8 | 0,038 | 0,038 | 0,038 | 0,038 | 0,046 |
| | | 0,070 | 0,0015 | 0,0015 | 0,0015 | 0,0015 | 0,0018 |
| H8 | MP10-10006C90Z2-M03 F40M | 1,5 | 0,028 | 0,028 | 0,028 | 0,028 | 0,034 |
| | | 0,060 | 0,0011 | 0,0011 | 0,0011 | 0,0011 | 0,0013 |
| H11 | MP10-10006C90Z2-M03 F40M | 1,8 | 0,038 | 0,038 | 0,038 | 0,038 | 0,046 |
| | | 0,070 | 0,0015 | 0,0015 | 0,0015 | 0,0015 | 0,0018 |
| H12 | MP10-10006C90Z2-M03 F40M | 1,5 | 0,028 | 0,028 | 0,028 | 0,028 | 0,034 |
| | | 0,060 | 0,0011 | 0,0011 | 0,0011 | 0,0011 | 0,0013 |
| H21 | MP10-10006C90Z2-M03 F40M | 1,5 | 0,028 | 0,028 | 0,028 | 0,028 | 0,034 |
| | | 0,060 | 0,0011 | 0,0011 | 0,0011 | 0,0011 | 0,0013 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (stf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MP10 Anfasen – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | F40M | | | | |
|-----|------|------|------|------|------|
| | 100% | 50% | 30% | 20% | 10% |
| P1 | 330 | 300 | 360 | 395 | 465 |
| | 1075 | 980 | 1175 | 1300 | 1525 |
| P2 | 320 | 290 | 350 | 385 | 455 |
| | 1050 | 950 | 1150 | 1275 | 1500 |
| P3 | 285 | 255 | 305 | 340 | 395 |
| | 940 | 840 | 1000 | 1125 | 1300 |
| P4 | 250 | 225 | 270 | 300 | 350 |
| | 820 | 740 | 890 | 980 | 1150 |
| P5 | 240 | 215 | 260 | 285 | 335 |
| | 790 | 710 | 850 | 940 | 1100 |
| P6 | 265 | 240 | 290 | 320 | 380 |
| | 870 | 790 | 950 | 1050 | 1250 |
| P7 | 250 | 230 | 275 | 300 | 355 |
| | 820 | 750 | 900 | 980 | 1175 |
| P8 | 240 | 215 | 260 | 285 | 330 |
| | 790 | 710 | 850 | 940 | 1075 |
| P11 | 245 | 220 | 265 | 295 | 345 |
| | 800 | 720 | 870 | 970 | 1125 |
| P12 | 155 | 140 | 160 | 175 | 220 |
| | 510 | 460 | 520 | 570 | 720 |
| M1 | 260 | 235 | 280 | 310 | 365 |
| | 850 | 770 | 920 | 1025 | 1200 |
| M2 | 215 | 195 | 230 | 255 | 305 |
| | 710 | 640 | 750 | 840 | 1000 |
| M3 | 170 | 150 | 175 | 195 | 240 |
| | 560 | 490 | 570 | 640 | 790 |
| M4 | 130 | 110 | 125 | 140 | 185 |
| | 425 | 360 | 410 | 460 | 610 |
| M5 | 105 | 90 | 105 | 120 | 155 |
| | 345 | 295 | 345 | 395 | 510 |
| K1 | 255 | 230 | 275 | 305 | 360 |
| | 840 | 750 | 900 | 1000 | 1175 |
| K2 | 225 | 205 | 245 | 270 | 320 |
| | 740 | 670 | 800 | 890 | 1050 |
| K3 | 190 | 175 | 205 | 230 | 270 |
| | 620 | 570 | 670 | 750 | 890 |
| K4 | 180 | 165 | 200 | 220 | 260 |
| | 590 | 540 | 660 | 720 | 850 |
| K5 | 110 | 100 | 120 | 135 | 155 |
| | 360 | 330 | 395 | 445 | 510 |
| K6 | 160 | 145 | 175 | 190 | 230 |
| | 520 | 475 | 570 | 620 | 750 |
| K7 | 140 | 130 | 155 | 170 | 200 |
| | 460 | 425 | 510 | 560 | 660 |
| N1 | 1925 | 1725 | 2075 | 2300 | 2700 |
| | 6325 | 5650 | 6800 | 7550 | 8850 |
| N2 | 770 | 690 | 840 | 930 | 1100 |
| | 2525 | 2275 | 2750 | 3050 | 3600 |
| N3 | 520 | 465 | 560 | 620 | 730 |
| | 1700 | 1525 | 1825 | 2025 | 2400 |
| N11 | 590 | 530 | 640 | 710 | 830 |
| | 1925 | 1750 | 2100 | 2325 | 2725 |
| S1 | 60 | 50 | 60 | 65 | 85 |
| | 195 | 165 | 195 | 215 | 280 |
| S2 | 48 | 41 | 47 | 55 | 70 |
| | 155 | 135 | 155 | 180 | 230 |
| S3 | 42 | 36 | 41 | 46 | 60 |
| | 140 | 120 | 135 | 150 | 195 |
| S11 | 85 | 75 | 85 | 95 | 120 |
| | 280 | 245 | 280 | 310 | 395 |
| S12 | 60 | 50 | 60 | 65 | 85 |
| | 195 | 165 | 195 | 215 | 280 |
| S13 | 34 | 29 | 33 | 37 | 48 |
| | 110 | 95 | 110 | 120 | 155 |
| H5 | 50 | 46 | 50 | 60 | 75 |
| | 165 | 150 | 165 | 195 | 245 |
| H8 | 55 | 47 | 55 | 60 | 75 |
| | 180 | 155 | 180 | 195 | 245 |
| H11 | 65 | 60 | 65 | 75 | 90 |
| | 215 | 195 | 215 | 245 | 295 |
| H12 | 95 | 85 | 95 | 110 | 135 |
| | 310 | 280 | 310 | 360 | 445 |
| H21 | 55 | 47 | 55 | 60 | 75 |
| | 180 | 155 | 180 | 195 | 245 |

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Minimaster

MP12 Schaft

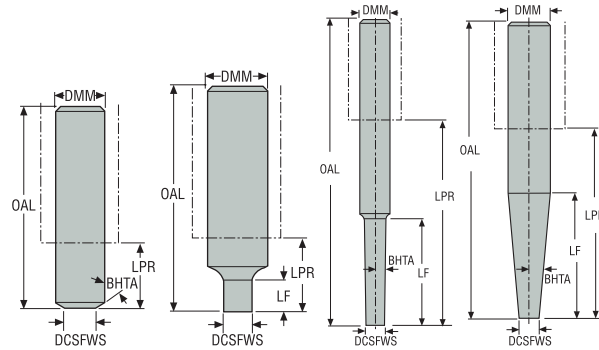



Abb. 1

Abb. 2

Abb. 3

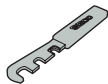
Abb. 4

- Zylindrischer Schaft DMM mit Toleranz h5 kompatibel mit Schrupfaufnahmen

| Bezeichnung | Aufnahme | DCSFWS | DMM | OAL | LPR | LF | RPMX | BHTA° | Abb. |  | Gewicht |
|---------------------|-------------|--------|------|-------|-------|-------|-------|-------|------|---|---------|
| | | mm | mm | mm | mm | mm | | | | | kg |
| MP12-12060-012.00 | Zylindrisch | 11,5 | 12,0 | 60,0 | 15,0 | 12,0 | 72700 | 0,0 | 2 | ✓ | 0,1 |
| MP12-16068-000.60 | Zylindrisch | 11,5 | 16,0 | 68,0 | 20,0 | 0,0 | 72700 | 60,0 | 1 | ✓ | 0,2 |
| MP12-16078-018.00 | Zylindrisch | 11,5 | 16,0 | 78,0 | 30,0 | 18,0 | 72700 | 0,0 | 2 | ✓ | 0,2 |
| MP12-16153-042.01 | Zylindrisch | 11,5 | 16,0 | 153,0 | 105,0 | 42,0 | 72700 | 1,0 | 3 | ✓ | 0,2 |
| MP12-20170-072.01 | Zylindrisch | 11,5 | 20,0 | 170,0 | 120,0 | 72,0 | 72700 | 1,0 | 3 | ✓ | 0,3 |
| MP12-20110-055.03 | Zylindrisch | 11,5 | 20,0 | 110,0 | 60,0 | 55,0 | 72700 | 3,0 | 3 | ✓ | 0,2 |
| MP12-20150-100.03 | Zylindrisch | 11,5 | 20,0 | 150,0 | 100,0 | 81,1 | 72700 | 3,0 | 3 | ✓ | 0,3 |
| MP12-20155-105.05 | Zylindrisch | 11,5 | 20,0 | 155,0 | 105,0 | 48,6 | 72700 | 5,0 | 4 | ✓ | 0,4 |
| MP12-16107-036.00-E | Zylindrisch | 11,5 | 16,0 | 107,0 | 59,0 | 36,0 | 72700 | 0,0 | 2 | ✓ | 0,3 |
| MP12-16120-048.00-E | Zylindrisch | 11,5 | 16,0 | 120,0 | 72,0 | 48,0 | 72700 | 0,0 | 2 | ✓ | 0,3 |
| MP12-16150-072.00-E | Zylindrisch | 11,5 | 16,0 | 150,0 | 102,0 | 72,0 | 72700 | 0,0 | 2 | ✓ | 0,4 |
| MP12-16120-060.01-E | Zylindrisch | 11,5 | 16,0 | 120,0 | 72,0 | 60,0 | 72700 | 1,0 | 3 | ✓ | 0,3 |
| MP12-16150-096.01-E | Zylindrisch | 11,5 | 16,0 | 150,0 | 102,0 | 96,0 | 72700 | 1,0 | 3 | ✓ | 0,4 |
| MP12-16175-120.01-E | Zylindrisch | 11,5 | 16,0 | 175,0 | 127,0 | 120,0 | 72700 | 1,0 | 3 | ✓ | 0,4 |
| MP12-16155-107.03-E | Zylindrisch | 11,5 | 16,0 | 155,0 | 107,0 | 42,9 | 72700 | 3,0 | 4 | ✓ | 0,5 |
| MP12-16180-132.03-E | Zylindrisch | 11,5 | 16,0 | 180,0 | 132,0 | 42,9 | 72700 | 3,0 | 4 | ✓ | 0,5 |

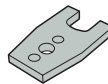
Zubehör

Schlüssel



MP1016

Ersatzklinge



MP00-12M

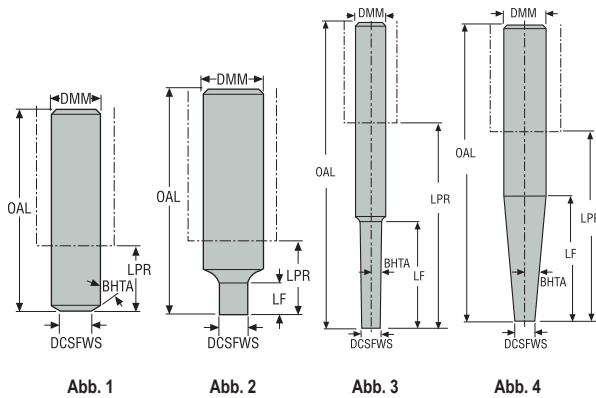
Drehmoment-
schlüssel



MP00-12.150

Die Klingen sind im Lieferumfang des Drehmomentschlüssels enthalten

MP12 Schaft – Zoll



• Zylindrischer Schaft DMM mit Toleranz h5 kompatibel mit Schrumpfaufnahmen

| Bezeichnung | Aufnahme | DCSFMS | DMM | OAL | LPR | LF | RPMX | BHTA° | Abb. | | Gewicht |
|-----------------------|-------------|--------|-------|-------|-------|-------|-------|-------|------|---|---------|
| | | Zoll | Zoll | Zoll | Zoll | Zoll | | | | | lbs |
| MP12-0502.3-0.47.00 | Zylindrisch | 0.453 | 0.500 | 2.341 | 0.591 | 0.472 | 72700 | 0,0 | 2 | ✓ | 0.220 |
| MP12-0622.6-0.00.60 | Zylindrisch | 0.453 | 0.625 | 2.662 | 0.787 | 0 | 72700 | 60,0 | 1 | ✓ | 0.220 |
| MP12-0623.0-0.70.00 | Zylindrisch | 0.453 | 0.625 | 3.056 | 1.181 | 0.709 | 72700 | 0,0 | 2 | ✓ | 0.440 |
| MP12-0626.0-1.65.01 | Zylindrisch | 0.453 | 0.625 | 6.009 | 4.134 | 1.654 | 72700 | 1,0 | 3 | ✓ | 0.440 |
| MP12-0754.3-2.20.03 | Zylindrisch | 0.453 | 0.750 | 4.362 | 2.362 | 2.201 | 72700 | 3,0 | 3 | ✓ | 0.440 |
| MP12-0755.9-3.93.03 | Zylindrisch | 0.453 | 0.750 | 5.937 | 3.937 | 2.835 | 72700 | 3,0 | 3 | ✓ | 0.660 |
| MP12-0756.1-4.13.05 | Zylindrisch | 0.453 | 0.750 | 6.134 | 4.134 | 1.697 | 72700 | 5,0 | 4 | ✓ | 0.660 |
| MP12-0756.7-2.83.01 | Zylindrisch | 0.453 | 0.750 | 6.724 | 4.724 | 2.835 | 72700 | 1,0 | 4 | ✓ | 0.660 |
| MP12-0627.0-5.19.03-E | Zylindrisch | 0.453 | 0.625 | 7.072 | 5.197 | 1.654 | 72700 | 3,0 | 4 | ✓ | 1.100 |
| MP12-0625.8-2.83.00-E | Zylindrisch | 0.453 | 0.625 | 5.891 | 4.016 | 2.835 | 72700 | 0,0 | 2 | ✓ | 0.660 |

Zubehör

| Schlüssel | Ersatzklinge | Drehmoment-schlüssel |
|-----------|--------------|----------------------|
| | | |
| MP1016 | MP00-12M | MP00-12.150 |

Die Klingen sind im Lieferumfang des Drehmomentschlüssels enthalten

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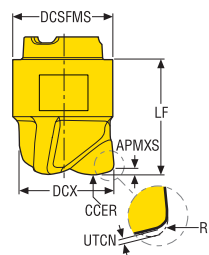
Graphit

X-Heads

Minimaster Plus

Minimaster

MP12 Hochvorschubfräser



• Auswahl der Wendschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 606-607

Z3



| Bezeichnung | DCX | DC | APMXS | DCSFMS | CCER | RP | LF | UTCN | RMPX° | C min | C max | ZEFP | Beschichtung | | |
|----------------------|---------------|--------------|--------------|----------------|--------------|---------------|---------------|---------------|-------|-------|-------|------|--------------|-------------|------|
| | | | | | | | | | | | | | Beschichtet | Beschichtet | |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | | | MP3000 | F40M |
| MP12-1200.7HFZ3-MD10 | 12,0 0.472 | 6,0 0.236 | 0,7 0.028 | 11,52 0.454 | 7,5 0.295 | 1,66 0.065 | 13,3 0.524 | 0,33 0.013 | 5,0 | 13,1 | 17,8 | 3 | | ■ | |
| MP12-1270.7HFZ3-MD10 | 12,7 0.500 | 6,7 0.264 | 0,7 0.028 | 11,52 0.454 | 7,5 0.295 | 1,66 0.065 | 13,3 0.524 | 0,32 0.013 | 5,0 | 13,8 | 19,2 | 3 | | ■ | |

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Rostfrei und ISO-S-Werkstoffe

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Harter

Kunststoffe und Composite

Graphit

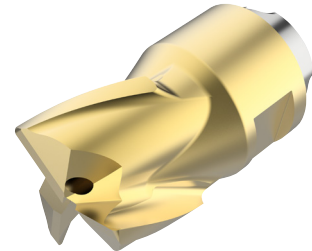
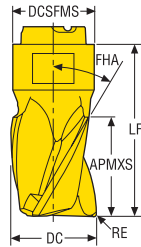
X-Heads

Minimaster Plus

Minimaster

MP12 Eckfräser

Nut- und Konturfräsen



• Auswahl der Wandeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 608-609

Z3



| Bezeichnung | DC | APMXS | RE | DCSFMS | FHA | LF | RMPX° | C min | C max | ZEFP | Beschichtung | |
|---------------------|---------------|--------------|--------------|---------------|-------------|---------------|-------|-------|-------|------|--------------|------|
| | | | | | | | | | | | MP3000 | F40M |
| MP12-12008R04Z3-E04 | 12,0 0.472 | 8,0 0.315 | 0,4 0.016 | 11,5 0.453 | 30 1.181 | 18,8 0.740 | 15,0 | 14,6 | 23,0 | 3 | | ■ |
| MP12-12008R04Z3-M04 | 12,0 0.472 | 8,0 0.315 | 0,4 0.016 | 11,5 0.453 | 30 1.181 | 18,8 0.740 | 15,0 | 14,6 | 23,0 | 3 | ■ | |
| MP12-12008R05Z3-E04 | 12,0 0.472 | 8,0 0.315 | 0,5 0.020 | 11,5 0.453 | 30 1.181 | 18,8 0.740 | 15,0 | 14,6 | 22,8 | 3 | | ■ |
| MP12-12008R08Z3-E04 | 12,0 0.472 | 8,0 0.315 | 0,8 0.031 | 11,5 0.453 | 30 1.181 | 18,8 0.740 | 15,0 | 14,6 | 22,2 | 3 | | ■ |
| MP12-12008R08Z3-M04 | 12,0 0.472 | 8,0 0.315 | 0,8 0.031 | 11,5 0.453 | 30 1.181 | 18,8 0.740 | 15,0 | 14,6 | 22,2 | 3 | ■ | |
| MP12-12008R16Z3-E04 | 12,0 0.472 | 8,0 0.315 | 1,6 0.063 | 11,5 0.453 | 30 1.181 | 18,8 0.740 | 15,0 | 14,6 | 20,6 | 3 | | ■ |
| MP12-12008R31Z3-E04 | 12,0 0.472 | 8,0 0.315 | 3,1 0.122 | 11,5 0.453 | 30 1.181 | 18,8 0.740 | 15,0 | 14,6 | 17,6 | 3 | | ■ |
| MP12-12708R08Z3-M04 | 12,7 0.500 | 8,0 0.315 | 0,8 0.031 | 11,5 0.453 | 30 1.181 | 18,8 0.740 | 15,0 | 15,4 | 23,6 | 3 | ■ | |

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NE-Metalle

Harter

Graphit

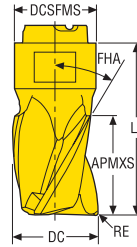
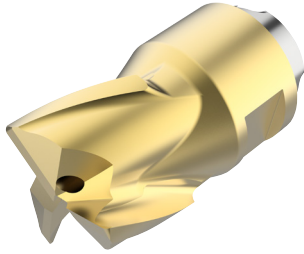
X-Heads

Minimaster Plus

Minimaster

MP12 Eckfräser

Nut- und Konturfräsen



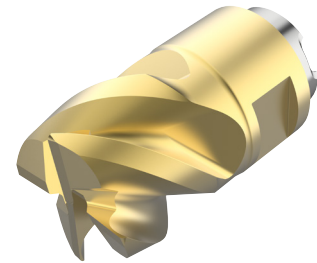
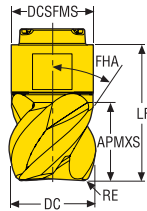
• Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 608-609

Z3



| Bezeichnung | DC | APMXS | RE | DCSFMS | FHA | LF | RMPX° | C min | C max | ZEFP | Beschichtung | |
|---------------------|---------------|---------------|--------------|---------------|-------------|---------------|-------|-------|-------|------|--------------|--------|
| | | | | | | | | | | | Beschichtet | MP3000 |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | | | |
| MP12-11714KWZ3-E04 | 11,7 0.461 | 14,0 0.551 | 0,3 0.012 | 11,5 0.453 | 30 1.181 | 24,0 0.945 | 15,0 | 14,2 | 22,6 | 3 | | ■ |
| MP12-12014R04Z3-E04 | 12,0 0.472 | 14,0 0.551 | 0,4 0.016 | 11,5 0.453 | 30 1.181 | 24,0 0.945 | 15,0 | 14,6 | 23,0 | 3 | | ■ |
| MP12-12014R04Z3-M04 | 12,0 0.472 | 14,0 0.551 | 0,4 0.016 | 11,5 0.453 | 30 1.181 | 24,0 0.945 | 15,0 | 14,6 | 23,0 | 3 | ■ | |
| MP12-12014R05Z3-E04 | 12,0 0.472 | 14,0 0.551 | 0,5 0.020 | 11,5 0.453 | 30 1.181 | 24,0 0.945 | 15,0 | 14,6 | 22,8 | 3 | | ■ |
| MP12-12014R08Z3-M04 | 12,0 0.472 | 14,0 0.551 | 0,8 0.031 | 11,5 0.453 | 30 1.181 | 24,0 0.945 | 15,0 | 14,6 | 22,2 | 3 | ■ | |
| MP12-12014R12Z3-E04 | 12,0 0.472 | 14,0 0.551 | 1,2 0.047 | 11,5 0.453 | 30 1.181 | 24,0 0.945 | 15,0 | 14,6 | 21,4 | 3 | | ■ |
| MP12-12014R12Z3-M04 | 12,0 0.472 | 14,0 0.551 | 1,2 0.047 | 11,5 0.453 | 30 1.181 | 24,0 0.945 | 15,0 | 14,6 | 21,4 | 3 | ■ | |
| MP12-12014R20Z3-E04 | 12,0 0.472 | 14,0 0.551 | 2,0 0.079 | 11,5 0.453 | 30 1.181 | 24,0 0.945 | 15,0 | 14,6 | 19,8 | 3 | | ■ |
| MP12-12014R31Z3-E04 | 12,0 0.472 | 14,0 0.551 | 3,1 0.122 | 11,5 0.453 | 30 1.181 | 24,0 0.945 | 15,0 | 14,6 | 17,6 | 3 | | ■ |
| MP12-12714R04Z3-E04 | 12,7 0.500 | 14,0 0.551 | 0,4 0.016 | 11,5 0.453 | 30 1.181 | 24,0 0.945 | 15,0 | 15,4 | 24,4 | 3 | | ■ |
| MP12-12714R04Z3-M04 | 12,7 0.500 | 14,0 0.551 | 0,4 0.016 | 11,5 0.453 | 30 1.181 | 24,0 0.945 | 15,0 | 15,4 | 24,4 | 3 | ■ | |

MP12 Eckfräser
Nut- und Konturfräsen



• Auswahl der Wandeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 608-609

Z4



| Bezeichnung | DC | APMXS | RE | DCSFMS | FHA | LF | RMPX° | C min | C max | ZEFP | Beschichtung | |
|---------------------|---------------|---------------|--------------|---------------|-------------|---------------|-------|-------|-------|------|--------------|------|
| | | | | | | | | | | | MP3000 | F40M |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | | | |
| MP12-12008R04Z4-M03 | 12,0 0.472 | 8,0 0.315 | 0,4 0.016 | 11,5 0.453 | 50 1.969 | 18,8 0.740 | 15,0 | 14,6 | 23,0 | 4 | ■ | |
| MP12-12008R05Z4-E03 | 12,0 0.472 | 8,0 0.315 | 0,5 0.020 | 11,5 0.453 | 50 1.969 | 18,8 0.740 | 15,0 | 14,6 | 22,8 | 4 | | ■ |
| MP12-12008R08Z4-E03 | 12,0 0.472 | 8,0 0.315 | 0,8 0.031 | 11,5 0.453 | 50 1.969 | 18,8 0.740 | 15,0 | 14,6 | 22,2 | 4 | | ■ |
| MP12-12008R08Z4-M03 | 12,0 0.472 | 8,0 0.315 | 0,8 0.031 | 11,5 0.453 | 50 1.969 | 18,8 0.740 | 15,0 | 14,6 | 22,2 | 4 | ■ | |
| MP12-12008R12Z4-M03 | 12,0 0.472 | 8,0 0.315 | 1,2 0.047 | 11,5 0.453 | 50 1.969 | 18,8 0.740 | 15,0 | 14,6 | 21,4 | 4 | ■ | |
| MP12-12008R24Z4-E03 | 12,0 0.472 | 8,0 0.315 | 2,4 0.094 | 11,5 0.453 | 50 1.969 | 18,8 0.740 | 15,0 | 14,6 | 19,0 | 4 | | ■ |
| MP12-12014R04Z4-M03 | 12,0 0.472 | 14,0 0.551 | 0,4 0.016 | 11,5 0.453 | 50 1.969 | 24,0 0.945 | 15,0 | 14,6 | 23,0 | 4 | ■ | |
| MP12-12014R05Z4-E03 | 12,0 0.472 | 14,0 0.551 | 0,5 0.020 | 11,5 0.453 | 50 1.969 | 24,0 0.945 | 15,0 | 14,6 | 22,8 | 4 | | ■ |
| MP12-12014R08Z4-E03 | 12,0 0.472 | 14,0 0.551 | 0,8 0.031 | 11,5 0.453 | 50 1.969 | 24,0 0.945 | 15,0 | 14,6 | 22,2 | 4 | | ■ |
| MP12-12014R08Z4-M03 | 12,0 0.472 | 14,0 0.551 | 0,8 0.031 | 11,5 0.453 | 50 1.969 | 24,0 0.945 | 15,0 | 14,6 | 22,2 | 4 | ■ | |
| MP12-12014R12Z4-E03 | 12,0 0.472 | 14,0 0.551 | 1,2 0.047 | 11,5 0.453 | 50 1.969 | 24,0 0.945 | 15,0 | 14,6 | 21,4 | 4 | | ■ |
| MP12-12014R12Z4-M03 | 12,0 0.472 | 14,0 0.551 | 1,2 0.047 | 11,5 0.453 | 50 1.969 | 24,0 0.945 | 15,0 | 14,6 | 21,4 | 4 | ■ | |
| MP12-12014R16Z4-E03 | 12,0 0.472 | 14,0 0.551 | 1,6 0.063 | 11,5 0.453 | 50 1.969 | 24,0 0.945 | 15,0 | 14,6 | 20,6 | 4 | | ■ |
| MP12-12714R04Z4-E03 | 12,7 0.500 | 14,0 0.551 | 0,4 0.016 | 11,5 0.453 | 50 1.969 | 24,0 0.945 | 15,0 | 15,4 | 24,4 | 4 | | ■ |
| MP12-12714R04Z4-M03 | 12,7 0.500 | 14,0 0.551 | 0,4 0.016 | 11,5 0.453 | 50 1.969 | 24,0 0.945 | 15,0 | 15,4 | 24,4 | 4 | ■ | |
| MP12-12714R08Z4-E03 | 12,7 0.500 | 14,0 0.551 | 0,8 0.031 | 11,5 0.453 | 50 1.969 | 24,0 0.945 | 15,0 | 15,4 | 23,9 | 4 | | ■ |
| MP12-12714R08Z4-M03 | 12,7 0.500 | 14,0 0.551 | 0,8 0.031 | 11,5 0.453 | 50 1.969 | 24,0 0.945 | 15,0 | 15,4 | 23,6 | 4 | ■ | |

Unversell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Graphit

X-Heads

Minimaster Plus

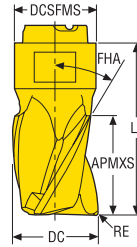
Minimaster

Universell

MP12 Eckfräser

Nur Konturfräsen

Stahl und Guss



Rostfrei und ISO-S-Werkstoffe

- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 608-609

Z6



NE-Metalle

| Bezeichnung | DC | APMXS | RE | DCSFMS | LF | FHA | ZAFP | Beschichtung | |
|---------------------|---------------|---------------|--------------|---------------|---------------|-----|------|--------------|--------------|
| | | | | | | | | Beschichtet | Beschichtung |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | MP3000 | F40M |
| MP12-12014R04Z6-M03 | 12,0 0.472 | 14,0 0.551 | 0,4 0.016 | 11,5 0.453 | 24,0 0.945 | 40 | 6 | ■ | |
| MP12-12714R04Z6-M03 | 12,7 0.500 | 14,0 0.551 | 0,4 0.016 | 11,5 0.453 | 24,0 0.945 | 40 | 6 | ■ | |

Harter

Kunststoffe und Composite

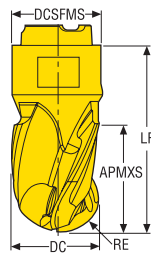
Graphit

X-Heads

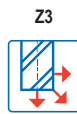
Minimaster Plus

Minimaster

MP12 Kugelkopffräser



• Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 610-611



| Bezeichnung | DC | APMXS | RE | DCSFMS | LF | FHA | RMPX° | ZEPF | Beschichtung | |
|---------------------|---------------|---------------|---------------|---------------|---------------|-----|-------|------|--------------|-------------|
| | | | | | | | | | Beschichtet | Beschichtet |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | MP3000 | F40M |
| MP12-12008B90Z3-E04 | 12,0 0.472 | 8,0 0.315 | 6,0 0.236 | 11,5 0.453 | 18,8 0.740 | 30 | 15,0 | 3 | | ■ |
| MP12-12008B90Z3-M04 | 12,0 0.472 | 8,0 0.315 | 6,0 0.236 | 11,5 0.453 | 18,8 0.740 | 30 | 15,0 | 3 | ■ | |
| MP12-12008B90Z4-E03 | 12,0 0.472 | 8,0 0.315 | 6,0 0.236 | 11,5 0.453 | 18,7 0.736 | 20 | 15,0 | 4 | | ■ |
| MP12-12008B90Z4-M03 | 12,0 0.472 | 8,0 0.315 | 6,0 0.236 | 11,5 0.453 | 18,7 0.736 | 20 | 15,0 | 4 | ■ | |
| MP12-12014B90Z3-E04 | 12,0 0.472 | 14,0 0.551 | 6,0 0.236 | 11,5 0.453 | 24,0 0.945 | 30 | 15,0 | 3 | | ■ |
| MP12-12014B90Z3-M04 | 12,0 0.472 | 14,0 0.551 | 6,0 0.236 | 11,5 0.453 | 24,0 0.945 | 30 | 15,0 | 3 | ■ | |
| MP12-12708B90Z3-E04 | 12,7 0.500 | 8,0 0.315 | 6,35 0.250 | 11,5 0.453 | 18,8 0.740 | 30 | 15,0 | 3 | | ■ |
| MP12-12708B90Z3-M04 | 12,7 0.500 | 8,0 0.315 | 6,35 0.250 | 11,5 0.453 | 18,8 0.740 | 30 | 15,0 | 3 | ■ | |
| MP12-12708B90Z4-E03 | 12,7 0.500 | 8,0 0.315 | 6,35 0.250 | 11,5 0.453 | 18,7 0.736 | 20 | 15,0 | 4 | | ■ |
| MP12-12708B90Z4-M03 | 12,7 0.500 | 8,0 0.315 | 6,35 0.250 | 11,5 0.453 | 18,7 0.736 | 20 | 15,0 | 4 | ■ | |
| MP12-12714B90Z3-E04 | 12,7 0.500 | 14,0 0.551 | 6,35 0.250 | 11,5 0.453 | 24,0 0.945 | 30 | 15,0 | 3 | | ■ |
| MP12-12714B90Z3-M04 | 12,7 0.500 | 14,0 0.551 | 6,35 0.250 | 11,5 0.453 | 24,0 0.945 | 30 | 15,0 | 3 | ■ | |

Unversell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

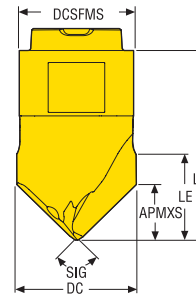
Graphit

X-Heads

Minimaster Plus

Minimaster

MP12 Zentrierbohren



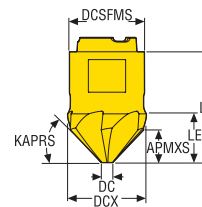
• Auswahl der Wendschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 612-613

Z2



| Bezeichnung | DC | APMXS | DCSFMS | LE | LF | SIG° | ZEFP | | Beschichtung | |
|---------------------|---------------|--------------|---------------|--------------|---------------|------|------|--|--------------|-------------|
| | | | | | | | | | Beschichtet | Beschichtet |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | MP3000 | F40M |
| MP12-12007C90Z2-M04 | 12,0 0.472 | 5,6 0.220 | 11,5 0.453 | 8,7 0.343 | 19,0 0.748 | 90,0 | 2 | | | ■ |

MP12 Anfasen



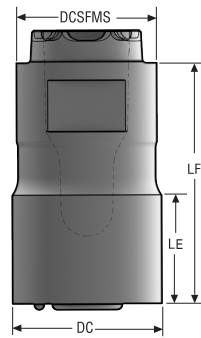
• Auswahl der Wendschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 614-615

Z6




| Bezeichnung | DCX | DC | APMXS | DCSFMS | LE | LF | KAPRS° | ZEFP | | Beschichtung | |
|---------------------|---------------|---------------|--------------|---------------|--------------|---------------|--------|------|--|--------------|-------------|
| | | | | | | | | | | Beschichtet | Beschichtet |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | MP3000 | F40M |
| MP12-12007C90Z6-M04 | 12,1 0.476 | 2,95 0.116 | 4,4 0.173 | 11,5 0.453 | 7,5 0.295 | 18,0 0.709 | 45,0 | 6 | | | ■ |

MP12 Zylindrische Rohlinge



• Zylindrische Hartmetall-Rohlinge zur Herstellung eigener Geometrien



| Bezeichnung | DC | DCSFMS | LE | LF | Beschichtung | |
|--------------------|----------------|---------------|---------------|----------------|---|---------------|
| | | | | |  | Unbeschichtet |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | H25 |
| MP12-12008CYL-SEMI | 12,95 0.510 | 11,5 0.453 | 9,4 0.370 | 19,35 0.762 | | ■ |
| MP12-12014CYL-SEMI | 12,95 0.510 | 11,5 0.453 | 14,3 0.563 | 24,15 0.951 | | ■ |

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Graphit

X-Heads

Minimaster Plus

Minimaster

MP12 Hochvorschubfräsen – Auswahl der Wendschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|-----------------------------|----------------|----------------|-------|-------|-------|
| | | | 100% | 70% | 30% | 20% |
| P1 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,55 | 0,55 | 0,70 | 0,90 |
| | | 0,019 | 0,022 | 0,022 | 0,028 | 0,036 |
| P2 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,55 | 0,55 | 0,75 | 0,90 |
| | | 0,019 | 0,022 | 0,022 | 0,030 | 0,036 |
| P3 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,55 | 0,55 | 0,70 | 0,85 |
| | | 0,019 | 0,022 | 0,022 | 0,028 | 0,034 |
| P4 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,50 | 0,50 | 0,70 | 0,85 |
| | | 0,019 | 0,020 | 0,020 | 0,028 | 0,034 |
| P5 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,50 | 0,50 | 0,65 | 0,80 |
| | | 0,019 | 0,020 | 0,020 | 0,026 | 0,032 |
| P6 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,50 | 0,50 | 0,65 | 0,80 |
| | | 0,019 | 0,020 | 0,020 | 0,026 | 0,032 |
| P7 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,50 | 0,50 | 0,65 | 0,80 |
| | | 0,019 | 0,020 | 0,020 | 0,026 | 0,032 |
| P8 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,55 | 0,55 | 0,70 | 0,85 |
| | | 0,019 | 0,022 | 0,022 | 0,028 | 0,034 |
| P11 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,50 | 0,50 | 0,65 | 0,80 |
| | | 0,019 | 0,020 | 0,020 | 0,026 | 0,032 |
| P12 | MP12-1200.7HFZ3-MD10 MP3000 | 0,40 | 0,36 | 0,34 | 0,44 | 0,55 |
| | | 0,016 | 0,014 | 0,013 | 0,017 | 0,022 |
| M1 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,55 | 0,55 | 0,75 | 0,90 |
| | | 0,019 | 0,022 | 0,022 | 0,030 | 0,036 |
| M2 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,50 | 0,50 | 0,65 | 0,80 |
| | | 0,019 | 0,020 | 0,020 | 0,026 | 0,032 |
| M3 | MP12-1200.7HFZ3-MD10 MP3000 | 0,40 | 0,42 | 0,42 | 0,55 | 0,65 |
| | | 0,016 | 0,017 | 0,017 | 0,022 | 0,026 |
| M4 | MP12-1200.7HFZ3-MD10 MP3000 | 0,30 | 0,36 | 0,36 | 0,46 | 0,55 |
| | | 0,012 | 0,014 | 0,014 | 0,018 | 0,022 |
| M5 | MP12-1200.7HFZ3-MD10 MP3000 | 0,30 | 0,36 | 0,36 | 0,46 | 0,55 |
| | | 0,012 | 0,014 | 0,014 | 0,018 | 0,022 |
| K1 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,55 | 0,55 | 0,75 | 0,90 |
| | | 0,019 | 0,022 | 0,022 | 0,030 | 0,036 |
| K2 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,50 | 0,50 | 0,65 | 0,80 |
| | | 0,019 | 0,020 | 0,020 | 0,026 | 0,032 |
| K3 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,50 | 0,50 | 0,65 | 0,80 |
| | | 0,019 | 0,020 | 0,020 | 0,026 | 0,032 |
| K4 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,50 | 0,50 | 0,65 | 0,80 |
| | | 0,019 | 0,020 | 0,020 | 0,026 | 0,032 |
| K5 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,46 | 0,46 | 0,60 | 0,75 |
| | | 0,019 | 0,018 | 0,018 | 0,024 | 0,030 |
| K6 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,50 | 0,50 | 0,65 | 0,80 |
| | | 0,019 | 0,020 | 0,020 | 0,026 | 0,032 |
| K7 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,46 | 0,46 | 0,60 | 0,75 |
| | | 0,019 | 0,018 | 0,018 | 0,024 | 0,030 |
| N1 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,70 | 0,70 | 0,95 | 1,2 |
| | | 0,019 | 0,028 | 0,028 | 0,038 | 0,048 |
| N2 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,70 | 0,70 | 0,95 | 1,2 |
| | | 0,019 | 0,028 | 0,028 | 0,038 | 0,048 |
| N3 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,70 | 0,70 | 0,95 | 1,2 |
| | | 0,019 | 0,028 | 0,028 | 0,038 | 0,048 |
| N11 | MP12-1200.7HFZ3-MD10 MP3000 | 0,48 | 0,70 | 0,70 | 0,95 | 1,2 |
| | | 0,019 | 0,028 | 0,028 | 0,038 | 0,048 |
| S1 | MP12-1200.7HFZ3-MD10 MP3000 | 0,30 | 0,36 | 0,36 | 0,46 | 0,55 |
| | | 0,012 | 0,014 | 0,014 | 0,018 | 0,022 |
| S2 | MP12-1200.7HFZ3-MD10 MP3000 | 0,30 | 0,36 | 0,36 | 0,46 | 0,55 |
| | | 0,012 | 0,014 | 0,014 | 0,018 | 0,022 |
| S3 | MP12-1200.7HFZ3-MD10 MP3000 | 0,30 | 0,34 | 0,34 | 0,42 | 0,50 |
| | | 0,012 | 0,013 | 0,013 | 0,017 | 0,020 |
| S11 | MP12-1200.7HFZ3-MD10 MP3000 | 0,34 | 0,42 | 0,42 | 0,55 | 0,65 |
| | | 0,013 | 0,017 | 0,017 | 0,022 | 0,026 |
| S12 | MP12-1200.7HFZ3-MD10 MP3000 | 0,34 | 0,42 | 0,42 | 0,55 | 0,65 |
| | | 0,013 | 0,017 | 0,017 | 0,022 | 0,026 |
| S13 | MP12-1200.7HFZ3-MD10 MP3000 | 0,30 | 0,36 | 0,36 | 0,46 | 0,55 |
| | | 0,012 | 0,014 | 0,014 | 0,018 | 0,022 |
| H5 | MP12-1200.7HFZ3-MD10 MP3000 | 0,40 | 0,36 | 0,34 | 0,44 | 0,55 |
| | | 0,016 | 0,014 | 0,013 | 0,017 | 0,022 |
| H8 | MP12-1200.7HFZ3-MD10 MP3000 | 0,34 | 0,28 | 0,26 | 0,34 | 0,40 |
| | | 0,013 | 0,011 | 0,010 | 0,013 | 0,016 |
| H11 | MP12-1200.7HFZ3-MD10 MP3000 | 0,40 | 0,36 | 0,34 | 0,44 | 0,55 |
| | | 0,016 | 0,014 | 0,013 | 0,017 | 0,022 |
| H12 | MP12-1200.7HFZ3-MD10 MP3000 | 0,34 | 0,28 | 0,26 | 0,34 | 0,40 |
| | | 0,013 | 0,011 | 0,010 | 0,013 | 0,016 |
| H21 | MP12-1200.7HFZ3-MD10 MP3000 | 0,34 | 0,28 | 0,26 | 0,34 | 0,40 |
| | | 0,013 | 0,011 | 0,010 | 0,013 | 0,016 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MP12 Hochvorschubfräsen – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | MP3000 | | | | |
|-----|--------|------|------|------|-------------------------------|
| | 100% | 70% | 30% | 20% | |
| P1 | 240 | 295 | 340 | 355 | Universell |
| | 790 | 970 | 1125 | 1175 | |
| P2 | 235 | 285 | 325 | 345 | Stahl und Guss |
| | 770 | 940 | 1075 | 1125 | |
| P3 | 205 | 245 | 285 | 300 | Stahl und Guss |
| | 670 | 800 | 940 | 980 | |
| P4 | 185 | 220 | 250 | 265 | Stahl und Guss |
| | 610 | 720 | 820 | 870 | |
| P5 | 175 | 210 | 245 | 255 | Stahl und Guss |
| | 570 | 690 | 800 | 840 | |
| P6 | 195 | 240 | 275 | 290 | Stahl und Guss |
| | 640 | 790 | 900 | 950 | |
| P7 | 185 | 225 | 260 | 275 | Rostfrei und ISO-S-Werkstoffe |
| | 610 | 740 | 850 | 900 | |
| P8 | 170 | 205 | 240 | 255 | Rostfrei und ISO-S-Werkstoffe |
| | 560 | 670 | 790 | 840 | |
| P11 | 180 | 220 | 250 | 265 | Rostfrei und ISO-S-Werkstoffe |
| | 590 | 720 | 820 | 870 | |
| P12 | 115 | 140 | 160 | 170 | Rostfrei und ISO-S-Werkstoffe |
| | 375 | 460 | 520 | 560 | |
| M1 | 175 | 215 | 245 | 260 | Rostfrei und ISO-S-Werkstoffe |
| | 570 | 710 | 800 | 850 | |
| M2 | 145 | 175 | 205 | 215 | Rostfrei und ISO-S-Werkstoffe |
| | 475 | 570 | 670 | 710 | |
| M3 | 120 | 140 | 160 | 170 | Rostfrei und ISO-S-Werkstoffe |
| | 395 | 460 | 520 | 560 | |
| M4 | 95 | 110 | 125 | 135 | Rostfrei und ISO-S-Werkstoffe |
| | 310 | 360 | 410 | 445 | |
| M5 | 80 | 90 | 105 | 110 | NE-Metalle |
| | 260 | 295 | 345 | 360 | |
| K1 | 185 | 225 | 260 | 275 | NE-Metalle |
| | 610 | 740 | 850 | 900 | |
| K2 | 165 | 200 | 230 | 245 | NE-Metalle |
| | 540 | 660 | 750 | 800 | |
| K3 | 140 | 170 | 195 | 205 | NE-Metalle |
| | 460 | 560 | 640 | 670 | |
| K4 | 135 | 160 | 190 | 195 | NE-Metalle |
| | 445 | 520 | 620 | 640 | |
| K5 | 80 | 100 | 115 | 120 | Harter |
| | 260 | 330 | 375 | 395 | |
| K6 | 120 | 145 | 165 | 175 | Harter |
| | 395 | 475 | 540 | 570 | |
| K7 | 105 | 125 | 145 | 150 | Harter |
| | 345 | 410 | 475 | 490 | |
| N1 | 1400 | 1700 | 1925 | 2025 | Graphit |
| | 4600 | 5575 | 6325 | 6650 | |
| N2 | 560 | 680 | 780 | 820 | Graphit |
| | 1825 | 2225 | 2550 | 2700 | |
| N3 | 375 | 455 | 520 | 540 | Graphit |
| | 1225 | 1500 | 1700 | 1775 | |
| N11 | 430 | 520 | 600 | 620 | Graphit |
| | 1400 | 1700 | 1975 | 2025 | |
| S1 | 44 | 50 | 60 | 60 | X-Heads |
| | 145 | 165 | 195 | 195 | |
| S2 | 35 | 41 | 47 | 50 | X-Heads |
| | 115 | 135 | 155 | 165 | |
| S3 | 31 | 36 | 42 | 44 | X-Heads |
| | 100 | 120 | 140 | 145 | |
| S11 | 60 | 70 | 80 | 85 | X-Heads |
| | 195 | 230 | 260 | 280 | |
| S12 | 42 | 49 | 55 | 60 | X-Heads |
| | 140 | 160 | 180 | 195 | |
| S13 | 25 | 29 | 33 | 35 | X-Heads |
| | 80 | 95 | 110 | 115 | |
| H5 | 36 | 44 | 50 | 55 | Minimaster Plus |
| | 120 | 145 | 165 | 180 | |
| H8 | 39 | 46 | 55 | 55 | Minimaster Plus |
| | 130 | 150 | 180 | 180 | |
| H11 | 46 | 55 | 65 | 65 | Minimaster Plus |
| | 150 | 180 | 215 | 215 | |
| H12 | 75 | 90 | 100 | 110 | Minimaster Plus |
| | 245 | 295 | 330 | 360 | |
| H21 | 39 | 46 | 55 | 55 | Minimaster |
| | 130 | 150 | 180 | 180 | |

MP12 Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|----------------------------|----------------|----------------|--------|--------|--------|
| | | | 100% | 30% | 10% | 5% |
| P1 | MP12-12008R04Z3-M04 MP3000 | 4,0 | 0,055 | 0,060 | 0,095 | 0,13 |
| | | 0,16 | 0,0022 | 0,0024 | 0,0038 | 0,0050 |
| P2 | MP12-12008R04Z3-M04 MP3000 | 4,0 | 0,055 | 0,065 | 0,095 | 0,13 |
| | | 0,16 | 0,0022 | 0,0026 | 0,0038 | 0,0050 |
| P3 | MP12-12008R04Z3-M04 MP3000 | 4,0 | 0,055 | 0,060 | 0,090 | 0,13 |
| | | 0,16 | 0,0022 | 0,0024 | 0,0036 | 0,0050 |
| P4 | MP12-12008R04Z3-M04 MP3000 | 4,0 | 0,055 | 0,060 | 0,090 | 0,12 |
| | | 0,16 | 0,0022 | 0,0024 | 0,0036 | 0,0048 |
| P5 | MP12-12008R04Z3-M04 MP3000 | 4,0 | 0,050 | 0,055 | 0,090 | 0,12 |
| | | 0,16 | 0,0020 | 0,0022 | 0,0036 | 0,0048 |
| P6 | MP12-12008R04Z3-M04 MP3000 | 4,0 | 0,050 | 0,055 | 0,085 | 0,12 |
| | | 0,16 | 0,0020 | 0,0022 | 0,0034 | 0,0048 |
| P7 | MP12-12008R04Z3-M04 MP3000 | 4,0 | 0,050 | 0,055 | 0,085 | 0,12 |
| | | 0,16 | 0,0020 | 0,0022 | 0,0034 | 0,0048 |
| P8 | MP12-12008R04Z3-M04 MP3000 | 4,0 | 0,055 | 0,060 | 0,090 | 0,13 |
| | | 0,16 | 0,0022 | 0,0024 | 0,0036 | 0,0050 |
| P11 | MP12-12008R04Z3-M04 MP3000 | 4,0 | 0,050 | 0,055 | 0,085 | 0,12 |
| | | 0,16 | 0,0020 | 0,0022 | 0,0034 | 0,0048 |
| P12 | MP12-12008R08Z3-M04 MP3000 | 3,0 | 0,036 | 0,040 | 0,060 | 0,085 |
| | | 0,12 | 0,0014 | 0,0016 | 0,0024 | 0,0034 |
| M1 | MP12-12008R04Z3-E04 F40M | 4,0 | 0,055 | 0,065 | 0,095 | 0,13 |
| | | 0,16 | 0,0022 | 0,0026 | 0,0038 | 0,0050 |
| M2 | MP12-12008R04Z3-E04 F40M | 4,0 | 0,050 | 0,055 | 0,090 | 0,12 |
| | | 0,16 | 0,0020 | 0,0022 | 0,0036 | 0,0048 |
| M3 | MP12-12008R04Z3-E04 F40M | 3,0 | 0,042 | 0,046 | 0,070 | 0,095 |
| | | 0,12 | 0,0017 | 0,0018 | 0,0028 | 0,0038 |
| M4 | MP12-12008R04Z3-E04 F40M | 2,5 | 0,036 | 0,040 | 0,060 | 0,085 |
| | | 0,10 | 0,0014 | 0,0016 | 0,0024 | 0,0034 |
| M5 | MP12-12008R04Z3-E04 F40M | 2,5 | 0,036 | 0,040 | 0,060 | 0,085 |
| | | 0,10 | 0,0014 | 0,0016 | 0,0024 | 0,0034 |
| K1 | MP12-12008R04Z3-M04 MP3000 | 4,0 | 0,055 | 0,065 | 0,095 | 0,13 |
| | | 0,16 | 0,0022 | 0,0026 | 0,0038 | 0,0050 |
| K2 | MP12-12008R04Z3-M04 MP3000 | 4,0 | 0,050 | 0,055 | 0,090 | 0,12 |
| | | 0,16 | 0,0020 | 0,0022 | 0,0036 | 0,0048 |
| K3 | MP12-12008R04Z3-M04 MP3000 | 4,0 | 0,050 | 0,055 | 0,090 | 0,12 |
| | | 0,16 | 0,0020 | 0,0022 | 0,0036 | 0,0048 |
| K4 | MP12-12008R04Z3-M04 MP3000 | 4,0 | 0,050 | 0,055 | 0,090 | 0,12 |
| | | 0,16 | 0,0020 | 0,0022 | 0,0036 | 0,0048 |
| K5 | MP12-12008R04Z3-M04 MP3000 | 4,0 | 0,048 | 0,050 | 0,080 | 0,11 |
| | | 0,16 | 0,0019 | 0,0020 | 0,0032 | 0,0044 |
| K6 | MP12-12008R04Z3-M04 MP3000 | 4,0 | 0,050 | 0,055 | 0,090 | 0,12 |
| | | 0,16 | 0,0020 | 0,0022 | 0,0036 | 0,0048 |
| K7 | MP12-12008R04Z3-M04 MP3000 | 4,0 | 0,048 | 0,050 | 0,080 | 0,11 |
| | | 0,16 | 0,0019 | 0,0020 | 0,0032 | 0,0044 |
| N1 | MP12-12008R04Z3-E04 F40M | 4,0 | 0,075 | 0,080 | 0,12 | 0,17 |
| | | 0,16 | 0,0030 | 0,0032 | 0,0048 | 0,0065 |
| N2 | MP12-12008R04Z3-E04 F40M | 4,0 | 0,075 | 0,080 | 0,12 | 0,17 |
| | | 0,16 | 0,0030 | 0,0032 | 0,0048 | 0,0065 |
| N3 | MP12-12008R04Z3-E04 F40M | 4,0 | 0,075 | 0,080 | 0,12 | 0,17 |
| | | 0,16 | 0,0030 | 0,0032 | 0,0048 | 0,0065 |
| N11 | MP12-12008R04Z3-E04 F40M | 4,0 | 0,075 | 0,080 | 0,12 | 0,17 |
| | | 0,16 | 0,0030 | 0,0032 | 0,0048 | 0,0065 |
| S1 | MP12-12008R04Z3-E04 F40M | 2,5 | 0,036 | 0,040 | 0,060 | 0,085 |
| | | 0,10 | 0,0014 | 0,0016 | 0,0024 | 0,0034 |
| S2 | MP12-12008R04Z3-E04 F40M | 2,5 | 0,036 | 0,040 | 0,060 | 0,085 |
| | | 0,10 | 0,0014 | 0,0016 | 0,0024 | 0,0034 |
| S3 | MP12-12008R04Z3-E04 F40M | 2,5 | 0,034 | 0,038 | 0,055 | 0,080 |
| | | 0,10 | 0,0013 | 0,0015 | 0,0022 | 0,0032 |
| S11 | MP12-12008R04Z3-E04 F40M | 2,5 | 0,042 | 0,046 | 0,070 | 0,095 |
| | | 0,10 | 0,0017 | 0,0018 | 0,0028 | 0,0038 |
| S12 | MP12-12008R04Z3-E04 F40M | 2,5 | 0,042 | 0,046 | 0,070 | 0,095 |
| | | 0,10 | 0,0017 | 0,0018 | 0,0028 | 0,0038 |
| S13 | MP12-12008R04Z3-E04 F40M | 2,5 | 0,036 | 0,040 | 0,060 | 0,085 |
| | | 0,10 | 0,0014 | 0,0016 | 0,0024 | 0,0034 |
| H5 | MP12-12008R04Z3-M04 MP3000 | 3,0 | 0,036 | 0,038 | 0,060 | 0,080 |
| | | 0,12 | 0,0014 | 0,0015 | 0,0024 | 0,0032 |
| H8 | MP12-12008R04Z3-M04 MP3000 | 2,5 | 0,028 | 0,030 | 0,046 | 0,065 |
| | | 0,10 | 0,0011 | 0,0012 | 0,0018 | 0,0026 |
| H11 | MP12-12008R04Z3-M04 MP3000 | 3,0 | 0,036 | 0,038 | 0,060 | 0,080 |
| | | 0,12 | 0,0014 | 0,0015 | 0,0024 | 0,0032 |
| H12 | MP12-12008R04Z3-M04 MP3000 | 2,5 | 0,028 | 0,030 | 0,046 | 0,065 |
| | | 0,10 | 0,0011 | 0,0012 | 0,0018 | 0,0026 |
| H21 | MP12-12008R04Z3-M04 MP3000 | 2,5 | 0,028 | 0,030 | 0,046 | 0,065 |
| | | 0,10 | 0,0011 | 0,0012 | 0,0018 | 0,0026 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MP12 Nut- und Eckfräsen – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | MP3000 | | | | F40M | | | |
|-----|--------|------|------|------|------|------|------|------|
| | 100% | 30% | 10% | 5% | 100% | 30% | 10% | 5% |
| P1 | 250 | 325 | 380 | 415 | 235 | 310 | 360 | 390 |
| | 820 | 1075 | 1250 | 1350 | 770 | 1025 | 1175 | 1275 |
| P2 | 240 | 315 | 370 | 405 | 225 | 295 | 350 | 380 |
| | 790 | 1025 | 1225 | 1325 | 740 | 970 | 1150 | 1250 |
| P3 | 210 | 275 | 320 | 345 | 200 | 260 | 305 | 325 |
| | 690 | 900 | 1050 | 1125 | 660 | 850 | 1000 | 1075 |
| P4 | 185 | 240 | 285 | 310 | 175 | 230 | 270 | 295 |
| | 610 | 790 | 940 | 1025 | 570 | 750 | 890 | 970 |
| P5 | 180 | 235 | 275 | 295 | 170 | 220 | 260 | 280 |
| | 590 | 770 | 900 | 970 | 560 | 720 | 850 | 920 |
| P6 | 200 | 265 | 310 | 330 | 190 | 250 | 290 | 315 |
| | 660 | 870 | 1025 | 1075 | 620 | 820 | 950 | 1025 |
| P7 | 190 | 250 | 290 | 315 | 180 | 235 | 275 | 295 |
| | 620 | 820 | 950 | 1025 | 590 | 770 | 900 | 970 |
| P8 | 175 | 230 | 270 | 290 | 165 | 215 | 255 | 275 |
| | 570 | 750 | 890 | 950 | 540 | 710 | 840 | 900 |
| P11 | 185 | 240 | 280 | 305 | 175 | 230 | 265 | 290 |
| | 610 | 790 | 920 | 1000 | 570 | 750 | 870 | 950 |
| P12 | 115 | 150 | 175 | 195 | 110 | 145 | 165 | 180 |
| | 375 | 490 | 570 | 640 | 360 | 475 | 540 | 590 |
| M1 | 180 | 235 | 275 | 300 | 180 | 240 | 280 | 305 |
| | 590 | 770 | 900 | 980 | 590 | 790 | 920 | 1000 |
| M2 | 150 | 195 | 230 | 245 | 150 | 200 | 235 | 250 |
| | 490 | 640 | 750 | 800 | 490 | 660 | 770 | 820 |
| M3 | 120 | 155 | 180 | 195 | 120 | 155 | 185 | 200 |
| | 395 | 510 | 590 | 640 | 395 | 510 | 610 | 660 |
| M4 | 90 | 120 | 140 | 150 | 95 | 120 | 140 | 155 |
| | 295 | 395 | 460 | 490 | 310 | 395 | 460 | 510 |
| M5 | 75 | 100 | 115 | 125 | 75 | 100 | 120 | 125 |
| | 245 | 330 | 375 | 410 | 245 | 330 | 395 | 410 |
| K1 | 190 | 250 | 295 | 320 | 180 | 235 | 275 | 300 |
| | 620 | 820 | 970 | 1050 | 590 | 770 | 900 | 980 |
| K2 | 170 | 220 | 260 | 280 | 160 | 210 | 245 | 265 |
| | 560 | 720 | 850 | 920 | 520 | 690 | 800 | 870 |
| K3 | 145 | 190 | 220 | 240 | 135 | 180 | 210 | 225 |
| | 475 | 620 | 720 | 790 | 445 | 590 | 690 | 740 |
| K4 | 140 | 180 | 210 | 225 | 130 | 170 | 200 | 215 |
| | 460 | 590 | 690 | 740 | 425 | 560 | 660 | 710 |
| K5 | 85 | 110 | 125 | 135 | 80 | 105 | 120 | 130 |
| | 280 | 360 | 410 | 445 | 260 | 345 | 395 | 425 |
| K6 | 120 | 160 | 185 | 200 | 115 | 150 | 175 | 190 |
| | 395 | 520 | 610 | 660 | 375 | 490 | 570 | 620 |
| K7 | 105 | 140 | 160 | 175 | 100 | 130 | 155 | 165 |
| | 345 | 460 | 520 | 570 | 330 | 425 | 510 | 540 |
| N1 | 1425 | 1875 | 2200 | 2375 | 1350 | 1775 | 2100 | 2250 |
| | 4675 | 6150 | 7225 | 7800 | 4425 | 5825 | 6900 | 7375 |
| N2 | 570 | 760 | 890 | 960 | 540 | 720 | 840 | 910 |
| | 1875 | 2500 | 2925 | 3150 | 1775 | 2350 | 2750 | 2975 |
| N3 | 385 | 500 | 600 | 640 | 360 | 475 | 560 | 610 |
| | 1275 | 1650 | 1975 | 2100 | 1175 | 1550 | 1825 | 2000 |
| N11 | 440 | 580 | 680 | 730 | 415 | 540 | 640 | 690 |
| | 1450 | 1900 | 2225 | 2400 | 1350 | 1775 | 2100 | 2275 |
| S1 | 43 | 55 | 65 | 70 | 43 | 55 | 65 | 70 |
| | 140 | 180 | 215 | 230 | 140 | 180 | 215 | 230 |
| S2 | 34 | 45 | 50 | 55 | 35 | 46 | 55 | 55 |
| | 110 | 150 | 165 | 180 | 115 | 150 | 180 | 180 |
| S3 | 30 | 39 | 46 | 49 | 31 | 40 | 46 | 50 |
| | 100 | 130 | 150 | 160 | 100 | 130 | 150 | 165 |
| S11 | 60 | 80 | 90 | 100 | 60 | 80 | 95 | 100 |
| | 195 | 260 | 295 | 330 | 195 | 260 | 310 | 330 |
| S12 | 42 | 55 | 65 | 70 | 42 | 55 | 65 | 70 |
| | 140 | 180 | 215 | 230 | 140 | 180 | 215 | 230 |
| S13 | 24 | 31 | 36 | 39 | 24 | 32 | 37 | 40 |
| | 80 | 100 | 120 | 130 | 80 | 105 | 120 | 130 |
| H5 | 36 | 47 | 55 | 60 | 36 | 48 | 55 | 60 |
| | 120 | 155 | 180 | 195 | 120 | 155 | 180 | 195 |
| H8 | 38 | 49 | 55 | 60 | 38 | 50 | 60 | 60 |
| | 125 | 160 | 180 | 195 | 125 | 165 | 195 | 195 |
| H11 | 46 | 60 | 70 | 75 | 46 | 60 | 70 | 75 |
| | 150 | 195 | 230 | 245 | 150 | 195 | 230 | 245 |
| H12 | 70 | 95 | 110 | 120 | 70 | 90 | 105 | 110 |
| | 230 | 310 | 360 | 395 | 230 | 295 | 345 | 360 |
| H21 | 38 | 49 | 55 | 60 | 38 | 50 | 60 | 60 |
| | 125 | 160 | 180 | 195 | 125 | 165 | 195 | 195 |

Universell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MP12 Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | | | |
|---------------------------|----------------------------|----------------------------|----------------|--------|--------|--------|--------|--------|
| | | | 100% | 30% | 10% | 5% | 2% | |
| Universell | P1 | MP12-12008B90Z3-M04 MP3000 | 4,0 | 0,065 | 0,065 | 0,10 | 0,14 | 0,22 |
| | | | 0,16 | 0,0026 | 0,0026 | 0,0040 | 0,0055 | 0,0085 |
| | P2 | MP12-12008B90Z3-M04 MP3000 | 4,0 | 0,065 | 0,070 | 0,10 | 0,14 | 0,22 |
| | | | 0,16 | 0,0026 | 0,0028 | 0,0040 | 0,0055 | 0,0085 |
| | P3 | MP12-12008B90Z3-M04 MP3000 | 4,0 | 0,060 | 0,065 | 0,095 | 0,13 | 0,22 |
| | | | 0,16 | 0,0024 | 0,0026 | 0,0038 | 0,0050 | 0,0085 |
| | P4 | MP12-12008B90Z3-M04 MP3000 | 4,0 | 0,060 | 0,065 | 0,095 | 0,13 | 0,22 |
| | | | 0,16 | 0,0024 | 0,0026 | 0,0038 | 0,0050 | 0,0085 |
| | P5 | MP12-12008B90Z3-M04 MP3000 | 4,0 | 0,060 | 0,060 | 0,090 | 0,13 | 0,20 |
| | | | 0,16 | 0,0024 | 0,0024 | 0,0036 | 0,0050 | 0,0080 |
| | P6 | MP12-12008B90Z3-M04 MP3000 | 4,0 | 0,060 | 0,060 | 0,090 | 0,13 | 0,20 |
| | | | 0,16 | 0,0024 | 0,0024 | 0,0036 | 0,0050 | 0,0080 |
| P7 | MP12-12008B90Z3-M04 MP3000 | 4,0 | 0,060 | 0,060 | 0,090 | 0,13 | 0,20 | |
| | | 0,16 | 0,0024 | 0,0024 | 0,0036 | 0,0050 | 0,0080 | |
| P8 | MP12-12008B90Z3-M04 MP3000 | 4,0 | 0,060 | 0,065 | 0,095 | 0,13 | 0,22 | |
| | | 0,16 | 0,0024 | 0,0026 | 0,0038 | 0,0050 | 0,0085 | |
| P11 | MP12-12008B90Z3-M04 MP3000 | 4,0 | 0,060 | 0,060 | 0,090 | 0,13 | 0,20 | |
| | | 0,16 | 0,0024 | 0,0024 | 0,0036 | 0,0050 | 0,0080 | |
| P12 | MP12-12008B90Z3-M04 MP3000 | 3,0 | 0,044 | 0,044 | 0,060 | 0,085 | 0,14 | |
| | | 0,12 | 0,0017 | 0,0017 | 0,0024 | 0,0034 | 0,0055 | |
| Stahl und Guss | M1 | MP12-12008B90Z3-E04 F40M | 4,0 | 0,065 | 0,070 | 0,10 | 0,14 | 0,22 |
| | | | 0,16 | 0,0026 | 0,0028 | 0,0040 | 0,0055 | 0,0085 |
| | M2 | MP12-12008B90Z3-E04 F40M | 4,0 | 0,060 | 0,060 | 0,090 | 0,13 | 0,20 |
| | | | 0,16 | 0,0024 | 0,0024 | 0,0036 | 0,0050 | 0,0080 |
| | M3 | MP12-12008B90Z3-E04 F40M | 3,0 | 0,050 | 0,050 | 0,075 | 0,10 | 0,16 |
| 0,12 | | | 0,0020 | 0,0020 | 0,0030 | 0,0040 | 0,0065 | |
| M4 | MP12-12008B90Z3-E04 F40M | 2,5 | 0,046 | 0,046 | 0,065 | 0,090 | 0,14 | |
| | | 0,10 | 0,0018 | 0,0018 | 0,0026 | 0,0036 | 0,0055 | |
| M5 | MP12-12008B90Z3-E04 F40M | 2,5 | 0,046 | 0,046 | 0,065 | 0,090 | 0,14 | |
| | | 0,10 | 0,0018 | 0,0018 | 0,0026 | 0,0036 | 0,0055 | |
| NE-Metalle | K1 | MP12-12008B90Z3-M04 MP3000 | 4,0 | 0,065 | 0,070 | 0,10 | 0,14 | 0,22 |
| | | | 0,16 | 0,0026 | 0,0028 | 0,0040 | 0,0055 | 0,0085 |
| | K2 | MP12-12008B90Z3-M04 MP3000 | 4,0 | 0,060 | 0,060 | 0,090 | 0,13 | 0,20 |
| | | | 0,16 | 0,0024 | 0,0024 | 0,0036 | 0,0050 | 0,0080 |
| | K3 | MP12-12008B90Z3-M04 MP3000 | 4,0 | 0,060 | 0,060 | 0,090 | 0,13 | 0,20 |
| | | | 0,16 | 0,0024 | 0,0024 | 0,0036 | 0,0050 | 0,0080 |
| | K4 | MP12-12008B90Z3-M04 MP3000 | 4,0 | 0,060 | 0,060 | 0,090 | 0,13 | 0,20 |
| 0,16 | | | 0,0024 | 0,0024 | 0,0036 | 0,0050 | 0,0080 | |
| K5 | MP12-12008B90Z3-M04 MP3000 | 4,0 | 0,055 | 0,055 | 0,085 | 0,11 | 0,18 | |
| | | 0,16 | 0,0022 | 0,0022 | 0,0034 | 0,0044 | 0,0070 | |
| K6 | MP12-12008B90Z3-M04 MP3000 | 4,0 | 0,060 | 0,060 | 0,090 | 0,13 | 0,20 | |
| | | 0,16 | 0,0024 | 0,0024 | 0,0036 | 0,0050 | 0,0080 | |
| K7 | MP12-12008B90Z3-M04 MP3000 | 4,0 | 0,055 | 0,055 | 0,085 | 0,11 | 0,18 | |
| | | 0,16 | 0,0022 | 0,0022 | 0,0034 | 0,0044 | 0,0070 | |
| Harter | N1 | MP12-12008B90Z3-E04 F40M | 4,0 | 0,085 | 0,085 | 0,13 | 0,18 | 0,30 |
| | | | 0,16 | 0,0034 | 0,0034 | 0,0050 | 0,0070 | 0,012 |
| | N2 | MP12-12008B90Z3-E04 F40M | 4,0 | 0,085 | 0,085 | 0,13 | 0,18 | 0,30 |
| | | | 0,16 | 0,0034 | 0,0034 | 0,0050 | 0,0070 | 0,012 |
| | N3 | MP12-12008B90Z3-E04 F40M | 4,0 | 0,085 | 0,085 | 0,13 | 0,18 | 0,30 |
| 0,16 | | | 0,0034 | 0,0034 | 0,0050 | 0,0070 | 0,012 | |
| N11 | MP12-12008B90Z3-E04 F40M | 4,0 | 0,085 | 0,085 | 0,13 | 0,18 | 0,30 | |
| | | 0,16 | 0,0034 | 0,0034 | 0,0050 | 0,0070 | 0,012 | |
| Kunststoffe und Composite | S1 | MP12-12008B90Z3-E04 F40M | 2,5 | 0,046 | 0,046 | 0,065 | 0,090 | 0,14 |
| | | | 0,10 | 0,0018 | 0,0018 | 0,0026 | 0,0036 | 0,0055 |
| | S2 | MP12-12008B90Z3-E04 F40M | 2,5 | 0,046 | 0,046 | 0,065 | 0,090 | 0,14 |
| | | | 0,10 | 0,0018 | 0,0018 | 0,0026 | 0,0036 | 0,0055 |
| | S3 | MP12-12008B90Z3-E04 F40M | 2,5 | 0,042 | 0,044 | 0,060 | 0,080 | 0,13 |
| 0,10 | | | 0,0017 | 0,0017 | 0,0024 | 0,0032 | 0,0050 | |
| S11 | MP12-12008B90Z3-E04 F40M | 2,5 | 0,055 | 0,050 | 0,075 | 0,10 | 0,16 | |
| | | 0,10 | 0,0022 | 0,0020 | 0,0030 | 0,0040 | 0,0065 | |
| S12 | MP12-12008B90Z3-E04 F40M | 2,5 | 0,055 | 0,050 | 0,075 | 0,10 | 0,16 | |
| | | 0,10 | 0,0022 | 0,0020 | 0,0030 | 0,0040 | 0,0065 | |
| S13 | MP12-12008B90Z3-E04 F40M | 2,5 | 0,046 | 0,046 | 0,065 | 0,090 | 0,14 | |
| | | 0,10 | 0,0018 | 0,0018 | 0,0026 | 0,0036 | 0,0055 | |
| Graphit | H5 | MP12-12008B90Z3-M04 MP3000 | 3,0 | 0,044 | 0,044 | 0,060 | 0,085 | 0,14 |
| | | | 0,12 | 0,0017 | 0,0017 | 0,0024 | 0,0034 | 0,0055 |
| | H8 | MP12-12008B90Z3-M04 MP3000 | 2,5 | 0,034 | 0,034 | 0,048 | 0,065 | 0,10 |
| | | | 0,10 | 0,0013 | 0,0013 | 0,0019 | 0,0026 | 0,0040 |
| | H11 | MP12-12008B90Z3-M04 MP3000 | 3,0 | 0,044 | 0,044 | 0,060 | 0,085 | 0,14 |
| 0,12 | | | 0,0017 | 0,0017 | 0,0024 | 0,0034 | 0,0055 | |
| H12 | MP12-12008B90Z3-M04 MP3000 | 2,5 | 0,034 | 0,034 | 0,048 | 0,065 | 0,10 | |
| | | 0,10 | 0,0013 | 0,0013 | 0,0019 | 0,0026 | 0,0040 | |
| H21 | MP12-12008B90Z3-M04 MP3000 | 2,5 | 0,034 | 0,034 | 0,048 | 0,065 | 0,10 | |
| | | 0,10 | 0,0013 | 0,0013 | 0,0019 | 0,0026 | 0,0040 | |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MP12 Kopierfräsen – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | MP3000 | | | | | F40M | | | | |
|-----|--------|------|------|------|------|------|------|------|------|------|
| | 100% | 30% | 10% | 5% | 2% | 100% | 30% | 10% | 5% | 2% |
| P1 | 265 | 320 | 345 | 375 | 370 | 250 | 300 | 325 | 355 | 350 |
| | 870 | 1050 | 1125 | 1225 | 1225 | 820 | 980 | 1075 | 1175 | 1150 |
| P2 | 255 | 310 | 330 | 360 | 360 | 240 | 295 | 315 | 340 | 340 |
| | 840 | 1025 | 1075 | 1175 | 1175 | 790 | 970 | 1025 | 1125 | 1125 |
| P3 | 220 | 265 | 290 | 315 | 315 | 210 | 255 | 270 | 295 | 295 |
| | 720 | 870 | 950 | 1025 | 1025 | 690 | 840 | 890 | 970 | 970 |
| P4 | 195 | 240 | 255 | 275 | 275 | 185 | 225 | 240 | 260 | 260 |
| | 640 | 790 | 840 | 900 | 900 | 610 | 740 | 790 | 850 | 850 |
| P5 | 190 | 230 | 245 | 265 | 265 | 175 | 215 | 230 | 250 | 250 |
| | 620 | 750 | 800 | 870 | 870 | 570 | 710 | 750 | 820 | 820 |
| P6 | 210 | 255 | 275 | 300 | 295 | 200 | 240 | 260 | 285 | 280 |
| | 690 | 840 | 900 | 980 | 970 | 660 | 790 | 850 | 940 | 920 |
| P7 | 200 | 240 | 260 | 285 | 280 | 190 | 230 | 245 | 265 | 265 |
| | 660 | 790 | 850 | 940 | 920 | 620 | 750 | 800 | 870 | 870 |
| P8 | 185 | 225 | 240 | 265 | 265 | 175 | 210 | 230 | 250 | 250 |
| | 610 | 740 | 790 | 870 | 870 | 570 | 690 | 750 | 820 | 820 |
| P11 | 195 | 235 | 250 | 275 | 270 | 185 | 220 | 240 | 260 | 255 |
| | 640 | 770 | 820 | 900 | 890 | 610 | 720 | 790 | 850 | 840 |
| P12 | 120 | 150 | 160 | 170 | 170 | 115 | 140 | 150 | 160 | 160 |
| | 395 | 490 | 520 | 560 | 560 | 375 | 460 | 490 | 520 | 520 |
| M1 | 190 | 230 | 250 | 270 | 270 | 190 | 235 | 255 | 275 | 275 |
| | 620 | 750 | 820 | 890 | 890 | 620 | 770 | 840 | 900 | 900 |
| M2 | 155 | 190 | 205 | 225 | 220 | 160 | 195 | 210 | 225 | 225 |
| | 510 | 620 | 670 | 740 | 720 | 520 | 640 | 690 | 740 | 740 |
| M3 | 125 | 155 | 160 | 175 | 175 | 130 | 155 | 165 | 180 | 175 |
| | 410 | 510 | 520 | 570 | 570 | 425 | 510 | 540 | 590 | 570 |
| M4 | 100 | 120 | 125 | 135 | 135 | 100 | 120 | 125 | 135 | 135 |
| | 330 | 395 | 410 | 445 | 445 | 330 | 395 | 410 | 445 | 445 |
| M5 | 85 | 100 | 105 | 110 | 110 | 85 | 100 | 105 | 115 | 115 |
| | 280 | 330 | 345 | 360 | 360 | 280 | 330 | 345 | 375 | 375 |
| K1 | 200 | 245 | 265 | 285 | 285 | 190 | 235 | 250 | 270 | 270 |
| | 660 | 800 | 870 | 940 | 940 | 620 | 770 | 820 | 890 | 890 |
| K2 | 180 | 215 | 230 | 255 | 250 | 170 | 205 | 220 | 240 | 235 |
| | 590 | 710 | 750 | 840 | 820 | 560 | 670 | 720 | 790 | 770 |
| K3 | 150 | 185 | 195 | 215 | 210 | 140 | 175 | 185 | 200 | 200 |
| | 490 | 610 | 640 | 710 | 690 | 460 | 570 | 610 | 660 | 660 |
| K4 | 145 | 175 | 185 | 205 | 205 | 135 | 165 | 175 | 195 | 190 |
| | 475 | 570 | 610 | 670 | 670 | 445 | 540 | 570 | 640 | 620 |
| K5 | 85 | 105 | 115 | 125 | 125 | 80 | 100 | 105 | 115 | 115 |
| | 280 | 345 | 375 | 410 | 410 | 260 | 330 | 345 | 375 | 375 |
| K6 | 125 | 155 | 165 | 180 | 180 | 120 | 145 | 155 | 170 | 170 |
| | 410 | 510 | 540 | 590 | 590 | 395 | 475 | 510 | 560 | 560 |
| K7 | 110 | 135 | 145 | 160 | 155 | 105 | 130 | 135 | 150 | 150 |
| | 360 | 445 | 475 | 520 | 510 | 345 | 425 | 445 | 490 | 490 |
| N1 | 1525 | 1850 | 1975 | 2150 | 2150 | 1450 | 1750 | 1875 | 2025 | 2025 |
| | 5000 | 6075 | 6475 | 7050 | 7050 | 4750 | 5750 | 6150 | 6650 | 6650 |
| N2 | 620 | 750 | 800 | 870 | 870 | 580 | 710 | 760 | 820 | 820 |
| | 2025 | 2450 | 2625 | 2850 | 2850 | 1900 | 2325 | 2500 | 2700 | 2700 |
| N3 | 410 | 500 | 530 | 580 | 580 | 390 | 470 | 500 | 550 | 550 |
| | 1350 | 1650 | 1750 | 1900 | 1900 | 1275 | 1550 | 1650 | 1800 | 1800 |
| N11 | 470 | 570 | 610 | 660 | 660 | 445 | 540 | 580 | 620 | 630 |
| | 1550 | 1875 | 2000 | 2175 | 2175 | 1450 | 1775 | 1900 | 2025 | 2075 |
| S1 | 46 | 55 | 60 | 65 | 60 | 47 | 55 | 60 | 65 | 65 |
| | 150 | 180 | 195 | 215 | 195 | 155 | 180 | 195 | 215 | 215 |
| S2 | 37 | 45 | 47 | 50 | 50 | 38 | 45 | 47 | 50 | 50 |
| | 120 | 150 | 155 | 165 | 165 | 125 | 150 | 155 | 165 | 165 |
| S3 | 32 | 39 | 40 | 44 | 44 | 33 | 40 | 41 | 45 | 44 |
| | 105 | 130 | 130 | 145 | 145 | 110 | 130 | 135 | 150 | 145 |
| S11 | 65 | 80 | 80 | 90 | 90 | 65 | 80 | 85 | 90 | 90 |
| | 215 | 260 | 260 | 295 | 295 | 215 | 260 | 280 | 295 | 295 |
| S12 | 44 | 55 | 55 | 60 | 60 | 45 | 55 | 60 | 60 | 60 |
| | 145 | 180 | 180 | 195 | 195 | 150 | 180 | 195 | 195 | 195 |
| S13 | 26 | 31 | 33 | 35 | 35 | 27 | 32 | 33 | 36 | 36 |
| | 85 | 100 | 110 | 115 | 115 | 90 | 105 | 110 | 120 | 120 |
| H5 | 38 | 47 | 49 | 55 | 55 | 38 | 47 | 49 | 55 | 55 |
| | 125 | 155 | 160 | 180 | 180 | 125 | 155 | 160 | 180 | 180 |
| H8 | 40 | 48 | 50 | 55 | 55 | 40 | 49 | 50 | 55 | 55 |
| | 130 | 155 | 165 | 180 | 180 | 130 | 160 | 165 | 180 | 180 |
| H11 | 48 | 60 | 60 | 65 | 70 | 49 | 60 | 65 | 70 | 70 |
| | 155 | 195 | 195 | 215 | 230 | 160 | 195 | 215 | 230 | 230 |
| H12 | 75 | 95 | 95 | 105 | 105 | 70 | 85 | 90 | 100 | 100 |
| | 245 | 310 | 310 | 345 | 345 | 230 | 280 | 295 | 330 | 330 |
| H21 | 40 | 48 | 50 | 55 | 55 | 40 | 49 | 50 | 55 | 55 |
| | 130 | 155 | 165 | 180 | 180 | 130 | 160 | 165 | 180 | 180 |

Universell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MP12 Zentrierbohren – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | f_z | a_{so} | | | |
|---------------------------|-------------------------------|--------------------------|--------------------------|--------------------------|-----------------|-------------|
| | | | | 100% | | |
| Universell | P1 | MP12-12007C90Z2-M04 F40M | 0,055 0,0022 | 3,5 0,14 | | |
| | P2 | MP12-12007C90Z2-M04 F40M | 0,055 0,0022 | 3,5 0,14 | | |
| | Stahl und Guss | P3 | MP12-12007C90Z2-M04 F40M | 0,055 0,0022 | 3,5 0,14 | |
| | | P4 | MP12-12007C90Z2-M04 F40M | 0,055 0,0022 | 3,5 0,14 | |
| | | P5 | MP12-12007C90Z2-M04 F40M | 0,050 0,0020 | 3,5 0,14 | |
| | | P6 | MP12-12007C90Z2-M04 F40M | 0,050 0,0020 | 3,5 0,14 | |
| | | P7 | MP12-12007C90Z2-M04 F40M | 0,050 0,0020 | 3,5 0,14 | |
| | | P8 | MP12-12007C90Z2-M04 F40M | 0,055 0,0022 | 3,5 0,14 | |
| | Rostfrei und ISO-S-Werkstoffe | P11 | MP12-12007C90Z2-M04 F40M | 0,050 0,0020 | 3,5 0,14 | |
| | | P12 | MP12-12007C90Z2-M04 F40M | 0,036 0,0014 | 2,5 0,10 | |
| | | NE-Metalle | M1 | MP12-12007C90Z2-M04 F40M | 0,055 0,0022 | 3,5 0,14 |
| | | | M2 | MP12-12007C90Z2-M04 F40M | 0,050 0,0020 | 3,5 0,14 |
| M3 | MP12-12007C90Z2-M04 F40M | | 0,042 0,0017 | 2,5 0,10 | | |
| M4 | MP12-12007C90Z2-M04 F40M | | 0,036 0,0014 | 2,0 0,080 | | |
| M5 | MP12-12007C90Z2-M04 F40M | | 0,036 0,0014 | 2,0 0,080 | | |
| Harter | K1 | MP12-12007C90Z2-M04 F40M | 0,055 0,0022 | 3,5 0,14 | | |
| | K2 | MP12-12007C90Z2-M04 F40M | 0,050 0,0020 | 3,5 0,14 | | |
| | K3 | MP12-12007C90Z2-M04 F40M | 0,050 0,0020 | 3,5 0,14 | | |
| | K4 | MP12-12007C90Z2-M04 F40M | 0,050 0,0020 | 3,5 0,14 | | |
| | K5 | MP12-12007C90Z2-M04 F40M | 0,046 0,0018 | 3,5 0,14 | | |
| | K6 | MP12-12007C90Z2-M04 F40M | 0,050 0,0020 | 3,5 0,14 | | |
| | K7 | MP12-12007C90Z2-M04 F40M | 0,046 0,0018 | 3,5 0,14 | | |
| Kunststoffe und Composite | N1 | MP12-12007C90Z2-M04 F40M | 0,075 0,0030 | 3,5 0,14 | | |
| | N2 | MP12-12007C90Z2-M04 F40M | 0,075 0,0030 | 3,5 0,14 | | |
| | N3 | MP12-12007C90Z2-M04 F40M | 0,075 0,0030 | 3,5 0,14 | | |
| | N11 | MP12-12007C90Z2-M04 F40M | 0,075 0,0030 | 3,5 0,14 | | |
| Graphit | S1 | MP12-12007C90Z2-M04 F40M | 0,036 0,0014 | 2,0 0,080 | | |
| | S2 | MP12-12007C90Z2-M04 F40M | 0,036 0,0014 | 2,0 0,080 | | |
| | S3 | MP12-12007C90Z2-M04 F40M | 0,034 0,0013 | 2,0 0,080 | | |
| | S11 | MP12-12007C90Z2-M04 F40M | 0,042 0,0017 | 2,5 0,10 | | |
| | S12 | MP12-12007C90Z2-M04 F40M | 0,042 0,0017 | 2,5 0,10 | | |
| | S13 | MP12-12007C90Z2-M04 F40M | 0,036 0,0014 | 2,0 0,080 | | |
| X-Heads | H5 | MP12-12007C90Z2-M04 F40M | 0,036 0,0014 | 2,5 0,10 | | |
| | H8 | MP12-12007C90Z2-M04 F40M | 0,028 0,0011 | 2,5 0,10 | | |
| | H11 | MP12-12007C90Z2-M04 F40M | 0,036 0,0014 | 2,5 0,10 | | |
| | H12 | MP12-12007C90Z2-M04 F40M | 0,028 0,0011 | 2,5 0,10 | | |
| | H21 | MP12-12007C90Z2-M04 F40M | 0,028 0,0011 | 2,5 0,10 | | |

SMG = Seco Werkstoff-Gruppe
 f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_e/DC = %
 Alle Schnittdaten sind Startwerte

MP12 Zentrierbohren – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | F40M | | | |
|-----|--------------|-----|----------------------------------|-----------------|
| | v_c | f | | |
| | 100% | | Universell | |
| P1 | 275 900 | | | |
| P2 | 265 870 | | Stahl und Guss | |
| P3 | 235 770 | | | |
| P4 | 205 670 | | | |
| P5 | 195 640 | | | |
| P6 | 220 720 | | Rostfrei und ISO-S-Werkstoffe | |
| P7 | 205 670 | | | |
| P8 | 195 640 | | | |
| P11 | 200 660 | | | |
| P12 | 125 410 | | Rostfrei und ISO-S-Werkstoffe | |
| M1 | 215 710 | | | |
| M2 | 175 570 | | | |
| M3 | 140 460 | | | |
| M4 | 105 345 | | | |
| M5 | 85 280 | | NE-Metalle | |
| K1 | 210 690 | | | |
| K2 | 185 610 | | Harter | |
| K3 | 155 510 | | | |
| K4 | 150 490 | | | |
| K5 | 90 295 | | | |
| K6 | 130 425 | | | |
| K7 | 120 395 | | | |
| N1 | 1575 5175 | | | Graphit |
| N2 | 640 2100 | | | |
| N3 | 425 1400 | | | |
| N11 | 490 1600 | | | |
| S1 | 49 160 | | X-Heads | |
| S2 | 39 130 | | | |
| S3 | 34 110 | | | |
| S11 | 70 230 | | | |
| S12 | 48 155 | | | |
| S13 | 27 90 | | | |
| H5 | 42 140 | | | Minimaster Plus |
| H8 | 43 140 | | | |
| H11 | 55 180 | | | |
| H12 | 80 260 | | | |
| H21 | 43 140 | | | |
| | | | Minimaster | |
| | | | | |

MP12 Anfasen – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | | | | | |
|---------------------------|-------------------------------|--------------------------|--------------------------|--------------------------|-----------------|-----------------|-----------------|-----------------|-----------------|-----------------|
| | | | 100% | 50% | 30% | 20% | 10% | | | |
| Universell | P1 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,080 0,0032 | 0,080 0,0032 | 0,080 0,0032 | 0,080 0,0032 | 0,10 0,0040 | | |
| | P2 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,080 0,0032 | 0,080 0,0032 | 0,080 0,0032 | 0,080 0,0032 | 0,10 0,0040 | | |
| | Stahl und Guss | P3 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,095 0,0038 | |
| | | P4 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,095 0,0038 | |
| | | P5 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,090 0,0036 | |
| | | P6 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,090 0,0036 | |
| | | P7 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,090 0,0036 | |
| | | P8 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,095 0,0038 | |
| | Rostfrei und ISO-S-Werkstoffe | P11 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,090 0,0036 | |
| | | P12 | MP12-12007C90Z2-M04 F40M | 2,0 0,080 | 0,050 0,0020 | 0,050 0,0020 | 0,050 0,0020 | 0,050 0,0020 | 0,060 0,0024 | |
| | | NE-Metalle | M1 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,080 0,0032 | 0,080 0,0032 | 0,080 0,0032 | 0,080 0,0032 | 0,10 0,0040 |
| | | | M2 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,090 0,0036 |
| M3 | | | MP12-12007C90Z2-M04 F40M | 2,0 0,080 | 0,060 0,0024 | 0,060 0,0024 | 0,060 0,0024 | 0,060 0,0024 | 0,075 0,0030 | |
| M4 | | | MP12-12007C90Z2-M04 F40M | 1,6 0,065 | 0,050 0,0020 | 0,050 0,0020 | 0,050 0,0020 | 0,050 0,0020 | 0,065 0,0026 | |
| M5 | MP12-12007C90Z2-M04 F40M | | 1,6 0,065 | 0,050 0,0020 | 0,050 0,0020 | 0,050 0,0020 | 0,050 0,0020 | 0,065 0,0026 | | |
| Harter | K1 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,080 0,0032 | 0,080 0,0032 | 0,080 0,0032 | 0,080 0,0032 | 0,10 0,0040 | | |
| | K2 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,090 0,0036 | | |
| | K3 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,090 0,0036 | | |
| | K4 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,090 0,0036 | | |
| | K5 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,065 0,0026 | 0,065 0,0026 | 0,065 0,0026 | 0,065 0,0026 | 0,085 0,0034 | | |
| | K6 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,075 0,0030 | 0,090 0,0036 | | |
| | K7 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,065 0,0026 | 0,065 0,0026 | 0,065 0,0026 | 0,065 0,0026 | 0,085 0,0034 | | |
| Kunststoffe und Composite | N1 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,10 0,0040 | 0,10 0,0040 | 0,10 0,0040 | 0,10 0,0040 | 0,13 0,0050 | | |
| | N2 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,10 0,0040 | 0,10 0,0040 | 0,10 0,0040 | 0,10 0,0040 | 0,13 0,0050 | | |
| | N3 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,10 0,0040 | 0,10 0,0040 | 0,10 0,0040 | 0,10 0,0040 | 0,13 0,0050 | | |
| | N11 | MP12-12007C90Z2-M04 F40M | 2,5 0,10 | 0,10 0,0040 | 0,10 0,0040 | 0,10 0,0040 | 0,10 0,0040 | 0,13 0,0050 | | |
| Graphit | S1 | MP12-12007C90Z2-M04 F40M | 1,6 0,065 | 0,050 0,0020 | 0,050 0,0020 | 0,050 0,0020 | 0,050 0,0020 | 0,065 0,0026 | | |
| | S2 | MP12-12007C90Z2-M04 F40M | 1,6 0,065 | 0,050 0,0020 | 0,050 0,0020 | 0,050 0,0020 | 0,050 0,0020 | 0,065 0,0026 | | |
| | S3 | MP12-12007C90Z2-M04 F40M | 1,6 0,065 | 0,048 0,0019 | 0,048 0,0019 | 0,048 0,0019 | 0,048 0,0019 | 0,060 0,0024 | | |
| X-Heads | S11 | MP12-12007C90Z2-M04 F40M | 1,9 0,075 | 0,060 0,0024 | 0,060 0,0024 | 0,060 0,0024 | 0,060 0,0024 | 0,075 0,0030 | | |
| | S12 | MP12-12007C90Z2-M04 F40M | 1,9 0,075 | 0,060 0,0024 | 0,060 0,0024 | 0,060 0,0024 | 0,060 0,0024 | 0,075 0,0030 | | |
| | S13 | MP12-12007C90Z2-M04 F40M | 1,6 0,065 | 0,050 0,0020 | 0,050 0,0020 | 0,050 0,0020 | 0,050 0,0020 | 0,065 0,0026 | | |
| | H5 | MP12-12007C90Z2-M04 F40M | 2,0 0,080 | 0,050 0,0020 | 0,050 0,0020 | 0,050 0,0020 | 0,050 0,0020 | 0,060 0,0024 | | |
| Minimaster Plus | H8 | MP12-12007C90Z2-M04 F40M | 1,9 0,075 | 0,038 0,0015 | 0,038 0,0015 | 0,038 0,0015 | 0,038 0,0015 | 0,048 0,0019 | | |
| | H11 | MP12-12007C90Z2-M04 F40M | 2,0 0,080 | 0,050 0,0020 | 0,050 0,0020 | 0,050 0,0020 | 0,050 0,0020 | 0,060 0,0024 | | |
| | H12 | MP12-12007C90Z2-M04 F40M | 1,9 0,075 | 0,038 0,0015 | 0,038 0,0015 | 0,038 0,0015 | 0,038 0,0015 | 0,048 0,0019 | | |
| | H21 | MP12-12007C90Z2-M04 F40M | 1,9 0,075 | 0,038 0,0015 | 0,038 0,0015 | 0,038 0,0015 | 0,038 0,0015 | 0,048 0,0019 | | |
| | H21 | MP12-12007C90Z2-M04 F40M | 1,9 0,075 | 0,038 0,0015 | 0,038 0,0015 | 0,038 0,0015 | 0,038 0,0015 | 0,048 0,0019 | | |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (stf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MP12 Anfasen – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | F40M | | | | |
|-----|------|------|------|------|------|
| | 100% | 50% | 30% | 20% | 10% |
| P1 | 300 | 275 | 330 | 365 | 430 |
| | 980 | 900 | 1075 | 1200 | 1400 |
| P2 | 290 | 270 | 320 | 355 | 415 |
| | 950 | 890 | 1050 | 1175 | 1350 |
| P3 | 255 | 235 | 280 | 310 | 360 |
| | 840 | 770 | 920 | 1025 | 1175 |
| P4 | 225 | 210 | 250 | 275 | 320 |
| | 740 | 690 | 820 | 900 | 1050 |
| P5 | 215 | 200 | 235 | 260 | 310 |
| | 710 | 660 | 770 | 850 | 1025 |
| P6 | 240 | 225 | 265 | 295 | 345 |
| | 790 | 740 | 870 | 970 | 1125 |
| P7 | 225 | 210 | 250 | 275 | 325 |
| | 740 | 690 | 820 | 900 | 1075 |
| P8 | 215 | 200 | 235 | 260 | 305 |
| | 710 | 660 | 770 | 850 | 1000 |
| P11 | 220 | 205 | 245 | 270 | 320 |
| | 720 | 670 | 800 | 890 | 1050 |
| P12 | 140 | 125 | 150 | 165 | 205 |
| | 460 | 410 | 490 | 540 | 670 |
| M1 | 235 | 220 | 260 | 285 | 335 |
| | 770 | 720 | 850 | 940 | 1100 |
| M2 | 190 | 180 | 215 | 235 | 280 |
| | 620 | 590 | 710 | 770 | 920 |
| M3 | 150 | 135 | 165 | 180 | 220 |
| | 490 | 445 | 540 | 590 | 720 |
| M4 | 115 | 100 | 115 | 130 | 170 |
| | 375 | 330 | 375 | 425 | 560 |
| M5 | 95 | 85 | 95 | 110 | 140 |
| | 310 | 280 | 310 | 360 | 460 |
| K1 | 230 | 215 | 255 | 280 | 330 |
| | 750 | 710 | 840 | 920 | 1075 |
| K2 | 200 | 190 | 225 | 250 | 295 |
| | 660 | 620 | 740 | 820 | 970 |
| K3 | 170 | 160 | 190 | 210 | 250 |
| | 560 | 520 | 620 | 690 | 820 |
| K4 | 165 | 150 | 180 | 200 | 235 |
| | 540 | 490 | 590 | 660 | 770 |
| K5 | 100 | 95 | 110 | 125 | 145 |
| | 330 | 310 | 360 | 410 | 475 |
| K6 | 145 | 135 | 160 | 175 | 210 |
| | 475 | 445 | 520 | 570 | 690 |
| K7 | 130 | 120 | 145 | 160 | 185 |
| | 425 | 395 | 475 | 520 | 610 |
| N1 | 1725 | 1600 | 1900 | 2100 | 2450 |
| | 5650 | 5250 | 6225 | 6900 | 8050 |
| N2 | 690 | 640 | 770 | 850 | 990 |
| | 2275 | 2100 | 2525 | 2800 | 3250 |
| N3 | 460 | 430 | 510 | 570 | 660 |
| | 1500 | 1400 | 1675 | 1875 | 2175 |
| N11 | 530 | 490 | 590 | 650 | 750 |
| | 1750 | 1600 | 1925 | 2125 | 2450 |
| S1 | 55 | 47 | 55 | 60 | 80 |
| | 180 | 155 | 180 | 195 | 260 |
| S2 | 44 | 38 | 44 | 50 | 65 |
| | 145 | 125 | 145 | 165 | 215 |
| S3 | 38 | 33 | 38 | 43 | 55 |
| | 125 | 110 | 125 | 140 | 180 |
| S11 | 75 | 70 | 80 | 85 | 110 |
| | 245 | 230 | 260 | 280 | 360 |
| S12 | 55 | 47 | 55 | 60 | 75 |
| | 180 | 155 | 180 | 195 | 245 |
| S13 | 30 | 27 | 30 | 35 | 45 |
| | 100 | 90 | 100 | 115 | 150 |
| H5 | 46 | 42 | 50 | 55 | 70 |
| | 150 | 140 | 165 | 180 | 230 |
| H8 | 49 | 44 | 50 | 55 | 70 |
| | 160 | 145 | 165 | 180 | 230 |
| H11 | 60 | 55 | 65 | 70 | 85 |
| | 195 | 180 | 215 | 230 | 280 |
| H12 | 85 | 80 | 90 | 100 | 125 |
| | 280 | 260 | 295 | 330 | 410 |
| H21 | 49 | 44 | 50 | 55 | 70 |
| | 160 | 145 | 165 | 180 | 230 |

Universell
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MP16 Schaft – Metrisch

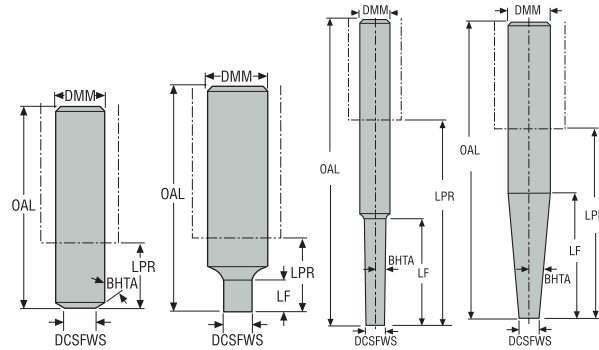


Abb. 1

Abb. 2

Abb. 3

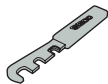
Abb. 4

- Zylindrischer Schaft DMM mit Toleranz h5 kompatibel mit Schrupfaufnahmen

| Bezeichnung | Aufnahme | DCSFWS | DMM | OAL | LPR | LF | RPMX | BHTA° | Abb. | | Gewicht |
|---------------------|-------------|--------|------|-------|-------|-------|-------|-------|------|---|---------|
| | | mm | mm | mm | mm | mm | | | | | kg |
| MP16-16068-016.00 | Zylindrisch | 15,2 | 16,0 | 68,0 | 20,0 | 16,0 | 63600 | 0,0 | 2 | ✓ | 0,2 |
| MP16-20070-000.60 | Zylindrisch | 15,2 | 20,0 | 70,0 | 20,0 | 0,0 | 63600 | 60,0 | 1 | ✓ | 0,2 |
| MP16-20090-024.00 | Zylindrisch | 15,2 | 20,0 | 90,0 | 40,0 | 24,0 | 63600 | 0,0 | 2 | ✓ | 0,2 |
| MP16-20190-056.01 | Zylindrisch | 15,2 | 20,0 | 190,0 | 140,0 | 56,0 | 63600 | 1,0 | 3 | ✓ | 0,4 |
| MP16-20195-095.01 | Zylindrisch | 15,2 | 20,0 | 195,0 | 145,0 | 95,0 | 63600 | 1,0 | 3 | ✓ | 0,4 |
| MP16-25136-075.03 | Zylindrisch | 15,2 | 25,0 | 136,0 | 80,0 | 75,0 | 63600 | 3,0 | 3 | ✓ | 0,4 |
| MP16-25181-125.03 | Zylindrisch | 15,2 | 25,0 | 181,0 | 125,0 | 93,5 | 63600 | 3,0 | 4 | ✓ | 0,6 |
| MP16-25181-125.05 | Zylindrisch | 15,2 | 25,0 | 181,0 | 125,0 | 56,0 | 63600 | 5,0 | 4 | ✓ | 0,6 |
| MP16-16126-048.00-E | Zylindrisch | 15,2 | 16,0 | 126,0 | 78,0 | 48,0 | 63600 | 0,0 | 2 | ✓ | 0,4 |
| MP16-16140-064.00-E | Zylindrisch | 15,2 | 16,0 | 140,0 | 92,0 | 64,0 | 63600 | 0,0 | 2 | ✓ | 0,4 |
| MP16-16180-096.00-E | Zylindrisch | 15,2 | 16,0 | 180,0 | 132,0 | 96,0 | 63600 | 0,0 | 2 | ✓ | 0,5 |
| MP16-20135-080.01-E | Zylindrisch | 15,2 | 20,0 | 135,0 | 85,0 | 80,0 | 63600 | 1,0 | 3 | ✓ | 0,5 |
| MP16-20180-128.01-E | Zylindrisch | 15,2 | 20,0 | 180,0 | 130,0 | 128,0 | 63600 | 1,0 | 3 | ✓ | 0,7 |
| MP16-20200-150.01-E | Zylindrisch | 15,2 | 20,0 | 200,0 | 150,0 | 137,5 | 63600 | 1,0 | 4 | ✓ | 0,8 |
| MP16-20180-130.03-E | Zylindrisch | 15,2 | 20,0 | 180,0 | 130,0 | 45,8 | 63600 | 3,0 | 4 | ✓ | 0,8 |
| MP16-20210-160.03-E | Zylindrisch | 15,2 | 20,0 | 210,0 | 160,0 | 45,8 | 63600 | 3,0 | 4 | ✓ | 4,7 |

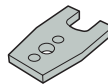
Zubehör

Schlüssel



MP1016

Ersatzklinge



MP00-16M

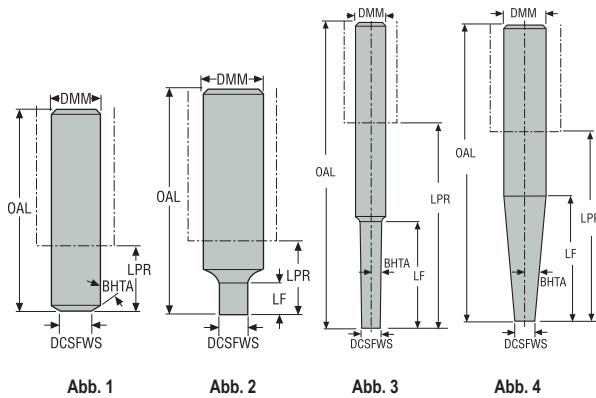
Drehmoment-
schlüssel



MP00-16.190

Die Klingen sind im Lieferumfang des Drehmomentschlüssels enthalten

MP16 Schaft – Zoll



• Zylindrischer Schaft DMM mit Toleranz h5 kompatibel mit Schrumpfaufnahmen

| Bezeichnung | Aufnahme | DCSFMS | DMM | OAL | LPR | LF | RPMX | BHTA° | Abb. | | Gewicht |
|-----------------------|-------------|--------|-------|-------|-------|-------|-------|-------|------|---|---------|
| | | Zoll | Zoll | Zoll | Zoll | Zoll | | | | | lbs |
| MP16-0622.6-0.63.00 | Zylindrisch | 0.598 | 0.625 | 2.662 | 0.787 | 0.630 | 63600 | 0,0 | 2 | ✓ | 0.220 |
| MP16-0752.7-0.00.60 | Zylindrisch | 0.598 | 0.750 | 2.787 | 0.787 | 0 | 63600 | 60,0 | 1 | ✓ | 0.440 |
| MP16-0753.5-0.94.00 | Zylindrisch | 0.598 | 0.750 | 3.575 | 1.575 | 0.945 | 63600 | 0,0 | 2 | ✓ | 0.440 |
| MP16-0757.5-2.20.01 | Zylindrisch | 0.598 | 0.750 | 7.512 | 5.512 | 2.205 | 63600 | 1,0 | 3 | ✓ | 0.880 |
| MP16-0757.7-3.74.01 | Zylindrisch | 0.598 | 0.750 | 7.709 | 5.709 | 3.740 | 63600 | 1,0 | 3 | ✓ | 0.880 |
| MP16-1007.1-4.92.05 | Zylindrisch | 0.598 | 1.000 | 7.171 | 4.921 | 2.295 | 63600 | 5,0 | 4 | ✓ | 1.540 |
| MP16-0627.0-3.77.00-E | Zylindrisch | 0.598 | 0.625 | 7.072 | 5.197 | 3.780 | 63600 | 0,0 | 2 | ✓ | 1.100 |
| MP16-0757.9-5.90.01-E | Zylindrisch | 0.598 | 0.750 | 7.906 | 5.906 | 4.342 | 63600 | 1,0 | 4 | ✓ | 1.540 |
| MP16-0758.2-6.29.03-E | Zylindrisch | 0.598 | 0.750 | 8.299 | 6.299 | 1.446 | 63600 | 3,0 | 4 | ✓ | 1.760 |

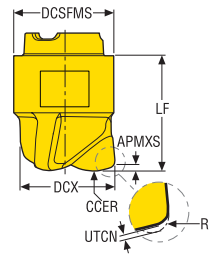
Zubehör

| Schlüssel | Ersatzklinge | Drehmoment-schlüssel |
|-----------|--------------|----------------------|
| | | |
| MP1016 | MP00-16M | MP00-16.190 |

Die Klingen sind im Lieferumfang des Drehmomentschlüssels enthalten

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MP16 Hochvorschubfräser



• Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 625-626

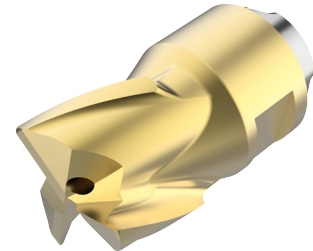
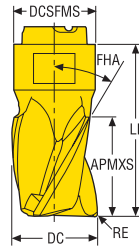
Z3



| Bezeichnung | DCX | DC | APMXS | DCSFMS | CCER | RP | LF | UTCN | RMPX° | C min | C max | ZEFP | Beschichtung | | |
|----------------------|-----------------|---------------|--------------|---------------|--------------|---------------|---------------|---------------|-------|-------|-------|------|--------------|--------------|------|
| | | | | | | | | | | | | | Beschichtet | Beschichtung | |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | | | MP3000 | F40M |
| MP16-1580.9HFZ3-MD12 | 15,875 0.625 | 7,88 0.310 | 0,9 0.035 | 15,4 0.606 | 7,8 0.307 | 1,79 0.070 | 18,5 0.728 | 0,46 0.018 | 5,0 | 17,2 | 23,5 | 3 | | ■ | |
| MP16-1600.9HFZ3-MD12 | 16,0 0.630 | 8,0 0.315 | 0,9 0.035 | 15,4 0.606 | 7,8 0.307 | 1,79 0.070 | 18,5 0.728 | 0,46 0.018 | 5,0 | 17,3 | 23,8 | 3 | | ■ | |

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- Harter
- Kunststoffe und Composite
- Graphit
- X-Heads
- Minimaster Plus
- Minimaster

MP16 Eckfräser
Nut- und Konturfräsen



• Auswahl der Wandeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 627-628

Z3



| Bezeichnung | DC | APMXS | RE | DCSFMS | FHA | LF | RMPX° | C min | C max | ZEFP | Beschichtung | |
|---------------------|-----------------|---------------|--------------|---------------|-------------|---------------|-------|-------|-------|------|--------------|------|
| | | | | | | | | | | | MP3000 | F40M |
| MP16-15719KWZ3-E05 | 15,7 0.618 | 19,0 0.748 | 0,3 0.012 | 15,4 0.606 | 30 1.181 | 32,6 1.283 | 15,0 | 19,0 | 29,6 | 3 | | ■ |
| MP16-15919R04Z3-E05 | 15,875 0.625 | 19,0 0.748 | 0,4 0.016 | 15,4 0.606 | 30 1.181 | 32,6 1.283 | 15,0 | 19,3 | 30,7 | 3 | | ■ |
| MP16-15919R04Z3-M05 | 15,875 0.625 | 19,0 0.748 | 0,4 0.016 | 15,4 0.606 | 30 1.181 | 32,6 1.283 | 15,0 | 19,3 | 30,7 | 3 | ■ | |
| MP16-15919R08Z3-E05 | 15,875 0.625 | 19,0 0.748 | 0,8 0.031 | 15,4 0.606 | 30 1.181 | 32,6 1.283 | 15,0 | 19,3 | 29,9 | 3 | | ■ |
| MP16-15919R08Z3-M05 | 15,875 0.625 | 19,0 0.748 | 0,8 0.031 | 15,4 0.606 | 30 1.181 | 32,6 1.283 | 15,0 | 19,3 | 29,9 | 3 | ■ | |
| MP16-15919R31Z3-E05 | 15,875 0.625 | 19,0 0.748 | 3,1 0.122 | 15,4 0.606 | 30 1.181 | 32,6 1.283 | 15,0 | 19,3 | 25,3 | 3 | | ■ |
| MP16-16010R04Z3-M05 | 16,0 0.630 | 10,0 0.394 | 0,4 0.016 | 15,4 0.606 | 30 1.181 | 24,6 0.969 | 15,0 | 19,4 | 31,0 | 3 | ■ | |
| MP16-16010R05Z3-E05 | 16,0 0.630 | 10,0 0.394 | 0,5 0.020 | 15,4 0.606 | 30 1.181 | 24,6 0.969 | 15,0 | 19,4 | 30,8 | 3 | | ■ |
| MP16-16010R08Z3-E05 | 16,0 0.630 | 10,0 0.394 | 0,8 0.031 | 15,4 0.606 | 30 1.181 | 24,6 0.969 | 15,0 | 19,4 | 30,0 | 3 | | ■ |
| MP16-16010R08Z3-M05 | 16,0 0.630 | 10,0 0.394 | 0,8 0.031 | 15,4 0.606 | 30 1.181 | 24,6 0.969 | 15,0 | 19,4 | 30,0 | 3 | ■ | |
| MP16-16010R12Z3-E05 | 16,0 0.630 | 10,0 0.394 | 1,2 0.047 | 15,4 0.606 | 30 1.181 | 24,6 0.969 | 15,0 | 19,4 | 29,4 | 3 | | ■ |
| MP16-16010R20Z3-E05 | 16,0 0.630 | 10,0 0.394 | 2,0 0.079 | 15,4 0.606 | 30 1.181 | 24,6 0.969 | 15,0 | 19,4 | 27,8 | 3 | | ■ |
| MP16-16010R31Z3-E05 | 16,0 0.630 | 10,0 0.394 | 3,1 0.122 | 15,4 0.606 | 30 1.181 | 24,6 0.969 | 15,0 | 19,4 | 25,6 | 3 | | ■ |
| MP16-16019R04Z3-M05 | 16,0 0.630 | 19,0 0.748 | 0,4 0.016 | 15,4 0.606 | 30 1.181 | 32,6 1.283 | 15,0 | 19,4 | 31,0 | 3 | ■ | |
| MP16-16019R05Z3-E05 | 16,0 0.630 | 19,0 0.748 | 0,5 0.020 | 15,4 0.606 | 30 1.181 | 32,6 1.283 | 15,0 | 19,4 | 30,8 | 3 | | ■ |
| MP16-16019R08Z3-E05 | 16,0 0.630 | 19,0 0.748 | 0,8 0.031 | 15,4 0.606 | 30 1.181 | 32,6 1.283 | 15,0 | 19,4 | 30,2 | 3 | | ■ |
| MP16-16019R08Z3-M05 | 16,0 0.630 | 19,0 0.748 | 0,8 0.031 | 15,4 0.606 | 30 1.181 | 32,6 1.283 | 15,0 | 19,4 | 30,2 | 3 | ■ | |
| MP16-16019R20Z3-E05 | 16,0 0.630 | 19,0 0.748 | 2,0 0.079 | 15,4 0.606 | 30 1.181 | 32,6 1.283 | 15,0 | 19,4 | 27,8 | 3 | | ■ |
| MP16-16019R31Z3-E05 | 16,0 0.630 | 19,0 0.748 | 3,1 0.122 | 15,4 0.606 | 30 1.181 | 32,6 1.283 | 15,0 | 19,4 | 25,6 | 3 | | ■ |

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NE-Metalle

Harter

Graphit

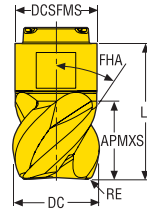
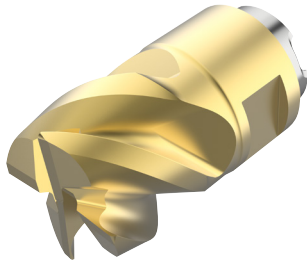
X-Heads

Minimaster Plus

Minimaster

MP16 Eckfräser

Nut- und Konturfräsen



- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 627-628

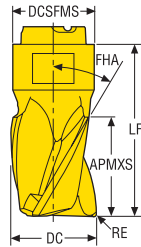
Z4



| Bezeichnung | DC | APMXS | RE | DCSFMS | FHA | LF | RMPX° | C min | C max | ZEFP | Beschichtung | |
|---------------------|-----------------|---------------|--------------|---------------|-------------|---------------|-------|-------|-------|------|--------------|------|
| | | | | | | | | | | | Beschichtet | |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | | MP3000 | F40M |
| MP16-15919R04Z4-E04 | 15,875 0.625 | 19,0 0.748 | 0,4 0.016 | 15,4 0.606 | 50 1.969 | 32,6 1.283 | 15,0 | 19,3 | 30,7 | 4 | | ■ |
| MP16-15919R04Z4-M04 | 15,875 0.625 | 19,0 0.748 | 0,4 0.016 | 15,4 0.606 | 50 1.969 | 32,6 1.283 | 15,0 | 19,3 | 30,7 | 4 | ■ | |
| MP16-15919R08Z4-E04 | 15,875 0.625 | 19,0 0.748 | 0,8 0.031 | 15,4 0.606 | 50 1.969 | 32,6 1.283 | 15,0 | 19,3 | 29,9 | 4 | | ■ |
| MP16-15919R08Z4-M04 | 15,875 0.625 | 19,0 0.748 | 0,8 0.031 | 15,4 0.606 | 50 1.969 | 32,6 1.283 | 15,0 | 19,3 | 29,9 | 4 | ■ | |
| MP16-16010R04Z4-M04 | 16,0 0.630 | 10,0 0.394 | 0,4 0.016 | 15,4 0.606 | 50 1.969 | 24,6 0.969 | 15,0 | 19,4 | 31,0 | 4 | ■ | |
| MP16-16010R05Z4-E04 | 16,0 0.630 | 10,0 0.394 | 0,5 0.020 | 15,4 0.606 | 50 1.969 | 24,6 0.969 | 15,0 | 19,4 | 30,8 | 4 | | ■ |
| MP16-16010R08Z4-E04 | 16,0 0.630 | 10,0 0.394 | 0,8 0.031 | 15,4 0.606 | 50 1.969 | 24,6 0.969 | 15,0 | 19,4 | 30,2 | 4 | | ■ |
| MP16-16010R08Z4-M04 | 16,0 0.630 | 10,0 0.394 | 0,8 0.031 | 15,4 0.606 | 50 1.969 | 24,6 0.969 | 15,0 | 19,4 | 30,2 | 4 | ■ | |
| MP16-16010R16Z4-M04 | 16,0 0.630 | 10,0 0.394 | 1,6 0.063 | 15,4 0.606 | 50 1.969 | 24,6 0.969 | 15,0 | 19,4 | 28,6 | 4 | ■ | |
| MP16-16010R31Z4-E04 | 16,0 0.630 | 10,0 0.394 | 3,1 0.122 | 15,4 0.606 | 50 1.969 | 24,6 0.969 | 15,0 | 19,4 | 25,6 | 4 | | ■ |
| MP16-16019R04Z4-E04 | 16,0 0.630 | 19,0 0.748 | 0,4 0.016 | 15,4 0.606 | 50 1.969 | 32,6 1.283 | 15,0 | 19,4 | 31,0 | 4 | | ■ |
| MP16-16019R04Z4-M04 | 16,0 0.630 | 19,0 0.748 | 0,4 0.016 | 15,4 0.606 | 50 1.969 | 32,6 1.283 | 15,0 | 19,4 | 31,0 | 4 | ■ | |
| MP16-16019R05Z4-E04 | 16,0 0.630 | 19,0 0.748 | 0,5 0.020 | 15,4 0.606 | 50 1.969 | 32,6 1.283 | 15,0 | 19,4 | 30,8 | 4 | | ■ |
| MP16-16019R08Z4-E04 | 16,0 0.630 | 19,0 0.748 | 0,8 0.031 | 15,4 0.606 | 50 1.969 | 32,6 1.283 | 15,0 | 19,4 | 30,2 | 4 | | ■ |
| MP16-16019R08Z4-M04 | 16,0 0.630 | 19,0 0.748 | 0,8 0.031 | 15,4 0.606 | 50 1.969 | 32,6 1.283 | 15,0 | 19,4 | 30,2 | 4 | ■ | |
| MP16-16019R16Z4-E04 | 16,0 0.630 | 19,0 0.748 | 1,6 0.063 | 15,4 0.606 | 50 1.969 | 32,6 1.283 | 15,0 | 19,4 | 28,6 | 4 | | ■ |
| MP16-16019R20Z4-E04 | 16,0 0.630 | 19,0 0.748 | 2,0 0.079 | 15,4 0.606 | 50 1.969 | 32,6 1.283 | 15,0 | 19,4 | 27,8 | 4 | | ■ |

MP16 Eckfräser

Nur Konturfräsen



• Auswahl der Wandeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 627-628

Z6/Z8



| Bezeichnung | DC | APMXS | RE | DCSFMS | LF | FHA | ZEFP | Beschichtung | |
|---------------------|-----------------|---------------|--------------|---------------|---------------|-----|------|--------------|--------------|
| | | | | | | | | Beschichtet | Beschichtung |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | MP3000 | F40M |
| MP16-15919R04Z6-M04 | 15,875 0.625 | 19,0 0.748 | 0,4 0.016 | 15,4 0.606 | 32,6 1.283 | 40 | 6 | ■ | |
| MP16-16019R04Z6-M04 | 16,0 0.630 | 19,0 0.748 | 0,4 0.016 | 15,4 0.606 | 32,6 1.283 | 40 | 6 | ■ | |
| MP16-16019R04Z8-M04 | 16,0 0.630 | 19,0 0.748 | 0,4 0.016 | 15,4 0.606 | 32,6 1.283 | 40 | 8 | ■ | |

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Harter

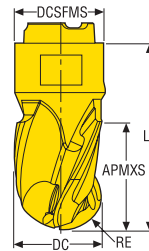
Graphit

X-Heads

Minimaster Plus

Minimaster

MP16 Kugelkopfräser



- Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 629-630

Z3

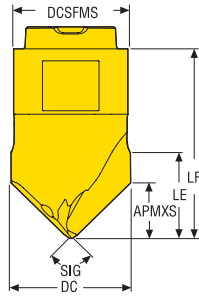


Z4



| Bezeichnung | DC | APMXS | RE | DCSFMS | LF | FHA | RMPX° | ZEFP | Beschichtung | |
|---------------------|-----------------|---------------|-----------------|---------------|---------------|-----|-------|------|--------------|-------------|
| | | | | | | | | | Beschichtet | Beschichtet |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | MP3000 | F40M |
| MP16-15910B90Z3-E05 | 15,875 0.625 | 10,0 0.394 | 7,9375 0.313 | 15,4 0.606 | 24,6 0.969 | 30 | 15,0 | 3 | | ■ |
| MP16-15910B90Z3-M05 | 15,875 0.625 | 10,0 0.394 | 7,9375 0.313 | 15,4 0.606 | 24,6 0.969 | 30 | 15,0 | 3 | ■ | |
| MP16-15910B90Z4-E04 | 15,875 0.625 | 10,0 0.394 | 7,9375 0.313 | 15,4 0.606 | 24,6 0.969 | 20 | 15,0 | 4 | | ■ |
| MP16-15910B90Z4-M04 | 15,875 0.625 | 10,0 0.394 | 7,9375 0.313 | 15,4 0.606 | 24,6 0.969 | 20 | 15,0 | 4 | ■ | |
| MP16-15919B90Z3-E05 | 15,875 0.625 | 19,0 0.748 | 7,9375 0.313 | 15,4 0.606 | 32,6 1.283 | 30 | 15,0 | 3 | | ■ |
| MP16-15919B90Z3-M05 | 15,875 0.625 | 19,0 0.748 | 7,9375 0.313 | 15,4 0.606 | 32,6 1.283 | 30 | 15,0 | 3 | ■ | |
| MP16-16010B90Z3-E05 | 16,0 0.630 | 10,0 0.394 | 8,0 0.315 | 15,4 0.606 | 24,6 0.969 | 30 | 15,0 | 3 | | ■ |
| MP16-16010B90Z3-M05 | 16,0 0.630 | 10,0 0.394 | 8,0 0.315 | 15,4 0.606 | 24,6 0.969 | 30 | 15,0 | 3 | ■ | |
| MP16-16010B90Z4-E04 | 16,0 0.630 | 10,0 0.394 | 8,0 0.315 | 15,4 0.606 | 24,6 0.969 | 20 | 15,0 | 4 | | ■ |
| MP16-16010B90Z4-M04 | 16,0 0.630 | 10,0 0.394 | 8,0 0.315 | 15,4 0.606 | 24,6 0.969 | 20 | 15,0 | 4 | ■ | |
| MP16-16019B90Z3-E05 | 16,0 0.630 | 19,0 0.748 | 8,0 0.315 | 15,4 0.606 | 32,6 1.283 | 30 | 15,0 | 3 | | ■ |
| MP16-16019B90Z3-M05 | 16,0 0.630 | 19,0 0.748 | 8,0 0.315 | 15,4 0.606 | 32,6 1.283 | 30 | 15,0 | 3 | ■ | |

MP16 Zentrierbohren



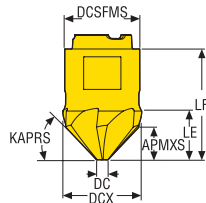
• Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 631-632

Z2



| Bezeichnung | DC | APMXS | DCSFMS | LE | LF | SIG° | ZEFP | | Beschichtung | |
|---------------------|---------------|--------------|---------------|---------------|---------------|------|------|--|--------------|-------------|
| | | | | | | | | | Beschichtet | Beschichtet |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | MP3000 | F40M |
| MP16-16009C90Z2-M05 | 16,0 0.630 | 7,4 0.291 | 15,4 0.606 | 12,0 0.472 | 26,4 1.039 | 90,0 | 2 | | | ■ |

MP16 Anfasen



• Auswahl der Wendeschneidplatten und Schnittdatenempfehlungen, s. Seite(n) 633-634

Z6



| Bezeichnung | DCX | DC | APMXS | DCSFMS | LE | LF | KAPRS° | ZEFP | | Beschichtung | |
|---------------------|---------------|---------------|--------------|---------------|---------------|---------------|--------|------|--|--------------|-------------|
| | | | | | | | | | | Beschichtet | Beschichtet |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | MP3000 | F40M |
| MP16-16009C90Z6-M05 | 16,4 0.646 | 3,95 0.156 | 6,0 0.236 | 15,4 0.606 | 10,4 0.409 | 23,5 0.925 | 45,0 | 6 | | | ■ |

Unversell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

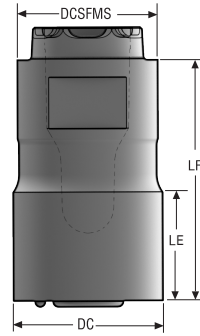
Graphit

X-Heads

Minimaster Plus

Minimaster

MP16 Zylindrische Rohlinge



- Zylindrische Hartmetall-Rohlinge zur Herstellung eigener Geometrien



| Bezeichnung | DC | DCSFMS | LE | LF | Beschichtung | |
|--------------------|----------------------|----------------------|----------------------|-----------------------|---------------|-----|
| | | | | | Unbeschichtet | H25 |
| MP16-16010CYL-SEMI | 16,4 <i>0.646</i> | 15,4 <i>0.606</i> | 11,4 <i>0.449</i> | 24,8 <i>0.976</i> | | ■ |
| MP16-16019CYL-SEMI | 16,4 <i>0.646</i> | 15,4 <i>0.606</i> | 19,5 <i>0.768</i> | 32,85 <i>1.293</i> | ✓ | ■ |

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und
Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

MP16 Hochvorschubfräsen – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a_p | | f_z | | | |
|-----|-----------------------------|-------|-------|-------|-------|-------|-------|
| | | | | 100% | 70% | 30% | 20% |
| P1 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,60 | 0,65 | 0,65 | 0,85 | 1,0 |
| | | 0,026 | 0,024 | 0,026 | 0,026 | 0,034 | 0,040 |
| P2 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,65 | 0,65 | 0,65 | 0,85 | 1,0 |
| | | 0,026 | 0,026 | 0,026 | 0,026 | 0,034 | 0,040 |
| P3 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,60 | 0,60 | 0,60 | 0,80 | 1,0 |
| | | 0,026 | 0,024 | 0,024 | 0,024 | 0,032 | 0,040 |
| P4 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,60 | 0,60 | 0,60 | 0,80 | 0,95 |
| | | 0,026 | 0,024 | 0,024 | 0,024 | 0,032 | 0,038 |
| P5 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,60 | 0,60 | 0,60 | 0,75 | 0,95 |
| | | 0,026 | 0,024 | 0,024 | 0,024 | 0,030 | 0,038 |
| P6 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,55 | 0,60 | 0,60 | 0,75 | 0,95 |
| | | 0,026 | 0,022 | 0,024 | 0,024 | 0,030 | 0,038 |
| P7 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,55 | 0,60 | 0,60 | 0,75 | 0,95 |
| | | 0,026 | 0,022 | 0,024 | 0,024 | 0,030 | 0,038 |
| P8 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,60 | 0,60 | 0,60 | 0,80 | 1,0 |
| | | 0,026 | 0,024 | 0,024 | 0,024 | 0,032 | 0,040 |
| P11 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,55 | 0,60 | 0,60 | 0,75 | 0,95 |
| | | 0,026 | 0,022 | 0,024 | 0,024 | 0,030 | 0,038 |
| P12 | MP16-1600.9HFZ3-MD12 MP3000 | 0,50 | 0,44 | 0,40 | 0,40 | 0,50 | 0,60 |
| | | 0,020 | 0,017 | 0,016 | 0,016 | 0,020 | 0,024 |
| M1 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,65 | 0,65 | 0,65 | 0,85 | 1,0 |
| | | 0,026 | 0,026 | 0,026 | 0,026 | 0,034 | 0,040 |
| M2 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,60 | 0,60 | 0,60 | 0,75 | 0,95 |
| | | 0,026 | 0,024 | 0,024 | 0,024 | 0,030 | 0,038 |
| M3 | MP16-1600.9HFZ3-MD12 MP3000 | 0,50 | 0,55 | 0,46 | 0,46 | 0,60 | 0,75 |
| | | 0,020 | 0,022 | 0,018 | 0,018 | 0,024 | 0,030 |
| M4 | MP16-1600.9HFZ3-MD12 MP3000 | 0,38 | 0,48 | 0,40 | 0,40 | 0,55 | 0,65 |
| | | 0,015 | 0,019 | 0,016 | 0,016 | 0,022 | 0,026 |
| M5 | MP16-1600.9HFZ3-MD12 MP3000 | 0,38 | 0,48 | 0,40 | 0,40 | 0,55 | 0,65 |
| | | 0,015 | 0,019 | 0,016 | 0,016 | 0,022 | 0,026 |
| K1 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,65 | 0,65 | 0,65 | 0,85 | 1,0 |
| | | 0,026 | 0,026 | 0,026 | 0,026 | 0,034 | 0,040 |
| K2 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,60 | 0,60 | 0,60 | 0,75 | 0,95 |
| | | 0,026 | 0,024 | 0,024 | 0,024 | 0,030 | 0,038 |
| K3 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,60 | 0,60 | 0,60 | 0,75 | 0,95 |
| | | 0,026 | 0,024 | 0,024 | 0,024 | 0,030 | 0,038 |
| K4 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,60 | 0,60 | 0,60 | 0,75 | 0,95 |
| | | 0,026 | 0,024 | 0,024 | 0,024 | 0,030 | 0,038 |
| K5 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,50 | 0,50 | 0,50 | 0,70 | 0,85 |
| | | 0,026 | 0,020 | 0,020 | 0,020 | 0,028 | 0,034 |
| K6 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,60 | 0,60 | 0,60 | 0,75 | 0,95 |
| | | 0,026 | 0,024 | 0,024 | 0,024 | 0,030 | 0,038 |
| K7 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,50 | 0,50 | 0,50 | 0,70 | 0,85 |
| | | 0,026 | 0,020 | 0,020 | 0,020 | 0,028 | 0,034 |
| N1 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,80 | 0,80 | 0,80 | 1,1 | 1,4 |
| | | 0,026 | 0,032 | 0,032 | 0,032 | 0,044 | 0,055 |
| N2 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,80 | 0,80 | 0,80 | 1,1 | 1,4 |
| | | 0,026 | 0,032 | 0,032 | 0,032 | 0,044 | 0,055 |
| N3 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,80 | 0,80 | 0,80 | 1,1 | 1,4 |
| | | 0,026 | 0,032 | 0,032 | 0,032 | 0,044 | 0,055 |
| N11 | MP16-1600.9HFZ3-MD12 MP3000 | 0,65 | 0,80 | 0,80 | 0,80 | 1,1 | 1,4 |
| | | 0,026 | 0,032 | 0,032 | 0,032 | 0,044 | 0,055 |
| S1 | MP16-1600.9HFZ3-MD12 MP3000 | 0,38 | 0,48 | 0,40 | 0,40 | 0,55 | 0,65 |
| | | 0,015 | 0,019 | 0,016 | 0,016 | 0,022 | 0,026 |
| S2 | MP16-1600.9HFZ3-MD12 MP3000 | 0,38 | 0,48 | 0,40 | 0,40 | 0,55 | 0,65 |
| | | 0,015 | 0,019 | 0,016 | 0,016 | 0,022 | 0,026 |
| S3 | MP16-1600.9HFZ3-MD12 MP3000 | 0,38 | 0,44 | 0,38 | 0,38 | 0,50 | 0,60 |
| | | 0,015 | 0,017 | 0,015 | 0,015 | 0,020 | 0,024 |
| S11 | MP16-1600.9HFZ3-MD12 MP3000 | 0,44 | 0,55 | 0,46 | 0,46 | 0,60 | 0,75 |
| | | 0,017 | 0,022 | 0,018 | 0,018 | 0,024 | 0,030 |
| S12 | MP16-1600.9HFZ3-MD12 MP3000 | 0,44 | 0,55 | 0,46 | 0,46 | 0,60 | 0,75 |
| | | 0,017 | 0,022 | 0,018 | 0,018 | 0,024 | 0,030 |
| S13 | MP16-1600.9HFZ3-MD12 MP3000 | 0,38 | 0,48 | 0,40 | 0,40 | 0,55 | 0,65 |
| | | 0,015 | 0,019 | 0,016 | 0,016 | 0,022 | 0,026 |
| H5 | MP16-1600.9HFZ3-MD12 MP3000 | 0,50 | 0,44 | 0,40 | 0,40 | 0,50 | 0,60 |
| | | 0,020 | 0,017 | 0,016 | 0,016 | 0,020 | 0,024 |
| H8 | MP16-1600.9HFZ3-MD12 MP3000 | 0,44 | 0,34 | 0,30 | 0,30 | 0,40 | 0,46 |
| | | 0,017 | 0,013 | 0,012 | 0,012 | 0,016 | 0,018 |
| H11 | MP16-1600.9HFZ3-MD12 MP3000 | 0,50 | 0,44 | 0,40 | 0,40 | 0,50 | 0,60 |
| | | 0,020 | 0,017 | 0,016 | 0,016 | 0,020 | 0,024 |
| H12 | MP16-1600.9HFZ3-MD12 MP3000 | 0,44 | 0,34 | 0,30 | 0,30 | 0,40 | 0,46 |
| | | 0,017 | 0,013 | 0,012 | 0,012 | 0,016 | 0,018 |
| H21 | MP16-1600.9HFZ3-MD12 MP3000 | 0,44 | 0,34 | 0,30 | 0,30 | 0,40 | 0,46 |
| | | 0,017 | 0,013 | 0,012 | 0,012 | 0,016 | 0,018 |

SMG = Seco Werkstoff-Gruppe
 f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
 Alle Schnittdaten sind Startwerte

Universell
 Stahl und Guss
 Stahl und Guss
 Rostfrei und ISO-S-Werkstoffe
 Rostfrei und ISO-S-Werkstoffe
 NE-Metalle
 Harter
 Graphit
 X-Heads
 Minimaster Plus
 Minimaster

MP16 Hochvorschubfräsen – Schnittdaten v_c =(m/min)

| | SMG | MP3000 | | | |
|-------------------------------|-----|--------|------|------|------|
| | | 100% | 70% | 30% | 20% |
| Universell | P1 | 225 | 270 | 315 | 335 |
| | | 740 | 890 | 1025 | 1100 |
| Stahl und Guss | P2 | 215 | 265 | 305 | 325 |
| | | 710 | 870 | 1000 | 1075 |
| Rostfrei und ISO-S-Werkstoffe | P3 | 190 | 230 | 265 | 280 |
| | | 620 | 750 | 870 | 920 |
| NE-Metalle | P4 | 165 | 205 | 235 | 250 |
| | | 540 | 670 | 770 | 820 |
| Harter | P5 | 160 | 195 | 230 | 240 |
| | | 520 | 640 | 750 | 790 |
| Kunststoffe und Composite | P6 | 180 | 220 | 255 | 265 |
| | | 590 | 720 | 840 | 870 |
| Graphit | P7 | 170 | 205 | 240 | 250 |
| | | 560 | 670 | 790 | 820 |
| X-Heads | P8 | 160 | 195 | 225 | 235 |
| | | 520 | 640 | 740 | 770 |
| Minimaster Plus | P11 | 165 | 200 | 235 | 245 |
| | | 540 | 660 | 770 | 800 |
| Minimaster | P12 | 105 | 130 | 150 | 160 |
| | | 345 | 425 | 490 | 520 |
| | M1 | 160 | 195 | 230 | 245 |
| | | 520 | 640 | 750 | 800 |
| | M2 | 130 | 165 | 190 | 200 |
| | | 425 | 540 | 620 | 660 |
| | M3 | 105 | 135 | 155 | 160 |
| | | 345 | 445 | 510 | 520 |
| | M4 | 85 | 105 | 115 | 125 |
| | | 280 | 345 | 375 | 410 |
| | M5 | 70 | 85 | 100 | 105 |
| | | 230 | 280 | 330 | 345 |
| | K1 | 170 | 210 | 240 | 255 |
| | | 560 | 690 | 790 | 840 |
| | K2 | 150 | 185 | 215 | 225 |
| | | 490 | 610 | 710 | 740 |
| | K3 | 125 | 155 | 185 | 190 |
| | | 410 | 510 | 610 | 620 |
| | K4 | 120 | 150 | 175 | 180 |
| | | 395 | 490 | 570 | 590 |
| | K5 | 75 | 95 | 105 | 110 |
| | | 245 | 310 | 345 | 360 |
| | K6 | 105 | 130 | 155 | 160 |
| | | 345 | 425 | 510 | 520 |
| | K7 | 95 | 120 | 135 | 145 |
| | | 310 | 395 | 445 | 475 |
| | N1 | 1275 | 1550 | 1775 | 1850 |
| | | 4175 | 5075 | 5825 | 6075 |
| | N2 | 510 | 630 | 720 | 750 |
| | | 1675 | 2075 | 2350 | 2450 |
| | N3 | 340 | 420 | 480 | 500 |
| | | 1125 | 1375 | 1575 | 1650 |
| | N11 | 390 | 480 | 550 | 570 |
| | | 1275 | 1575 | 1800 | 1875 |
| | S1 | 40 | 48 | 55 | 60 |
| | | 130 | 155 | 180 | 195 |
| | S2 | 32 | 39 | 44 | 47 |
| | | 105 | 130 | 145 | 155 |
| | S3 | 28 | 34 | 39 | 41 |
| | | 90 | 110 | 130 | 135 |
| | S11 | 55 | 65 | 75 | 80 |
| | | 180 | 215 | 245 | 260 |
| | S12 | 38 | 46 | 55 | 55 |
| | | 125 | 150 | 180 | 180 |
| | S13 | 22 | 27 | 31 | 33 |
| | | 70 | 90 | 100 | 110 |
| | H5 | 33 | 41 | 47 | 50 |
| | | 110 | 135 | 155 | 165 |
| | H8 | 36 | 43 | 50 | 55 |
| | | 120 | 140 | 165 | 180 |
| | H11 | 42 | 50 | 60 | 65 |
| | | 140 | 165 | 195 | 215 |
| | H12 | 70 | 85 | 95 | 100 |
| | | 230 | 280 | 310 | 330 |
| | H21 | 36 | 43 | 50 | 55 |
| | | 120 | 140 | 165 | 180 |

MP16 Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a_p | f_z | | | |
|-----|----------------------------|-------|--------|--------|--------|--------|
| | | | 100% | 30% | 10% | 5% |
| P1 | MP16-16010R04Z3-M05 MP3000 | 5,0 | 0,070 | 0,075 | 0,12 | 0,16 |
| | | 0,20 | 0,0028 | 0,0030 | 0,0048 | 0,0065 |
| P2 | MP16-16010R04Z3-M05 MP3000 | 5,0 | 0,070 | 0,080 | 0,12 | 0,17 |
| | | 0,20 | 0,0028 | 0,0032 | 0,0048 | 0,0065 |
| P3 | MP16-16010R04Z3-M05 MP3000 | 5,0 | 0,070 | 0,075 | 0,11 | 0,16 |
| | | 0,20 | 0,0028 | 0,0030 | 0,0044 | 0,0065 |
| P4 | MP16-16010R04Z3-M05 MP3000 | 5,0 | 0,065 | 0,075 | 0,11 | 0,16 |
| | | 0,20 | 0,0026 | 0,0030 | 0,0044 | 0,0065 |
| P5 | MP16-16010R04Z3-M05 MP3000 | 5,0 | 0,065 | 0,070 | 0,11 | 0,15 |
| | | 0,20 | 0,0026 | 0,0028 | 0,0044 | 0,0060 |
| P6 | MP16-16010R04Z3-M05 MP3000 | 5,0 | 0,065 | 0,070 | 0,11 | 0,15 |
| | | 0,20 | 0,0026 | 0,0028 | 0,0044 | 0,0060 |
| P7 | MP16-16010R04Z3-M05 MP3000 | 5,0 | 0,065 | 0,070 | 0,11 | 0,15 |
| | | 0,20 | 0,0026 | 0,0028 | 0,0044 | 0,0060 |
| P8 | MP16-16010R04Z3-M05 MP3000 | 5,0 | 0,070 | 0,075 | 0,11 | 0,16 |
| | | 0,20 | 0,0028 | 0,0030 | 0,0044 | 0,0065 |
| P11 | MP16-16010R04Z3-M05 MP3000 | 5,0 | 0,065 | 0,070 | 0,11 | 0,15 |
| | | 0,20 | 0,0026 | 0,0028 | 0,0044 | 0,0060 |
| P12 | MP16-16010R04Z3-M05 MP3000 | 4,0 | 0,044 | 0,048 | 0,075 | 0,10 |
| | | 0,16 | 0,0017 | 0,0019 | 0,0030 | 0,0040 |
| M1 | MP16-16010R05Z3-E05 F40M | 5,0 | 0,070 | 0,080 | 0,12 | 0,17 |
| | | 0,20 | 0,0028 | 0,0032 | 0,0048 | 0,0065 |
| M2 | MP16-16010R05Z3-E05 F40M | 5,0 | 0,065 | 0,070 | 0,11 | 0,15 |
| | | 0,20 | 0,0026 | 0,0028 | 0,0044 | 0,0060 |
| M3 | MP16-16010R05Z3-E05 F40M | 4,0 | 0,050 | 0,055 | 0,085 | 0,12 |
| | | 0,16 | 0,0020 | 0,0022 | 0,0034 | 0,0048 |
| M4 | MP16-16010R05Z3-E05 F40M | 3,0 | 0,046 | 0,050 | 0,075 | 0,11 |
| | | 0,12 | 0,0018 | 0,0020 | 0,0030 | 0,0044 |
| M5 | MP16-16010R05Z3-E05 F40M | 3,0 | 0,046 | 0,050 | 0,075 | 0,11 |
| | | 0,12 | 0,0018 | 0,0020 | 0,0030 | 0,0044 |
| K1 | MP16-16010R04Z3-M05 MP3000 | 5,0 | 0,070 | 0,080 | 0,12 | 0,17 |
| | | 0,20 | 0,0028 | 0,0032 | 0,0048 | 0,0065 |
| K2 | MP16-16010R04Z3-M05 MP3000 | 5,0 | 0,065 | 0,070 | 0,11 | 0,15 |
| | | 0,20 | 0,0026 | 0,0028 | 0,0044 | 0,0060 |
| K3 | MP16-16010R04Z3-M05 MP3000 | 5,0 | 0,065 | 0,070 | 0,11 | 0,15 |
| | | 0,20 | 0,0026 | 0,0028 | 0,0044 | 0,0060 |
| K4 | MP16-16010R04Z3-M05 MP3000 | 5,0 | 0,065 | 0,070 | 0,11 | 0,15 |
| | | 0,20 | 0,0026 | 0,0028 | 0,0044 | 0,0060 |
| K5 | MP16-16010R04Z3-M05 MP3000 | 5,0 | 0,060 | 0,065 | 0,10 | 0,14 |
| | | 0,20 | 0,0024 | 0,0026 | 0,0040 | 0,0055 |
| K6 | MP16-16010R04Z3-M05 MP3000 | 5,0 | 0,065 | 0,070 | 0,11 | 0,15 |
| | | 0,20 | 0,0026 | 0,0028 | 0,0044 | 0,0060 |
| K7 | MP16-16010R04Z3-M05 MP3000 | 5,0 | 0,060 | 0,065 | 0,10 | 0,14 |
| | | 0,20 | 0,0024 | 0,0026 | 0,0040 | 0,0055 |
| N1 | MP16-16010R05Z3-E05 F40M | 5,0 | 0,090 | 0,10 | 0,15 | 0,22 |
| | | 0,20 | 0,0036 | 0,0040 | 0,0060 | 0,0085 |
| N2 | MP16-16010R05Z3-E05 F40M | 5,0 | 0,090 | 0,10 | 0,15 | 0,22 |
| | | 0,20 | 0,0036 | 0,0040 | 0,0060 | 0,0085 |
| N3 | MP16-16010R05Z3-E05 F40M | 5,0 | 0,090 | 0,10 | 0,15 | 0,22 |
| | | 0,20 | 0,0036 | 0,0040 | 0,0060 | 0,0085 |
| N11 | MP16-16010R05Z3-E05 F40M | 5,0 | 0,090 | 0,10 | 0,15 | 0,22 |
| | | 0,20 | 0,0036 | 0,0040 | 0,0060 | 0,0085 |
| S1 | MP16-16010R05Z3-E05 F40M | 3,0 | 0,046 | 0,050 | 0,075 | 0,11 |
| | | 0,12 | 0,0018 | 0,0020 | 0,0030 | 0,0044 |
| S2 | MP16-16010R05Z3-E05 F40M | 3,0 | 0,046 | 0,050 | 0,075 | 0,11 |
| | | 0,12 | 0,0018 | 0,0020 | 0,0030 | 0,0044 |
| S3 | MP16-16010R05Z3-E05 F40M | 3,0 | 0,042 | 0,046 | 0,070 | 0,10 |
| | | 0,12 | 0,0017 | 0,0018 | 0,0028 | 0,0040 |
| S11 | MP16-16010R05Z3-E05 F40M | 3,5 | 0,055 | 0,055 | 0,085 | 0,12 |
| | | 0,14 | 0,0022 | 0,0022 | 0,0034 | 0,0048 |
| S12 | MP16-16010R05Z3-E05 F40M | 3,5 | 0,055 | 0,055 | 0,085 | 0,12 |
| | | 0,14 | 0,0022 | 0,0022 | 0,0034 | 0,0048 |
| S13 | MP16-16010R05Z3-E05 F40M | 3,0 | 0,046 | 0,050 | 0,075 | 0,11 |
| | | 0,12 | 0,0018 | 0,0020 | 0,0030 | 0,0044 |
| H5 | MP16-16010R04Z3-M05 MP3000 | 4,0 | 0,044 | 0,048 | 0,075 | 0,10 |
| | | 0,16 | 0,0017 | 0,0019 | 0,0030 | 0,0040 |
| H8 | MP16-16010R04Z3-M05 MP3000 | 3,5 | 0,034 | 0,038 | 0,055 | 0,080 |
| | | 0,14 | 0,0013 | 0,0015 | 0,0022 | 0,0032 |
| H11 | MP16-16010R04Z3-M05 MP3000 | 4,0 | 0,044 | 0,048 | 0,075 | 0,10 |
| | | 0,16 | 0,0017 | 0,0019 | 0,0030 | 0,0040 |
| H12 | MP16-16010R04Z3-M05 MP3000 | 3,5 | 0,034 | 0,038 | 0,055 | 0,080 |
| | | 0,14 | 0,0013 | 0,0015 | 0,0022 | 0,0032 |
| H21 | MP16-16010R04Z3-M05 MP3000 | 3,5 | 0,034 | 0,038 | 0,055 | 0,080 |
| | | 0,14 | 0,0013 | 0,0015 | 0,0022 | 0,0032 |

SMG = Seco Werkstoff-Gruppe
 f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
 Alle Schnittdaten sind Startwerte

Univerrsell
 Stahl und Guss
 Rostfrei und ISO-S-Werkstoffe
 Rostfrei und ISO-S-Werkstoffe
 NE-Metalle
 Harter
 Graphit
 X-Heads
 Minimaster Plus
 Minimaster

MP16 Nutfräsen – Schnittdaten v_c (m/min)

| | SMG | MP3000 | | | | F40M | | | |
|-------------------------------|-----|--------|------|------|------|------|------|------|------|
| | | 100% | 30% | 10% | 5% | 100% | 30% | 10% | 5% |
| Universell | P1 | 235 | 310 | 360 | 395 | 225 | 295 | 340 | 375 |
| | | 770 | 1025 | 1175 | 1300 | 740 | 970 | 1125 | 1225 |
| Stahl und Guss | P2 | 230 | 300 | 350 | 380 | 215 | 280 | 335 | 360 |
| | | 750 | 980 | 1150 | 1250 | 710 | 920 | 1100 | 1175 |
| Rostfrei und ISO-S-Werkstoffe | P3 | 195 | 260 | 310 | 330 | 185 | 245 | 290 | 315 |
| | | 640 | 850 | 1025 | 1075 | 610 | 800 | 950 | 1025 |
| NE-Metalle | P4 | 175 | 230 | 270 | 290 | 165 | 215 | 255 | 275 |
| | | 570 | 750 | 890 | 950 | 540 | 710 | 840 | 900 |
| Harter | P5 | 170 | 220 | 260 | 280 | 160 | 210 | 245 | 265 |
| | | 560 | 720 | 850 | 920 | 520 | 690 | 800 | 870 |
| Kunststoffe und Composite | P6 | 190 | 250 | 290 | 315 | 180 | 235 | 275 | 300 |
| | | 620 | 820 | 950 | 1025 | 590 | 770 | 900 | 980 |
| Graphit | P7 | 180 | 235 | 275 | 300 | 170 | 225 | 260 | 285 |
| | | 590 | 770 | 900 | 980 | 560 | 740 | 850 | 940 |
| X-Heads | P8 | 165 | 220 | 260 | 280 | 155 | 205 | 245 | 265 |
| | | 540 | 720 | 850 | 920 | 510 | 670 | 800 | 870 |
| Minimaster Plus | P11 | 175 | 230 | 265 | 290 | 165 | 215 | 255 | 275 |
| | | 570 | 750 | 870 | 950 | 540 | 710 | 840 | 900 |
| Minimaster | P12 | 110 | 145 | 170 | 185 | 105 | 140 | 160 | 175 |
| | | 360 | 475 | 560 | 610 | 345 | 460 | 520 | 570 |
| Minimaster | M1 | 170 | 225 | 265 | 285 | 175 | 225 | 270 | 290 |
| | | 560 | 740 | 870 | 940 | 570 | 740 | 890 | 950 |
| Minimaster | M2 | 140 | 185 | 215 | 235 | 145 | 190 | 220 | 240 |
| | | 460 | 610 | 710 | 770 | 475 | 620 | 720 | 790 |
| Minimaster | M3 | 115 | 150 | 175 | 190 | 115 | 150 | 175 | 190 |
| | | 375 | 490 | 570 | 620 | 375 | 490 | 570 | 620 |
| Minimaster | M4 | 85 | 115 | 135 | 145 | 90 | 115 | 135 | 145 |
| | | 280 | 375 | 445 | 475 | 295 | 375 | 445 | 475 |
| Minimaster | M5 | 75 | 95 | 110 | 120 | 75 | 95 | 115 | 120 |
| | | 245 | 310 | 360 | 395 | 245 | 310 | 375 | 395 |
| Minimaster | K1 | 180 | 235 | 280 | 300 | 170 | 225 | 265 | 285 |
| | | 590 | 770 | 920 | 980 | 560 | 740 | 870 | 940 |
| Minimaster | K2 | 160 | 210 | 245 | 270 | 150 | 200 | 235 | 255 |
| | | 520 | 690 | 800 | 890 | 490 | 660 | 770 | 840 |
| Minimaster | K3 | 135 | 180 | 210 | 225 | 130 | 170 | 195 | 215 |
| | | 445 | 590 | 690 | 740 | 425 | 560 | 640 | 710 |
| Minimaster | K4 | 130 | 170 | 200 | 215 | 120 | 160 | 190 | 205 |
| | | 425 | 560 | 660 | 710 | 395 | 520 | 620 | 670 |
| Minimaster | K5 | 80 | 105 | 120 | 130 | 75 | 95 | 115 | 125 |
| | | 260 | 345 | 395 | 425 | 245 | 310 | 375 | 410 |
| Minimaster | K6 | 115 | 150 | 175 | 190 | 110 | 140 | 165 | 180 |
| | | 375 | 490 | 570 | 620 | 360 | 460 | 540 | 590 |
| Minimaster | K7 | 100 | 130 | 155 | 165 | 95 | 125 | 145 | 160 |
| | | 330 | 425 | 510 | 540 | 310 | 410 | 475 | 520 |
| Minimaster | N1 | 1350 | 1775 | 2100 | 2250 | 1275 | 1675 | 1975 | 2125 |
| | | 4425 | 5825 | 6900 | 7375 | 4175 | 5500 | 6475 | 6975 |
| Minimaster | N2 | 550 | 720 | 850 | 910 | 520 | 680 | 800 | 860 |
| | | 1800 | 2350 | 2800 | 2975 | 1700 | 2225 | 2625 | 2825 |
| Minimaster | N3 | 365 | 475 | 560 | 600 | 345 | 450 | 530 | 570 |
| | | 1200 | 1550 | 1825 | 1975 | 1125 | 1475 | 1750 | 1875 |
| Minimaster | N11 | 415 | 540 | 640 | 690 | 395 | 520 | 610 | 650 |
| | | 1350 | 1775 | 2100 | 2275 | 1300 | 1700 | 2000 | 2125 |
| Minimaster | S1 | 41 | 55 | 60 | 65 | 42 | 55 | 65 | 70 |
| | | 135 | 180 | 195 | 215 | 140 | 180 | 215 | 230 |
| Minimaster | S2 | 33 | 43 | 50 | 55 | 34 | 44 | 50 | 55 |
| | | 110 | 140 | 165 | 180 | 110 | 145 | 165 | 180 |
| Minimaster | S3 | 29 | 38 | 44 | 47 | 29 | 38 | 45 | 48 |
| | | 95 | 125 | 145 | 155 | 95 | 125 | 150 | 155 |
| Minimaster | S11 | 60 | 75 | 90 | 95 | 60 | 75 | 90 | 95 |
| | | 195 | 245 | 295 | 310 | 195 | 245 | 295 | 310 |
| Minimaster | S12 | 40 | 50 | 60 | 65 | 40 | 55 | 60 | 65 |
| | | 130 | 165 | 195 | 215 | 130 | 180 | 195 | 215 |
| Minimaster | S13 | 23 | 30 | 35 | 38 | 23 | 31 | 36 | 38 |
| | | 75 | 100 | 115 | 125 | 75 | 100 | 120 | 125 |
| Minimaster | H5 | 35 | 45 | 55 | 60 | 35 | 46 | 55 | 60 |
| | | 115 | 150 | 180 | 195 | 115 | 150 | 180 | 195 |
| Minimaster | H8 | 36 | 47 | 55 | 60 | 37 | 48 | 55 | 60 |
| | | 120 | 155 | 180 | 195 | 120 | 155 | 180 | 195 |
| Minimaster | H11 | 44 | 60 | 65 | 75 | 45 | 60 | 70 | 75 |
| | | 145 | 195 | 215 | 245 | 150 | 195 | 230 | 245 |
| Minimaster | H12 | 70 | 90 | 105 | 115 | 65 | 85 | 100 | 110 |
| | | 230 | 295 | 345 | 375 | 215 | 280 | 330 | 360 |
| Minimaster | H21 | 36 | 47 | 55 | 60 | 37 | 48 | 55 | 60 |
| | | 120 | 155 | 180 | 195 | 120 | 155 | 180 | 195 |

MP16 Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | | |
|-----|----------------------------|----------------|----------------|--------|--------|--------|--------|
| | | | 100% | 30% | 10% | 5% | 2% |
| P1 | MP16-16010B90Z3-M05 MP3000 | 5,0 | 0,080 | 0,085 | 0,12 | 0,17 | 0,28 |
| | | 0.20 | 0.0032 | 0.0034 | 0.0048 | 0.0065 | 0.011 |
| P2 | MP16-16010B90Z3-M05 MP3000 | 5,0 | 0,085 | 0,085 | 0,13 | 0,18 | 0,28 |
| | | 0.20 | 0.0034 | 0.0034 | 0.0050 | 0.0070 | 0.011 |
| P3 | MP16-16010B90Z3-M05 MP3000 | 5,0 | 0,080 | 0,080 | 0,12 | 0,17 | 0,26 |
| | | 0.20 | 0.0032 | 0.0032 | 0.0048 | 0.0065 | 0.010 |
| P4 | MP16-16010B90Z3-M05 MP3000 | 5,0 | 0,075 | 0,080 | 0,12 | 0,16 | 0,26 |
| | | 0.20 | 0.0030 | 0.0032 | 0.0048 | 0.0065 | 0.010 |
| P5 | MP16-16010B90Z3-M05 MP3000 | 5,0 | 0,075 | 0,080 | 0,12 | 0,16 | 0,26 |
| | | 0.20 | 0.0030 | 0.0032 | 0.0048 | 0.0065 | 0.010 |
| P6 | MP16-16010B90Z3-M05 MP3000 | 5,0 | 0,075 | 0,080 | 0,11 | 0,16 | 0,26 |
| | | 0.20 | 0.0030 | 0.0032 | 0.0044 | 0.0065 | 0.010 |
| P7 | MP16-16010B90Z3-M05 MP3000 | 5,0 | 0,075 | 0,080 | 0,11 | 0,16 | 0,26 |
| | | 0.20 | 0.0030 | 0.0032 | 0.0044 | 0.0065 | 0.010 |
| P8 | MP16-16010B90Z3-M05 MP3000 | 5,0 | 0,080 | 0,080 | 0,12 | 0,17 | 0,26 |
| | | 0.20 | 0.0032 | 0.0032 | 0.0048 | 0.0065 | 0.010 |
| P11 | MP16-16010B90Z3-M05 MP3000 | 5,0 | 0,075 | 0,080 | 0,11 | 0,16 | 0,26 |
| | | 0.20 | 0.0030 | 0.0032 | 0.0044 | 0.0065 | 0.010 |
| P12 | MP16-16010B90Z3-M05 MP3000 | 4,0 | 0,055 | 0,055 | 0,080 | 0,11 | 0,17 |
| | | 0.16 | 0.0022 | 0.0022 | 0.0032 | 0.0044 | 0.0065 |
| M1 | MP16-16010B90Z3-E05 F40M | 5,0 | 0,085 | 0,085 | 0,13 | 0,18 | 0,28 |
| | | 0.20 | 0.0034 | 0.0034 | 0.0050 | 0.0070 | 0.011 |
| M2 | MP16-16010B90Z3-E05 F40M | 5,0 | 0,075 | 0,080 | 0,12 | 0,16 | 0,26 |
| | | 0.20 | 0.0030 | 0.0032 | 0.0048 | 0.0065 | 0.010 |
| M3 | MP16-16010B90Z3-E05 F40M | 4,0 | 0,065 | 0,065 | 0,090 | 0,13 | 0,20 |
| | | 0.16 | 0.0026 | 0.0026 | 0.0036 | 0.0050 | 0.0080 |
| M4 | MP16-16010B90Z3-E05 F40M | 3,0 | 0,060 | 0,060 | 0,080 | 0,11 | 0,18 |
| | | 0.12 | 0.0024 | 0.0024 | 0.0032 | 0.0044 | 0.0070 |
| M5 | MP16-16010B90Z3-E05 F40M | 3,0 | 0,060 | 0,060 | 0,080 | 0,11 | 0,18 |
| | | 0.12 | 0.0024 | 0.0024 | 0.0032 | 0.0044 | 0.0070 |
| K1 | MP16-16010B90Z3-M05 MP3000 | 5,0 | 0,085 | 0,085 | 0,13 | 0,18 | 0,28 |
| | | 0.20 | 0.0034 | 0.0034 | 0.0050 | 0.0070 | 0.011 |
| K2 | MP16-16010B90Z3-M05 MP3000 | 5,0 | 0,075 | 0,080 | 0,12 | 0,16 | 0,26 |
| | | 0.20 | 0.0030 | 0.0032 | 0.0048 | 0.0065 | 0.010 |
| K3 | MP16-16010B90Z3-M05 MP3000 | 5,0 | 0,075 | 0,080 | 0,12 | 0,16 | 0,26 |
| | | 0.20 | 0.0030 | 0.0032 | 0.0048 | 0.0065 | 0.010 |
| K4 | MP16-16010B90Z3-M05 MP3000 | 5,0 | 0,075 | 0,080 | 0,12 | 0,16 | 0,26 |
| | | 0.20 | 0.0030 | 0.0032 | 0.0048 | 0.0065 | 0.010 |
| K5 | MP16-16010B90Z3-M05 MP3000 | 5,0 | 0,070 | 0,070 | 0,10 | 0,14 | 0,24 |
| | | 0.20 | 0.0028 | 0.0028 | 0.0040 | 0.0055 | 0.0095 |
| K6 | MP16-16010B90Z3-M05 MP3000 | 5,0 | 0,075 | 0,080 | 0,12 | 0,16 | 0,26 |
| | | 0.20 | 0.0030 | 0.0032 | 0.0048 | 0.0065 | 0.010 |
| K7 | MP16-16010B90Z3-M05 MP3000 | 5,0 | 0,070 | 0,070 | 0,10 | 0,14 | 0,24 |
| | | 0.20 | 0.0028 | 0.0028 | 0.0040 | 0.0055 | 0.0095 |
| N1 | MP16-16010B90Z3-E05 F40M | 5,0 | 0,11 | 0,11 | 0,16 | 0,22 | 0,38 |
| | | 0.20 | 0.0044 | 0.0044 | 0.0065 | 0.0085 | 0.015 |
| N2 | MP16-16010B90Z3-E05 F40M | 5,0 | 0,11 | 0,11 | 0,16 | 0,22 | 0,38 |
| | | 0.20 | 0.0044 | 0.0044 | 0.0065 | 0.0085 | 0.015 |
| N3 | MP16-16010B90Z3-E05 F40M | 5,0 | 0,11 | 0,11 | 0,16 | 0,22 | 0,38 |
| | | 0.20 | 0.0044 | 0.0044 | 0.0065 | 0.0085 | 0.015 |
| N11 | MP16-16010B90Z3-E05 F40M | 5,0 | 0,11 | 0,11 | 0,16 | 0,22 | 0,38 |
| | | 0.20 | 0.0044 | 0.0044 | 0.0065 | 0.0085 | 0.015 |
| S1 | MP16-16010B90Z3-E05 F40M | 3,0 | 0,060 | 0,060 | 0,080 | 0,11 | 0,18 |
| | | 0.12 | 0.0024 | 0.0024 | 0.0032 | 0.0044 | 0.0070 |
| S2 | MP16-16010B90Z3-E05 F40M | 3,0 | 0,060 | 0,060 | 0,080 | 0,11 | 0,18 |
| | | 0.12 | 0.0024 | 0.0024 | 0.0032 | 0.0044 | 0.0070 |
| S3 | MP16-16010B90Z3-E05 F40M | 3,0 | 0,055 | 0,055 | 0,075 | 0,10 | 0,16 |
| | | 0.12 | 0.0022 | 0.0022 | 0.0030 | 0.0040 | 0.0065 |
| S11 | MP16-16010B90Z3-E05 F40M | 3,5 | 0,065 | 0,065 | 0,090 | 0,13 | 0,20 |
| | | 0.14 | 0.0026 | 0.0026 | 0.0036 | 0.0050 | 0.0080 |
| S12 | MP16-16010B90Z3-E05 F40M | 3,5 | 0,065 | 0,065 | 0,090 | 0,13 | 0,20 |
| | | 0.14 | 0.0026 | 0.0026 | 0.0036 | 0.0050 | 0.0080 |
| S13 | MP16-16010B90Z3-E05 F40M | 3,0 | 0,060 | 0,060 | 0,080 | 0,11 | 0,18 |
| | | 0.12 | 0.0024 | 0.0024 | 0.0032 | 0.0044 | 0.0070 |
| H5 | MP16-16010B90Z3-M05 MP3000 | 4,0 | 0,055 | 0,055 | 0,080 | 0,11 | 0,17 |
| | | 0.16 | 0.0022 | 0.0022 | 0.0032 | 0.0044 | 0.0065 |
| H8 | MP16-16010B90Z3-M05 MP3000 | 3,5 | 0,042 | 0,042 | 0,060 | 0,080 | 0,13 |
| | | 0.14 | 0.0017 | 0.0017 | 0.0024 | 0.0032 | 0.0050 |
| H11 | MP16-16010B90Z3-M05 MP3000 | 4,0 | 0,055 | 0,055 | 0,080 | 0,11 | 0,17 |
| | | 0.16 | 0.0022 | 0.0022 | 0.0032 | 0.0044 | 0.0065 |
| H12 | MP16-16010B90Z3-M05 MP3000 | 3,5 | 0,042 | 0,042 | 0,060 | 0,080 | 0,13 |
| | | 0.14 | 0.0017 | 0.0017 | 0.0024 | 0.0032 | 0.0050 |
| H21 | MP16-16010B90Z3-M05 MP3000 | 3,5 | 0,042 | 0,042 | 0,060 | 0,080 | 0,13 |
| | | 0.14 | 0.0017 | 0.0017 | 0.0024 | 0.0032 | 0.0050 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

Unversell
Stahl und Guss
Stahl und Guss
Rostrfrei und ISO-S-Werkstoffe
Rostrfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MP16 Kopierfräsen – Schnittdaten $v_c = (m/min)$

| SMG | MP3000 | | | | | F40M | | | | |
|-----|--------|------|------|------|------|------|------|------|------|------|
| | 100% | 30% | 10% | 5% | 2% | 100% | 30% | 10% | 5% | 2% |
| P1 | 250 | 305 | 330 | 355 | 350 | 235 | 290 | 310 | 335 | 330 |
| | 820 | 1000 | 1075 | 1175 | 1150 | 770 | 950 | 1025 | 1100 | 1075 |
| P2 | 240 | 295 | 320 | 345 | 340 | 225 | 275 | 300 | 325 | 325 |
| | 790 | 970 | 1050 | 1125 | 1125 | 740 | 900 | 980 | 1075 | 1075 |
| P3 | 210 | 255 | 275 | 300 | 300 | 200 | 240 | 260 | 285 | 280 |
| | 690 | 840 | 900 | 980 | 980 | 660 | 790 | 850 | 940 | 920 |
| P4 | 185 | 225 | 245 | 265 | 265 | 175 | 215 | 235 | 250 | 250 |
| | 610 | 740 | 800 | 870 | 870 | 570 | 710 | 770 | 820 | 820 |
| P5 | 180 | 215 | 235 | 255 | 255 | 170 | 205 | 220 | 240 | 240 |
| | 590 | 710 | 770 | 840 | 840 | 560 | 670 | 720 | 790 | 790 |
| P6 | 200 | 245 | 265 | 285 | 285 | 190 | 230 | 250 | 270 | 270 |
| | 660 | 800 | 870 | 940 | 940 | 620 | 750 | 820 | 890 | 890 |
| P7 | 190 | 230 | 250 | 270 | 270 | 180 | 215 | 235 | 255 | 255 |
| | 620 | 750 | 820 | 890 | 890 | 590 | 710 | 770 | 840 | 840 |
| P8 | 175 | 215 | 230 | 250 | 250 | 165 | 205 | 220 | 240 | 235 |
| | 570 | 710 | 750 | 820 | 820 | 540 | 670 | 720 | 790 | 770 |
| P11 | 185 | 225 | 240 | 265 | 260 | 175 | 210 | 230 | 250 | 245 |
| | 610 | 740 | 790 | 870 | 850 | 570 | 690 | 750 | 820 | 800 |
| P12 | 120 | 145 | 150 | 165 | 165 | 110 | 135 | 145 | 155 | 155 |
| | 395 | 475 | 490 | 540 | 540 | 360 | 445 | 475 | 510 | 510 |
| M1 | 180 | 220 | 240 | 260 | 255 | 185 | 225 | 245 | 265 | 260 |
| | 590 | 720 | 790 | 850 | 840 | 610 | 740 | 800 | 870 | 850 |
| M2 | 150 | 180 | 195 | 215 | 210 | 150 | 185 | 200 | 215 | 215 |
| | 490 | 590 | 640 | 710 | 690 | 490 | 610 | 660 | 710 | 710 |
| M3 | 120 | 145 | 155 | 170 | 165 | 125 | 150 | 160 | 170 | 170 |
| | 395 | 475 | 510 | 560 | 540 | 410 | 490 | 520 | 560 | 560 |
| M4 | 95 | 115 | 120 | 130 | 130 | 95 | 120 | 120 | 130 | 130 |
| | 310 | 375 | 395 | 425 | 425 | 310 | 395 | 395 | 425 | 425 |
| M5 | 80 | 95 | 100 | 105 | 105 | 80 | 100 | 100 | 110 | 110 |
| | 260 | 310 | 330 | 345 | 345 | 260 | 330 | 330 | 360 | 360 |
| K1 | 190 | 230 | 255 | 275 | 270 | 180 | 220 | 240 | 260 | 255 |
| | 620 | 750 | 840 | 900 | 890 | 590 | 720 | 790 | 850 | 840 |
| K2 | 170 | 205 | 225 | 245 | 240 | 160 | 195 | 210 | 230 | 225 |
| | 560 | 670 | 740 | 800 | 790 | 520 | 640 | 690 | 750 | 740 |
| K3 | 145 | 175 | 190 | 205 | 205 | 135 | 165 | 180 | 195 | 190 |
| | 475 | 570 | 620 | 670 | 670 | 445 | 540 | 590 | 640 | 620 |
| K4 | 135 | 165 | 180 | 195 | 195 | 130 | 155 | 170 | 185 | 185 |
| | 445 | 540 | 590 | 640 | 640 | 425 | 510 | 560 | 610 | 610 |
| K5 | 80 | 100 | 110 | 120 | 120 | 80 | 95 | 105 | 110 | 110 |
| | 260 | 330 | 360 | 395 | 395 | 260 | 310 | 345 | 360 | 360 |
| K6 | 120 | 145 | 160 | 175 | 170 | 115 | 140 | 150 | 165 | 160 |
| | 395 | 475 | 520 | 570 | 560 | 375 | 460 | 490 | 540 | 520 |
| K7 | 105 | 130 | 140 | 150 | 150 | 100 | 120 | 130 | 145 | 145 |
| | 345 | 425 | 460 | 490 | 490 | 330 | 395 | 425 | 475 | 475 |
| N1 | 1425 | 1750 | 1900 | 2050 | 2025 | 1350 | 1650 | 1775 | 1950 | 1925 |
| | 4675 | 5750 | 6225 | 6725 | 6650 | 4425 | 5425 | 5825 | 6400 | 6325 |
| N2 | 580 | 700 | 760 | 830 | 820 | 550 | 660 | 720 | 780 | 780 |
| | 1900 | 2300 | 2500 | 2725 | 2700 | 1800 | 2175 | 2350 | 2550 | 2550 |
| N3 | 385 | 470 | 510 | 550 | 550 | 365 | 445 | 480 | 520 | 520 |
| | 1275 | 1550 | 1675 | 1800 | 1800 | 1200 | 1450 | 1575 | 1700 | 1700 |
| N11 | 440 | 540 | 580 | 630 | 630 | 415 | 510 | 550 | 600 | 590 |
| | 1450 | 1775 | 1900 | 2075 | 2075 | 1350 | 1675 | 1800 | 1975 | 1925 |
| S1 | 44 | 55 | 55 | 60 | 60 | 45 | 55 | 55 | 60 | 60 |
| | 145 | 180 | 180 | 195 | 195 | 150 | 180 | 180 | 195 | 195 |
| S2 | 36 | 44 | 45 | 48 | 48 | 36 | 44 | 45 | 49 | 49 |
| | 120 | 145 | 150 | 155 | 155 | 120 | 145 | 150 | 160 | 160 |
| S3 | 31 | 38 | 39 | 42 | 42 | 32 | 38 | 40 | 43 | 43 |
| | 100 | 125 | 130 | 140 | 140 | 105 | 125 | 130 | 140 | 140 |
| S11 | 60 | 75 | 80 | 85 | 85 | 65 | 75 | 80 | 85 | 85 |
| | 195 | 245 | 260 | 280 | 280 | 215 | 245 | 260 | 280 | 280 |
| S12 | 43 | 50 | 55 | 60 | 60 | 44 | 55 | 55 | 60 | 60 |
| | 140 | 165 | 180 | 195 | 195 | 145 | 180 | 180 | 195 | 195 |
| S13 | 25 | 30 | 31 | 34 | 34 | 25 | 31 | 32 | 34 | 34 |
| | 80 | 100 | 100 | 110 | 110 | 80 | 100 | 105 | 110 | 110 |
| H5 | 37 | 45 | 47 | 50 | 50 | 37 | 45 | 48 | 50 | 50 |
| | 120 | 150 | 155 | 165 | 165 | 120 | 150 | 155 | 165 | 165 |
| H8 | 39 | 47 | 49 | 55 | 55 | 39 | 48 | 49 | 55 | 55 |
| | 130 | 155 | 160 | 180 | 180 | 130 | 155 | 160 | 180 | 180 |
| H11 | 47 | 55 | 60 | 65 | 65 | 47 | 60 | 60 | 65 | 65 |
| | 155 | 180 | 195 | 215 | 215 | 155 | 195 | 195 | 215 | 215 |
| H12 | 75 | 90 | 95 | 100 | 100 | 70 | 85 | 90 | 95 | 95 |
| | 245 | 295 | 310 | 330 | 330 | 230 | 280 | 295 | 310 | 310 |
| H21 | 39 | 47 | 49 | 55 | 55 | 39 | 48 | 49 | 55 | 55 |
| | 130 | 155 | 160 | 180 | 180 | 130 | 155 | 160 | 180 | 180 |

MP16 Zentrierbohren – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | f_z | a_{so} |
|-----|--------------------------|-----------------|-------------|
| | | | 100% |
| P1 | MP16-16009C90Z2-M05 F40M | 0,070 0.0028 | 4,5 0.18 |
| P2 | MP16-16009C90Z2-M05 F40M | 0,070 0.0028 | 4,5 0.18 |
| P3 | MP16-16009C90Z2-M05 F40M | 0,070 0.0028 | 4,5 0.18 |
| P4 | MP16-16009C90Z2-M05 F40M | 0,065 0.0026 | 4,5 0.18 |
| P5 | MP16-16009C90Z2-M05 F40M | 0,065 0.0026 | 4,5 0.18 |
| P6 | MP16-16009C90Z2-M05 F40M | 0,065 0.0026 | 4,5 0.18 |
| P7 | MP16-16009C90Z2-M05 F40M | 0,065 0.0026 | 4,5 0.18 |
| P8 | MP16-16009C90Z2-M05 F40M | 0,070 0.0028 | 4,5 0.18 |
| P11 | MP16-16009C90Z2-M05 F40M | 0,065 0.0026 | 4,5 0.18 |
| P12 | MP16-16009C90Z2-M05 F40M | 0,044 0.0017 | 3,5 0.14 |
| M1 | MP16-16009C90Z2-M05 F40M | 0,070 0.0028 | 4,5 0.18 |
| M2 | MP16-16009C90Z2-M05 F40M | 0,065 0.0026 | 4,5 0.18 |
| M3 | MP16-16009C90Z2-M05 F40M | 0,050 0.0020 | 3,5 0.14 |
| M4 | MP16-16009C90Z2-M05 F40M | 0,046 0.0018 | 2,5 0.10 |
| M5 | MP16-16009C90Z2-M05 F40M | 0,046 0.0018 | 2,5 0.10 |
| K1 | MP16-16009C90Z2-M05 F40M | 0,070 0.0028 | 4,5 0.18 |
| K2 | MP16-16009C90Z2-M05 F40M | 0,065 0.0026 | 4,5 0.18 |
| K3 | MP16-16009C90Z2-M05 F40M | 0,065 0.0026 | 4,5 0.18 |
| K4 | MP16-16009C90Z2-M05 F40M | 0,065 0.0026 | 4,5 0.18 |
| K5 | MP16-16009C90Z2-M05 F40M | 0,060 0.0024 | 4,5 0.18 |
| K6 | MP16-16009C90Z2-M05 F40M | 0,065 0.0026 | 4,5 0.18 |
| K7 | MP16-16009C90Z2-M05 F40M | 0,060 0.0024 | 4,5 0.18 |
| N1 | MP16-16009C90Z2-M05 F40M | 0,090 0.0036 | 4,5 0.18 |
| N2 | MP16-16009C90Z2-M05 F40M | 0,090 0.0036 | 4,5 0.18 |
| N3 | MP16-16009C90Z2-M05 F40M | 0,090 0.0036 | 4,5 0.18 |
| N11 | MP16-16009C90Z2-M05 F40M | 0,090 0.0036 | 4,5 0.18 |
| S1 | MP16-16009C90Z2-M05 F40M | 0,046 0.0018 | 2,5 0.10 |
| S2 | MP16-16009C90Z2-M05 F40M | 0,046 0.0018 | 2,5 0.10 |
| S3 | MP16-16009C90Z2-M05 F40M | 0,042 0.0017 | 2,5 0.10 |
| S11 | MP16-16009C90Z2-M05 F40M | 0,050 0.0020 | 3,0 0.12 |
| S12 | MP16-16009C90Z2-M05 F40M | 0,050 0.0020 | 3,0 0.12 |
| S13 | MP16-16009C90Z2-M05 F40M | 0,046 0.0018 | 2,5 0.10 |
| H5 | MP16-16009C90Z2-M05 F40M | 0,044 0.0017 | 3,5 0.14 |
| H8 | MP16-16009C90Z2-M05 F40M | 0,034 0.0013 | 3,0 0.12 |
| H11 | MP16-16009C90Z2-M05 F40M | 0,044 0.0017 | 3,5 0.14 |
| H12 | MP16-16009C90Z2-M05 F40M | 0,034 0.0013 | 3,0 0.12 |
| H21 | MP16-16009C90Z2-M05 F40M | 0,034 0.0013 | 3,0 0.12 |

SMG = Seco Werkstoff-Gruppe
 f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
 Alle Schnittdaten sind Startwerte

Universell
 Stahl und Guss
 Rostfrei und ISO-S-Werkstoffe
 Rostfrei und ISO-S-Werkstoffe
 NE-Metalle
 Harter
 Graphit
 X-Heads
 Minimaster Plus
 Minimaster

MP16 Zentrierbohren – Schnittdaten $v_c = (m/min)/(sf/min)$

| | MP16 Zentrierbohren – Schnittdaten $v_c = (m/min)/(sf/min)$ | |
|----------------------------------|---|--------------|
| | SMG | F40M |
| Universell | | 100% |
| | P1 | 290 950 |
| Stahl und Guss | P2 | 285 940 |
| | P3 | 250 820 |
| | P4 | 220 720 |
| | P5 | 210 690 |
| | P6 | 235 770 |
| | P7 | 225 740 |
| Rostfrei und ISO-S-Werkstoffe | P8 | 210 690 |
| | P11 | 220 720 |
| | P12 | 140 460 |
| | M1 | 230 750 |
| NE-Metalle | M2 | 190 620 |
| | M3 | 150 490 |
| | M4 | 115 375 |
| | M5 | 95 310 |
| | Harter | K1 |
| K2 | | 200 660 |
| K3 | | 170 560 |
| K4 | | 160 520 |
| K5 | | 100 330 |
| K6 | | 145 475 |
| K7 | | 125 410 |
| Kunststoffe und Composite | N1 | 1650 5425 |
| | N2 | 670 2200 |
| | N3 | 445 1450 |
| | N11 | 510 1675 |
| | Graphit | S1 |
| S2 | | 43 140 |
| S3 | | 37 120 |
| S11 | | 75 245 |
| S12 | | 50 165 |
| S13 | | 30 100 |
| X-Heads | H5 | 46 150 |
| | H8 | 48 155 |
| | H11 | 60 195 |
| Minimaster Plus | H12 | 85 280 |
| | H21 | 48 155 |
| | | |

MP16 Anfasen – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | | |
|-----|--------------------------|----------------|----------------|--------|--------|--------|--------|
| | | | 100% | 50% | 30% | 20% | 10% |
| P1 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,10 | 0,10 | 0,10 | 0,10 | 0,12 |
| | | 0,14 | 0,0040 | 0,0040 | 0,0040 | 0,0040 | 0,0048 |
| P2 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,10 | 0,10 | 0,10 | 0,10 | 0,12 |
| | | 0,14 | 0,0040 | 0,0040 | 0,0040 | 0,0040 | 0,0048 |
| P3 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,095 | 0,095 | 0,095 | 0,095 | 0,12 |
| | | 0,14 | 0,0038 | 0,0038 | 0,0038 | 0,0038 | 0,0048 |
| P4 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,095 | 0,095 | 0,095 | 0,095 | 0,11 |
| | | 0,14 | 0,0038 | 0,0038 | 0,0038 | 0,0038 | 0,0044 |
| P5 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,090 | 0,090 | 0,090 | 0,090 | 0,11 |
| | | 0,14 | 0,0036 | 0,0036 | 0,0036 | 0,0036 | 0,0044 |
| P6 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,090 | 0,090 | 0,090 | 0,090 | 0,11 |
| | | 0,14 | 0,0036 | 0,0036 | 0,0036 | 0,0036 | 0,0044 |
| P7 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,090 | 0,090 | 0,090 | 0,090 | 0,11 |
| | | 0,14 | 0,0036 | 0,0036 | 0,0036 | 0,0036 | 0,0044 |
| P8 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,095 | 0,095 | 0,095 | 0,095 | 0,12 |
| | | 0,14 | 0,0038 | 0,0038 | 0,0038 | 0,0038 | 0,0048 |
| P11 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,090 | 0,090 | 0,090 | 0,090 | 0,11 |
| | | 0,14 | 0,0036 | 0,0036 | 0,0036 | 0,0036 | 0,0044 |
| P12 | MP16-16009C90Z2-M05 F40M | 3,0 | 0,065 | 0,065 | 0,065 | 0,065 | 0,075 |
| | | 0,12 | 0,0026 | 0,0026 | 0,0026 | 0,0026 | 0,0030 |
| M1 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,10 | 0,10 | 0,10 | 0,10 | 0,12 |
| | | 0,14 | 0,0040 | 0,0040 | 0,0040 | 0,0040 | 0,0048 |
| M2 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,090 | 0,090 | 0,090 | 0,090 | 0,11 |
| | | 0,14 | 0,0036 | 0,0036 | 0,0036 | 0,0036 | 0,0044 |
| M3 | MP16-16009C90Z2-M05 F40M | 3,0 | 0,075 | 0,075 | 0,075 | 0,075 | 0,090 |
| | | 0,12 | 0,0030 | 0,0030 | 0,0030 | 0,0030 | 0,0036 |
| M4 | MP16-16009C90Z2-M05 F40M | 2,0 | 0,065 | 0,065 | 0,065 | 0,065 | 0,080 |
| | | 0,080 | 0,0026 | 0,0026 | 0,0026 | 0,0026 | 0,0032 |
| M5 | MP16-16009C90Z2-M05 F40M | 2,0 | 0,065 | 0,065 | 0,065 | 0,065 | 0,080 |
| | | 0,080 | 0,0026 | 0,0026 | 0,0026 | 0,0026 | 0,0032 |
| K1 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,10 | 0,10 | 0,10 | 0,10 | 0,12 |
| | | 0,14 | 0,0040 | 0,0040 | 0,0040 | 0,0040 | 0,0048 |
| K2 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,090 | 0,090 | 0,090 | 0,090 | 0,11 |
| | | 0,14 | 0,0036 | 0,0036 | 0,0036 | 0,0036 | 0,0044 |
| K3 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,090 | 0,090 | 0,090 | 0,090 | 0,11 |
| | | 0,14 | 0,0036 | 0,0036 | 0,0036 | 0,0036 | 0,0044 |
| K4 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,090 | 0,090 | 0,090 | 0,090 | 0,11 |
| | | 0,14 | 0,0036 | 0,0036 | 0,0036 | 0,0036 | 0,0044 |
| K5 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,085 | 0,085 | 0,085 | 0,085 | 0,10 |
| | | 0,14 | 0,0034 | 0,0034 | 0,0034 | 0,0034 | 0,0040 |
| K6 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,090 | 0,090 | 0,090 | 0,090 | 0,11 |
| | | 0,14 | 0,0036 | 0,0036 | 0,0036 | 0,0036 | 0,0044 |
| K7 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,085 | 0,085 | 0,085 | 0,085 | 0,10 |
| | | 0,14 | 0,0034 | 0,0034 | 0,0034 | 0,0034 | 0,0040 |
| N1 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,13 | 0,13 | 0,13 | 0,13 | 0,16 |
| | | 0,14 | 0,0050 | 0,0050 | 0,0050 | 0,0050 | 0,0065 |
| N2 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,13 | 0,13 | 0,13 | 0,13 | 0,16 |
| | | 0,14 | 0,0050 | 0,0050 | 0,0050 | 0,0050 | 0,0065 |
| N3 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,13 | 0,13 | 0,13 | 0,13 | 0,16 |
| | | 0,14 | 0,0050 | 0,0050 | 0,0050 | 0,0050 | 0,0065 |
| N11 | MP16-16009C90Z2-M05 F40M | 3,5 | 0,13 | 0,13 | 0,13 | 0,13 | 0,16 |
| | | 0,14 | 0,0050 | 0,0050 | 0,0050 | 0,0050 | 0,0065 |
| S1 | MP16-16009C90Z2-M05 F40M | 2,0 | 0,065 | 0,065 | 0,065 | 0,065 | 0,080 |
| | | 0,080 | 0,0026 | 0,0026 | 0,0026 | 0,0026 | 0,0032 |
| S2 | MP16-16009C90Z2-M05 F40M | 2,0 | 0,065 | 0,065 | 0,065 | 0,065 | 0,080 |
| | | 0,080 | 0,0026 | 0,0026 | 0,0026 | 0,0026 | 0,0032 |
| S3 | MP16-16009C90Z2-M05 F40M | 2,0 | 0,060 | 0,060 | 0,060 | 0,060 | 0,070 |
| | | 0,080 | 0,0024 | 0,0024 | 0,0024 | 0,0024 | 0,0028 |
| S11 | MP16-16009C90Z2-M05 F40M | 2,5 | 0,075 | 0,075 | 0,075 | 0,075 | 0,090 |
| | | 0,10 | 0,0030 | 0,0030 | 0,0030 | 0,0030 | 0,0036 |
| S12 | MP16-16009C90Z2-M05 F40M | 2,5 | 0,075 | 0,075 | 0,075 | 0,075 | 0,090 |
| | | 0,10 | 0,0030 | 0,0030 | 0,0030 | 0,0030 | 0,0036 |
| S13 | MP16-16009C90Z2-M05 F40M | 2,0 | 0,065 | 0,065 | 0,065 | 0,065 | 0,080 |
| | | 0,080 | 0,0026 | 0,0026 | 0,0026 | 0,0026 | 0,0032 |
| H5 | MP16-16009C90Z2-M05 F40M | 3,0 | 0,065 | 0,065 | 0,065 | 0,065 | 0,075 |
| | | 0,12 | 0,0026 | 0,0026 | 0,0026 | 0,0026 | 0,0030 |
| H8 | MP16-16009C90Z2-M05 F40M | 2,5 | 0,048 | 0,048 | 0,048 | 0,048 | 0,060 |
| | | 0,10 | 0,0019 | 0,0019 | 0,0019 | 0,0019 | 0,0024 |
| H11 | MP16-16009C90Z2-M05 F40M | 3,0 | 0,065 | 0,065 | 0,065 | 0,065 | 0,075 |
| | | 0,12 | 0,0026 | 0,0026 | 0,0026 | 0,0026 | 0,0030 |
| H12 | MP16-16009C90Z2-M05 F40M | 2,5 | 0,048 | 0,048 | 0,048 | 0,048 | 0,060 |
| | | 0,10 | 0,0019 | 0,0019 | 0,0019 | 0,0019 | 0,0024 |
| H21 | MP16-16009C90Z2-M05 F40M | 2,5 | 0,048 | 0,048 | 0,048 | 0,048 | 0,060 |
| | | 0,10 | 0,0019 | 0,0019 | 0,0019 | 0,0019 | 0,0024 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

Univerrsell
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MP16 Anfasen – Schnittdaten $v_c = (m/min)/(sf/min)$

| | SMG | F40M | | | | |
|-------------------------------|-----|------|------|------|------|------|
| | | 100% | 50% | 30% | 20% | 10% |
| Universell | P1 | 290 | 270 | 315 | 350 | 415 |
| | | 950 | 890 | 1025 | 1150 | 1350 |
| Stahl und Guss | P2 | 285 | 260 | 310 | 345 | 400 |
| | | 940 | 850 | 1025 | 1125 | 1300 |
| Rostfrei und ISO-S-Werkstoffe | P3 | 250 | 230 | 270 | 300 | 345 |
| | | 820 | 750 | 890 | 980 | 1125 |
| NE-Metalle | P4 | 220 | 200 | 235 | 265 | 310 |
| | | 720 | 660 | 770 | 870 | 1025 |
| Harter | P5 | 210 | 195 | 230 | 255 | 295 |
| | | 690 | 640 | 750 | 840 | 970 |
| Kunststoffe und Composite | P6 | 235 | 220 | 260 | 285 | 335 |
| | | 770 | 720 | 850 | 940 | 1100 |
| Graphit | P7 | 225 | 205 | 245 | 270 | 315 |
| | | 740 | 670 | 800 | 890 | 1025 |
| X-Heads | P8 | 210 | 190 | 225 | 250 | 290 |
| | | 690 | 620 | 740 | 820 | 950 |
| Minimaster Plus | P11 | 220 | 200 | 235 | 260 | 305 |
| | | 720 | 660 | 770 | 850 | 1000 |
| Minimaster | P12 | 140 | 125 | 140 | 160 | 195 |
| | | 460 | 410 | 460 | 520 | 640 |
| Minimaster Plus | M1 | 230 | 210 | 250 | 275 | 325 |
| | | 750 | 690 | 820 | 900 | 1075 |
| Minimaster Plus | M2 | 190 | 175 | 205 | 230 | 265 |
| | | 620 | 570 | 670 | 750 | 870 |
| Minimaster Plus | M3 | 150 | 135 | 155 | 175 | 215 |
| | | 490 | 445 | 510 | 570 | 710 |
| Minimaster Plus | M4 | 115 | 95 | 115 | 125 | 165 |
| | | 375 | 310 | 375 | 410 | 540 |
| Minimaster Plus | M5 | 95 | 80 | 95 | 105 | 135 |
| | | 310 | 260 | 310 | 345 | 445 |
| Minimaster Plus | K1 | 225 | 205 | 245 | 270 | 320 |
| | | 740 | 670 | 800 | 890 | 1050 |
| Minimaster Plus | K2 | 200 | 185 | 220 | 240 | 280 |
| | | 660 | 610 | 720 | 790 | 920 |
| Minimaster Plus | K3 | 170 | 155 | 185 | 205 | 240 |
| | | 560 | 510 | 610 | 670 | 790 |
| Minimaster Plus | K4 | 160 | 150 | 175 | 195 | 230 |
| | | 520 | 490 | 570 | 640 | 750 |
| Minimaster Plus | K5 | 100 | 90 | 105 | 120 | 140 |
| | | 330 | 295 | 345 | 395 | 460 |
| Minimaster Plus | K6 | 145 | 130 | 155 | 170 | 200 |
| | | 475 | 425 | 510 | 560 | 660 |
| Minimaster Plus | K7 | 125 | 115 | 135 | 150 | 175 |
| | | 410 | 375 | 445 | 490 | 570 |
| Minimaster Plus | N1 | 1650 | 1500 | 1800 | 2000 | 2325 |
| | | 5425 | 4925 | 5900 | 6550 | 7625 |
| Minimaster Plus | N2 | 670 | 610 | 720 | 810 | 940 |
| | | 2200 | 2000 | 2350 | 2650 | 3075 |
| Minimaster Plus | N3 | 445 | 405 | 485 | 540 | 630 |
| | | 1450 | 1325 | 1600 | 1775 | 2075 |
| Minimaster Plus | N11 | 510 | 465 | 550 | 610 | 720 |
| | | 1675 | 1525 | 1800 | 2000 | 2350 |
| Minimaster Plus | S1 | 55 | 44 | 55 | 60 | 75 |
| | | 180 | 145 | 180 | 195 | 245 |
| Minimaster Plus | S2 | 43 | 35 | 43 | 47 | 60 |
| | | 140 | 115 | 140 | 155 | 195 |
| Minimaster Plus | S3 | 37 | 31 | 38 | 42 | 55 |
| | | 120 | 100 | 125 | 140 | 180 |
| Minimaster Plus | S11 | 75 | 65 | 75 | 85 | 110 |
| | | 245 | 215 | 245 | 280 | 360 |
| Minimaster Plus | S12 | 50 | 45 | 50 | 60 | 75 |
| | | 165 | 150 | 165 | 195 | 245 |
| Minimaster Plus | S13 | 30 | 25 | 30 | 33 | 43 |
| | | 100 | 80 | 100 | 110 | 140 |
| Minimaster Plus | H5 | 46 | 41 | 47 | 55 | 65 |
| | | 150 | 135 | 155 | 180 | 215 |
| Minimaster Plus | H8 | 48 | 42 | 48 | 55 | 70 |
| | | 155 | 140 | 155 | 180 | 230 |
| Minimaster Plus | H11 | 60 | 50 | 60 | 70 | 85 |
| | | 195 | 165 | 195 | 230 | 280 |
| Minimaster Plus | H12 | 85 | 75 | 85 | 100 | 125 |
| | | 280 | 245 | 280 | 330 | 410 |
| Minimaster Plus | H21 | 48 | 42 | 48 | 55 | 70 |
| | | 155 | 140 | 155 | 180 | 230 |



MINIMASTER™

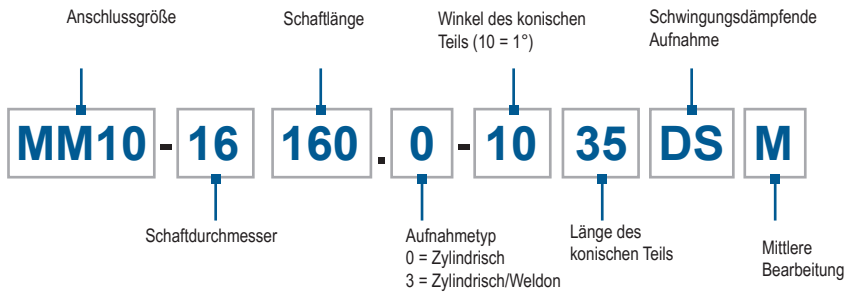
Minimaster™ ist ein einzigartig vielseitiges Schaftfräasersystem, das verschiedene Lösungen kombiniert. Es bietet optimale Zugänglichkeit sowie maximale Stabilität und Sicherheit.

Die flexible, zweiteilige Kombination aus Schäften und Wendeplatten spart Zeit und Geld. Ein vielseitiges Werkzeug, das dem Anwender in nahezu jedem Prozess eine Lösung bietet – egal, ob die Auskragung verringert werden soll, maximale Stabilität gefragt ist oder andere Anforderungen erfüllt werden müssen.

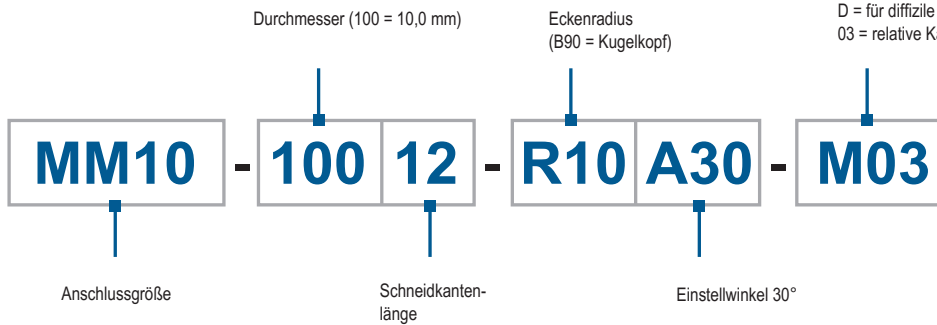
- Schaftfräser: 6 bis 20 mm (.250 - .750")
- Kugelkopffräser: 6 bis 20 mm (.250 - .750")
- Zentrier-/Anfasfräser: 6 bis 19,05 mm (.250 - .750")
- Hochvorschubfräser: 8 bis 12 mm (.375 - .625")
- Tauchfräser: 6 bis 16 mm (.250 - .625")
- Konvexradienfräser: 12 mm (.472")

Code-Schlüssel

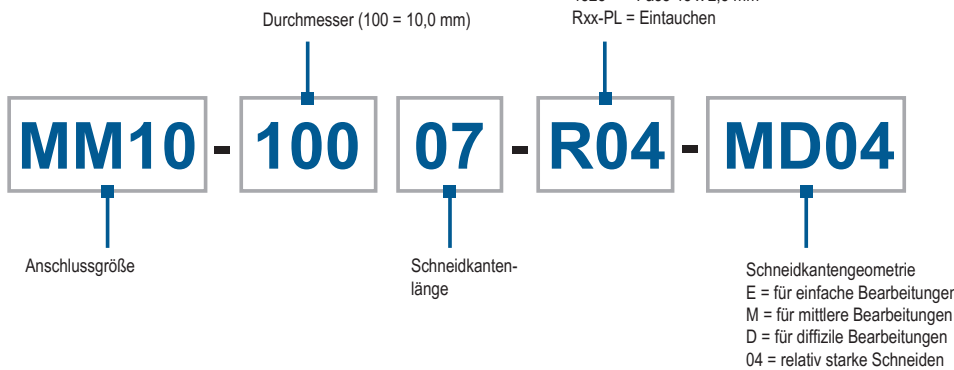
Schäfte



Minimaster Schneidkopf 3-schneidig



Minimaster Schneidkopf 2-schneidig



Teile des Codes können bei unterschiedlichen Fräsern variieren.

Innenkühlung



Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

Montagehinweise - MM-Schlüssel nur für 2-schneidige Schneidköpfe

| Drehmomentschlüssel | |
|--|---|
|  <p>Spannhülse Schaft Spannschraube</p> | <p>Die Spannhülse muss bei erneuter Montage zuerst befestigt werden. Danach Spannschraube und Schneidkopf montieren. Bei abgebrochenem Schneidkopf die Spannhülse lösen. Den Innensechskant-Schlüssel gegen den Uhrzeigersinn drehen. Danach Spannschraube und Schneidkopf entnehmen. Für Minimaster 3-schneidig ist der Schlüssel (MM0416) erforderlich (Schlüsselansatz an sechseckigem Teil des Schneidkopfs).</p> |
|  | <p>Den korrekten Schlüsselansatz beachten.</p> |
|  | <p>Bei nicht korrektem Ansatz können die Schneidkanten beschädigt werden.</p> |
|  | <p>Den Schneidkopf nicht mit einem Hammer oder ähnlichem Gegenstand festklopfen.</p> |
|  | <p>Den Schneidkopf handfest anziehen.</p> |

| |
|-------------------------------|
| Unversell |
| Stahl und Guss |
| Rostfrei und ISO-S-Werkstoffe |
| Rostfrei und ISO-S-Werkstoffe |
| NE-Metalle |
| Harter |
| Graphit |
| X-Heads |
| Minimaster Plus |
| Minimaster |

Auswahl

1. Anschlussgröße wählen

Die Ausführung des Werkstückes und die Bearbeitung entscheiden über die Anschlussgröße. Je größer der Anschlussdurchmesser, desto höher ist die Stabilität.

2. Schneidkopf wählen

- Werkstoff anhand der Seco Werkstoff-Gruppen ab Seite 728 klassifizieren
- Die gewählte Anschlussgröße den Katalogseiten entnehmen und den geeigneten Schneidkopf in der Auswahltable wählen.

3. Aufnahme wählen

- Auf den Katalogseiten die geeignete Aufnahme auswählen.
- Schneidkopf und Aufnahme müssen die gleiche Anschlussgröße haben. Je kürzer die Aufnahme, desto größer ist die Stabilität.

4. Schnittdaten wählen

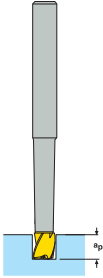
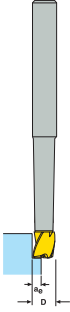
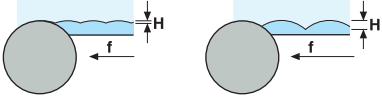
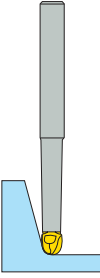
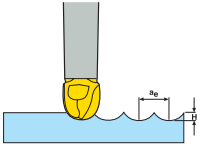
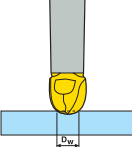
- Die maximale axiale Schnitttiefe ist in der Tabelle Abmessungen angegeben. Die Schnittdatenempfehlungen basieren auf stabilen Arbeitsbedingungen und müssen daher je nach Stabilität der Bearbeitung (Werkzeugsystem, Maschine und Aufspannung) angepasst werden. Eine allgemeine Regel für die max. Schnitttiefe beim Nutfräsen ist $DC \cdot 0.3 = \text{Max APMXS}$. (Siehe Abb. 1).
- Empfehlungen zu Vorschub und Schnittgeschwindigkeit finden Sie ebenfalls in der Tabelle Abmessungen.
- Die empfohlene Maximaldrehzahl, die aus Sicherheitsgründen nie überschritten werden darf, ist auf Seite N/A angegeben
- Wenn die radiale Schnitttiefe (Eingriffsbreite) geringer ist als der volle Schneiddurchmesser, müssen Vorschub/Zahn und Schnittgeschwindigkeit erhöht werden, um die Mittenspanndicke und die Arbeitstemperatur konstant zu halten.
- Den Prozentsatz für das Eingriffsverhältnis ermitteln: radiale Schnitttiefe durch den Durchmesser dividieren (bei Kopierfräsern $a_e/DC\%$), bei Kugelkopffräsern den effektiven Wirkdurchmesser D_w anstatt DC (siehe Abb. 2 & 6) verwenden
- Die Tabelle Schnittdaten enthält Richtwerte für Vorschub/Zahn sowie den Korrekturfaktor für die Schnittgeschwindigkeit.

5. Allgemein

- Beim Fräsen an Ecken und Taschenboden vergrößert sich die Eingriffsbreite dramatisch. Der Vorschub muss reduziert werden, weil sonst die Mittenspanndicke enorm zunimmt. Setzen Sie deshalb die Vorschubwerte für volle Eingriffsbreite ein.
- Beim Bohrfräsen mit einem Kopierwinkel von 40° oder beim Ziehfräsen mit einem Kopierwinkel von 30° in Kombination mit einer geringen Schnitttiefe wird der Wirkdurchmesser D_w immer größer sein als die genannten Werte in der Tabelle. In diesem Falle für die Vorschubberechnung den Fräserdurchmesser DC als Wirkdurchmesser D_w einsetzen.
- Nutzen Sie zur Berechnung von Vorschub/U stets den ZEFP-Faktor. Der ZEFP-Faktor ist die effektive Zähnezahl zur Berechnung von Vorschub und Vorschubgeschwindigkeit. Den ZEFP-Faktor finden Sie in der Tabelle Abmessungen.


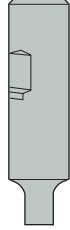
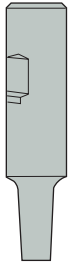


Hinweis! Bei höheren Vorschubwerten nimmt die Qualität der Werkstück-Oberfläche ab (siehe Abb. 3& 5)

Minimaster

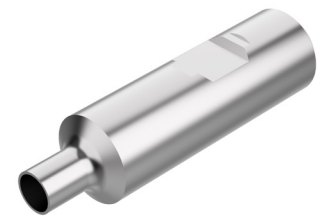
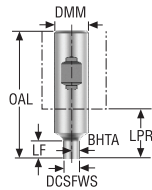
| | |
|---|---|
| <p>Abb. 1</p> | <p>Abb. 2</p> |
|  |  |
| <p>Abb. 3</p> | <p>Abb. 4</p> |
|  |  |
| <p>Abb. 5</p> | <p>Abb. 6</p> |
|  |  |

| |
|-------------------------------|
| Unversell |
| Stahl und Guss |
| Rostfrei und ISO-S-Werkstoffe |
| Rostfrei und ISO-S-Werkstoffe |
| NE-Metalle |
| Harter |
| Graphit |
| X-Heads |
| Minimaster Plus |
| Minimaster |

Schaftkonstruktion

| | | |
|-------------------------------|---|--|
| Universell | Ausführung 1, Keilnut-Schaft | Ausführung 2, Zylindrische/Weldon Schnittstelle und 90° Stirnseite |
| |  |  |
| Stahl und Guss | | |
| Rostfrei und ISO-S-Werkstoffe | | |
| | Ausführung 3, Zylindrische/Weldon Schnittstelle und 87°/89° Stirnseite | Ausführung 4, Zylindrische/Weldon Schnittstelle und 80°/85°/87° Stirnseite |
| NE-Metalle |  |  |
| Harter | | |
| Kunststoffe und Composite | | |
| | Ausführung 5, Zylindrische Schnittstelle und doppelt konische Stirnseite 89°/85° | |
| Graphit |  | |
| X-Heads | | |
| Minimaster Plus | | |

MM06 Schaft – Metrisch



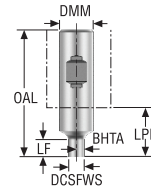
| Bezeichnung | Produkt- nummer | Aufnahme | DCSFWS | DMM | OAL | LF | LPR | BHTA° | Abb. | | RPMX | Gewicht | Ersatzteil |
|---------------------|--------------------|-------------|--------|------|-------|------|-------|-------|------|---|-------|---------|-------------|
| | | | | | | | | | | | | | Bezeichnung |
| | | | mm | mm | mm | mm | mm | | | | | | kg |
| MM06-12070.3-0005 | 75080695 | Weldon | 5,75 | 12,0 | 70,0 | 5,0 | 25,0 | 0,0 | 2 | ✓ | 80000 | 0,1 | 1 |
| MM06-16075.3-3009 | 75080696 | Weldon | 5,75 | 16,0 | 75,0 | 9,0 | 27,0 | 3,0 | 3 | ✓ | 80000 | 0,1 | 1 |
| MM06-16110.3-5058 | 75080697 | Weldon | 5,75 | 16,0 | 110,0 | 58,6 | 62,0 | 5,0 | 4 | ✓ | 80000 | 0,1 | 4 |
| MM06-10040.0-0007 | 00094747 | Zylindrisch | 5,75 | 10,0 | 40,0 | 7,0 | 7,0 | 0,0 | 2 | ✓ | 80000 | 0,1 | 2 |
| MM06-12065.0-0000 | 75080694 | Zylindrisch | 5,7 | 12,0 | 65,0 | 0,0 | 15,0 | 60,0 | 1 | ✓ | 80000 | 0,1 | 1 |
| MM06-16140.0-1020M | 00027102 | Zylindrisch | 5,75 | 16,0 | 140,0 | 20,0 | 92,0 | 1,0 | 3 | ✓ | 80000 | 0,2 | 5 |
| MM06-16140.0-1035M | 00027103 | Zylindrisch | 5,75 | 16,0 | 140,0 | 35,0 | 92,0 | 1,0 | 3 | ✓ | 80000 | 0,2 | 6 |
| MM06-16140.0-1050M | 00094748 | Zylindrisch | 5,75 | 16,0 | 140,0 | 50,0 | 92,0 | 1,0 | 3 | ✓ | 80000 | 0,2 | 6 |
| MM06-10050.0-0007DS | 02580666 | Zylindrisch | 5,75 | 10,0 | 50,0 | 7,0 | 7,0 | 0,0 | 2 | ✓ | 80000 | 0,1 | 3 |
| MM06-10075.0-3041DS | 02580701 | Zylindrisch | 5,75 | 10,0 | 75,0 | 40,5 | 35,0 | 3,0 | 4 | ✓ | 80000 | 0,1 | 3 |
| MM06-10100.0-1035DS | 02580713 | Zylindrisch | 5,75 | 10,0 | 100,0 | 35,0 | 60,0 | 1,0 | 3 | ✓ | 80000 | 0,1 | 3 |
| MM06-12120.0-1050DS | 02580714 | Zylindrisch | 5,75 | 12,0 | 120,0 | 50,0 | 75,0 | 1,0 | 3 | ✓ | 80000 | 0,2 | 3 |
| MM06-16090.0-0012DS | 02580670 | Zylindrisch | 5,75 | 16,0 | 90,0 | 12,0 | 42,0 | 0,0 | 2 | ✓ | 80000 | 0,3 | 3 |
| MM06-16095.0-0024DS | 02580673 | Zylindrisch | 5,75 | 16,0 | 95,0 | 24,0 | 47,0 | 0,0 | 2 | ✓ | 80000 | 0,3 | 3 |
| MM06-16140.0-1050DS | 02580717 | Zylindrisch | 5,75 | 16,0 | 140,0 | 50,0 | 92,0 | 1,0 | 3 | ✓ | 80000 | 0,3 | 3 |
| MM06-16140.0-1035DS | 02580716 | Zylindrisch | 5,75 | 16,0 | 140,0 | 35,0 | 92,0 | 1,0 | 3 | ✓ | 80000 | 0,4 | 3 |
| MM06-20250.0-1035DS | 02580718 | Zylindrisch | 5,75 | 20,0 | 250,0 | 35,0 | 190,0 | 1,0 | 5 | ✓ | 80000 | 0,9 | 3 |

Ersatzteile, im Lieferumfang enthalten

Zubehör

| Für Fräser | Hülse | Spannschraube | Schlüssel |
|------------|-----------|---------------|-----------|
| 1 | MM-035046 | MM06-03518 | H05-4 |
| 4 | MM-035091 | MM06-03518 | H05-4 |
| 2 | MM-035023 | MM06-03518 | H05-4 |
| 5 | MM-035046 | MM06-03544 | H05-4 |
| 6 | MM-035046 | MM06-03564 | H05-4 |
| 3 | - | MM06-03518 | - |



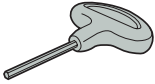
MM06 Schaft – Zoll



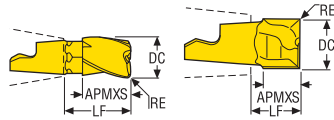
| Bezeichnung | Produkt- nummer | Aufnahme | | | | | | | Abb. | RPMX | Gewicht lbs | Ersatzteil Bezeichnung | |
|-------------------------|--------------------|-------------|--------|-------|-------|-------|-------|-------|------|------|----------------|---------------------------|---|
| | | | DCSFMS | DMM | OAL | LF | LPR | BHTA° | | | | | |
| MM06-0.50-2.8-3-0002 | 00096108 | Weldon | 0.224 | 0.500 | 2.756 | 0.197 | 0.984 | 0,0 | 2 | ✓ | 80000 | 0.220 | 1 |
| MM06-0.62-3.0-3-3003 | 00096116 | Weldon | 0.224 | 0.625 | 2.953 | 0.354 | 1.063 | 3,0 | 1 | ✓ | 80000 | 0.220 | 1 |
| MM06-0.62-4.3-3-5022 | 00096117 | Weldon | 0.224 | 0.625 | 4.331 | 2.291 | 2.441 | 5,0 | 2 | ✓ | 80000 | 0.440 | 4 |
| MM06-0.38-1.6-0-0002 | 00096107 | Zylindrisch | 0.224 | 0.375 | 1.575 | 0.276 | 0.276 | 0,0 | 2 | ✓ | 80000 | 0.220 | 2 |
| MM06-0.50-2.6-0-0000 | 00096106 | Zylindrisch | 0.224 | 0.500 | 2.559 | 0 | 0.787 | 60,0 | 1 | ✓ | 80000 | 0.220 | 1 |
| MM06-0.62-5.5-0-1007 | 00096111 | Zylindrisch | 0.224 | 0.625 | 5.512 | 0.787 | 3.622 | 1,0 | 3 | ✓ | 80000 | 0.440 | 5 |
| MM06-0.62-5.5-0-1013 | 00096112 | Zylindrisch | 0.224 | 0.625 | 5.512 | 1.378 | 3.622 | 1,0 | 3 | ✓ | 80000 | 0.440 | 6 |
| MM06-0.62-5.5-0-1019 | 00096114 | Zylindrisch | 0.224 | 0.625 | 5.512 | 1.969 | 3.622 | 1,0 | 3 | ✓ | 80000 | 0.440 | 6 |
| MM06-0.62-3.5-0-0004DS | 02593394 | Zylindrisch | 0.224 | 0.625 | 3.543 | 0.472 | 1.654 | 0,0 | 2 | ✓ | 80000 | 0.660 | 3 |
| MM06-0.62-3.7-0-0009DS | 02593395 | Zylindrisch | 0.224 | 0.625 | 3.740 | 0.945 | 1.850 | 0,0 | 2 | ✓ | 80000 | 0.660 | 3 |
| MM06-0.62-5.5-0-1013DS | 02593396 | Zylindrisch | 0.224 | 0.625 | 5.512 | 1.378 | 3.622 | 1,0 | 3 | ✓ | 80000 | 0.880 | 3 |
| MM06-0.62-5.5-0-1019DS | 02593397 | Zylindrisch | 0.224 | 0.625 | 5.512 | 1.969 | 3.622 | 1,0 | 3 | ✓ | 80000 | 0.660 | 3 |
| MM06-0.75-10.0-0-1013DS | 02593399 | Zylindrisch | 0.224 | 0.750 | 9.843 | 1.378 | 7.874 | 1,0 | 5 | ✓ | 80000 | 1.980 | 3 |

Ersatzteile, im Lieferumfang enthalten

Zubehör

| Für Fräser | Hülse | Spannschraube | Schlüssel |
|------------|---|---|---|
| 1 |  MM-035046 |  MM06-03518 |  H05-4 |
| 4 | MM-035091 | MM06-03518 | H05-4 |
| 2 | MM-035023 | MM06-03518 | H05-4 |
| 5 | MM-035046 | MM06-03544 | H05-4 |
| 6 | MM-035046 | MM06-03564 | H05-4 |
| 3 | - | MM06-03518 | - |

Nutfräsen/Eckfräsen



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | RE | LF | RMPX° | C min | C max | FHA | ZEFP | Schlüssel | Beschichtung | | | |
|-----------------------|---------------|--------------|--------------|--------------|-------|-------|-------|-----|------|-----------|--------------|------|------|------|
| | | | | | | | | | | | Beschichtet | | | |
| | | | | | | | | | | | T60M | F15M | F30M | F40M |
| MM06-05804T-R02-D02 | 5,8 0.228 | 4,1 0.161 | 0,2 0.008 | 5,1 0.201 | 15,0 | 7,2 | 11,0 | 0 | 2 | MM0612 | ■ | | | |
| MM06-05807-R02A30-M02 | 5,8 0.228 | 7,5 0.295 | 0,2 0.008 | 9,9 0.390 | 15,0 | 7,2 | 11,0 | 30 | 3 | MM0612 ✓ | | | | ■ |
| MM06-06004-M02 | 6,0 0.236 | 4,1 0.161 | 0,0 - | 5,1 0.201 | 15,0 | 7,4 | 11,8 | 0 | 2 | MM0612 | ■ | | | |
| MM06-06004-R04-MD02 | 6,0 0.236 | 4,1 0.161 | 0,4 0.016 | 5,1 0.201 | 15,0 | 7,4 | 11,0 | 0 | 2 | MM0612 | ■ | | ■ | |
| MM06-06004-R10-MD02 | 6,0 0.236 | 4,1 0.161 | 1,0 0.039 | 5,1 0.201 | 15,0 | 7,4 | 9,8 | 0 | 2 | MM0612 | | | ■ | |
| MM06-06007-A30-E02 | 6,0 0.236 | 7,5 0.295 | 0,0 - | 9,9 0.390 | 15,0 | 7,4 | 11,8 | 30 | 3 | MM0416 ✓ | | | ■ | |
| MM06-06007-R05A30-M02 | 6,0 0.236 | 7,5 0.295 | 0,5 0.020 | 9,9 0.390 | 15,0 | 7,4 | 10,8 | 30 | 3 | MM0416 ✓ | | | | ■ |
| MM06-06007-R10A30-D02 | 6,0 0.236 | 7,5 0.295 | 1,0 0.039 | 9,9 0.390 | 15,0 | 7,4 | 9,8 | 30 | 3 | MM0416 ✓ | | | ■ | |
| MM06-06007-R10A30-E02 | 6,0 0.236 | 7,5 0.295 | 1,0 0.039 | 9,9 0.390 | 15,0 | 7,4 | 9,8 | 30 | 3 | MM0416 ✓ | | | ■ | |
| MM06-06007-R10A30-M02 | 6,0 0.236 | 7,5 0.295 | 1,0 0.039 | 9,9 0.390 | 15,0 | 7,4 | 9,8 | 30 | 3 | MM0416 ✓ | | | | ■ |
| MM06-06007-R20A30-M02 | 6,0 0.236 | 7,5 0.295 | 2,0 0.079 | 9,9 0.390 | 15,0 | 7,4 | 7,8 | 30 | 3 | MM0416 ✓ | | | | ■ |
| MM06-06407-A30-E02 | 6,35 0.250 | 7,5 0.295 | 0,0 - | 9,9 0.390 | 15,0 | 7,8 | 12,5 | 30 | 3 | MM0416 ✓ | | | ■ | |
| MM06-06407-R04A30-M02 | 6,35 0.250 | 7,5 0.295 | 0,4 0.016 | 9,9 0.390 | 15,0 | 7,8 | 11,7 | 30 | 3 | MM0416 ✓ | | | | ■ |
| MM06-06407-R08A30-M02 | 6,35 0.250 | 7,5 0.295 | 0,8 0.031 | 9,9 0.390 | 15,0 | 7,8 | 10,9 | 30 | 3 | MM0416 ✓ | | | | ■ |

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Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

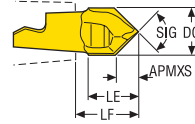
Graphit

X-Heads

Minimaster Plus

Minimaster

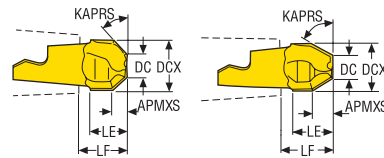
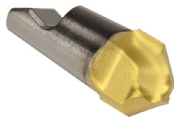
Zentrierbohren



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | LE | LF | SIG° | ZEFP | Schlüssel | Beschichtung | | | |
|---------------------|--------------|---------------|---------------|---------------|-------|------|-----------|--------------|------|------|------|
| | | | | | | | | T60M | F15M | F30M | F40M |
| MM06-06003-C120-M02 | 6,0 0.236 | 1,6 0.063 | 6,27 0.247 | 7,19 0.283 | 120,0 | 2 | MM0612 | ■ | | | |
| MM06-06003-C90-M02 | 6,0 0.236 | 2,86 0.113 | 6,0 0.236 | 7,12 0.280 | 90,0 | 2 | MM0612 | ■ | | | |

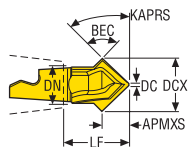
Anfasen




• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DCX | DC | APMXS | LE | LF | KAPRS° | ZEFP | Schlüssel | Beschichtung | | | |
|---------------------|--------------|---------------|--------------|--------------|---------------|--------|------|-----------|--------------|------|------|------|
| | | | | | | | | | T60M | F15M | F30M | F40M |
| MM06-06004-4515-E02 | 6,0 0.236 | 1,8 0.071 | 2,1 0.083 | 4,0 0.157 | 5,1 0.201 | 45,0 | 2 | MM0612 | ■ | | | |
| MM06-06004-6015-E02 | 6,0 0.236 | 3,14 0.124 | 2,4 0.094 | 4,6 0.181 | 5,75 0.226 | 60,0 | 2 | MM0612 | ■ | | | |

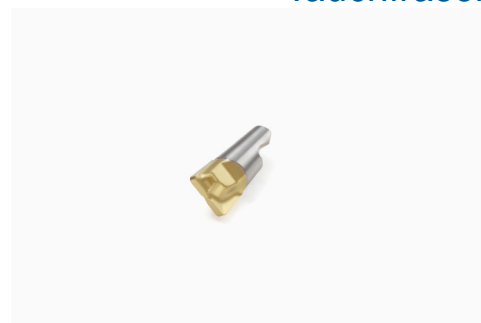
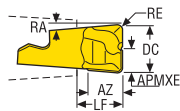
Doppeltes Anfasen




• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DCX | DC | APMXS | LF | DN | BEC° | KAPRS° | ZEFP | Schlüssel  | Beschichtung | | | |
|-----------------------|--------------|--------------|--------------|--------------|--------------|------|--------|------|---|--------------|------|------|------|
| | | | | | | | | | | T60M | F15M | F30M | F40M |
| MM06-08008-D4510P-M02 | 8,0 0.315 | 0,6 0.024 | 3,7 0.146 | 8,5 0.335 | 6,0 0.236 | 90,0 | 45,0 | 2 | MM0612 | | ■ | | |

Tauchfräser



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXE | RE | AZ | LF | RA° | ZEFP | Schlüssel  | Beschichtung | | | |
|------------------------|--------------|--------------|--------------|--------------|---------------|-----|------|---|--------------|------|------|------|
| | | | | | | | | | T60M | F15M | F30M | F40M |
| MM06-06004-R10-PL-MD02 | 6,0 0.236 | 3,0 0.118 | 1,0 0.039 | 4,3 0.169 | 5,08 0.200 | 5,0 | 2 | MM0612 | | | ■ | |

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ISO-S-Werkstoffe

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

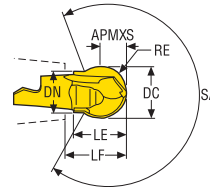
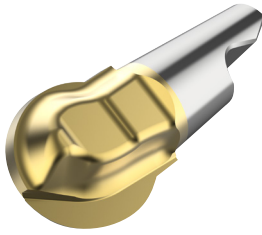
Graphit

X-Heads

Minimaster Plus

Minimaster

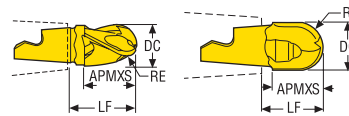
Präzisionswendeschneidplatten zum Vorschlichten in allen Werkstoffen



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | RE | LE | LF | DN | SA | ZEFP | Schlüssel | Beschichtung | | | |
|-----------------------|--------------|--------------|--------------|--------------|---------------|--------------|-------|------|-----------|--------------|------|------|------|
| | | | | | | | | | | T60M | F15M | F30M | F40M |
| MM06-08008-B120PF-M01 | 8,0 0.315 | 4,0 0.157 | 4,0 0.157 | 8,0 0.315 | 8,73 0.344 | 6,0 0.236 | 263,0 | 2 | MM0612 | | ■ | | |
| MM06-08008-B120P-M03 | 8,0 0.315 | 4,0 0.157 | 4,0 0.157 | 8,0 0.315 | 8,73 0.344 | 6,0 0.236 | 263,0 | 2 | MM0612 | | | ■ | |

Kopierfräser



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | RE | LF | FHA | ZEFP | Schlüssel | Beschichtung | | | |
|-----------------------|---------------|--------------|----------------|---------------|------|------|-----------|--------------|------|------|------|
| | | | | | | | | T60M | F15M | F30M | F40M |
| MM06-06006-B90-MD02 | 6,0 0.236 | 6,1 0.240 | 3,0 0.118 | 7,06 0.278 | 0,0 | 2 | MM0612 | ■ | | ■ | |
| MM06-06006-B90PF-M01 | 6,0 0.236 | 5,2 0.205 | 3,0 0.118 | 7,04 0.277 | 0,0 | 2 | MM0612 | | ■ | | |
| MM06-06006-B90P-M02 | 6,0 0.236 | 5,2 0.205 | 3,0 0.118 | 7,04 0.277 | 0,0 | 2 | MM0612 | | | ■ | |
| MM06-06006-B90S-E02 | 6,0 0.236 | 6,1 0.240 | 3,0 0.118 | 7,06 0.278 | 0,0 | 2 | MM0612 | | | ■ | |
| MM06-06007-B90A30-E02 | 6,0 0.236 | 7,4 0.291 | 3,0 0.118 | 9,85 0.388 | 30,0 | 3 | MM0416 | ✓ | | ■ | |
| MM06-06007-B90A30-M02 | 6,0 0.236 | 7,4 0.291 | 3,0 0.118 | 9,85 0.388 | 30,0 | 3 | MM0416 | ✓ | | | ■ |
| MM06-06406-B90P-M02 | 6,35 0.250 | 5,4 0.213 | 3,175 0.125 | 7,22 0.284 | 0,0 | 2 | MM0612 | | | ■ | |
| MM06-06406-B90S-E02 | 6,35 0.250 | 6,3 0.248 | 3,175 0.125 | 7,24 0.285 | 0,0 | 2 | MM0612 | | | ■ | |

MM06 - Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|----------------------------|----------------|----------------|---------|---------|---------|
| | | | 100% | 40% | 20% | 10% |
| P1 | MM06-06007-R05A30-M02 F40M | 1,3 | 0,030 | 0,030 | 0,036 | 0,048 |
| | | 0,050 | 0,0012 | 0,0012 | 0,0014 | 0,0019 |
| P2 | MM06-06007-R05A30-M02 F40M | 1,3 | 0,030 | 0,030 | 0,036 | 0,048 |
| | | 0,050 | 0,0012 | 0,0012 | 0,0014 | 0,0019 |
| P3 | MM06-06007-R05A30-M02 F40M | 1,3 | 0,028 | 0,028 | 0,034 | 0,046 |
| | | 0,050 | 0,0011 | 0,0011 | 0,0013 | 0,0018 |
| P4 | MM06-06007-R05A30-M02 F40M | 1,3 | 0,028 | 0,028 | 0,034 | 0,044 |
| | | 0,050 | 0,0011 | 0,0011 | 0,0013 | 0,0017 |
| P5 | MM06-06007-R05A30-M02 F40M | 1,3 | 0,028 | 0,028 | 0,032 | 0,044 |
| | | 0,050 | 0,0011 | 0,0011 | 0,0013 | 0,0017 |
| P6 | MM06-06007-R05A30-M02 F40M | 1,3 | 0,028 | 0,028 | 0,032 | 0,044 |
| | | 0,050 | 0,0011 | 0,0011 | 0,0013 | 0,0017 |
| P7 | MM06-06007-R05A30-M02 F40M | 1,3 | 0,028 | 0,028 | 0,032 | 0,044 |
| | | 0,050 | 0,0011 | 0,0011 | 0,0013 | 0,0017 |
| P8 | MM06-06007-R05A30-M02 F40M | 1,3 | 0,028 | 0,028 | 0,034 | 0,046 |
| | | 0,050 | 0,0011 | 0,0011 | 0,0013 | 0,0018 |
| P11 | MM06-06007-R05A30-M02 F40M | 1,3 | 0,028 | 0,028 | 0,032 | 0,044 |
| | | 0,050 | 0,0011 | 0,0011 | 0,0013 | 0,0017 |
| P12 | MM06-06007-R05A30-M02 F40M | 1,0 | 0,020 | 0,020 | 0,022 | 0,030 |
| | | 0,040 | 0,00080 | 0,00080 | 0,00085 | 0,0012 |
| M1 | MM06-06007-R05A30-M02 F40M | 1,3 | 0,030 | 0,030 | 0,036 | 0,048 |
| | | 0,050 | 0,0012 | 0,0012 | 0,0014 | 0,0019 |
| M2 | MM06-06007-R05A30-M02 F40M | 1,3 | 0,028 | 0,028 | 0,032 | 0,044 |
| | | 0,050 | 0,0011 | 0,0011 | 0,0013 | 0,0017 |
| M3 | MM06-06007-R05A30-M02 F40M | 1,0 | 0,024 | 0,024 | 0,026 | 0,036 |
| | | 0,040 | 0,00095 | 0,00095 | 0,0010 | 0,0014 |
| M4 | MM06-06007-R05A30-M02 F40M | 0,80 | 0,022 | 0,020 | 0,024 | 0,030 |
| | | 0,032 | 0,00085 | 0,00080 | 0,00095 | 0,0012 |
| M5 | MM06-06007-R05A30-M02 F40M | 0,80 | 0,022 | 0,020 | 0,024 | 0,030 |
| | | 0,032 | 0,00085 | 0,00080 | 0,00095 | 0,0012 |
| K1 | MM06-06007-R10A30-D02 F30M | 1,3 | 0,036 | 0,034 | 0,038 | 0,050 |
| | | 0,050 | 0,0014 | 0,0013 | 0,0015 | 0,0020 |
| K2 | MM06-06007-R10A30-D02 F30M | 1,3 | 0,032 | 0,032 | 0,034 | 0,044 |
| | | 0,050 | 0,0013 | 0,0013 | 0,0013 | 0,0017 |
| K3 | MM06-06007-R10A30-D02 F30M | 1,3 | 0,032 | 0,032 | 0,034 | 0,044 |
| | | 0,050 | 0,0013 | 0,0013 | 0,0013 | 0,0017 |
| K4 | MM06-06007-R10A30-D02 F30M | 1,3 | 0,032 | 0,032 | 0,034 | 0,044 |
| | | 0,050 | 0,0013 | 0,0013 | 0,0013 | 0,0017 |
| K5 | MM06-06007-R10A30-D02 F30M | 1,3 | 0,030 | 0,028 | 0,030 | 0,040 |
| | | 0,050 | 0,0012 | 0,0011 | 0,0012 | 0,0016 |
| K6 | MM06-06007-R10A30-D02 F30M | 1,3 | 0,032 | 0,032 | 0,034 | 0,044 |
| | | 0,050 | 0,0013 | 0,0013 | 0,0013 | 0,0017 |
| K7 | MM06-06007-R10A30-D02 F30M | 1,3 | 0,030 | 0,028 | 0,030 | 0,040 |
| | | 0,050 | 0,0012 | 0,0011 | 0,0012 | 0,0016 |
| N1 | MM06-06007-R10A30-E02 F30M | 1,3 | 0,046 | 0,044 | 0,048 | 0,065 |
| | | 0,050 | 0,0018 | 0,0017 | 0,0019 | 0,0026 |
| N2 | MM06-06007-R10A30-E02 F30M | 1,3 | 0,046 | 0,044 | 0,048 | 0,065 |
| | | 0,050 | 0,0018 | 0,0017 | 0,0019 | 0,0026 |
| N3 | MM06-06007-R10A30-E02 F30M | 1,3 | 0,046 | 0,044 | 0,048 | 0,065 |
| | | 0,050 | 0,0018 | 0,0017 | 0,0019 | 0,0026 |
| N11 | MM06-06007-R10A30-E02 F30M | 1,3 | 0,046 | 0,044 | 0,048 | 0,065 |
| | | 0,050 | 0,0018 | 0,0017 | 0,0019 | 0,0026 |
| S1 | MM06-06007-R10A30-D02 F30M | 0,80 | 0,028 | 0,026 | 0,025 | 0,032 |
| | | 0,032 | 0,0011 | 0,0010 | 0,0010 | 0,0013 |
| S2 | MM06-06007-R10A30-D02 F30M | 0,80 | 0,028 | 0,026 | 0,025 | 0,032 |
| | | 0,032 | 0,0011 | 0,0010 | 0,0010 | 0,0013 |
| S3 | MM06-06007-R10A30-D02 F30M | 0,80 | 0,026 | 0,025 | 0,024 | 0,028 |
| | | 0,032 | 0,0010 | 0,0010 | 0,00095 | 0,0012 |
| S11 | MM06-06007-R05A30-M02 F40M | 0,90 | 0,024 | 0,024 | 0,026 | 0,036 |
| | | 0,036 | 0,00095 | 0,00095 | 0,0010 | 0,0014 |
| S12 | MM06-06007-R05A30-M02 F40M | 0,90 | 0,024 | 0,024 | 0,026 | 0,036 |
| | | 0,036 | 0,00095 | 0,00095 | 0,0010 | 0,0014 |
| S13 | MM06-06007-R05A30-M02 F40M | 0,80 | 0,022 | 0,020 | 0,024 | 0,030 |
| | | 0,032 | 0,00085 | 0,00080 | 0,00095 | 0,0012 |
| H5 | MM06-06007-R10A30-D02 F30M | 1,0 | 0,025 | 0,024 | 0,024 | 0,030 |
| | | 0,040 | 0,0010 | 0,00095 | 0,00095 | 0,0012 |
| H8 | MM06-06007-R10A30-D02 F30M | 0,90 | 0,020 | 0,019 | 0,018 | 0,024 |
| | | 0,036 | 0,00080 | 0,00075 | 0,00070 | 0,00095 |
| H11 | MM06-06007-R10A30-D02 F30M | 1,0 | 0,025 | 0,024 | 0,024 | 0,030 |
| | | 0,040 | 0,0010 | 0,00095 | 0,00095 | 0,0012 |
| H12 | MM06-06007-R10A30-D02 F30M | 0,90 | 0,020 | 0,019 | 0,018 | 0,024 |
| | | 0,036 | 0,00080 | 0,00075 | 0,00070 | 0,00095 |
| H21 | MM06-06007-R10A30-D02 F30M | 0,90 | 0,020 | 0,019 | 0,018 | 0,024 |
| | | 0,036 | 0,00080 | 0,00075 | 0,00070 | 0,00095 |

SMG = Seco Werkstoff-Gruppe
 f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
 Alle Schnittdaten sind Startwerte

Universell
 Stahl und Guss
 Stahl und Guss
 Rostfrei und ISO-S-Werkstoffe
 Rostfrei und ISO-S-Werkstoffe
 NE-Metalle
 Harter
 Graphit
 X-Heads
 Minimaster Plus
 Minimaster

MM06 - Nut- und Eckfräsen – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | F30M | | | | F40M | | | | T60M | | | |
|-----|------|------|------|------|------|------|------|------|------|------|------|------|
| | 100% | 40% | 20% | 10% | 100% | 40% | 20% | 10% | 100% | 40% | 20% | 10% |
| P1 | 280 | 350 | 395 | 435 | 270 | 335 | 375 | 415 | 220 | 270 | 300 | 330 |
| | 920 | 1150 | 1300 | 1425 | 890 | 1100 | 1225 | 1350 | 720 | 890 | 980 | 1075 |
| P2 | 275 | 340 | 380 | 420 | 260 | 325 | 365 | 400 | 210 | 260 | 295 | 320 |
| | 900 | 1125 | 1250 | 1375 | 850 | 1075 | 1200 | 1300 | 690 | 850 | 970 | 1050 |
| P3 | 240 | 295 | 330 | 365 | 225 | 285 | 315 | 350 | 185 | 230 | 255 | 280 |
| | 790 | 970 | 1075 | 1200 | 740 | 940 | 1025 | 1150 | 610 | 750 | 840 | 920 |
| P4 | 210 | 260 | 295 | 320 | 200 | 250 | 280 | 305 | 160 | 200 | 225 | 245 |
| | 690 | 850 | 970 | 1050 | 660 | 820 | 920 | 1000 | 520 | 660 | 740 | 800 |
| P5 | 200 | 250 | 280 | 310 | 190 | 240 | 265 | 295 | 155 | 190 | 215 | 235 |
| | 660 | 820 | 920 | 1025 | 620 | 790 | 870 | 970 | 510 | 620 | 710 | 770 |
| P6 | 225 | 285 | 315 | 345 | 215 | 270 | 300 | 330 | 175 | 215 | 240 | 265 |
| | 740 | 940 | 1025 | 1125 | 710 | 890 | 980 | 1075 | 570 | 710 | 790 | 870 |
| P7 | 215 | 265 | 295 | 325 | 205 | 255 | 285 | 310 | 165 | 205 | 230 | 250 |
| | 710 | 870 | 970 | 1075 | 670 | 840 | 940 | 1025 | 540 | 670 | 750 | 820 |
| P8 | 200 | 250 | 280 | 305 | 190 | 240 | 265 | 290 | 155 | 190 | 215 | 235 |
| | 660 | 820 | 920 | 1000 | 620 | 790 | 870 | 950 | 510 | 620 | 710 | 770 |
| P11 | 210 | 260 | 290 | 320 | 200 | 245 | 275 | 305 | 160 | 200 | 220 | 245 |
| | 690 | 850 | 950 | 1050 | 660 | 800 | 900 | 1000 | 520 | 660 | 720 | 800 |
| P12 | 130 | 160 | 175 | 195 | 125 | 150 | 170 | 185 | 100 | 125 | 135 | 150 |
| | 425 | 520 | 570 | 640 | 410 | 490 | 560 | 610 | 330 | 410 | 445 | 490 |
| M1 | — | — | — | — | 210 | 265 | 295 | 320 | 170 | 210 | 235 | 260 |
| | — | — | — | — | 690 | 870 | 970 | 1050 | 560 | 690 | 770 | 850 |
| M2 | — | — | — | — | 175 | 215 | 240 | 265 | 140 | 170 | 195 | 210 |
| | — | — | — | — | 570 | 710 | 790 | 870 | 460 | 560 | 640 | 690 |
| M3 | — | — | — | — | 135 | 165 | 190 | 205 | 110 | 135 | 150 | 165 |
| | — | — | — | — | 445 | 540 | 620 | 670 | 360 | 445 | 490 | 540 |
| M4 | — | — | — | — | 105 | 130 | 145 | 155 | 85 | 105 | 115 | 125 |
| | — | — | — | — | 345 | 425 | 475 | 510 | 280 | 345 | 375 | 410 |
| M5 | — | — | — | — | 85 | 105 | 120 | 130 | 70 | 85 | 95 | 105 |
| | — | — | — | — | 280 | 345 | 395 | 425 | 230 | 280 | 310 | 345 |
| K1 | 215 | 270 | 305 | 335 | 205 | 260 | 290 | 315 | 165 | 210 | 230 | 255 |
| | 710 | 890 | 1000 | 1100 | 670 | 850 | 950 | 1025 | 540 | 690 | 750 | 840 |
| K2 | 190 | 235 | 265 | 295 | 180 | 225 | 255 | 280 | 150 | 180 | 205 | 225 |
| | 620 | 770 | 870 | 970 | 590 | 740 | 840 | 920 | 490 | 590 | 670 | 740 |
| K3 | 160 | 200 | 225 | 250 | 155 | 190 | 215 | 235 | 125 | 155 | 175 | 190 |
| | 520 | 660 | 740 | 820 | 510 | 620 | 710 | 770 | 410 | 510 | 570 | 620 |
| K4 | 155 | 190 | 215 | 235 | 145 | 180 | 205 | 225 | 120 | 145 | 165 | 180 |
| | 510 | 620 | 710 | 770 | 475 | 590 | 670 | 740 | 395 | 475 | 540 | 590 |
| K5 | 95 | 115 | 130 | 145 | 90 | 110 | 125 | 135 | 70 | 90 | 100 | 110 |
| | 310 | 375 | 425 | 475 | 295 | 360 | 410 | 445 | 230 | 295 | 330 | 360 |
| K6 | 135 | 170 | 190 | 210 | 130 | 160 | 180 | 200 | 105 | 130 | 145 | 160 |
| | 445 | 560 | 620 | 690 | 425 | 520 | 590 | 660 | 345 | 425 | 475 | 520 |
| K7 | 120 | 150 | 165 | 180 | 115 | 140 | 160 | 175 | 90 | 115 | 125 | 140 |
| | 395 | 490 | 540 | 590 | 375 | 460 | 520 | 570 | 295 | 375 | 410 | 460 |
| N1 | 1650 | 2050 | 2325 | 2525 | 1575 | 1975 | 2200 | 2400 | 1275 | 1575 | 1775 | 1950 |
| | 5425 | 6725 | 7625 | 8275 | 5175 | 6475 | 7225 | 7875 | 4175 | 5175 | 5825 | 6400 |
| N2 | 670 | 830 | 930 | 1025 | 640 | 790 | 890 | 970 | 510 | 640 | 710 | 790 |
| | 2200 | 2725 | 3050 | 3375 | 2100 | 2600 | 2925 | 3175 | 1675 | 2100 | 2325 | 2600 |
| N3 | 445 | 560 | 620 | 680 | 425 | 530 | 590 | 650 | 340 | 425 | 475 | 530 |
| | 1450 | 1825 | 2025 | 2225 | 1400 | 1750 | 1925 | 2125 | 1125 | 1400 | 1550 | 1750 |
| N11 | 510 | 630 | 710 | 780 | 485 | 600 | 680 | 740 | 390 | 485 | 540 | 600 |
| | 1675 | 2075 | 2325 | 2550 | 1600 | 1975 | 2225 | 2425 | 1275 | 1600 | 1775 | 1975 |
| S1 | 50 | 65 | 70 | 75 | 49 | 60 | 65 | 75 | 39 | 49 | 55 | 60 |
| | 165 | 215 | 230 | 245 | 160 | 195 | 215 | 245 | 130 | 160 | 180 | 195 |
| S2 | 41 | 50 | 55 | 60 | 39 | 48 | 55 | 60 | 32 | 39 | 44 | 48 |
| | 135 | 165 | 180 | 195 | 130 | 155 | 180 | 195 | 105 | 130 | 145 | 155 |
| S3 | 36 | 44 | 49 | 55 | 34 | 42 | 47 | 50 | 27 | 34 | 38 | 41 |
| | 120 | 145 | 160 | 180 | 110 | 140 | 155 | 165 | 90 | 110 | 125 | 135 |
| S11 | — | — | — | — | 70 | 85 | 95 | 105 | 55 | 70 | 75 | 85 |
| | — | — | — | — | 230 | 280 | 310 | 345 | 180 | 230 | 245 | 280 |
| S12 | — | — | — | — | 48 | 60 | 65 | 70 | 38 | 48 | 55 | 60 |
| | — | — | — | — | 155 | 195 | 215 | 245 | 125 | 155 | 180 | 195 |
| S13 | — | — | — | — | 27 | 34 | 38 | 41 | 22 | 27 | 30 | 33 |
| | — | — | — | — | 90 | 110 | 125 | 135 | 70 | 90 | 100 | 110 |
| H5 | 43 | 55 | 60 | 65 | 41 | 50 | 55 | 60 | 33 | 41 | 45 | 50 |
| | 140 | 180 | 195 | 215 | 135 | 165 | 180 | 195 | 110 | 135 | 150 | 165 |
| H8 | 44 | 55 | 60 | 65 | 42 | 50 | 60 | 65 | 34 | 42 | 47 | 50 |
| | 145 | 180 | 195 | 215 | 140 | 165 | 195 | 215 | 110 | 140 | 155 | 165 |
| H11 | 55 | 65 | 75 | 85 | 50 | 65 | 70 | 80 | 42 | 50 | 60 | 65 |
| | 180 | 215 | 245 | 280 | 165 | 215 | 230 | 260 | 140 | 165 | 195 | 215 |
| H12 | 80 | 95 | 110 | 120 | 75 | 90 | 105 | 115 | 60 | 75 | 85 | 90 |
| | 260 | 310 | 360 | 395 | 245 | 295 | 345 | 375 | 195 | 245 | 280 | 295 |
| H21 | 44 | 55 | 60 | 65 | 42 | 50 | 60 | 65 | 34 | 42 | 47 | 50 |
| | 145 | 180 | 195 | 215 | 140 | 165 | 195 | 215 | 110 | 140 | 155 | 165 |

MM06 Z3-Kopierfräser – Auswahl der Wendeschneidplatten – Schruppen – Metrisch/ Zoll

| SMG | | a_p | f_z | | | |
|-----|----------------------------|-------|---------|---------|---------|---------|
| | | | 100% | 40% | 20% | 10% |
| P1 | MM06-06007-B90A30-M02 F40M | 1,3 | 0,036 | 0,034 | 0,036 | 0,048 |
| | | 0,050 | 0,0014 | 0,0013 | 0,0014 | 0,0019 |
| P2 | MM06-06007-B90A30-M02 F40M | 1,3 | 0,036 | 0,034 | 0,036 | 0,048 |
| | | 0,050 | 0,0014 | 0,0013 | 0,0014 | 0,0019 |
| P3 | MM06-06007-B90A30-M02 F40M | 1,3 | 0,034 | 0,034 | 0,034 | 0,046 |
| | | 0,050 | 0,0013 | 0,0013 | 0,0013 | 0,0018 |
| P4 | MM06-06007-B90A30-M02 F40M | 1,3 | 0,034 | 0,032 | 0,034 | 0,044 |
| | | 0,050 | 0,0013 | 0,0013 | 0,0013 | 0,0017 |
| P5 | MM06-06007-B90A30-M02 F40M | 1,3 | 0,032 | 0,032 | 0,034 | 0,044 |
| | | 0,050 | 0,0013 | 0,0013 | 0,0013 | 0,0017 |
| P6 | MM06-06007-B90A30-M02 F40M | 1,3 | 0,032 | 0,032 | 0,034 | 0,044 |
| | | 0,050 | 0,0013 | 0,0013 | 0,0013 | 0,0017 |
| P7 | MM06-06007-B90A30-M02 F40M | 1,3 | 0,032 | 0,032 | 0,034 | 0,044 |
| | | 0,050 | 0,0013 | 0,0013 | 0,0013 | 0,0017 |
| P8 | MM06-06007-B90A30-M02 F40M | 1,3 | 0,034 | 0,034 | 0,034 | 0,046 |
| | | 0,050 | 0,0013 | 0,0013 | 0,0013 | 0,0018 |
| P11 | MM06-06007-B90A30-M02 F40M | 1,3 | 0,032 | 0,032 | 0,034 | 0,044 |
| | | 0,050 | 0,0013 | 0,0013 | 0,0013 | 0,0017 |
| P12 | MM06-06007-B90A30-M02 F40M | 1,0 | 0,024 | 0,022 | 0,024 | 0,030 |
| | | 0,040 | 0,00095 | 0,00085 | 0,00095 | 0,0012 |
| M1 | MM06-06007-B90A30-M02 F40M | 1,3 | 0,036 | 0,034 | 0,036 | 0,048 |
| | | 0,050 | 0,0014 | 0,0013 | 0,0014 | 0,0019 |
| M2 | MM06-06007-B90A30-M02 F40M | 1,3 | 0,032 | 0,032 | 0,034 | 0,044 |
| | | 0,050 | 0,0013 | 0,0013 | 0,0013 | 0,0017 |
| M3 | MM06-06007-B90A30-M02 F40M | 1,0 | 0,028 | 0,026 | 0,028 | 0,036 |
| | | 0,040 | 0,0011 | 0,0010 | 0,0011 | 0,0014 |
| M4 | MM06-06007-B90A30-M02 F40M | 0,80 | 0,025 | 0,025 | 0,025 | 0,030 |
| | | 0,032 | 0,0010 | 0,0010 | 0,0010 | 0,0013 |
| M5 | MM06-06007-B90A30-M02 F40M | 0,80 | 0,025 | 0,025 | 0,025 | 0,030 |
| | | 0,032 | 0,0010 | 0,0010 | 0,0010 | 0,0013 |
| K1 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,036 | 0,034 | 0,036 | 0,048 |
| | | 0,050 | 0,0014 | 0,0013 | 0,0014 | 0,0019 |
| K2 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,032 | 0,032 | 0,034 | 0,044 |
| | | 0,050 | 0,0013 | 0,0013 | 0,0013 | 0,0017 |
| K3 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,032 | 0,032 | 0,034 | 0,044 |
| | | 0,050 | 0,0013 | 0,0013 | 0,0013 | 0,0017 |
| K4 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,032 | 0,032 | 0,034 | 0,044 |
| | | 0,050 | 0,0013 | 0,0013 | 0,0013 | 0,0017 |
| K5 | MM06-06007-B90A30-M02 F40M | 1,3 | 0,030 | 0,028 | 0,030 | 0,040 |
| | | 0,050 | 0,0012 | 0,0011 | 0,0012 | 0,0016 |
| K6 | MM06-06007-B90A30-M02 F40M | 1,3 | 0,032 | 0,032 | 0,034 | 0,044 |
| | | 0,050 | 0,0013 | 0,0013 | 0,0013 | 0,0017 |
| K7 | MM06-06007-B90A30-M02 F40M | 1,3 | 0,030 | 0,028 | 0,030 | 0,040 |
| | | 0,050 | 0,0012 | 0,0011 | 0,0012 | 0,0016 |
| N1 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,046 | 0,044 | 0,046 | 0,060 |
| | | 0,050 | 0,0018 | 0,0017 | 0,0018 | 0,0024 |
| N2 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,046 | 0,044 | 0,046 | 0,060 |
| | | 0,050 | 0,0018 | 0,0017 | 0,0018 | 0,0024 |
| N3 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,046 | 0,044 | 0,046 | 0,060 |
| | | 0,050 | 0,0018 | 0,0017 | 0,0018 | 0,0024 |
| N11 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,046 | 0,044 | 0,046 | 0,060 |
| | | 0,050 | 0,0018 | 0,0017 | 0,0018 | 0,0024 |
| S1 | MM06-06007-B90A30-M02 F40M | 0,80 | 0,025 | 0,025 | 0,025 | 0,030 |
| | | 0,032 | 0,0010 | 0,0010 | 0,0010 | 0,0013 |
| S2 | MM06-06007-B90A30-M02 F40M | 0,80 | 0,025 | 0,025 | 0,025 | 0,030 |
| | | 0,032 | 0,0010 | 0,0010 | 0,0010 | 0,0013 |
| S3 | MM06-06007-B90A30-M02 F40M | 0,80 | 0,024 | 0,022 | 0,022 | 0,028 |
| | | 0,032 | 0,00095 | 0,00085 | 0,00085 | 0,0012 |
| S11 | MM06-06007-B90A30-M02 F40M | 0,90 | 0,028 | 0,028 | 0,028 | 0,036 |
| | | 0,036 | 0,0011 | 0,0011 | 0,0011 | 0,0014 |
| S12 | MM06-06007-B90A30-M02 F40M | 0,90 | 0,028 | 0,028 | 0,028 | 0,036 |
| | | 0,036 | 0,0011 | 0,0011 | 0,0011 | 0,0014 |
| S13 | MM06-06007-B90A30-M02 F40M | 0,80 | 0,025 | 0,025 | 0,025 | 0,030 |
| | | 0,032 | 0,0010 | 0,0010 | 0,0010 | 0,0013 |
| H5 | MM06-06007-B90A30-E02 F30M | 1,0 | 0,024 | 0,022 | 0,024 | 0,030 |
| | | 0,040 | 0,00095 | 0,00085 | 0,00095 | 0,0012 |
| H8 | MM06-06007-B90A30-E02 F30M | 0,90 | 0,018 | 0,018 | 0,018 | 0,022 |
| | | 0,036 | 0,00070 | 0,00070 | 0,00070 | 0,00095 |
| H11 | MM06-06007-B90A30-E02 F30M | 1,0 | 0,024 | 0,022 | 0,024 | 0,030 |
| | | 0,040 | 0,00095 | 0,00085 | 0,00095 | 0,0012 |
| H12 | MM06-06007-B90A30-E02 F30M | 0,90 | 0,018 | 0,018 | 0,018 | 0,022 |
| | | 0,036 | 0,00070 | 0,00070 | 0,00070 | 0,00095 |
| H21 | MM06-06007-B90A30-E02 F30M | 0,90 | 0,018 | 0,018 | 0,018 | 0,022 |
| | | 0,036 | 0,00070 | 0,00070 | 0,00070 | 0,00095 |

SMG = Seco Werkstoff-Gruppe
 f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
 Alle Schnittdaten sind Startwerte

Universell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MM06 Z3-Kopierfräser – Auswahl der Wendeschneidplatten – Schichten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|----------------------------|----------------|----------------|---------|--------|--------|
| | | | 15% | 10% | 5% | 2% |
| P1 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,040 | 0,048 | 0,065 | 0,11 |
| | | 0,050 | 0,0016 | 0,0019 | 0,0026 | 0,0044 |
| P2 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,040 | 0,048 | 0,065 | 0,11 |
| | | 0,050 | 0,0016 | 0,0019 | 0,0026 | 0,0044 |
| P3 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,038 | 0,046 | 0,065 | 0,10 |
| | | 0,050 | 0,0015 | 0,0018 | 0,0026 | 0,0040 |
| P4 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,038 | 0,044 | 0,060 | 0,10 |
| | | 0,050 | 0,0015 | 0,0017 | 0,0024 | 0,0040 |
| P5 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,036 | 0,044 | 0,060 | 0,10 |
| | | 0,050 | 0,0014 | 0,0017 | 0,0024 | 0,0040 |
| P6 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,036 | 0,044 | 0,060 | 0,10 |
| | | 0,050 | 0,0014 | 0,0017 | 0,0024 | 0,0040 |
| P7 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,036 | 0,044 | 0,060 | 0,10 |
| | | 0,050 | 0,0014 | 0,0017 | 0,0024 | 0,0040 |
| P8 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,038 | 0,046 | 0,065 | 0,10 |
| | | 0,050 | 0,0015 | 0,0018 | 0,0026 | 0,0040 |
| P11 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,036 | 0,044 | 0,060 | 0,10 |
| | | 0,050 | 0,0014 | 0,0017 | 0,0024 | 0,0040 |
| P12 | MM06-06007-B90A30-E02 F30M | 1,0 | 0,026 | 0,030 | 0,042 | 0,065 |
| | | 0,040 | 0,0010 | 0,0012 | 0,0017 | 0,0026 |
| M1 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,040 | 0,048 | 0,065 | 0,11 |
| | | 0,050 | 0,0016 | 0,0019 | 0,0026 | 0,0044 |
| M2 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,036 | 0,044 | 0,060 | 0,10 |
| | | 0,050 | 0,0014 | 0,0017 | 0,0024 | 0,0040 |
| M3 | MM06-06007-B90A30-E02 F30M | 1,0 | 0,030 | 0,036 | 0,048 | 0,080 |
| | | 0,040 | 0,0012 | 0,0014 | 0,0019 | 0,0032 |
| M4 | MM06-06007-B90A30-E02 F30M | 0,80 | 0,026 | 0,030 | 0,042 | 0,070 |
| | | 0,032 | 0,0010 | 0,0013 | 0,0017 | 0,0028 |
| M5 | MM06-06007-B90A30-E02 F30M | 0,80 | 0,026 | 0,030 | 0,042 | 0,070 |
| | | 0,032 | 0,0010 | 0,0013 | 0,0017 | 0,0028 |
| K1 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,040 | 0,048 | 0,065 | 0,11 |
| | | 0,050 | 0,0016 | 0,0019 | 0,0026 | 0,0044 |
| K2 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,036 | 0,044 | 0,060 | 0,10 |
| | | 0,050 | 0,0014 | 0,0017 | 0,0024 | 0,0040 |
| K3 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,036 | 0,044 | 0,060 | 0,10 |
| | | 0,050 | 0,0014 | 0,0017 | 0,0024 | 0,0040 |
| K4 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,036 | 0,044 | 0,060 | 0,10 |
| | | 0,050 | 0,0014 | 0,0017 | 0,0024 | 0,0040 |
| K5 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,034 | 0,040 | 0,055 | 0,090 |
| | | 0,050 | 0,0013 | 0,0016 | 0,0022 | 0,0036 |
| K6 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,036 | 0,044 | 0,060 | 0,10 |
| | | 0,050 | 0,0014 | 0,0017 | 0,0024 | 0,0040 |
| K7 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,034 | 0,040 | 0,055 | 0,090 |
| | | 0,050 | 0,0013 | 0,0016 | 0,0022 | 0,0036 |
| N1 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,050 | 0,060 | 0,085 | 0,14 |
| | | 0,050 | 0,0020 | 0,0024 | 0,0034 | 0,0055 |
| N2 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,050 | 0,060 | 0,085 | 0,14 |
| | | 0,050 | 0,0020 | 0,0024 | 0,0034 | 0,0055 |
| N3 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,050 | 0,060 | 0,085 | 0,14 |
| | | 0,050 | 0,0020 | 0,0024 | 0,0034 | 0,0055 |
| N11 | MM06-06007-B90A30-E02 F30M | 1,3 | 0,050 | 0,060 | 0,085 | 0,14 |
| | | 0,050 | 0,0020 | 0,0024 | 0,0034 | 0,0055 |
| S1 | MM06-06007-B90A30-E02 F30M | 0,80 | 0,026 | 0,030 | 0,042 | 0,070 |
| | | 0,032 | 0,0010 | 0,0013 | 0,0017 | 0,0028 |
| S2 | MM06-06007-B90A30-E02 F30M | 0,80 | 0,026 | 0,030 | 0,042 | 0,070 |
| | | 0,032 | 0,0010 | 0,0013 | 0,0017 | 0,0028 |
| S3 | MM06-06007-B90A30-E02 F30M | 0,80 | 0,025 | 0,028 | 0,040 | 0,065 |
| | | 0,032 | 0,0010 | 0,0012 | 0,0016 | 0,0026 |
| S11 | MM06-06007-B90A30-E02 F30M | 0,90 | 0,030 | 0,036 | 0,048 | 0,080 |
| | | 0,036 | 0,0012 | 0,0014 | 0,0019 | 0,0032 |
| S12 | MM06-06007-B90A30-E02 F30M | 0,90 | 0,030 | 0,036 | 0,048 | 0,080 |
| | | 0,036 | 0,0012 | 0,0014 | 0,0019 | 0,0032 |
| S13 | MM06-06007-B90A30-E02 F30M | 0,80 | 0,026 | 0,030 | 0,042 | 0,070 |
| | | 0,032 | 0,0010 | 0,0013 | 0,0017 | 0,0028 |
| H5 | MM06-06007-B90A30-E02 F30M | 1,0 | 0,026 | 0,030 | 0,042 | 0,065 |
| | | 0,040 | 0,0010 | 0,0012 | 0,0017 | 0,0026 |
| H8 | MM06-06007-B90A30-E02 F30M | 0,90 | 0,020 | 0,022 | 0,032 | 0,050 |
| | | 0,036 | 0,00080 | 0,00095 | 0,0013 | 0,0020 |
| H11 | MM06-06007-B90A30-E02 F30M | 1,0 | 0,026 | 0,030 | 0,042 | 0,065 |
| | | 0,040 | 0,0010 | 0,0012 | 0,0017 | 0,0026 |
| H12 | MM06-06007-B90A30-E02 F30M | 0,90 | 0,020 | 0,022 | 0,032 | 0,050 |
| | | 0,036 | 0,00080 | 0,00095 | 0,0013 | 0,0020 |
| H21 | MM06-06007-B90A30-E02 F30M | 0,90 | 0,020 | 0,022 | 0,032 | 0,050 |
| | | 0,036 | 0,00080 | 0,00095 | 0,0013 | 0,0020 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MM06 Z3-Kopierfräser – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | F30M | | | | | F40M | | | | |
|-----|------|------|------|------|------|------|------|------|------|------|
| | 100% | 20% | 10% | 5% | 2% | 100% | 20% | 10% | 5% | 2% |
| P1 | 295 | 350 | 370 | 405 | 400 | 280 | 330 | 355 | 385 | 380 |
| | 970 | 1150 | 1225 | 1325 | 1300 | 920 | 1075 | 1175 | 1275 | 1250 |
| P2 | 285 | 340 | 360 | 395 | 390 | 275 | 325 | 345 | 375 | 370 |
| | 940 | 1125 | 1175 | 1300 | 1275 | 900 | 1075 | 1125 | 1225 | 1225 |
| P3 | 250 | 295 | 315 | 340 | 340 | 235 | 280 | 300 | 320 | 325 |
| | 820 | 970 | 1025 | 1125 | 1125 | 770 | 920 | 980 | 1050 | 1075 |
| P4 | 220 | 260 | 275 | 300 | 300 | 210 | 245 | 265 | 285 | 285 |
| | 720 | 850 | 900 | 980 | 980 | 690 | 800 | 870 | 940 | 940 |
| P5 | 210 | 245 | 265 | 285 | 285 | 200 | 235 | 250 | 275 | 270 |
| | 690 | 800 | 870 | 940 | 940 | 660 | 770 | 820 | 900 | 890 |
| P6 | 235 | 275 | 295 | 320 | 320 | 225 | 265 | 285 | 305 | 305 |
| | 770 | 900 | 970 | 1050 | 1050 | 740 | 870 | 940 | 1000 | 1000 |
| P7 | 225 | 260 | 280 | 305 | 300 | 210 | 250 | 265 | 290 | 285 |
| | 740 | 850 | 920 | 1000 | 980 | 690 | 820 | 870 | 950 | 940 |
| P8 | 210 | 245 | 265 | 285 | 285 | 200 | 235 | 250 | 270 | 270 |
| | 690 | 800 | 870 | 940 | 940 | 660 | 770 | 820 | 890 | 890 |
| P11 | 215 | 255 | 270 | 295 | 295 | 205 | 240 | 260 | 280 | 280 |
| | 710 | 840 | 890 | 970 | 970 | 670 | 790 | 850 | 920 | 920 |
| P12 | 135 | 160 | 165 | 180 | 180 | 125 | 150 | 160 | 170 | 170 |
| | 445 | 520 | 560 | 590 | 590 | 410 | 490 | 520 | 560 | 560 |
| M1 | 230 | 275 | 290 | 315 | 315 | 220 | 260 | 280 | 300 | 300 |
| | 750 | 900 | 950 | 1025 | 1025 | 720 | 850 | 920 | 980 | 980 |
| M2 | 190 | 220 | 240 | 260 | 255 | 180 | 210 | 225 | 245 | 245 |
| | 620 | 720 | 790 | 850 | 840 | 590 | 690 | 740 | 800 | 800 |
| M3 | 150 | 180 | 185 | 200 | 200 | 140 | 170 | 175 | 190 | 190 |
| | 490 | 590 | 610 | 660 | 660 | 460 | 560 | 590 | 620 | 620 |
| M4 | 105 | 145 | 140 | 150 | 150 | 100 | 135 | 135 | 145 | 145 |
| | 345 | 475 | 490 | 490 | 490 | 330 | 445 | 460 | 475 | 475 |
| M5 | 85 | 120 | 115 | 125 | 125 | 85 | 115 | 110 | 120 | 120 |
| | 280 | 395 | 410 | 410 | 410 | 280 | 375 | 395 | 395 | 395 |
| K1 | 230 | 270 | 285 | 310 | 310 | 215 | 255 | 275 | 295 | 295 |
| | 750 | 890 | 940 | 1025 | 1025 | 710 | 840 | 900 | 970 | 970 |
| K2 | 200 | 235 | 250 | 270 | 270 | 190 | 225 | 240 | 260 | 255 |
| | 660 | 770 | 820 | 890 | 890 | 620 | 740 | 790 | 850 | 840 |
| K3 | 170 | 200 | 210 | 230 | 230 | 160 | 190 | 200 | 220 | 220 |
| | 560 | 660 | 690 | 750 | 750 | 520 | 620 | 660 | 720 | 720 |
| K4 | 160 | 190 | 205 | 220 | 220 | 155 | 180 | 195 | 210 | 210 |
| | 520 | 620 | 670 | 720 | 720 | 510 | 590 | 640 | 690 | 690 |
| K5 | 95 | 115 | 120 | 130 | 130 | 90 | 110 | 115 | 125 | 125 |
| | 310 | 375 | 395 | 425 | 425 | 295 | 360 | 375 | 410 | 410 |
| K6 | 140 | 165 | 180 | 195 | 190 | 135 | 160 | 170 | 185 | 185 |
| | 460 | 540 | 590 | 640 | 620 | 445 | 520 | 560 | 610 | 610 |
| K7 | 125 | 145 | 155 | 170 | 170 | 120 | 140 | 150 | 160 | 160 |
| | 410 | 475 | 510 | 560 | 560 | 395 | 460 | 490 | 520 | 520 |
| N1 | 1750 | 2075 | 2200 | 2375 | 2375 | 1675 | 1975 | 2100 | 2275 | 2250 |
| | 5750 | 6800 | 7225 | 7800 | 7800 | 5500 | 6475 | 6900 | 7475 | 7375 |
| N2 | 710 | 830 | 890 | 960 | 950 | 670 | 790 | 850 | 920 | 910 |
| | 2325 | 2725 | 2925 | 3150 | 3125 | 2200 | 2600 | 2800 | 3025 | 2975 |
| N3 | 470 | 560 | 590 | 640 | 640 | 450 | 530 | 570 | 610 | 610 |
| | 1550 | 1825 | 1925 | 2100 | 2100 | 1475 | 1750 | 1875 | 2000 | 2000 |
| N11 | 540 | 630 | 680 | 730 | 730 | 510 | 600 | 650 | 700 | 690 |
| | 1775 | 2075 | 2225 | 2400 | 2400 | 1675 | 1975 | 2125 | 2300 | 2275 |
| S1 | 49 | 65 | 65 | 70 | 70 | 46 | 65 | 65 | 70 | 65 |
| | 160 | 215 | 230 | 230 | 230 | 150 | 215 | 215 | 230 | 215 |
| S2 | 39 | 55 | 55 | 55 | 55 | 37 | 50 | 50 | 55 | 55 |
| | 130 | 180 | 180 | 180 | 180 | 120 | 165 | 180 | 180 | 180 |
| S3 | 34 | 47 | 46 | 50 | 49 | 32 | 44 | 44 | 47 | 47 |
| | 110 | 155 | 155 | 165 | 160 | 105 | 145 | 150 | 155 | 155 |
| S11 | 75 | 95 | 95 | 100 | 100 | 70 | 90 | 90 | 95 | 95 |
| | 245 | 310 | 310 | 330 | 330 | 230 | 295 | 295 | 310 | 310 |
| S12 | 50 | 65 | 65 | 70 | 70 | 48 | 60 | 60 | 65 | 65 |
| | 165 | 215 | 215 | 230 | 230 | 155 | 195 | 215 | 215 | 215 |
| S13 | 27 | 38 | 37 | 40 | 40 | 26 | 36 | 35 | 38 | 38 |
| | 90 | 125 | 130 | 130 | 130 | 85 | 120 | 120 | 125 | 125 |
| H5 | 44 | 55 | 55 | 60 | 60 | 42 | 50 | 55 | 55 | 55 |
| | 145 | 180 | 180 | 195 | 195 | 140 | 165 | 180 | 180 | 180 |
| H8 | 44 | 55 | 55 | 60 | 60 | 42 | 55 | 55 | 60 | 60 |
| | 145 | 180 | 195 | 195 | 195 | 140 | 180 | 180 | 195 | 195 |
| H11 | 55 | 70 | 70 | 75 | 75 | 55 | 65 | 65 | 70 | 75 |
| | 180 | 230 | 230 | 245 | 245 | 180 | 215 | 230 | 230 | 245 |
| H12 | 80 | 100 | 100 | 110 | 110 | 75 | 95 | 95 | 105 | 105 |
| | 260 | 330 | 345 | 360 | 360 | 245 | 310 | 330 | 345 | 345 |
| H21 | 44 | 55 | 55 | 60 | 60 | 42 | 55 | 55 | 60 | 60 |
| | 145 | 180 | 195 | 195 | 195 | 140 | 180 | 180 | 195 | 195 |

Universell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MM06 Z2-Kopierfräser – Auswahl der Wendeschneidplatten – Schruppen – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|--------------------------|----------------|----------------|---------|---------|---------|
| | | | 100% | 40% | 20% | 10% |
| P1 | MM06-06006-B90S-E02 F30M | 2,5 | 0,030 | 0,032 | 0,036 | 0,048 |
| | | 0,10 | 0,0012 | 0,0013 | 0,0014 | 0,0019 |
| P2 | MM06-06006-B90S-E02 F30M | 2,5 | 0,032 | 0,032 | 0,036 | 0,048 |
| | | 0,10 | 0,0013 | 0,0013 | 0,0014 | 0,0019 |
| P3 | MM06-06006-B90S-E02 F30M | 2,5 | 0,030 | 0,030 | 0,034 | 0,046 |
| | | 0,10 | 0,0012 | 0,0012 | 0,0013 | 0,0018 |
| P4 | MM06-06006-B90-MD02 F30M | 2,5 | 0,030 | 0,030 | 0,034 | 0,044 |
| | | 0,10 | 0,0012 | 0,0012 | 0,0013 | 0,0017 |
| P5 | MM06-06006-B90-MD02 F30M | 2,5 | 0,028 | 0,028 | 0,034 | 0,044 |
| | | 0,10 | 0,0011 | 0,0011 | 0,0013 | 0,0017 |
| P6 | MM06-06006-B90-MD02 F30M | 2,5 | 0,028 | 0,028 | 0,032 | 0,044 |
| | | 0,10 | 0,0011 | 0,0011 | 0,0013 | 0,0017 |
| P7 | MM06-06006-B90-MD02 F30M | 2,5 | 0,028 | 0,028 | 0,032 | 0,044 |
| | | 0,10 | 0,0011 | 0,0011 | 0,0013 | 0,0017 |
| P8 | MM06-06006-B90-MD02 F30M | 2,5 | 0,030 | 0,030 | 0,034 | 0,046 |
| | | 0,10 | 0,0012 | 0,0012 | 0,0013 | 0,0018 |
| P11 | MM06-06006-B90-MD02 F30M | 2,5 | 0,028 | 0,028 | 0,032 | 0,044 |
| | | 0,10 | 0,0011 | 0,0011 | 0,0013 | 0,0017 |
| P12 | MM06-06006-B90-MD02 F30M | 2,0 | 0,020 | 0,020 | 0,024 | 0,030 |
| | | 0,080 | 0,00080 | 0,00080 | 0,00095 | 0,0012 |
| M1 | MM06-06006-B90S-E02 F30M | 2,5 | 0,032 | 0,032 | 0,036 | 0,048 |
| | | 0,10 | 0,0013 | 0,0013 | 0,0014 | 0,0019 |
| M2 | MM06-06006-B90S-E02 F30M | 2,5 | 0,028 | 0,028 | 0,034 | 0,044 |
| | | 0,10 | 0,0011 | 0,0011 | 0,0013 | 0,0017 |
| M3 | MM06-06006-B90S-E02 F30M | 2,0 | 0,024 | 0,024 | 0,028 | 0,036 |
| | | 0,080 | 0,00095 | 0,00095 | 0,0011 | 0,0014 |
| M4 | MM06-06006-B90-MD02 F30M | 1,5 | 0,022 | 0,022 | 0,024 | 0,030 |
| | | 0,060 | 0,00085 | 0,00085 | 0,00095 | 0,0013 |
| M5 | MM06-06006-B90-MD02 F30M | 1,5 | 0,022 | 0,022 | 0,024 | 0,030 |
| | | 0,060 | 0,00085 | 0,00085 | 0,00095 | 0,0013 |
| K1 | MM06-06006-B90S-E02 F30M | 2,5 | 0,032 | 0,032 | 0,036 | 0,048 |
| | | 0,10 | 0,0013 | 0,0013 | 0,0014 | 0,0019 |
| K2 | MM06-06006-B90S-E02 F30M | 2,5 | 0,028 | 0,028 | 0,034 | 0,044 |
| | | 0,10 | 0,0011 | 0,0011 | 0,0013 | 0,0017 |
| K3 | MM06-06006-B90S-E02 F30M | 2,5 | 0,028 | 0,028 | 0,034 | 0,044 |
| | | 0,10 | 0,0011 | 0,0011 | 0,0013 | 0,0017 |
| K4 | MM06-06006-B90S-E02 F30M | 2,5 | 0,028 | 0,028 | 0,034 | 0,044 |
| | | 0,10 | 0,0011 | 0,0011 | 0,0013 | 0,0017 |
| K5 | MM06-06006-B90S-E02 F30M | 2,5 | 0,026 | 0,026 | 0,030 | 0,040 |
| | | 0,10 | 0,0010 | 0,0010 | 0,0012 | 0,0016 |
| K6 | MM06-06006-B90-MD02 F30M | 2,5 | 0,028 | 0,028 | 0,034 | 0,044 |
| | | 0,10 | 0,0011 | 0,0011 | 0,0013 | 0,0017 |
| K7 | MM06-06006-B90-MD02 F30M | 2,5 | 0,026 | 0,026 | 0,030 | 0,040 |
| | | 0,10 | 0,0010 | 0,0010 | 0,0012 | 0,0016 |
| N1 | MM06-06006-B90S-E02 F30M | 2,5 | 0,040 | 0,040 | 0,046 | 0,060 |
| | | 0,10 | 0,0016 | 0,0016 | 0,0018 | 0,0024 |
| N2 | MM06-06006-B90S-E02 F30M | 2,5 | 0,040 | 0,040 | 0,046 | 0,060 |
| | | 0,10 | 0,0016 | 0,0016 | 0,0018 | 0,0024 |
| N3 | MM06-06006-B90S-E02 F30M | 2,5 | 0,040 | 0,040 | 0,046 | 0,060 |
| | | 0,10 | 0,0016 | 0,0016 | 0,0018 | 0,0024 |
| N11 | MM06-06006-B90S-E02 F30M | 2,5 | 0,040 | 0,040 | 0,046 | 0,060 |
| | | 0,10 | 0,0016 | 0,0016 | 0,0018 | 0,0024 |
| S1 | MM06-06006-B90-MD02 F30M | 1,5 | 0,022 | 0,022 | 0,024 | 0,030 |
| | | 0,060 | 0,00085 | 0,00085 | 0,00095 | 0,0013 |
| S2 | MM06-06006-B90-MD02 F30M | 1,5 | 0,022 | 0,022 | 0,024 | 0,030 |
| | | 0,060 | 0,00085 | 0,00085 | 0,00095 | 0,0013 |
| S3 | MM06-06006-B90-MD02 F30M | 1,5 | 0,020 | 0,020 | 0,022 | 0,028 |
| | | 0,060 | 0,00080 | 0,00080 | 0,00085 | 0,0012 |
| S11 | MM06-06006-B90-MD02 F30M | 1,7 | 0,025 | 0,024 | 0,028 | 0,036 |
| | | 0,065 | 0,0010 | 0,00095 | 0,0011 | 0,0014 |
| S12 | MM06-06006-B90-MD02 F30M | 1,7 | 0,025 | 0,024 | 0,028 | 0,036 |
| | | 0,065 | 0,0010 | 0,00095 | 0,0011 | 0,0014 |
| S13 | MM06-06006-B90-MD02 F30M | 1,5 | 0,022 | 0,022 | 0,024 | 0,030 |
| | | 0,060 | 0,00085 | 0,00085 | 0,00095 | 0,0013 |
| H5 | MM06-06006-B90-MD02 F30M | 2,0 | 0,020 | 0,020 | 0,024 | 0,030 |
| | | 0,080 | 0,00080 | 0,00080 | 0,00095 | 0,0012 |
| H8 | MM06-06006-B90-MD02 F30M | 1,7 | 0,016 | 0,016 | 0,018 | 0,022 |
| | | 0,065 | 0,00065 | 0,00065 | 0,00070 | 0,00095 |
| H11 | MM06-06006-B90-MD02 F30M | 2,0 | 0,020 | 0,020 | 0,024 | 0,030 |
| | | 0,080 | 0,00080 | 0,00080 | 0,00095 | 0,0012 |
| H12 | MM06-06006-B90-MD02 F30M | 1,7 | 0,016 | 0,016 | 0,018 | 0,022 |
| | | 0,065 | 0,00065 | 0,00065 | 0,00070 | 0,00095 |
| H21 | MM06-06006-B90-MD02 F30M | 1,7 | 0,016 | 0,016 | 0,018 | 0,022 |
| | | 0,065 | 0,00065 | 0,00065 | 0,00070 | 0,00095 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (stf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MM06 Z2-Kopierfräser – Auswahl der Wendeschneidplatten – Schlichten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|---------------------------|----------------|----------------|---------|---------|--------|
| | | | 15% | 10% | 5% | 2% |
| P1 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,020 | 0,024 | 0,034 | 0,055 |
| | | 0,080 | 0,00080 | 0,00095 | 0,0013 | 0,0022 |
| P2 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,020 | 0,024 | 0,034 | 0,055 |
| | | 0,080 | 0,00080 | 0,00095 | 0,0013 | 0,0022 |
| P3 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,020 | 0,024 | 0,032 | 0,050 |
| | | 0,080 | 0,00080 | 0,00095 | 0,0013 | 0,0020 |
| P4 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,019 | 0,022 | 0,032 | 0,050 |
| | | 0,080 | 0,00075 | 0,00085 | 0,0013 | 0,0020 |
| P5 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,019 | 0,022 | 0,030 | 0,048 |
| | | 0,080 | 0,00075 | 0,00085 | 0,0012 | 0,0019 |
| P6 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,019 | 0,022 | 0,030 | 0,048 |
| | | 0,080 | 0,00075 | 0,00085 | 0,0012 | 0,0019 |
| P7 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,019 | 0,022 | 0,030 | 0,048 |
| | | 0,080 | 0,00075 | 0,00085 | 0,0012 | 0,0019 |
| P8 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,020 | 0,024 | 0,032 | 0,050 |
| | | 0,080 | 0,00080 | 0,00095 | 0,0013 | 0,0020 |
| P11 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,019 | 0,022 | 0,030 | 0,048 |
| | | 0,080 | 0,00075 | 0,00085 | 0,0012 | 0,0019 |
| P12 | MM06-06006-B90PF-M01 F15M | 1,7 | 0,013 | 0,015 | 0,020 | 0,032 |
| | | 0,065 | 0,00050 | 0,00060 | 0,00080 | 0,0013 |
| M1 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,020 | 0,024 | 0,034 | 0,055 |
| | | 0,080 | 0,00080 | 0,00095 | 0,0013 | 0,0022 |
| M2 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,019 | 0,022 | 0,030 | 0,048 |
| | | 0,080 | 0,00075 | 0,00085 | 0,0012 | 0,0019 |
| M3 | MM06-06006-B90PF-M01 F15M | 1,7 | 0,015 | 0,018 | 0,025 | 0,038 |
| | | 0,065 | 0,00060 | 0,00070 | 0,0010 | 0,0015 |
| M4 | MM06-06006-B90PF-M01 F15M | 1,2 | 0,014 | 0,016 | 0,022 | 0,034 |
| | | 0,048 | 0,00055 | 0,00065 | 0,00085 | 0,0013 |
| M5 | MM06-06006-B90PF-M01 F15M | 1,2 | 0,014 | 0,016 | 0,022 | 0,034 |
| | | 0,048 | 0,00055 | 0,00065 | 0,00085 | 0,0013 |
| K1 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,020 | 0,024 | 0,034 | 0,055 |
| | | 0,080 | 0,00080 | 0,00095 | 0,0013 | 0,0022 |
| K2 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,019 | 0,022 | 0,030 | 0,048 |
| | | 0,080 | 0,00075 | 0,00085 | 0,0012 | 0,0019 |
| K3 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,019 | 0,022 | 0,030 | 0,048 |
| | | 0,080 | 0,00075 | 0,00085 | 0,0012 | 0,0019 |
| K4 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,019 | 0,022 | 0,030 | 0,048 |
| | | 0,080 | 0,00075 | 0,00085 | 0,0012 | 0,0019 |
| K5 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,017 | 0,020 | 0,028 | 0,044 |
| | | 0,080 | 0,00065 | 0,00080 | 0,0011 | 0,0017 |
| K6 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,019 | 0,022 | 0,030 | 0,048 |
| | | 0,080 | 0,00075 | 0,00085 | 0,0012 | 0,0019 |
| K7 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,017 | 0,020 | 0,028 | 0,044 |
| | | 0,080 | 0,00065 | 0,00080 | 0,0011 | 0,0017 |
| N1 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,026 | 0,032 | 0,044 | 0,070 |
| | | 0,080 | 0,0010 | 0,0013 | 0,0017 | 0,0028 |
| N2 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,026 | 0,032 | 0,044 | 0,070 |
| | | 0,080 | 0,0010 | 0,0013 | 0,0017 | 0,0028 |
| N3 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,026 | 0,032 | 0,044 | 0,070 |
| | | 0,080 | 0,0010 | 0,0013 | 0,0017 | 0,0028 |
| N11 | MM06-06006-B90PF-M01 F15M | 2,0 | 0,026 | 0,032 | 0,044 | 0,070 |
| | | 0,080 | 0,0010 | 0,0013 | 0,0017 | 0,0028 |
| S1 | MM06-06006-B90PF-M01 F15M | 1,2 | 0,014 | 0,016 | 0,022 | 0,034 |
| | | 0,048 | 0,00055 | 0,00065 | 0,00085 | 0,0013 |
| S2 | MM06-06006-B90PF-M01 F15M | 1,2 | 0,014 | 0,016 | 0,022 | 0,034 |
| | | 0,048 | 0,00055 | 0,00065 | 0,00085 | 0,0013 |
| S3 | MM06-06006-B90PF-M01 F15M | 1,2 | 0,013 | 0,014 | 0,020 | 0,032 |
| | | 0,048 | 0,00050 | 0,00060 | 0,00080 | 0,0013 |
| S11 | MM06-06006-B90PF-M01 F15M | 1,5 | 0,015 | 0,018 | 0,025 | 0,038 |
| | | 0,060 | 0,00060 | 0,00070 | 0,0010 | 0,0015 |
| S12 | MM06-06006-B90PF-M01 F15M | 1,5 | 0,015 | 0,018 | 0,025 | 0,038 |
| | | 0,060 | 0,00060 | 0,00070 | 0,0010 | 0,0015 |
| S13 | MM06-06006-B90PF-M01 F15M | 1,2 | 0,014 | 0,016 | 0,022 | 0,034 |
| | | 0,048 | 0,00055 | 0,00065 | 0,00085 | 0,0013 |
| H5 | MM06-06006-B90PF-M01 F15M | 1,7 | 0,013 | 0,015 | 0,020 | 0,032 |
| | | 0,065 | 0,00050 | 0,00060 | 0,00080 | 0,0013 |
| H8 | MM06-06006-B90PF-M01 F15M | 1,5 | 0,010 | 0,012 | 0,016 | 0,025 |
| | | 0,060 | 0,00040 | 0,00048 | 0,00065 | 0,0010 |
| H11 | MM06-06006-B90PF-M01 F15M | 1,7 | 0,013 | 0,015 | 0,020 | 0,032 |
| | | 0,065 | 0,00050 | 0,00060 | 0,00080 | 0,0013 |
| H12 | MM06-06006-B90PF-M01 F15M | 1,5 | 0,010 | 0,012 | 0,016 | 0,025 |
| | | 0,060 | 0,00040 | 0,00048 | 0,00065 | 0,0010 |
| H21 | MM06-06006-B90PF-M01 F15M | 1,5 | 0,010 | 0,012 | 0,016 | 0,025 |
| | | 0,060 | 0,00040 | 0,00048 | 0,00065 | 0,0010 |

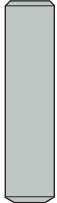
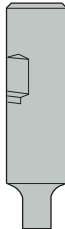
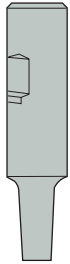


SMG = Seco Werkstoff-Gruppe
 f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
 Alle Schnittdaten sind Startwerte

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 Harter
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 Minimaster Plus
 Minimaster

MM06 Z2-Kopierfräser – Schnittdaten $v_c = (m/min)/(sf/min)$

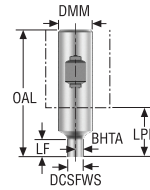
| SMG | F15M | | | | | F30M | | | | | T60M | | | | |
|-----|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|
| | 100% | 20% | 10% | 5% | 2% | 100% | 20% | 10% | 5% | 2% | 100% | 20% | 10% | 5% | 2% |
| P1 | 325 | 415 | 430 | 470 | 465 | 275 | 345 | 375 | 405 | 405 | 225 | 280 | 305 | 330 | 325 |
| | 1075 | 1350 | 1400 | 1550 | 1525 | 900 | 1125 | 1225 | 1325 | 1325 | 740 | 920 | 1000 | 1075 | 1075 |
| P2 | 320 | 400 | 420 | 455 | 455 | 265 | 335 | 365 | 395 | 395 | 215 | 270 | 295 | 320 | 320 |
| | 1050 | 1300 | 1375 | 1500 | 1500 | 870 | 1100 | 1200 | 1300 | 1300 | 710 | 890 | 970 | 1050 | 1050 |
| P3 | 275 | 345 | 360 | 395 | 395 | 230 | 290 | 315 | 340 | 340 | 190 | 235 | 255 | 275 | 275 |
| | 900 | 1125 | 1175 | 1300 | 1300 | 750 | 950 | 1025 | 1125 | 1125 | 620 | 770 | 840 | 900 | 900 |
| P4 | 240 | 305 | 320 | 345 | 345 | 205 | 255 | 280 | 305 | 300 | 165 | 205 | 225 | 245 | 245 |
| | 790 | 1000 | 1050 | 1125 | 1125 | 670 | 840 | 920 | 1000 | 980 | 540 | 670 | 740 | 800 | 800 |
| P5 | 230 | 290 | 305 | 330 | 330 | 195 | 245 | 265 | 290 | 290 | 160 | 200 | 215 | 235 | 235 |
| | 750 | 950 | 1000 | 1075 | 1075 | 640 | 800 | 870 | 950 | 950 | 520 | 660 | 710 | 770 | 770 |
| P6 | 260 | 330 | 345 | 370 | 370 | 220 | 275 | 300 | 325 | 325 | 180 | 225 | 245 | 265 | 260 |
| | 850 | 1075 | 1125 | 1225 | 1225 | 720 | 900 | 980 | 1075 | 1075 | 590 | 740 | 800 | 870 | 850 |
| P7 | 245 | 310 | 325 | 350 | 350 | 210 | 260 | 285 | 305 | 305 | 170 | 210 | 230 | 250 | 245 |
| | 800 | 1025 | 1075 | 1150 | 1150 | 690 | 850 | 940 | 1000 | 1000 | 560 | 690 | 750 | 820 | 800 |
| P8 | 230 | 290 | 305 | 330 | 330 | 195 | 245 | 265 | 285 | 290 | 160 | 200 | 215 | 230 | 235 |
| | 750 | 950 | 1000 | 1075 | 1075 | 640 | 800 | 870 | 940 | 950 | 520 | 660 | 710 | 750 | 770 |
| P11 | 240 | 300 | 315 | 340 | 340 | 200 | 255 | 275 | 300 | 295 | 165 | 205 | 220 | 240 | 240 |
| | 790 | 980 | 1025 | 1125 | 1125 | 660 | 840 | 900 | 980 | 970 | 540 | 670 | 720 | 790 | 790 |
| P12 | 145 | 185 | 190 | 205 | 205 | 130 | 160 | 170 | 180 | 180 | 105 | 130 | 135 | 145 | 145 |
| | 475 | 610 | 620 | 670 | 670 | 425 | 520 | 560 | 590 | 590 | 345 | 425 | 445 | 475 | 475 |
| M1 | 255 | 325 | 340 | 365 | 365 | 215 | 270 | 295 | 320 | 315 | 175 | 220 | 240 | 260 | 255 |
| | 840 | 1075 | 1125 | 1200 | 1200 | 710 | 890 | 970 | 1050 | 1025 | 570 | 720 | 790 | 850 | 840 |
| M2 | 210 | 265 | 275 | 300 | 300 | 175 | 220 | 240 | 260 | 260 | 145 | 180 | 195 | 210 | 210 |
| | 690 | 870 | 900 | 980 | 980 | 570 | 720 | 790 | 850 | 850 | 475 | 590 | 640 | 690 | 690 |
| M3 | 165 | 210 | 210 | 230 | 230 | 140 | 180 | 185 | 205 | 200 | 115 | 145 | 150 | 165 | 165 |
| | 540 | 690 | 710 | 750 | 750 | 460 | 590 | 620 | 670 | 660 | 375 | 475 | 510 | 540 | 540 |
| M4 | 125 | 160 | 160 | 170 | 170 | 110 | 140 | 140 | 155 | 155 | 90 | 115 | 115 | 125 | 125 |
| | 410 | 520 | 560 | 560 | 560 | 360 | 460 | 490 | 510 | 510 | 295 | 375 | 395 | 410 | 410 |
| M5 | 105 | 135 | 130 | 145 | 145 | 95 | 120 | 120 | 130 | 130 | 75 | 95 | 95 | 105 | 105 |
| | 345 | 445 | 475 | 475 | 475 | 310 | 395 | 410 | 425 | 425 | 245 | 310 | 330 | 345 | 345 |
| K1 | 250 | 320 | 335 | 360 | 360 | 210 | 265 | 290 | 315 | 310 | 170 | 215 | 235 | 255 | 250 |
| | 820 | 1050 | 1100 | 1175 | 1175 | 690 | 870 | 950 | 1025 | 1025 | 560 | 710 | 770 | 840 | 820 |
| K2 | 220 | 275 | 290 | 315 | 315 | 185 | 230 | 255 | 275 | 275 | 150 | 190 | 205 | 220 | 220 |
| | 720 | 900 | 950 | 1025 | 1025 | 610 | 750 | 840 | 900 | 900 | 490 | 620 | 670 | 720 | 720 |
| K3 | 185 | 235 | 245 | 265 | 265 | 160 | 195 | 215 | 230 | 230 | 130 | 160 | 175 | 190 | 185 |
| | 610 | 770 | 800 | 870 | 870 | 520 | 640 | 710 | 750 | 750 | 425 | 520 | 570 | 620 | 610 |
| K4 | 175 | 225 | 235 | 255 | 255 | 150 | 185 | 205 | 220 | 220 | 120 | 150 | 165 | 180 | 180 |
| | 570 | 740 | 770 | 840 | 840 | 490 | 610 | 670 | 720 | 720 | 395 | 490 | 540 | 590 | 590 |
| K5 | 105 | 135 | 140 | 150 | 150 | 90 | 115 | 125 | 135 | 135 | 75 | 90 | 100 | 110 | 105 |
| | 345 | 445 | 460 | 490 | 490 | 295 | 375 | 410 | 445 | 445 | 245 | 295 | 330 | 360 | 345 |
| K6 | 155 | 195 | 205 | 225 | 225 | 135 | 165 | 180 | 195 | 195 | 105 | 135 | 145 | 160 | 155 |
| | 510 | 640 | 670 | 740 | 740 | 445 | 540 | 590 | 640 | 640 | 345 | 445 | 475 | 520 | 510 |
| K7 | 135 | 170 | 180 | 195 | 195 | 115 | 145 | 155 | 170 | 170 | 95 | 115 | 125 | 140 | 140 |
| | 445 | 560 | 590 | 640 | 640 | 375 | 475 | 510 | 560 | 560 | 310 | 375 | 410 | 460 | 460 |
| N1 | 1975 | 2475 | 2600 | 2800 | 2800 | 1625 | 2050 | 2225 | 2400 | 2375 | 1325 | 1650 | 1800 | 1950 | 1925 |
| | 6475 | 8125 | 8525 | 9175 | 9175 | 5325 | 6725 | 7300 | 7875 | 7800 | 4350 | 5425 | 5900 | 6400 | 6325 |
| N2 | 790 | 1000 | 1050 | 1125 | 1125 | 660 | 820 | 900 | 970 | 960 | 530 | 670 | 730 | 790 | 780 |
| | 2600 | 3275 | 3450 | 3700 | 3700 | 2175 | 2700 | 2950 | 3175 | 3150 | 1750 | 2200 | 2400 | 2600 | 2550 |
| N3 | 530 | 670 | 700 | 760 | 750 | 440 | 550 | 600 | 650 | 640 | 355 | 445 | 485 | 520 | 520 |
| | 1750 | 2200 | 2300 | 2500 | 2450 | 1450 | 1800 | 1975 | 2125 | 2100 | 1175 | 1450 | 1600 | 1700 | 1700 |
| N11 | 600 | 760 | 800 | 860 | 860 | 500 | 630 | 680 | 740 | 730 | 405 | 510 | 550 | 600 | 590 |
| | 1975 | 2500 | 2625 | 2825 | 2825 | 1650 | 2075 | 2225 | 2425 | 2400 | 1325 | 1675 | 1800 | 1975 | 1925 |
| S1 | 60 | 75 | 75 | 80 | 80 | 50 | 65 | 65 | 70 | 70 | 42 | 55 | 55 | 60 | 60 |
| | 195 | 245 | 260 | 260 | 260 | 165 | 215 | 230 | 230 | 230 | 140 | 180 | 180 | 195 | 195 |
| S2 | 47 | 60 | 60 | 65 | 65 | 42 | 55 | 55 | 60 | 60 | 34 | 43 | 43 | 47 | 47 |
| | 155 | 195 | 215 | 215 | 215 | 140 | 180 | 180 | 195 | 195 | 110 | 140 | 150 | 155 | 155 |
| S3 | 41 | 50 | 50 | 55 | 55 | 36 | 46 | 46 | 50 | 50 | 29 | 37 | 38 | 40 | 40 |
| | 135 | 165 | 180 | 180 | 180 | 120 | 150 | 160 | 165 | 165 | 95 | 120 | 130 | 130 | 130 |
| S11 | 85 | 105 | 105 | 115 | 115 | 75 | 95 | 95 | 105 | 100 | 60 | 75 | 75 | 85 | 85 |
| | 280 | 345 | 360 | 375 | 375 | 245 | 310 | 310 | 345 | 330 | 195 | 245 | 260 | 280 | 280 |
| S12 | 55 | 75 | 75 | 80 | 80 | 50 | 65 | 65 | 70 | 70 | 41 | 55 | 55 | 55 | 55 |
| | 180 | 245 | 245 | 260 | 260 | 165 | 215 | 215 | 230 | 230 | 135 | 180 | 180 | 180 | 180 |
| S13 | 33 | 42 | 42 | 45 | 45 | 29 | 37 | 37 | 40 | 40 | 24 | 30 | 30 | 33 | 33 |
| | 110 | 140 | 150 | 150 | 150 | 95 | 120 | 130 | 130 | 130 | 80 | 100 | 105 | 110 | 110 |
| H5 | 48 | 60 | 60 | 65 | 65 | 42 | 55 | 55 | 60 | 60 | 34 | 43 | 45 | 49 | 49 |
| | 155 | 195 | 215 | 215 | 215 | 140 | 180 | 180 | 195 | 195 | 110 | 140 | 150 | 160 | 160 |
| H8 | 48 | 60 | 60 | 65 | 65 | 44 | 55 | 55 | 60 | 60 | 36 | 46 | 46 | 50 | 50 |
| | 155 | 195 | 215 | 215 | 215 | 145 | 180 | 195 | 195 | 195 | 120 | 150 | 155 | 165 | 165 |
| H11 | 60 | 80 | 80 | 85 | 85 | 55 | 70 | 70 | 75 | 75 | 44 | 55 | 55 | 60 | 60 |
| | 195 | 260 | 260 | 280 | 280 | 180 | 230 | 230 | 245 | 245 | 145 | 180 | 195 | 195 | 195 |
| H12 | 85 | 110 | 110 | 120 | 120 | 80 | 100 | 100 | 110 | 110 | 65 | 80 | 85 | 90 | 90 |
| | 280 | 360 | 375 | 395 | 395 | 260 | 330 | 345 | 360 | 360 | 215 | 260 | 280 | 295 | 295 |
| H21 | 48 | 60 | 60 | 65 | 65 | 44 | 55 | 55 | 60 | 60 | 36 | 46 | 46 | 50 | 50 |
| | 155 | 195 | 215 | 215 | 215 | 145 | 180 | 195 | 195 | 195 | 120 | 150 | 155 | 165 | 165 |


Schaftkonstruktion

| Ausführung 1, Keilnut-Schaft | Ausführung 2, Zylindrische/Weldon Schnittstelle und 90° Stirnseite |
|---|--|
|  |  |
| Ausführung 3, Zylindrische/Weldon Schnittstelle und 87°/89° Stirnseite | Konstruktion 4, Zylindrische/Weldon Schnittstelle und 80°/85°/87° Stirnseite |
|  |  |
| Ausführung 5, Zylindrische Schnittstelle und doppelt konische Stirnseite 89°/85° | |
|  | |

| |
|-------------------------------|
| Unversell |
| Stahl und Guss |
| Rostfrei und ISO-S-Werkstoffe |
| Rostfrei und ISO-S-Werkstoffe |
| NE-Metalle |
| Harter |
| Graphit |
| X-Heads |
| Minimaster Plus |
| Minimaster |




MM08 Schaft



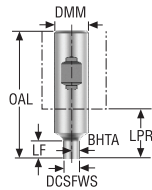
| Bezeichnung | Produkt- nummer | Aufnahme | DCSFWS | DMM | OAL | LF | LPR | BHTA° | Abb. |  | RPMX | Gewicht | Ersatzteil Bezeichnung |
|---------------------|--------------------|-------------|--------|------|-------|------|-------|-------|------|---|-------|---------|---------------------------|
| | | | | | | | | | | | | | |
| MM08-16070.3-0007 | 75034241 | Weldon | 7,6 | 16,0 | 70,0 | 7,6 | 22,0 | 0,0 | 2 | ✓ | 80000 | 0,1 | 1 |
| MM08-16075.3-3012 | 75034242 | Weldon | 7,6 | 16,0 | 75,0 | 12,0 | 27,0 | 3,0 | 3 | ✓ | 80000 | 0,1 | 1 |
| MM08-16120.3-5048M | 00042863 | Weldon | 7,6 | 16,0 | 120,0 | 48,0 | 72,0 | 5,0 | 4 | ✓ | 80000 | 0,2 | 5 |
| MM08-10040.0-0007 | 00083980 | Zylindrisch | 7,6 | 10,0 | 40,0 | 7,0 | 7,0 | 0,0 | 2 | ✓ | 80000 | 0,1 | 2 |
| MM08-12065.0-0000 | 75034240 | Zylindrisch | 7,6 | 12,0 | 65,0 | 0,0 | 20,0 | 60,0 | 1 | ✓ | 80000 | 0,1 | 1 |
| MM08-16150.0-1030M | 00094751 | Zylindrisch | 7,6 | 16,0 | 150,0 | 30,0 | 102,0 | 1,0 | 3 | ✓ | 80000 | 0,2 | 5 |
| MM08-16150.0-1050M | 00094752 | Zylindrisch | 7,6 | 16,0 | 150,0 | 50,0 | 102,0 | 1,0 | 3 | ✓ | 80000 | 0,2 | 4 |
| MM08-16150.0-1070M | 00094754 | Zylindrisch | 7,6 | 16,0 | 150,0 | 70,0 | 102,0 | 1,0 | 3 | ✓ | 80000 | 0,2 | 4 |
| MM08-10050.0-0007DS | 02580665 | Zylindrisch | 7,6 | 10,0 | 50,0 | 7,0 | 10,0 | 0,0 | 2 | ✓ | 80000 | 0,1 | 3 |
| MM08-10080.0-3023DS | 02580702 | Zylindrisch | 7,6 | 10,0 | 80,0 | 22,9 | 40,0 | 3,0 | 4 | ✓ | 80000 | 0,1 | 3 |
| MM08-12100.0-1035DS | 02580719 | Zylindrisch | 7,6 | 12,0 | 100,0 | 35,0 | 55,0 | 1,0 | 3 | ✓ | 80000 | 0,2 | 3 |
| MM08-12120.0-1050DS | 02580720 | Zylindrisch | 7,6 | 12,0 | 120,0 | 50,0 | 75,0 | 1,0 | 3 | ✓ | 80000 | 0,2 | 3 |
| MM08-16085.0-0016DS | 02580675 | Zylindrisch | 7,6 | 16,0 | 85,0 | 16,0 | 37,0 | 0,0 | 2 | ✓ | 80000 | 0,3 | 3 |
| MM08-16100.0-0032DS | 02580687 | Zylindrisch | 7,6 | 16,0 | 100,0 | 32,0 | 52,0 | 0,0 | 2 | ✓ | 80000 | 0,3 | 3 |
| MM08-16150.0-1050DS | 02580722 | Zylindrisch | 7,6 | 16,0 | 150,0 | 50,0 | 102,0 | 1,0 | 3 | ✓ | 80000 | 0,4 | 3 |
| MM08-16150.0-1070DS | 02580727 | Zylindrisch | 7,6 | 16,0 | 150,0 | 70,0 | 102,0 | 1,0 | 3 | ✓ | 80000 | 0,3 | 3 |

Ersatzteile, im Lieferumfang enthalten

Zubehör

| | Ersatzteile, im Lieferumfang enthalten | | Zubehör | |
|---|--|---|--|---|
| | Für Fräser | Hülse | Spannschraube | Schlüssel |
| | |  |  |  |
| 1 | | MM-05044 | MM08-0524 | H05-4 |
| 5 | | MM-05044 | MM08-0543 | H05-4 |
| 2 | | MM-05019 | MM08-0524 | H05-4 |
| 4 | | MM-05044 | MM08-0582 | H05-4 |
| 3 | | – | MM08-0524 | – |


MM08 Schaft – Zoll



| Bezeichnung | Produkt- nummer | Aufnahme | DCSFMS | DMM | OAL | LF | LPR | BHTA° | Abb. | RPMX | Gewicht | Ersatzteil Bezeichnung | |
|-------------------------|--------------------|-------------|--------|-------|-------|-------|-------|-------|------|------|---------|---------------------------|------|
| | | | | | | | | | | | | | Zoll |
| MM08-0.62-2.8-3-0003 | 75054600 | Weldon | 0.299 | 0.625 | 2.756 | 0.299 | 0.866 | 0,0 | 2 | ✓ | 80000 | 0.220 | 1 |
| MM08-0.62-3.0-3-3004 | 75054601 | Weldon | 0.299 | 0.625 | 2.953 | 0.472 | 1.063 | 3,0 | 3 | ✓ | 80000 | 0.220 | 1 |
| MM08-0.62-4.7-3-5018 | 75054602 | Weldon | 0.299 | 0.625 | 4.724 | 1.850 | 2.835 | 5,0 | 4 | ✓ | 80000 | 0.440 | 2 |
| MM08-0.38-1.6-0-0002 | 00096119 | Zylindrisch | 0.299 | 0.375 | 1.575 | 0.276 | 0.276 | 0,0 | 2 | ✓ | 80000 | 0.220 | 3 |
| MM08-0.50-2.6-0-0000 | 75054599 | Zylindrisch | 0.299 | 0.500 | 2.559 | 0 | 0.787 | 60,0 | 1 | ✓ | 80000 | 0.220 | 1 |
| MM08-0.62-5.9-0-1011 | 75054604 | Zylindrisch | 0.299 | 0.625 | 5.906 | 1.181 | 4.016 | 1,0 | 3 | ✓ | 80000 | 0.440 | 2 |
| MM08-0.62-3.3-0-0006DS | 02593402 | Zylindrisch | 0.299 | 0.625 | 3.346 | 0.630 | 1.457 | 0,0 | 2 | ✓ | 80000 | 0.660 | 4 |
| MM08-0.62-4.0-0-0012DS | 02593403 | Zylindrisch | 0.299 | 0.625 | 3.937 | 1.260 | 2.047 | 0,0 | 2 | ✓ | 80000 | 0.660 | 4 |
| MM08-0.62-5.9-0-1019DS | 02593407 | Zylindrisch | 0.299 | 0.625 | 5.906 | 1.969 | 4.016 | 1,0 | 3 | ✓ | 80000 | 0.880 | 4 |
| MM08-0.62-5.9-0-1027DS | 02593410 | Zylindrisch | 0.299 | 0.625 | 5.906 | 2.756 | 4.016 | 1,0 | 3 | ✓ | 80000 | 0.660 | 4 |
| MM08-0.75-10.0-0-1019DS | 02593413 | Zylindrisch | 0.299 | 0.750 | 9.843 | 1.969 | 7.874 | 1,0 | 5 | ✓ | 80000 | 1.980 | 4 |

Ersatzteile, im Lieferumfang enthalten

Zubehör

| Für Fräser | Hülse | Spannschraube | Schlüssel |
|------------|---|---|--|
| 1 |  MM-05044 |  MM08-0524 |  H05-4 |
| 2 | MM-05044 | MM08-0543 | H05-4 |
| 3 | MM-05019 | MM08-0524 | H05-4 |
| 4 | – | MM08-0524 | – |

Unversell

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Rostfrei und
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Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

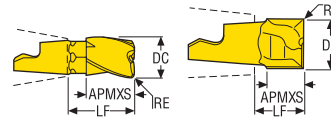
Graphit

X-Heads

Minimaster Plus

Minimaster

Nutfräsen/Eckfräsen



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | RE | LF | RMPX° | C min | C max | FHA | ZEPF | Schlüssel | Beschichtung | | | | |
|-----------------------|--------------|---------------|--------------|---------------|-------|-------|-------|-----|------|-----------|--------------|------|------|------|---|
| | | | | | | | | | | | Beschichtet | | | | |
| | | | | | | | | | | | T60M | F15M | F30M | F40M | |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | | | | | | | | |
| MM08-07805T-R02-D03 | 7,8 0.307 | 5,4 0.213 | 0,2 0.008 | 6,8 0.268 | 15,0 | 9,6 | 15,0 | 0 | 2 | MM0612 | ■ | | | | |
| MM08-07809-R02A30-M03 | 7,8 0.307 | 10,0 0.394 | 0,2 0.008 | 13,0 0.512 | 15,0 | 9,6 | 15,0 | 30 | 3 | MM0416 ✓ | | | | | ■ |
| MM08-08005-M03 | 8,0 0.315 | 5,5 0.217 | 0,0 - | 6,8 0.268 | 15,0 | 9,8 | 15,8 | 0 | 2 | MM0612 | ■ | | | | |
| MM08-08005-R04A8-E03 | 8,0 0.315 | 5,4 0.213 | 0,4 0.016 | 6,7 0.264 | 15,0 | 9,8 | 15,0 | 8 | 2 | MM0612 | ■ | | | ■ | |
| MM08-08005-R04-MD03 | 8,0 0.315 | 5,5 0.217 | 0,4 0.016 | 6,8 0.268 | 15,0 | 9,8 | 15,0 | 0 | 2 | MM0612 | ■ | | | ■ | |
| MM08-08005-R04P-M02 | 8,0 0.315 | 5,4 0.213 | 0,4 0.016 | 6,7 0.264 | 15,0 | 9,8 | 15,0 | 0 | 2 | MM0612 | | | | ■ | |
| MM08-08005-R10-MD03 | 8,0 0.315 | 5,4 0.213 | 1,0 0.039 | 6,8 0.268 | 15,0 | 9,8 | 13,8 | 0 | 2 | MM0612 | | | | ■ | |
| MM08-08009-A30-E03 | 8,0 0.315 | 10,0 0.394 | 0,0 - | 13,0 0.512 | 15,0 | 9,8 | 15,0 | 30 | 3 | MM0416 ✓ | | | | ■ | |
| MM08-08009-R05A30-M03 | 8,0 0.315 | 10,0 0.394 | 0,5 0.020 | 13,0 0.512 | 15,0 | 9,8 | 14,8 | 30 | 3 | MM0416 ✓ | | | | | ■ |
| MM08-08009-R10A30-D03 | 8,0 0.315 | 10,0 0.394 | 1,0 0.039 | 13,0 0.512 | 15,0 | 9,8 | 13,8 | 30 | 3 | MM0416 ✓ | | | | ■ | |
| MM08-08009-R10A30-E03 | 8,0 0.315 | 10,0 0.394 | 1,0 0.039 | 13,0 0.512 | 15,0 | 9,8 | 13,8 | 30 | 3 | MM0416 ✓ | | | | ■ | |
| MM08-08009-R10A30-M03 | 8,0 0.315 | 10,0 0.394 | 1,0 0.039 | 13,0 0.512 | 15,0 | 9,8 | 13,8 | 30 | 3 | MM0416 ✓ | | | | | ■ |
| MM08-08009-R20A30-M03 | 8,0 0.315 | 10,0 0.394 | 2,0 0.079 | 13,0 0.512 | 15,0 | 9,8 | 11,8 | 30 | 3 | MM0416 ✓ | | | | | ■ |
| MM08-08009-R30A30-M03 | 8,0 0.315 | 10,0 0.394 | 3,0 0.118 | 13,0 0.512 | 15,0 | 9,8 | 9,8 | 30 | 3 | MM0416 ✓ | | | | | ■ |

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Kunststoffe und Composite

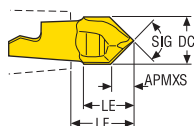
Graphit

X-Heads


Minimaster Plus

Minimaster

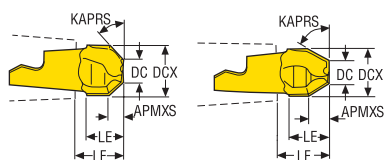
Zentrierbohren




• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | LE | LF | SIG° | ZEFP | Schlüssel  | Beschichtung | | | |
|---------------------|--------------|---------------|---------------|---------------|-------|------|---|--------------|------|------|------|
| | | | | | | | | T60M | F15M | F30M | F40M |
| MM08-08004-C90-M03 | 8,0 0.315 | 3,79 0.149 | 8,0 0.315 | 9,5 0.374 | 90,0 | 2 | MM0612 | ■ | | | |
| MM08-08006-C120-M03 | 8,0 0.315 | 2,15 0.085 | 8,32 0.328 | 9,46 0.372 | 120,0 | 2 | MM0612 | ■ | | | |

Anfasen



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DCX | DC | APMXS | LE | LF | KAPRS° | ZEFP | Schlüssel  | Beschichtung | | | |
|---------------------|--------------|---------------|--------------|---------------|---------------|--------|------|---|--------------|------|------|------|
| | | | | | | | | | T60M | F15M | F30M | F40M |
| MM08-08005-4520-E03 | 8,0 0.315 | 3,87 0.152 | 2,1 0.083 | 5,5 0.217 | 6,7 0.264 | 45,0 | 2 | MM0612 | ■ | | | |
| MM08-08006-6030-E03 | 8,0 0.315 | 4,19 0.165 | 3,3 0.130 | 6,45 0.254 | 7,66 0.302 | 60,0 | 2 | MM0612 | ■ | | | |

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

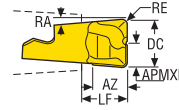
Graphit

X-Heads

Minimaster Plus

Minimaster

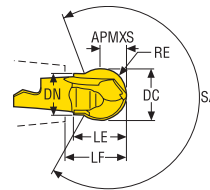
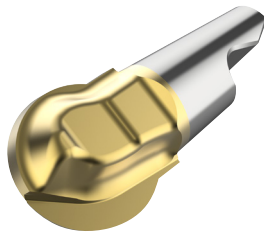
Tauchfräser



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXE | RE | AZ | LF | RA° | ZEFP | Schlüssel | Beschichtung | | | |
|------------------------|--------------|--------------|--------------|--------------|---------------|-----|------|-----------|--------------|------|------|------|
| | | | | | | | | | T60M | F15M | F30M | F40M |
| MM08-08005-R10-PL-MD03 | 8,0 0.315 | 4,0 0.157 | 1,0 0.039 | 5,7 0.224 | 6,78 0.267 | 5,0 | 2 | MM0612 | | | ■ | |

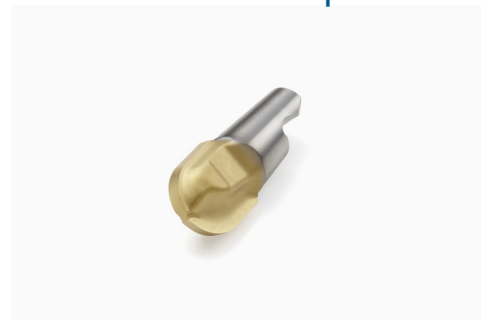
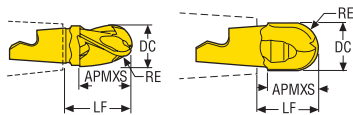
Präzisionswendeschneidplatten zum Vorschlichten in allen Werkstoffen



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | RE | LE | LF | DN | SA | ZEFP | Schlüssel | Beschichtung | | | |
|-----------------------|---------------|--------------|--------------|---------------|----------------|--------------|-------|------|-----------|--------------|------|------|------|
| | | | | | | | | | | T60M | F15M | F30M | F40M |
| MM08-10010-B120PF-M02 | 10,0 0.394 | 5,0 0.197 | 5,0 0.197 | 10,0 0.394 | 10,97 0.432 | 8,0 0.315 | 254,0 | 2 | MM0612 | | ■ | | |
| MM08-10010-B120P-M04 | 10,0 0.394 | 5,0 0.197 | 5,0 0.197 | 10,0 0.394 | 10,97 0.432 | 8,0 0.315 | 254,0 | 2 | MM0612 | | | ■ | |

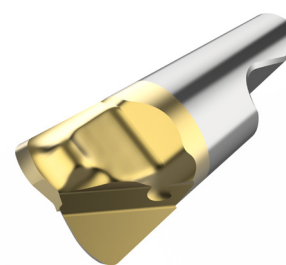
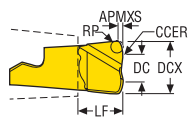
Kopierfräser



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | RE | LF | FHA | ZEFP | Schlüssel | Beschichtung | | | | | |
|-----------------------|--------------|---------------|--------------|---------------|------|------|-----------|--------------|------|------|------|---|--|
| | | | | | | | | Beschichtet | | | | | |
| | | | | | | | | T60M | F15M | F30M | F40M | | |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | | | | | | |
| MM08-08008-B90-MD03 | 8,0 0.315 | 8,1 0.319 | 4,0 0.157 | 9,42 0.371 | 0,0 | 2 | MM0612 | ■ | | ■ | | | |
| MM08-08008-B90PF-M01 | 8,0 0.315 | 6,9 0.272 | 4,0 0.157 | 9,39 0.370 | 0,0 | 2 | MM0612 | | ■ | | | | |
| MM08-08008-B90P-M03 | 8,0 0.315 | 6,9 0.272 | 4,0 0.157 | 9,39 0.370 | 0,0 | 2 | MM0612 | | | ■ | | | |
| MM08-08008-B90S-E03 | 8,0 0.315 | 8,1 0.319 | 4,0 0.157 | 9,42 0.371 | 0,0 | 2 | MM0612 | | | ■ | | | |
| MM08-08009-B90A30-E03 | 8,0 0.315 | 10,0 0.394 | 4,0 0.157 | 13,0 0.512 | 30,0 | 3 | MM0416 ✓ | | | ■ | | | |
| MM08-08009-B90A30-M03 | 8,0 0.315 | 10,0 0.394 | 4,0 0.157 | 13,0 0.512 | 30,0 | 3 | MM0416 ✓ | | | | | ■ | |

Hochvorschubfräser



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DCX | DC | APMXS | RP | CCER | LF | RMPX° | C min | C max | ZEFP | Schlüssel | Beschichtung | | | |
|--------------------|--------------|--------------|---------------|---------------|--------------|---------------|-------|-------|-------|------|-----------|--------------|------|------|------|
| | | | | | | | | | | | | Beschichtet | | | |
| | | | | | | | | | | | | T60M | F15M | F30M | F40M |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | | | | | | |
| MM08-08.40-HF-MD06 | 8,0 0.315 | 4,0 0.157 | 0,37 0.015 | 0,88 0.035 | 4,0 0.157 | 6,84 0.269 | 5,0 | 9,8 | 14,6 | 2 | MM0612 | | | ■ | |

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harder

Graphit

X-Heads

Minimaster Plus

Minimaster

MM08 - Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|----------------------------|----------------|----------------|--------|--------|--------|
| | | | 100% | 40% | 20% | 10% |
| P1 | MM08-08009-R05A30-M03 F40M | 1,8 | 0,044 | 0,044 | 0,055 | 0,070 |
| | | 0,070 | 0,0017 | 0,0017 | 0,0022 | 0,0028 |
| P2 | MM08-08009-R05A30-M03 F40M | 1,8 | 0,044 | 0,046 | 0,055 | 0,070 |
| | | 0,070 | 0,0017 | 0,0018 | 0,0022 | 0,0028 |
| P3 | MM08-08009-R05A30-M03 F40M | 1,8 | 0,042 | 0,042 | 0,050 | 0,070 |
| | | 0,070 | 0,0017 | 0,0017 | 0,0020 | 0,0028 |
| P4 | MM08-08009-R05A30-M03 F40M | 1,8 | 0,042 | 0,042 | 0,050 | 0,065 |
| | | 0,070 | 0,0017 | 0,0017 | 0,0020 | 0,0026 |
| P5 | MM08-08009-R05A30-M03 F40M | 1,8 | 0,040 | 0,042 | 0,050 | 0,065 |
| | | 0,070 | 0,0016 | 0,0017 | 0,0020 | 0,0026 |
| P6 | MM08-08009-R05A30-M03 F40M | 1,8 | 0,040 | 0,040 | 0,048 | 0,065 |
| | | 0,070 | 0,0016 | 0,0016 | 0,0019 | 0,0026 |
| P7 | MM08-08009-R05A30-M03 F40M | 1,8 | 0,040 | 0,040 | 0,048 | 0,065 |
| | | 0,070 | 0,0016 | 0,0016 | 0,0019 | 0,0026 |
| P8 | MM08-08009-R05A30-M03 F40M | 1,8 | 0,042 | 0,042 | 0,050 | 0,070 |
| | | 0,070 | 0,0017 | 0,0017 | 0,0020 | 0,0028 |
| P11 | MM08-08009-R05A30-M03 F40M | 1,8 | 0,040 | 0,040 | 0,048 | 0,065 |
| | | 0,070 | 0,0016 | 0,0016 | 0,0019 | 0,0026 |
| P12 | MM08-08009-R05A30-M03 F40M | 1,4 | 0,028 | 0,028 | 0,034 | 0,044 |
| | | 0,055 | 0,0011 | 0,0011 | 0,0013 | 0,0017 |
| M1 | MM08-08009-R05A30-M03 F40M | 1,8 | 0,044 | 0,046 | 0,055 | 0,070 |
| | | 0,070 | 0,0017 | 0,0018 | 0,0022 | 0,0028 |
| M2 | MM08-08009-R05A30-M03 F40M | 1,8 | 0,040 | 0,042 | 0,050 | 0,065 |
| | | 0,070 | 0,0016 | 0,0017 | 0,0020 | 0,0026 |
| M3 | MM08-08009-R05A30-M03 F40M | 1,4 | 0,034 | 0,034 | 0,040 | 0,055 |
| | | 0,055 | 0,0013 | 0,0013 | 0,0016 | 0,0022 |
| M4 | MM08-08009-R05A30-M03 F40M | 1,0 | 0,030 | 0,030 | 0,034 | 0,046 |
| | | 0,040 | 0,0012 | 0,0012 | 0,0013 | 0,0018 |
| M5 | MM08-08009-R05A30-M03 F40M | 1,0 | 0,030 | 0,030 | 0,034 | 0,046 |
| | | 0,040 | 0,0012 | 0,0012 | 0,0013 | 0,0018 |
| K1 | MM08-08009-R10A30-E03 F30M | 1,8 | 0,050 | 0,048 | 0,055 | 0,075 |
| | | 0,070 | 0,0020 | 0,0019 | 0,0022 | 0,0030 |
| K2 | MM08-08009-R10A30-E03 F30M | 1,8 | 0,044 | 0,044 | 0,050 | 0,065 |
| | | 0,070 | 0,0017 | 0,0017 | 0,0020 | 0,0026 |
| K3 | MM08-08009-R10A30-E03 F30M | 1,8 | 0,044 | 0,044 | 0,050 | 0,065 |
| | | 0,070 | 0,0017 | 0,0017 | 0,0020 | 0,0026 |
| K4 | MM08-08009-R10A30-E03 F30M | 1,8 | 0,044 | 0,044 | 0,050 | 0,065 |
| | | 0,070 | 0,0017 | 0,0017 | 0,0020 | 0,0026 |
| K5 | MM08-08009-R10A30-D03 F30M | 1,8 | 0,040 | 0,040 | 0,046 | 0,060 |
| | | 0,070 | 0,0016 | 0,0016 | 0,0018 | 0,0024 |
| K6 | MM08-08009-R10A30-D03 F30M | 1,8 | 0,044 | 0,044 | 0,050 | 0,065 |
| | | 0,070 | 0,0017 | 0,0017 | 0,0020 | 0,0026 |
| K7 | MM08-08009-R10A30-D03 F30M | 1,8 | 0,040 | 0,040 | 0,046 | 0,060 |
| | | 0,070 | 0,0016 | 0,0016 | 0,0018 | 0,0024 |
| N1 | MM08-08009-R10A30-E03 F30M | 1,8 | 0,060 | 0,060 | 0,070 | 0,095 |
| | | 0,070 | 0,0024 | 0,0024 | 0,0028 | 0,0038 |
| N2 | MM08-08009-R10A30-E03 F30M | 1,8 | 0,060 | 0,060 | 0,070 | 0,095 |
| | | 0,070 | 0,0024 | 0,0024 | 0,0028 | 0,0038 |
| N3 | MM08-08009-R10A30-E03 F30M | 1,8 | 0,060 | 0,060 | 0,070 | 0,095 |
| | | 0,070 | 0,0024 | 0,0024 | 0,0028 | 0,0038 |
| N11 | MM08-08009-R10A30-E03 F30M | 1,8 | 0,060 | 0,060 | 0,070 | 0,095 |
| | | 0,070 | 0,0024 | 0,0024 | 0,0028 | 0,0038 |
| S1 | MM08-08009-R10A30-D03 F30M | 1,0 | 0,038 | 0,036 | 0,036 | 0,046 |
| | | 0,040 | 0,0015 | 0,0014 | 0,0014 | 0,0019 |
| S2 | MM08-08009-R10A30-D03 F30M | 1,0 | 0,038 | 0,036 | 0,036 | 0,046 |
| | | 0,040 | 0,0015 | 0,0014 | 0,0014 | 0,0019 |
| S3 | MM08-08009-R10A30-D03 F30M | 1,0 | 0,036 | 0,034 | 0,034 | 0,042 |
| | | 0,040 | 0,0014 | 0,0013 | 0,0013 | 0,0017 |
| S11 | MM08-08009-R05A30-M03 F40M | 1,2 | 0,034 | 0,034 | 0,040 | 0,055 |
| | | 0,048 | 0,0013 | 0,0013 | 0,0016 | 0,0022 |
| S12 | MM08-08009-R05A30-M03 F40M | 1,2 | 0,034 | 0,034 | 0,040 | 0,055 |
| | | 0,048 | 0,0013 | 0,0013 | 0,0016 | 0,0022 |
| S13 | MM08-08009-R05A30-M03 F40M | 1,0 | 0,030 | 0,030 | 0,034 | 0,046 |
| | | 0,040 | 0,0012 | 0,0012 | 0,0013 | 0,0018 |
| H5 | MM08-08009-R10A30-E03 F30M | 1,4 | 0,032 | 0,032 | 0,034 | 0,044 |
| | | 0,055 | 0,0013 | 0,0013 | 0,0013 | 0,0018 |
| H8 | MM08-08009-R10A30-E03 F30M | 1,2 | 0,026 | 0,025 | 0,026 | 0,034 |
| | | 0,048 | 0,0010 | 0,0010 | 0,0010 | 0,0013 |
| H11 | MM08-08009-R10A30-E03 F30M | 1,4 | 0,032 | 0,032 | 0,034 | 0,044 |
| | | 0,055 | 0,0013 | 0,0013 | 0,0013 | 0,0018 |
| H12 | MM08-08009-R10A30-E03 F30M | 1,2 | 0,026 | 0,025 | 0,026 | 0,034 |
| | | 0,048 | 0,0010 | 0,0010 | 0,0010 | 0,0013 |
| H21 | MM08-08009-R10A30-E03 F30M | 1,2 | 0,026 | 0,025 | 0,026 | 0,034 |
| | | 0,048 | 0,0010 | 0,0010 | 0,0010 | 0,0013 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MM08 - Nut- und Eckfräsen – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | F30M | | | | F40M | | | | T60M | | | |
|-----|------|------|------|------|------|------|------|------|------|------|------|------|
| | 100% | 40% | 20% | 10% | 100% | 40% | 20% | 10% | 100% | 40% | 20% | 10% |
| P1 | 265 | 330 | 370 | 410 | 255 | 315 | 350 | 385 | 205 | 250 | 280 | 310 |
| | 870 | 1075 | 1225 | 1350 | 840 | 1025 | 1150 | 1275 | 670 | 820 | 920 | 1025 |
| P2 | 255 | 320 | 360 | 390 | 245 | 305 | 340 | 375 | 195 | 245 | 275 | 300 |
| | 840 | 1050 | 1175 | 1275 | 800 | 1000 | 1125 | 1225 | 640 | 800 | 900 | 980 |
| P3 | 225 | 280 | 315 | 340 | 215 | 265 | 295 | 325 | 170 | 210 | 240 | 260 |
| | 740 | 920 | 1025 | 1125 | 710 | 870 | 970 | 1075 | 560 | 690 | 790 | 850 |
| P4 | 195 | 245 | 275 | 300 | 190 | 235 | 260 | 290 | 150 | 185 | 210 | 230 |
| | 640 | 800 | 900 | 980 | 620 | 770 | 850 | 950 | 490 | 610 | 690 | 750 |
| P5 | 190 | 235 | 265 | 290 | 180 | 225 | 250 | 275 | 145 | 180 | 200 | 220 |
| | 620 | 770 | 870 | 950 | 590 | 740 | 820 | 900 | 475 | 590 | 660 | 720 |
| P6 | 215 | 265 | 295 | 325 | 205 | 255 | 280 | 310 | 160 | 200 | 225 | 250 |
| | 710 | 870 | 970 | 1075 | 670 | 840 | 920 | 1025 | 520 | 660 | 740 | 820 |
| P7 | 200 | 250 | 280 | 310 | 190 | 240 | 265 | 290 | 155 | 190 | 215 | 235 |
| | 660 | 820 | 920 | 1025 | 620 | 790 | 870 | 950 | 510 | 620 | 710 | 770 |
| P8 | 190 | 235 | 265 | 285 | 180 | 225 | 250 | 270 | 145 | 180 | 200 | 220 |
| | 620 | 770 | 870 | 940 | 590 | 740 | 820 | 890 | 475 | 590 | 660 | 720 |
| P11 | 195 | 245 | 270 | 300 | 185 | 230 | 260 | 285 | 150 | 185 | 210 | 230 |
| | 640 | 800 | 890 | 980 | 610 | 750 | 850 | 940 | 490 | 610 | 690 | 750 |
| P12 | 120 | 150 | 170 | 185 | 115 | 145 | 160 | 175 | 95 | 115 | 130 | 145 |
| | 395 | 490 | 560 | 610 | 375 | 475 | 520 | 570 | 310 | 375 | 425 | 475 |
| M1 | — | — | — | — | 200 | 245 | 275 | 305 | 160 | 195 | 220 | 240 |
| | — | — | — | — | 660 | 800 | 900 | 1000 | 520 | 640 | 720 | 790 |
| M2 | — | — | — | — | 165 | 200 | 225 | 250 | 130 | 160 | 180 | 200 |
| | — | — | — | — | 540 | 660 | 740 | 820 | 425 | 520 | 590 | 660 |
| M3 | — | — | — | — | 130 | 160 | 175 | 195 | 105 | 130 | 145 | 155 |
| | — | — | — | — | 425 | 520 | 570 | 640 | 345 | 425 | 475 | 510 |
| M4 | — | — | — | — | 100 | 120 | 135 | 150 | 80 | 100 | 110 | 120 |
| | — | — | — | — | 330 | 395 | 445 | 490 | 260 | 330 | 360 | 395 |
| M5 | — | — | — | — | 80 | 100 | 115 | 125 | 65 | 85 | 90 | 100 |
| | — | — | — | — | 260 | 330 | 375 | 410 | 215 | 280 | 295 | 330 |
| K1 | 205 | 255 | 285 | 310 | 195 | 240 | 270 | 300 | 155 | 195 | 215 | 235 |
| | 670 | 840 | 940 | 1025 | 640 | 790 | 890 | 980 | 510 | 640 | 710 | 770 |
| K2 | 180 | 225 | 250 | 275 | 170 | 210 | 235 | 260 | 135 | 170 | 190 | 210 |
| | 590 | 740 | 820 | 900 | 560 | 690 | 770 | 850 | 445 | 560 | 620 | 690 |
| K3 | 155 | 190 | 210 | 235 | 145 | 180 | 200 | 220 | 115 | 145 | 160 | 180 |
| | 510 | 620 | 690 | 770 | 475 | 590 | 660 | 720 | 375 | 475 | 520 | 590 |
| K4 | 145 | 180 | 200 | 225 | 140 | 170 | 190 | 210 | 110 | 140 | 155 | 170 |
| | 475 | 590 | 660 | 740 | 460 | 560 | 620 | 690 | 360 | 460 | 510 | 560 |
| K5 | 90 | 110 | 120 | 135 | 85 | 105 | 115 | 125 | 65 | 85 | 95 | 100 |
| | 295 | 360 | 395 | 445 | 280 | 345 | 375 | 410 | 215 | 280 | 310 | 330 |
| K6 | 130 | 160 | 180 | 195 | 120 | 150 | 170 | 185 | 95 | 120 | 135 | 150 |
| | 425 | 520 | 590 | 640 | 395 | 490 | 560 | 610 | 310 | 395 | 445 | 490 |
| K7 | 115 | 140 | 155 | 170 | 110 | 135 | 150 | 165 | 85 | 105 | 120 | 130 |
| | 375 | 460 | 510 | 560 | 360 | 445 | 490 | 540 | 280 | 345 | 395 | 425 |
| N1 | 1550 | 1950 | 2150 | 2350 | 1475 | 1850 | 2025 | 2250 | 1175 | 1475 | 1625 | 1800 |
| | 5075 | 6400 | 7050 | 7700 | 4850 | 6075 | 6650 | 7375 | 3850 | 4850 | 5325 | 5900 |
| N2 | 630 | 780 | 870 | 950 | 600 | 750 | 820 | 910 | 475 | 590 | 660 | 720 |
| | 2075 | 2550 | 2850 | 3125 | 1975 | 2450 | 2700 | 2975 | 1550 | 1925 | 2175 | 2350 |
| N3 | 420 | 520 | 580 | 630 | 400 | 495 | 550 | 610 | 315 | 395 | 440 | 485 |
| | 1375 | 1700 | 1900 | 2075 | 1300 | 1625 | 1800 | 2000 | 1025 | 1300 | 1450 | 1600 |
| N11 | 480 | 600 | 660 | 720 | 455 | 570 | 630 | 690 | 360 | 455 | 500 | 550 |
| | 1575 | 1975 | 2175 | 2350 | 1500 | 1875 | 2075 | 2275 | 1175 | 1500 | 1650 | 1800 |
| S1 | 48 | 60 | 65 | 75 | 46 | 55 | 65 | 70 | 37 | 46 | 50 | 55 |
| | 155 | 195 | 215 | 245 | 150 | 180 | 215 | 230 | 120 | 150 | 165 | 180 |
| S2 | 39 | 48 | 55 | 60 | 37 | 46 | 50 | 55 | 30 | 37 | 41 | 45 |
| | 130 | 155 | 180 | 195 | 120 | 150 | 165 | 180 | 100 | 120 | 135 | 150 |
| S3 | 34 | 42 | 47 | 50 | 32 | 40 | 45 | 49 | 26 | 32 | 36 | 39 |
| | 110 | 140 | 155 | 165 | 105 | 130 | 150 | 160 | 85 | 105 | 120 | 130 |
| S11 | — | — | — | — | 65 | 80 | 90 | 100 | 50 | 65 | 75 | 80 |
| | — | — | — | — | 215 | 260 | 295 | 330 | 165 | 215 | 245 | 260 |
| S12 | — | — | — | — | 45 | 55 | 60 | 70 | 36 | 45 | 50 | 55 |
| | — | — | — | — | 150 | 180 | 195 | 230 | 120 | 150 | 165 | 180 |
| S13 | — | — | — | — | 26 | 32 | 36 | 39 | 21 | 26 | 29 | 31 |
| | — | — | — | — | 85 | 105 | 120 | 130 | 70 | 85 | 95 | 100 |
| H5 | 41 | 50 | 55 | 60 | 39 | 48 | 55 | 60 | 31 | 39 | 43 | 47 |
| | 135 | 165 | 180 | 195 | 130 | 155 | 180 | 195 | 100 | 130 | 140 | 155 |
| H8 | 42 | 50 | 60 | 65 | 40 | 50 | 55 | 60 | 33 | 40 | 45 | 49 |
| | 140 | 165 | 195 | 215 | 130 | 165 | 180 | 195 | 110 | 130 | 150 | 160 |
| H11 | 50 | 65 | 70 | 80 | 49 | 60 | 70 | 75 | 39 | 49 | 55 | 60 |
| | 165 | 215 | 230 | 260 | 160 | 195 | 230 | 245 | 130 | 160 | 180 | 195 |
| H12 | 75 | 95 | 105 | 115 | 70 | 90 | 100 | 110 | 60 | 70 | 80 | 90 |
| | 245 | 310 | 345 | 375 | 230 | 295 | 330 | 360 | 195 | 230 | 260 | 295 |
| H21 | 42 | 50 | 60 | 65 | 40 | 50 | 55 | 60 | 33 | 40 | 45 | 49 |
| | 140 | 165 | 195 | 215 | 130 | 165 | 180 | 195 | 110 | 130 | 150 | 160 |

Unversell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MM08 Z3 – Kopierfräser – Auswahl der Wendschneidplatten – Schruppen – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|----------------------------|----------------|----------------|--------|--------|--------|
| | | | 100% | 40% | 20% | 10% |
| P1 | MM08-08009-B90A30-M03 F40M | 1,8 | 0,055 | 0,050 | 0,055 | 0,070 |
| | | 0,070 | 0,0022 | 0,0020 | 0,0022 | 0,0028 |
| P2 | MM08-08009-B90A30-M03 F40M | 1,8 | 0,055 | 0,050 | 0,055 | 0,070 |
| | | 0,070 | 0,0022 | 0,0020 | 0,0022 | 0,0028 |
| P3 | MM08-08009-B90A30-M03 F40M | 1,8 | 0,050 | 0,050 | 0,050 | 0,070 |
| | | 0,070 | 0,0020 | 0,0020 | 0,0020 | 0,0028 |
| P4 | MM08-08009-B90A30-M03 F40M | 1,8 | 0,050 | 0,048 | 0,050 | 0,065 |
| | | 0,070 | 0,0020 | 0,0019 | 0,0020 | 0,0026 |
| P5 | MM08-08009-B90A30-M03 F40M | 1,8 | 0,048 | 0,048 | 0,050 | 0,065 |
| | | 0,070 | 0,0019 | 0,0019 | 0,0020 | 0,0026 |
| P6 | MM08-08009-B90A30-M03 F40M | 1,8 | 0,048 | 0,048 | 0,050 | 0,065 |
| | | 0,070 | 0,0019 | 0,0019 | 0,0020 | 0,0026 |
| P7 | MM08-08009-B90A30-M03 F40M | 1,8 | 0,048 | 0,048 | 0,050 | 0,065 |
| | | 0,070 | 0,0019 | 0,0019 | 0,0020 | 0,0026 |
| P8 | MM08-08009-B90A30-M03 F40M | 1,8 | 0,050 | 0,050 | 0,050 | 0,070 |
| | | 0,070 | 0,0020 | 0,0020 | 0,0020 | 0,0028 |
| P11 | MM08-08009-B90A30-M03 F40M | 1,8 | 0,048 | 0,048 | 0,050 | 0,065 |
| | | 0,070 | 0,0019 | 0,0019 | 0,0020 | 0,0026 |
| P12 | MM08-08009-B90A30-M03 F40M | 1,4 | 0,034 | 0,034 | 0,034 | 0,044 |
| | | 0,055 | 0,0013 | 0,0013 | 0,0013 | 0,0017 |
| M1 | MM08-08009-B90A30-M03 F40M | 1,8 | 0,055 | 0,050 | 0,055 | 0,070 |
| | | 0,070 | 0,0022 | 0,0020 | 0,0022 | 0,0028 |
| M2 | MM08-08009-B90A30-M03 F40M | 1,8 | 0,048 | 0,048 | 0,050 | 0,065 |
| | | 0,070 | 0,0019 | 0,0019 | 0,0020 | 0,0026 |
| M3 | MM08-08009-B90A30-M03 F40M | 1,4 | 0,040 | 0,040 | 0,040 | 0,055 |
| | | 0,055 | 0,0016 | 0,0016 | 0,0016 | 0,0022 |
| M4 | MM08-08009-B90A30-M03 F40M | 1,0 | 0,038 | 0,036 | 0,036 | 0,046 |
| | | 0,040 | 0,0015 | 0,0014 | 0,0014 | 0,0019 |
| M5 | MM08-08009-B90A30-M03 F40M | 1,0 | 0,038 | 0,036 | 0,036 | 0,046 |
| | | 0,040 | 0,0015 | 0,0014 | 0,0014 | 0,0019 |
| K1 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,055 | 0,050 | 0,055 | 0,070 |
| | | 0,070 | 0,0022 | 0,0020 | 0,0022 | 0,0028 |
| K2 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,048 | 0,048 | 0,050 | 0,065 |
| | | 0,070 | 0,0019 | 0,0019 | 0,0020 | 0,0026 |
| K3 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,048 | 0,048 | 0,050 | 0,065 |
| | | 0,070 | 0,0019 | 0,0019 | 0,0020 | 0,0026 |
| K4 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,048 | 0,048 | 0,050 | 0,065 |
| | | 0,070 | 0,0019 | 0,0019 | 0,0020 | 0,0026 |
| K5 | MM08-08009-B90A30-M03 F40M | 1,8 | 0,044 | 0,042 | 0,046 | 0,060 |
| | | 0,070 | 0,0017 | 0,0017 | 0,0018 | 0,0024 |
| K6 | MM08-08009-B90A30-M03 F40M | 1,8 | 0,048 | 0,048 | 0,050 | 0,065 |
| | | 0,070 | 0,0019 | 0,0019 | 0,0020 | 0,0026 |
| K7 | MM08-08009-B90A30-M03 F40M | 1,8 | 0,044 | 0,042 | 0,046 | 0,060 |
| | | 0,070 | 0,0017 | 0,0017 | 0,0018 | 0,0024 |
| N1 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,070 | 0,065 | 0,070 | 0,090 |
| | | 0,070 | 0,0028 | 0,0026 | 0,0028 | 0,0036 |
| N2 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,070 | 0,065 | 0,070 | 0,090 |
| | | 0,070 | 0,0028 | 0,0026 | 0,0028 | 0,0036 |
| N3 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,070 | 0,065 | 0,070 | 0,090 |
| | | 0,070 | 0,0028 | 0,0026 | 0,0028 | 0,0036 |
| N11 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,070 | 0,065 | 0,070 | 0,090 |
| | | 0,070 | 0,0028 | 0,0026 | 0,0028 | 0,0036 |
| S1 | MM08-08009-B90A30-M03 F40M | 1,0 | 0,038 | 0,036 | 0,036 | 0,046 |
| | | 0,040 | 0,0015 | 0,0014 | 0,0014 | 0,0019 |
| S2 | MM08-08009-B90A30-M03 F40M | 1,0 | 0,038 | 0,036 | 0,036 | 0,046 |
| | | 0,040 | 0,0015 | 0,0014 | 0,0014 | 0,0019 |
| S3 | MM08-08009-B90A30-M03 F40M | 1,0 | 0,036 | 0,034 | 0,034 | 0,042 |
| | | 0,040 | 0,0014 | 0,0013 | 0,0013 | 0,0017 |
| S11 | MM08-08009-B90A30-M03 F40M | 1,2 | 0,042 | 0,040 | 0,042 | 0,055 |
| | | 0,048 | 0,0017 | 0,0016 | 0,0017 | 0,0022 |
| S12 | MM08-08009-B90A30-M03 F40M | 1,2 | 0,042 | 0,040 | 0,042 | 0,055 |
| | | 0,048 | 0,0017 | 0,0016 | 0,0017 | 0,0022 |
| S13 | MM08-08009-B90A30-M03 F40M | 1,0 | 0,038 | 0,036 | 0,036 | 0,046 |
| | | 0,040 | 0,0015 | 0,0014 | 0,0014 | 0,0019 |
| H5 | MM08-08009-B90A30-E03 F30M | 1,4 | 0,034 | 0,034 | 0,034 | 0,044 |
| | | 0,055 | 0,0013 | 0,0013 | 0,0013 | 0,0017 |
| H8 | MM08-08009-B90A30-E03 F30M | 1,2 | 0,028 | 0,026 | 0,026 | 0,034 |
| | | 0,048 | 0,0011 | 0,0010 | 0,0010 | 0,0013 |
| H11 | MM08-08009-B90A30-E03 F30M | 1,4 | 0,034 | 0,034 | 0,034 | 0,044 |
| | | 0,055 | 0,0013 | 0,0013 | 0,0013 | 0,0017 |
| H12 | MM08-08009-B90A30-E03 F30M | 1,2 | 0,028 | 0,026 | 0,026 | 0,034 |
| | | 0,048 | 0,0011 | 0,0010 | 0,0010 | 0,0013 |
| H21 | MM08-08009-B90A30-E03 F30M | 1,2 | 0,028 | 0,026 | 0,026 | 0,034 |
| | | 0,048 | 0,0011 | 0,0010 | 0,0010 | 0,0013 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MM08 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Schlichten – Metrisch/ Zoll

| SMG | | a_p | | f_z | | | |
|-----|----------------------------|-------|--------|--------|--------|--------|----|
| | | | | 15% | 10% | 5% | 2% |
| P1 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,060 | 0,070 | 0,10 | 0,16 | |
| | | 0,070 | 0,0024 | 0,0028 | 0,0040 | 0,0065 | |
| P2 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,060 | 0,070 | 0,10 | 0,17 | |
| | | 0,070 | 0,0024 | 0,0028 | 0,0040 | 0,0065 | |
| P3 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,060 | 0,070 | 0,095 | 0,16 | |
| | | 0,070 | 0,0024 | 0,0028 | 0,0038 | 0,0065 | |
| P4 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,055 | 0,065 | 0,095 | 0,15 | |
| | | 0,070 | 0,0022 | 0,0026 | 0,0038 | 0,0060 | |
| P5 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,055 | 0,065 | 0,090 | 0,15 | |
| | | 0,070 | 0,0022 | 0,0026 | 0,0036 | 0,0060 | |
| P6 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,055 | 0,065 | 0,090 | 0,15 | |
| | | 0,070 | 0,0022 | 0,0026 | 0,0036 | 0,0060 | |
| P7 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,055 | 0,065 | 0,090 | 0,15 | |
| | | 0,070 | 0,0022 | 0,0026 | 0,0036 | 0,0060 | |
| P8 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,060 | 0,070 | 0,095 | 0,16 | |
| | | 0,070 | 0,0024 | 0,0028 | 0,0038 | 0,0065 | |
| P11 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,055 | 0,065 | 0,090 | 0,15 | |
| | | 0,070 | 0,0022 | 0,0026 | 0,0036 | 0,0060 | |
| P12 | MM08-08009-B90A30-E03 F30M | 1,4 | 0,038 | 0,044 | 0,060 | 0,10 | |
| | | 0,055 | 0,0015 | 0,0017 | 0,0024 | 0,0040 | |
| M1 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,060 | 0,070 | 0,10 | 0,17 | |
| | | 0,070 | 0,0024 | 0,0028 | 0,0040 | 0,0065 | |
| M2 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,055 | 0,065 | 0,090 | 0,15 | |
| | | 0,070 | 0,0022 | 0,0026 | 0,0036 | 0,0060 | |
| M3 | MM08-08009-B90A30-E03 F30M | 1,4 | 0,046 | 0,055 | 0,075 | 0,12 | |
| | | 0,055 | 0,0018 | 0,0022 | 0,0030 | 0,0048 | |
| M4 | MM08-08009-B90A30-E03 F30M | 1,0 | 0,040 | 0,046 | 0,065 | 0,10 | |
| | | 0,040 | 0,0016 | 0,0019 | 0,0026 | 0,0040 | |
| M5 | MM08-08009-B90A30-E03 F30M | 1,0 | 0,040 | 0,046 | 0,065 | 0,10 | |
| | | 0,040 | 0,0016 | 0,0019 | 0,0026 | 0,0040 | |
| K1 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,060 | 0,070 | 0,10 | 0,17 | |
| | | 0,070 | 0,0024 | 0,0028 | 0,0040 | 0,0065 | |
| K2 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,055 | 0,065 | 0,090 | 0,15 | |
| | | 0,070 | 0,0022 | 0,0026 | 0,0036 | 0,0060 | |
| K3 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,055 | 0,065 | 0,090 | 0,15 | |
| | | 0,070 | 0,0022 | 0,0026 | 0,0036 | 0,0060 | |
| K4 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,055 | 0,065 | 0,090 | 0,15 | |
| | | 0,070 | 0,0022 | 0,0026 | 0,0036 | 0,0060 | |
| K5 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,050 | 0,060 | 0,080 | 0,13 | |
| | | 0,070 | 0,0020 | 0,0024 | 0,0032 | 0,0050 | |
| K6 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,055 | 0,065 | 0,090 | 0,15 | |
| | | 0,070 | 0,0022 | 0,0026 | 0,0036 | 0,0060 | |
| K7 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,050 | 0,060 | 0,080 | 0,13 | |
| | | 0,070 | 0,0020 | 0,0024 | 0,0032 | 0,0050 | |
| N1 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,080 | 0,090 | 0,13 | 0,22 | |
| | | 0,070 | 0,0032 | 0,0036 | 0,0050 | 0,0085 | |
| N2 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,080 | 0,090 | 0,13 | 0,22 | |
| | | 0,070 | 0,0032 | 0,0036 | 0,0050 | 0,0085 | |
| N3 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,080 | 0,090 | 0,13 | 0,22 | |
| | | 0,070 | 0,0032 | 0,0036 | 0,0050 | 0,0085 | |
| N11 | MM08-08009-B90A30-E03 F30M | 1,8 | 0,080 | 0,090 | 0,13 | 0,22 | |
| | | 0,070 | 0,0032 | 0,0036 | 0,0050 | 0,0085 | |
| S1 | MM08-08009-B90A30-E03 F30M | 1,0 | 0,040 | 0,046 | 0,065 | 0,10 | |
| | | 0,040 | 0,0016 | 0,0019 | 0,0026 | 0,0040 | |
| S2 | MM08-08009-B90A30-E03 F30M | 1,0 | 0,040 | 0,046 | 0,065 | 0,10 | |
| | | 0,040 | 0,0016 | 0,0019 | 0,0026 | 0,0040 | |
| S3 | MM08-08009-B90A30-E03 F30M | 1,0 | 0,038 | 0,042 | 0,060 | 0,095 | |
| | | 0,040 | 0,0015 | 0,0017 | 0,0024 | 0,0038 | |
| S11 | MM08-08009-B90A30-E03 F30M | 1,2 | 0,046 | 0,055 | 0,075 | 0,12 | |
| | | 0,048 | 0,0018 | 0,0022 | 0,0030 | 0,0048 | |
| S12 | MM08-08009-B90A30-E03 F30M | 1,2 | 0,046 | 0,055 | 0,075 | 0,12 | |
| | | 0,048 | 0,0018 | 0,0022 | 0,0030 | 0,0048 | |
| S13 | MM08-08009-B90A30-E03 F30M | 1,0 | 0,040 | 0,046 | 0,065 | 0,10 | |
| | | 0,040 | 0,0016 | 0,0019 | 0,0026 | 0,0040 | |
| H5 | MM08-08009-B90A30-E03 F30M | 1,4 | 0,038 | 0,044 | 0,060 | 0,10 | |
| | | 0,055 | 0,0015 | 0,0017 | 0,0024 | 0,0040 | |
| H8 | MM08-08009-B90A30-E03 F30M | 1,2 | 0,030 | 0,034 | 0,048 | 0,075 | |
| | | 0,048 | 0,0012 | 0,0013 | 0,0019 | 0,0030 | |
| H11 | MM08-08009-B90A30-E03 F30M | 1,4 | 0,038 | 0,044 | 0,060 | 0,10 | |
| | | 0,055 | 0,0015 | 0,0017 | 0,0024 | 0,0040 | |
| H12 | MM08-08009-B90A30-E03 F30M | 1,2 | 0,030 | 0,034 | 0,048 | 0,075 | |
| | | 0,048 | 0,0012 | 0,0013 | 0,0019 | 0,0030 | |
| H21 | MM08-08009-B90A30-E03 F30M | 1,2 | 0,030 | 0,034 | 0,048 | 0,075 | |
| | | 0,048 | 0,0012 | 0,0013 | 0,0019 | 0,0030 | |

SMG = Seco Werkstoff-Gruppe
 f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
 Alle Schnittdaten sind Startwerte

Unversell
 Stahl und Guss
 Restfrei und ISO-S-Werkstoffe
 Restfrei und ISO-S-Werkstoffe
 NE-Metalle
 Harter
 Graphit
 X-Heads
 Minimaster Plus
 Minimaster

MM08 Z3 – Kopierfräser – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | F30M | | | | | F40M | | | | |
|-----|------|------|------|------|------|------|------|------|------|------|
| | 100% | 20% | 10% | 5% | 2% | 100% | 20% | 10% | 5% | 2% |
| P1 | 280 | 330 | 355 | 380 | 380 | 265 | 315 | 335 | 360 | 360 |
| | 920 | 1075 | 1175 | 1250 | 1250 | 870 | 1025 | 1100 | 1175 | 1175 |
| P2 | 270 | 325 | 345 | 370 | 365 | 260 | 310 | 325 | 350 | 350 |
| | 890 | 1075 | 1125 | 1225 | 1200 | 850 | 1025 | 1075 | 1150 | 1150 |
| P3 | 235 | 280 | 295 | 320 | 320 | 225 | 270 | 280 | 305 | 300 |
| | 770 | 920 | 970 | 1050 | 1050 | 740 | 890 | 920 | 1000 | 980 |
| P4 | 210 | 250 | 265 | 280 | 280 | 200 | 235 | 250 | 270 | 270 |
| | 690 | 820 | 870 | 920 | 920 | 660 | 770 | 820 | 890 | 890 |
| P5 | 200 | 235 | 250 | 270 | 270 | 190 | 225 | 240 | 260 | 255 |
| | 660 | 770 | 820 | 890 | 890 | 620 | 740 | 790 | 850 | 840 |
| P6 | 225 | 265 | 280 | 305 | 305 | 215 | 255 | 270 | 290 | 290 |
| | 740 | 870 | 920 | 1000 | 1000 | 710 | 840 | 890 | 950 | 950 |
| P7 | 210 | 250 | 265 | 290 | 285 | 200 | 240 | 255 | 275 | 270 |
| | 690 | 820 | 870 | 950 | 940 | 660 | 790 | 840 | 900 | 890 |
| P8 | 200 | 235 | 250 | 270 | 265 | 190 | 225 | 235 | 255 | 255 |
| | 660 | 770 | 820 | 890 | 870 | 620 | 740 | 770 | 840 | 840 |
| P11 | 205 | 245 | 260 | 280 | 275 | 195 | 230 | 245 | 265 | 265 |
| | 670 | 800 | 850 | 920 | 900 | 640 | 750 | 800 | 870 | 870 |
| P12 | 130 | 155 | 160 | 175 | 175 | 125 | 150 | 155 | 165 | 165 |
| | 425 | 510 | 520 | 570 | 570 | 410 | 490 | 510 | 540 | 540 |
| M1 | 220 | 260 | 275 | 300 | 295 | 210 | 250 | 265 | 285 | 280 |
| | 720 | 850 | 900 | 980 | 970 | 690 | 820 | 870 | 940 | 920 |
| M2 | 180 | 215 | 225 | 245 | 245 | 170 | 205 | 215 | 235 | 230 |
| | 590 | 710 | 740 | 800 | 800 | 560 | 670 | 710 | 770 | 750 |
| M3 | 145 | 170 | 175 | 190 | 190 | 135 | 165 | 170 | 180 | 180 |
| | 475 | 560 | 570 | 620 | 620 | 445 | 540 | 560 | 590 | 590 |
| M4 | 100 | 135 | 135 | 145 | 145 | 95 | 130 | 130 | 140 | 140 |
| | 330 | 445 | 475 | 475 | 475 | 310 | 425 | 445 | 460 | 460 |
| M5 | 80 | 115 | 115 | 120 | 120 | 80 | 110 | 105 | 115 | 115 |
| | 260 | 375 | 395 | 395 | 395 | 260 | 360 | 375 | 375 | 375 |
| K1 | 215 | 255 | 270 | 295 | 290 | 205 | 245 | 260 | 280 | 275 |
| | 710 | 840 | 890 | 970 | 950 | 670 | 800 | 850 | 920 | 900 |
| K2 | 190 | 225 | 240 | 260 | 255 | 180 | 215 | 225 | 245 | 245 |
| | 620 | 740 | 790 | 850 | 840 | 590 | 710 | 740 | 800 | 800 |
| K3 | 160 | 190 | 200 | 220 | 215 | 155 | 180 | 190 | 210 | 205 |
| | 520 | 620 | 660 | 720 | 710 | 510 | 590 | 620 | 690 | 670 |
| K4 | 155 | 180 | 190 | 210 | 205 | 145 | 175 | 185 | 200 | 195 |
| | 510 | 590 | 620 | 690 | 670 | 475 | 570 | 610 | 660 | 640 |
| K5 | 90 | 110 | 115 | 125 | 125 | 90 | 105 | 110 | 120 | 120 |
| | 295 | 360 | 375 | 410 | 410 | 295 | 345 | 360 | 395 | 395 |
| K6 | 135 | 160 | 170 | 185 | 180 | 130 | 150 | 160 | 175 | 175 |
| | 445 | 520 | 560 | 610 | 590 | 425 | 490 | 520 | 570 | 570 |
| K7 | 120 | 140 | 150 | 160 | 160 | 110 | 135 | 140 | 155 | 155 |
| | 395 | 460 | 490 | 520 | 520 | 360 | 445 | 460 | 510 | 510 |
| N1 | 1625 | 1950 | 2075 | 2225 | 2200 | 1550 | 1850 | 1975 | 2125 | 2100 |
| | 5325 | 6400 | 6800 | 7300 | 7225 | 5075 | 6075 | 6475 | 6975 | 6900 |
| N2 | 660 | 790 | 830 | 900 | 890 | 630 | 750 | 790 | 850 | 840 |
| | 2175 | 2600 | 2725 | 2950 | 2925 | 2075 | 2450 | 2600 | 2800 | 2750 |
| N3 | 440 | 520 | 560 | 600 | 590 | 420 | 500 | 530 | 570 | 560 |
| | 1450 | 1700 | 1825 | 1975 | 1925 | 1375 | 1650 | 1750 | 1875 | 1825 |
| N11 | 500 | 600 | 640 | 680 | 670 | 480 | 570 | 610 | 650 | 640 |
| | 1650 | 1975 | 2100 | 2225 | 2200 | 1575 | 1875 | 2000 | 2125 | 2100 |
| S1 | 46 | 65 | 65 | 70 | 70 | 44 | 60 | 60 | 65 | 65 |
| | 150 | 215 | 215 | 230 | 230 | 145 | 195 | 215 | 215 | 215 |
| S2 | 37 | 50 | 50 | 55 | 55 | 35 | 49 | 48 | 50 | 50 |
| | 120 | 165 | 180 | 180 | 180 | 115 | 160 | 165 | 165 | 165 |
| S3 | 32 | 45 | 44 | 48 | 48 | 31 | 43 | 42 | 45 | 45 |
| | 105 | 150 | 155 | 155 | 155 | 100 | 140 | 150 | 150 | 150 |
| S11 | 70 | 90 | 90 | 95 | 95 | 65 | 85 | 85 | 90 | 90 |
| | 230 | 295 | 295 | 310 | 310 | 215 | 280 | 280 | 295 | 295 |
| S12 | 49 | 60 | 60 | 65 | 65 | 47 | 60 | 60 | 65 | 65 |
| | 160 | 195 | 215 | 215 | 215 | 155 | 195 | 195 | 215 | 215 |
| S13 | 26 | 36 | 35 | 38 | 38 | 25 | 34 | 34 | 36 | 37 |
| | 85 | 120 | 125 | 125 | 125 | 80 | 110 | 120 | 120 | 120 |
| H5 | 43 | 50 | 55 | 60 | 55 | 41 | 49 | 50 | 55 | 55 |
| | 140 | 165 | 180 | 195 | 180 | 135 | 160 | 165 | 180 | 180 |
| H8 | 43 | 55 | 55 | 60 | 60 | 41 | 50 | 50 | 55 | 55 |
| | 140 | 180 | 180 | 195 | 195 | 135 | 165 | 180 | 180 | 180 |
| H11 | 55 | 65 | 70 | 75 | 75 | 50 | 60 | 65 | 70 | 70 |
| | 180 | 215 | 230 | 245 | 245 | 165 | 195 | 215 | 230 | 230 |
| H12 | 75 | 95 | 100 | 105 | 105 | 75 | 95 | 95 | 100 | 100 |
| | 245 | 310 | 330 | 345 | 345 | 245 | 310 | 310 | 330 | 330 |
| H21 | 43 | 55 | 55 | 60 | 60 | 41 | 50 | 50 | 55 | 55 |
| | 140 | 180 | 180 | 195 | 195 | 135 | 165 | 180 | 180 | 180 |

MM08 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Schruppen – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|--------------------------|----------------|----------------|---------|--------|--------|
| | | | 100% | 40% | 20% | 10% |
| P1 | MM08-08008-B90S-E03 F30M | 3,0 | 0,048 | 0,046 | 0,055 | 0,070 |
| | | 0.12 | 0.0019 | 0.0018 | 0.0022 | 0.0028 |
| P2 | MM08-08008-B90S-E03 F30M | 3,0 | 0,048 | 0,048 | 0,055 | 0,075 |
| | | 0.12 | 0.0019 | 0.0019 | 0.0022 | 0.0030 |
| P3 | MM08-08008-B90S-E03 F30M | 3,0 | 0,046 | 0,044 | 0,050 | 0,070 |
| | | 0.12 | 0.0018 | 0.0017 | 0.0020 | 0.0028 |
| P4 | MM08-08008-B90-MD03 F30M | 3,0 | 0,044 | 0,044 | 0,050 | 0,070 |
| | | 0.12 | 0.0017 | 0.0017 | 0.0020 | 0.0028 |
| P5 | MM08-08008-B90-MD03 F30M | 3,0 | 0,044 | 0,042 | 0,050 | 0,065 |
| | | 0.12 | 0.0017 | 0.0017 | 0.0020 | 0.0026 |
| P6 | MM08-08008-B90-MD03 F30M | 3,0 | 0,044 | 0,042 | 0,050 | 0,065 |
| | | 0.12 | 0.0017 | 0.0017 | 0.0020 | 0.0026 |
| P7 | MM08-08008-B90-MD03 F30M | 3,0 | 0,044 | 0,042 | 0,050 | 0,065 |
| | | 0.12 | 0.0017 | 0.0017 | 0.0020 | 0.0026 |
| P8 | MM08-08008-B90-MD03 F30M | 3,0 | 0,046 | 0,044 | 0,050 | 0,070 |
| | | 0.12 | 0.0018 | 0.0017 | 0.0020 | 0.0028 |
| P11 | MM08-08008-B90-MD03 F30M | 3,0 | 0,044 | 0,042 | 0,050 | 0,065 |
| | | 0.12 | 0.0017 | 0.0017 | 0.0020 | 0.0026 |
| P12 | MM08-08008-B90-MD03 F30M | 2,5 | 0,030 | 0,030 | 0,034 | 0,044 |
| | | 0.10 | 0.0012 | 0.0012 | 0.0013 | 0.0018 |
| M1 | MM08-08008-B90S-E03 F30M | 3,0 | 0,048 | 0,048 | 0,055 | 0,075 |
| | | 0.12 | 0.0019 | 0.0019 | 0.0022 | 0.0030 |
| M2 | MM08-08008-B90S-E03 F30M | 3,0 | 0,044 | 0,042 | 0,050 | 0,065 |
| | | 0.12 | 0.0017 | 0.0017 | 0.0020 | 0.0026 |
| M3 | MM08-08008-B90S-E03 F30M | 2,5 | 0,036 | 0,036 | 0,040 | 0,055 |
| | | 0.10 | 0.0014 | 0.0014 | 0.0016 | 0.0022 |
| M4 | MM08-08008-B90-MD03 F30M | 1,9 | 0,034 | 0,034 | 0,036 | 0,046 |
| | | 0.075 | 0.0013 | 0.0013 | 0.0014 | 0.0019 |
| M5 | MM08-08008-B90-MD03 F30M | 1,9 | 0,034 | 0,034 | 0,036 | 0,046 |
| | | 0.075 | 0.0013 | 0.0013 | 0.0014 | 0.0019 |
| K1 | MM08-08008-B90S-E03 F30M | 3,0 | 0,048 | 0,048 | 0,055 | 0,075 |
| | | 0.12 | 0.0019 | 0.0019 | 0.0022 | 0.0030 |
| K2 | MM08-08008-B90S-E03 F30M | 3,0 | 0,044 | 0,042 | 0,050 | 0,065 |
| | | 0.12 | 0.0017 | 0.0017 | 0.0020 | 0.0026 |
| K3 | MM08-08008-B90S-E03 F30M | 3,0 | 0,044 | 0,042 | 0,050 | 0,065 |
| | | 0.12 | 0.0017 | 0.0017 | 0.0020 | 0.0026 |
| K4 | MM08-08008-B90S-E03 F30M | 3,0 | 0,044 | 0,042 | 0,050 | 0,065 |
| | | 0.12 | 0.0017 | 0.0017 | 0.0020 | 0.0026 |
| K5 | MM08-08008-B90-MD03 F30M | 3,0 | 0,040 | 0,038 | 0,046 | 0,060 |
| | | 0.12 | 0.0016 | 0.0015 | 0.0018 | 0.0024 |
| K6 | MM08-08008-B90-MD03 F30M | 3,0 | 0,044 | 0,042 | 0,050 | 0,065 |
| | | 0.12 | 0.0017 | 0.0017 | 0.0020 | 0.0026 |
| K7 | MM08-08008-B90-MD03 F30M | 3,0 | 0,040 | 0,038 | 0,046 | 0,060 |
| | | 0.12 | 0.0016 | 0.0015 | 0.0018 | 0.0024 |
| N1 | MM08-08008-B90S-E03 F30M | 3,0 | 0,060 | 0,060 | 0,070 | 0,095 |
| | | 0.12 | 0.0024 | 0.0024 | 0.0028 | 0.0038 |
| N2 | MM08-08008-B90S-E03 F30M | 3,0 | 0,060 | 0,060 | 0,070 | 0,095 |
| | | 0.12 | 0.0024 | 0.0024 | 0.0028 | 0.0038 |
| N3 | MM08-08008-B90S-E03 F30M | 3,0 | 0,060 | 0,060 | 0,070 | 0,095 |
| | | 0.12 | 0.0024 | 0.0024 | 0.0028 | 0.0038 |
| N11 | MM08-08008-B90S-E03 F30M | 3,0 | 0,060 | 0,060 | 0,070 | 0,095 |
| | | 0.12 | 0.0024 | 0.0024 | 0.0028 | 0.0038 |
| S1 | MM08-08008-B90-MD03 F30M | 1,9 | 0,034 | 0,034 | 0,036 | 0,046 |
| | | 0.075 | 0.0013 | 0.0013 | 0.0014 | 0.0019 |
| S2 | MM08-08008-B90-MD03 F30M | 1,9 | 0,034 | 0,034 | 0,036 | 0,046 |
| | | 0.075 | 0.0013 | 0.0013 | 0.0014 | 0.0019 |
| S3 | MM08-08008-B90-MD03 F30M | 1,9 | 0,032 | 0,030 | 0,034 | 0,042 |
| | | 0.075 | 0.0013 | 0.0012 | 0.0013 | 0.0017 |
| S11 | MM08-08008-B90-MD03 F30M | 2,5 | 0,036 | 0,036 | 0,042 | 0,055 |
| | | 0.10 | 0.0014 | 0.0014 | 0.0017 | 0.0022 |
| S12 | MM08-08008-B90-MD03 F30M | 2,5 | 0,036 | 0,036 | 0,042 | 0,055 |
| | | 0.10 | 0.0014 | 0.0014 | 0.0017 | 0.0022 |
| S13 | MM08-08008-B90-MD03 F30M | 1,9 | 0,034 | 0,034 | 0,036 | 0,046 |
| | | 0.075 | 0.0013 | 0.0013 | 0.0014 | 0.0019 |
| H5 | MM08-08008-B90-MD03 F30M | 2,5 | 0,030 | 0,030 | 0,034 | 0,044 |
| | | 0.10 | 0.0012 | 0.0012 | 0.0013 | 0.0018 |
| H8 | MM08-08008-B90-MD03 F30M | 2,5 | 0,024 | 0,024 | 0,026 | 0,034 |
| | | 0.10 | 0.00095 | 0.00095 | 0.0010 | 0.0013 |
| H11 | MM08-08008-B90-MD03 F30M | 2,5 | 0,030 | 0,030 | 0,034 | 0,044 |
| | | 0.10 | 0.0012 | 0.0012 | 0.0013 | 0.0018 |
| H12 | MM08-08008-B90-MD03 F30M | 2,5 | 0,024 | 0,024 | 0,026 | 0,034 |
| | | 0.10 | 0.00095 | 0.00095 | 0.0010 | 0.0013 |
| H21 | MM08-08008-B90-MD03 F30M | 2,5 | 0,024 | 0,024 | 0,026 | 0,034 |
| | | 0.10 | 0.00095 | 0.00095 | 0.0010 | 0.0013 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

Universell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MM08 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Schichten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|---------------------------|----------------|----------------|---------|---------|--------|
| | | | 15% | 10% | 5% | 2% |
| P1 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,020 | 0,024 | 0,032 | 0,050 |
| | | 0,12 | 0,00080 | 0,00095 | 0,0013 | 0,0020 |
| P2 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,020 | 0,024 | 0,034 | 0,055 |
| | | 0,12 | 0,00080 | 0,00095 | 0,0013 | 0,0022 |
| P3 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,019 | 0,022 | 0,032 | 0,050 |
| | | 0,12 | 0,00075 | 0,00085 | 0,0013 | 0,0020 |
| P4 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,019 | 0,022 | 0,030 | 0,048 |
| | | 0,12 | 0,00075 | 0,00085 | 0,0012 | 0,0019 |
| P5 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,019 | 0,022 | 0,030 | 0,048 |
| | | 0,12 | 0,00075 | 0,00085 | 0,0012 | 0,0019 |
| P6 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,018 | 0,022 | 0,030 | 0,048 |
| | | 0,12 | 0,00070 | 0,00085 | 0,0012 | 0,0019 |
| P7 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,018 | 0,022 | 0,030 | 0,048 |
| | | 0,12 | 0,00070 | 0,00085 | 0,0012 | 0,0019 |
| P8 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,019 | 0,022 | 0,032 | 0,050 |
| | | 0,12 | 0,00075 | 0,00085 | 0,0013 | 0,0020 |
| P11 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,018 | 0,022 | 0,030 | 0,048 |
| | | 0,12 | 0,00070 | 0,00085 | 0,0012 | 0,0019 |
| P12 | MM08-08008-B90PF-M01 F15M | 2,0 | 0,013 | 0,015 | 0,020 | 0,032 |
| | | 0,080 | 0,00050 | 0,00060 | 0,00080 | 0,0013 |
| M1 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,020 | 0,024 | 0,034 | 0,055 |
| | | 0,12 | 0,00080 | 0,00095 | 0,0013 | 0,0022 |
| M2 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,019 | 0,022 | 0,030 | 0,048 |
| | | 0,12 | 0,00075 | 0,00085 | 0,0012 | 0,0019 |
| M3 | MM08-08008-B90PF-M01 F15M | 2,0 | 0,015 | 0,018 | 0,024 | 0,038 |
| | | 0,080 | 0,00060 | 0,00070 | 0,00095 | 0,0015 |
| M4 | MM08-08008-B90PF-M01 F15M | 1,7 | 0,014 | 0,015 | 0,022 | 0,034 |
| | | 0,065 | 0,00055 | 0,00065 | 0,00085 | 0,0013 |
| M5 | MM08-08008-B90PF-M01 F15M | 1,7 | 0,014 | 0,015 | 0,022 | 0,034 |
| | | 0,065 | 0,00055 | 0,00065 | 0,00085 | 0,0013 |
| K1 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,020 | 0,024 | 0,034 | 0,055 |
| | | 0,12 | 0,00080 | 0,00095 | 0,0013 | 0,0022 |
| K2 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,019 | 0,022 | 0,030 | 0,048 |
| | | 0,12 | 0,00075 | 0,00085 | 0,0012 | 0,0019 |
| K3 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,019 | 0,022 | 0,030 | 0,048 |
| | | 0,12 | 0,00075 | 0,00085 | 0,0012 | 0,0019 |
| K4 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,019 | 0,022 | 0,030 | 0,048 |
| | | 0,12 | 0,00075 | 0,00085 | 0,0012 | 0,0019 |
| K5 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,017 | 0,020 | 0,028 | 0,044 |
| | | 0,12 | 0,00065 | 0,00080 | 0,0011 | 0,0017 |
| K6 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,019 | 0,022 | 0,030 | 0,048 |
| | | 0,12 | 0,00075 | 0,00085 | 0,0012 | 0,0019 |
| K7 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,017 | 0,020 | 0,028 | 0,044 |
| | | 0,12 | 0,00065 | 0,00080 | 0,0011 | 0,0017 |
| N1 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,026 | 0,030 | 0,042 | 0,070 |
| | | 0,12 | 0,0010 | 0,0012 | 0,0017 | 0,0028 |
| N2 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,026 | 0,030 | 0,042 | 0,070 |
| | | 0,12 | 0,0010 | 0,0012 | 0,0017 | 0,0028 |
| N3 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,026 | 0,030 | 0,042 | 0,070 |
| | | 0,12 | 0,0010 | 0,0012 | 0,0017 | 0,0028 |
| N11 | MM08-08008-B90PF-M01 F15M | 3,0 | 0,026 | 0,030 | 0,042 | 0,070 |
| | | 0,12 | 0,0010 | 0,0012 | 0,0017 | 0,0028 |
| S1 | MM08-08008-B90PF-M01 F15M | 1,7 | 0,014 | 0,015 | 0,022 | 0,034 |
| | | 0,065 | 0,00055 | 0,00065 | 0,00085 | 0,0013 |
| S2 | MM08-08008-B90PF-M01 F15M | 1,7 | 0,014 | 0,015 | 0,022 | 0,034 |
| | | 0,065 | 0,00055 | 0,00065 | 0,00085 | 0,0013 |
| S3 | MM08-08008-B90PF-M01 F15M | 1,7 | 0,013 | 0,014 | 0,020 | 0,030 |
| | | 0,065 | 0,00050 | 0,00060 | 0,00080 | 0,0012 |
| S11 | MM08-08008-B90PF-M01 F15M | 1,9 | 0,015 | 0,018 | 0,024 | 0,038 |
| | | 0,075 | 0,00060 | 0,00070 | 0,00095 | 0,0015 |
| S12 | MM08-08008-B90PF-M01 F15M | 1,9 | 0,015 | 0,018 | 0,024 | 0,038 |
| | | 0,075 | 0,00060 | 0,00070 | 0,00095 | 0,0015 |
| S13 | MM08-08008-B90PF-M01 F15M | 1,7 | 0,014 | 0,015 | 0,022 | 0,034 |
| | | 0,065 | 0,00055 | 0,00065 | 0,00085 | 0,0013 |
| H5 | MM08-08008-B90PF-M01 F15M | 2,0 | 0,013 | 0,015 | 0,020 | 0,032 |
| | | 0,080 | 0,00050 | 0,00060 | 0,00080 | 0,0013 |
| H8 | MM08-08008-B90PF-M01 F15M | 1,9 | 0,010 | 0,011 | 0,016 | 0,025 |
| | | 0,075 | 0,00040 | 0,00048 | 0,00065 | 0,0010 |
| H11 | MM08-08008-B90PF-M01 F15M | 2,0 | 0,013 | 0,015 | 0,020 | 0,032 |
| | | 0,080 | 0,00050 | 0,00060 | 0,00080 | 0,0013 |
| H12 | MM08-08008-B90PF-M01 F15M | 1,9 | 0,010 | 0,011 | 0,016 | 0,025 |
| | | 0,075 | 0,00040 | 0,00048 | 0,00065 | 0,0010 |
| H21 | MM08-08008-B90PF-M01 F15M | 1,9 | 0,010 | 0,011 | 0,016 | 0,025 |
| | | 0,075 | 0,00040 | 0,00048 | 0,00065 | 0,0010 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MM08 Z2 – Kopierfräser – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | F15M | | | | | F30M | | | | | T60M | | | | |
|-----|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|
| | 100% | 20% | 10% | 5% | 2% | 100% | 20% | 10% | 5% | 2% | 100% | 20% | 10% | 5% | 2% |
| P1 | 320 | 405 | 430 | 465 | 465 | 265 | 330 | 360 | 385 | 385 | 215 | 265 | 290 | 315 | 310 |
| | 1050 | 1325 | 1400 | 1525 | 1525 | 870 | 1075 | 1175 | 1275 | 1275 | 710 | 870 | 950 | 1025 | 1025 |
| P2 | 315 | 395 | 420 | 450 | 450 | 260 | 320 | 345 | 375 | 370 | 210 | 260 | 280 | 305 | 300 |
| | 1025 | 1300 | 1375 | 1475 | 1475 | 850 | 1050 | 1125 | 1225 | 1225 | 690 | 850 | 920 | 1000 | 980 |
| P3 | 270 | 340 | 360 | 390 | 390 | 225 | 280 | 300 | 325 | 325 | 180 | 225 | 245 | 265 | 260 |
| | 890 | 1125 | 1175 | 1275 | 1275 | 740 | 920 | 980 | 1075 | 1075 | 590 | 740 | 800 | 870 | 850 |
| P4 | 240 | 300 | 320 | 345 | 345 | 200 | 245 | 265 | 285 | 285 | 160 | 200 | 215 | 230 | 230 |
| | 790 | 980 | 1050 | 1125 | 1125 | 660 | 800 | 870 | 940 | 940 | 520 | 660 | 710 | 750 | 750 |
| P5 | 225 | 285 | 305 | 330 | 330 | 190 | 235 | 255 | 275 | 275 | 155 | 190 | 205 | 220 | 220 |
| | 740 | 940 | 1000 | 1075 | 1075 | 620 | 770 | 840 | 900 | 900 | 510 | 620 | 670 | 720 | 720 |
| P6 | 255 | 320 | 340 | 370 | 370 | 210 | 265 | 285 | 310 | 305 | 170 | 215 | 230 | 250 | 250 |
| | 840 | 1050 | 1125 | 1225 | 1225 | 690 | 870 | 940 | 1025 | 1000 | 560 | 710 | 750 | 820 | 820 |
| P7 | 240 | 300 | 320 | 350 | 350 | 200 | 250 | 270 | 295 | 290 | 160 | 200 | 220 | 235 | 235 |
| | 790 | 980 | 1050 | 1150 | 1150 | 660 | 820 | 890 | 970 | 950 | 520 | 660 | 720 | 770 | 770 |
| P8 | 225 | 285 | 305 | 330 | 330 | 190 | 235 | 250 | 275 | 270 | 150 | 190 | 205 | 220 | 220 |
| | 740 | 940 | 1000 | 1075 | 1075 | 620 | 770 | 820 | 900 | 890 | 490 | 620 | 670 | 720 | 720 |
| P11 | 235 | 295 | 315 | 340 | 340 | 195 | 240 | 260 | 285 | 280 | 160 | 195 | 210 | 230 | 230 |
| | 770 | 970 | 1025 | 1125 | 1125 | 640 | 790 | 850 | 940 | 920 | 520 | 640 | 690 | 750 | 750 |
| P12 | 145 | 185 | 185 | 200 | 200 | 125 | 155 | 165 | 175 | 175 | 100 | 125 | 130 | 145 | 140 |
| | 475 | 610 | 620 | 660 | 660 | 410 | 510 | 540 | 570 | 570 | 330 | 410 | 445 | 475 | 460 |
| M1 | 250 | 315 | 335 | 365 | 365 | 210 | 260 | 280 | 305 | 300 | 170 | 210 | 225 | 245 | 240 |
| | 820 | 1025 | 1100 | 1200 | 1200 | 690 | 850 | 920 | 1000 | 980 | 560 | 690 | 740 | 800 | 790 |
| M2 | 205 | 255 | 275 | 295 | 295 | 170 | 210 | 230 | 245 | 245 | 140 | 170 | 185 | 200 | 200 |
| | 670 | 840 | 900 | 970 | 970 | 560 | 690 | 750 | 800 | 800 | 460 | 560 | 610 | 660 | 660 |
| M3 | 165 | 205 | 210 | 225 | 225 | 135 | 175 | 180 | 195 | 195 | 110 | 140 | 145 | 155 | 155 |
| | 540 | 670 | 710 | 740 | 740 | 445 | 570 | 590 | 640 | 640 | 360 | 460 | 475 | 510 | 510 |
| M4 | 125 | 160 | 160 | 170 | 170 | 110 | 140 | 135 | 150 | 150 | 85 | 110 | 110 | 120 | 120 |
| | 410 | 520 | 560 | 560 | 560 | 360 | 460 | 475 | 490 | 490 | 280 | 360 | 375 | 395 | 395 |
| M5 | 105 | 135 | 130 | 140 | 140 | 90 | 115 | 115 | 125 | 125 | 75 | 95 | 90 | 100 | 100 |
| | 345 | 445 | 460 | 460 | 460 | 295 | 375 | 395 | 410 | 410 | 245 | 310 | 330 | 330 | 330 |
| K1 | 250 | 310 | 330 | 360 | 355 | 205 | 255 | 275 | 300 | 295 | 165 | 205 | 220 | 240 | 240 |
| | 820 | 1025 | 1075 | 1175 | 1175 | 670 | 840 | 900 | 980 | 970 | 540 | 670 | 720 | 790 | 790 |
| K2 | 215 | 270 | 290 | 310 | 310 | 180 | 225 | 240 | 260 | 260 | 145 | 180 | 195 | 210 | 210 |
| | 710 | 890 | 950 | 1025 | 1025 | 590 | 740 | 790 | 850 | 850 | 475 | 590 | 640 | 690 | 690 |
| K3 | 180 | 230 | 245 | 265 | 265 | 150 | 190 | 205 | 220 | 220 | 125 | 155 | 165 | 180 | 180 |
| | 590 | 750 | 800 | 870 | 870 | 490 | 620 | 670 | 720 | 720 | 410 | 510 | 540 | 590 | 590 |
| K4 | 175 | 220 | 235 | 250 | 250 | 145 | 180 | 195 | 210 | 210 | 115 | 145 | 160 | 170 | 170 |
| | 570 | 720 | 770 | 820 | 820 | 475 | 590 | 640 | 690 | 690 | 375 | 475 | 520 | 560 | 560 |
| K5 | 105 | 130 | 140 | 150 | 150 | 90 | 110 | 120 | 125 | 125 | 70 | 90 | 95 | 105 | 105 |
| | 345 | 425 | 460 | 490 | 490 | 295 | 360 | 395 | 410 | 410 | 230 | 295 | 310 | 345 | 345 |
| K6 | 155 | 190 | 205 | 220 | 220 | 130 | 160 | 170 | 185 | 185 | 105 | 130 | 140 | 150 | 150 |
| | 510 | 620 | 670 | 720 | 720 | 425 | 520 | 560 | 610 | 610 | 345 | 425 | 460 | 490 | 490 |
| K7 | 135 | 165 | 180 | 195 | 195 | 110 | 140 | 150 | 165 | 165 | 90 | 110 | 120 | 130 | 130 |
| | 445 | 540 | 590 | 640 | 640 | 360 | 460 | 490 | 540 | 540 | 295 | 360 | 395 | 425 | 425 |
| N1 | 1925 | 2425 | 2575 | 2800 | 2775 | 1550 | 1925 | 2075 | 2250 | 2225 | 1250 | 1550 | 1675 | 1825 | 1800 |
| | 6325 | 7950 | 8450 | 9175 | 9100 | 5075 | 6325 | 6800 | 7375 | 7300 | 4100 | 5075 | 5500 | 6000 | 5900 |
| N2 | 780 | 980 | 1050 | 1125 | 1125 | 630 | 780 | 840 | 910 | 900 | 510 | 630 | 680 | 740 | 730 |
| | 2550 | 3225 | 3450 | 3700 | 3700 | 2075 | 2550 | 2750 | 2975 | 2950 | 1675 | 2075 | 2225 | 2425 | 2400 |
| N3 | 520 | 650 | 700 | 750 | 750 | 420 | 520 | 560 | 610 | 600 | 340 | 420 | 455 | 490 | 485 |
| | 1700 | 2125 | 2300 | 2450 | 2450 | 1375 | 1700 | 1825 | 2000 | 1975 | 1125 | 1375 | 1500 | 1600 | 1600 |
| N11 | 590 | 740 | 800 | 860 | 860 | 480 | 590 | 640 | 700 | 690 | 390 | 480 | 520 | 560 | 560 |
| | 1925 | 2425 | 2625 | 2825 | 2825 | 1575 | 1925 | 2100 | 2300 | 2275 | 1275 | 1575 | 1700 | 1825 | 1825 |
| S1 | 60 | 75 | 75 | 80 | 80 | 50 | 65 | 65 | 70 | 70 | 41 | 50 | 50 | 55 | 55 |
| | 195 | 245 | 260 | 260 | 260 | 165 | 215 | 230 | 230 | 230 | 135 | 165 | 180 | 180 | 180 |
| S2 | 47 | 60 | 60 | 65 | 65 | 40 | 50 | 50 | 55 | 55 | 33 | 42 | 42 | 45 | 45 |
| | 155 | 195 | 215 | 215 | 215 | 130 | 165 | 180 | 180 | 180 | 110 | 140 | 145 | 150 | 150 |
| S3 | 40 | 50 | 50 | 55 | 55 | 35 | 45 | 45 | 48 | 48 | 28 | 36 | 36 | 39 | 39 |
| | 130 | 165 | 180 | 180 | 180 | 115 | 150 | 155 | 155 | 155 | 90 | 120 | 125 | 130 | 130 |
| S11 | 85 | 105 | 105 | 115 | 115 | 70 | 90 | 90 | 100 | 100 | 55 | 75 | 75 | 80 | 80 |
| | 280 | 345 | 360 | 375 | 375 | 230 | 295 | 310 | 330 | 330 | 180 | 245 | 245 | 260 | 260 |
| S12 | 60 | 75 | 75 | 80 | 80 | 48 | 60 | 65 | 70 | 70 | 39 | 50 | 50 | 55 | 55 |
| | 195 | 245 | 245 | 260 | 260 | 155 | 195 | 215 | 230 | 230 | 130 | 165 | 180 | 180 | 180 |
| S13 | 33 | 42 | 42 | 45 | 45 | 28 | 36 | 36 | 39 | 39 | 23 | 29 | 29 | 31 | 32 |
| | 110 | 140 | 150 | 150 | 150 | 90 | 120 | 125 | 130 | 130 | 75 | 95 | 100 | 100 | 105 |
| H5 | 48 | 60 | 60 | 65 | 65 | 41 | 50 | 55 | 60 | 60 | 33 | 42 | 44 | 47 | 47 |
| | 155 | 195 | 215 | 215 | 215 | 135 | 165 | 180 | 195 | 195 | 110 | 140 | 145 | 155 | 155 |
| H8 | 49 | 60 | 60 | 65 | 65 | 42 | 55 | 55 | 60 | 60 | 34 | 44 | 45 | 48 | 48 |
| | 160 | 195 | 215 | 215 | 215 | 140 | 180 | 180 | 195 | 195 | 110 | 145 | 150 | 155 | 155 |
| H11 | 60 | 80 | 80 | 85 | 85 | 55 | 65 | 70 | 75 | 75 | 43 | 55 | 55 | 60 | 60 |
| | 195 | 260 | 260 | 280 | 280 | 180 | 215 | 230 | 245 | 245 | 140 | 180 | 180 | 195 | 195 |
| H12 | 85 | 110 | 110 | 120 | 120 | 75 | 100 | 100 | 105 | 105 | 60 | 80 | 80 | 85 | 85 |
| | 280 | 360 | 375 | 395 | 395 | 245 | 330 | 345 | 345 | 345 | 195 | 260 | 280 | 280 | 280 |
| H21 | 49 | 60 | 60 | 65 | 65 | 42 | 55 | 55 | 60 | 60 | 34 | 44 | 45 | 48 | 48 |
| | 160 | 195 | 215 | 215 | 215 | 140 | 180 | 180 | 195 | 195 | 110 | 145 | 150 | 155 | 155 |

Unversell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MM08 Hohe Vorschübe – Auswahl der Wendeschneidplatten – Metrisch/ Zoll


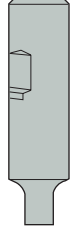
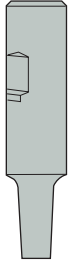


| SMG | | a _p | f _z | | | |
|-----|-------------------------|----------------|----------------|--------|--------|--------|
| | | | 100% | 70% | 30% | 20% |
| P1 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,32 | 0,32 | 0,42 | 0,50 |
| | | 0,010 | 0,013 | 0,013 | 0,017 | 0,020 |
| P2 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,32 | 0,32 | 0,42 | 0,50 |
| | | 0,010 | 0,013 | 0,013 | 0,017 | 0,020 |
| P3 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,30 | 0,30 | 0,40 | 0,48 |
| | | 0,010 | 0,012 | 0,012 | 0,016 | 0,019 |
| P4 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,30 | 0,30 | 0,38 | 0,48 |
| | | 0,010 | 0,012 | 0,012 | 0,015 | 0,019 |
| P5 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,28 | 0,30 | 0,38 | 0,46 |
| | | 0,010 | 0,011 | 0,012 | 0,015 | 0,018 |
| P6 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,28 | 0,28 | 0,38 | 0,46 |
| | | 0,010 | 0,011 | 0,011 | 0,015 | 0,018 |
| P7 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,28 | 0,28 | 0,38 | 0,46 |
| | | 0,010 | 0,011 | 0,011 | 0,015 | 0,018 |
| P8 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,30 | 0,30 | 0,40 | 0,48 |
| | | 0,010 | 0,012 | 0,012 | 0,016 | 0,019 |
| P11 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,28 | 0,28 | 0,38 | 0,46 |
| | | 0,010 | 0,011 | 0,011 | 0,015 | 0,018 |
| P12 | MM08-08.40-HF-MD06 F30M | 0,20 | 0,20 | 0,20 | 0,25 | 0,30 |
| | | 0,0080 | 0,0080 | 0,0080 | 0,010 | 0,012 |
| M1 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,32 | 0,32 | 0,42 | 0,50 |
| | | 0,010 | 0,013 | 0,013 | 0,017 | 0,020 |
| M2 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,28 | 0,30 | 0,38 | 0,46 |
| | | 0,010 | 0,011 | 0,012 | 0,015 | 0,018 |
| M3 | MM08-08.40-HF-MD06 F30M | 0,20 | 0,24 | 0,30 | 0,30 | 0,36 |
| | | 0,0080 | 0,0095 | 0,0095 | 0,012 | 0,014 |
| M4 | MM08-08.40-HF-MD06 F30M | 0,16 | 0,20 | 0,20 | 0,26 | 0,32 |
| | | 0,0065 | 0,0080 | 0,0080 | 0,010 | 0,013 |
| M5 | MM08-08.40-HF-MD06 F30M | 0,16 | 0,20 | 0,20 | 0,26 | 0,32 |
| | | 0,0065 | 0,0080 | 0,0080 | 0,010 | 0,013 |
| K1 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,32 | 0,32 | 0,42 | 0,50 |
| | | 0,010 | 0,013 | 0,013 | 0,017 | 0,020 |
| K2 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,28 | 0,30 | 0,38 | 0,46 |
| | | 0,010 | 0,011 | 0,012 | 0,015 | 0,018 |
| K3 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,28 | 0,30 | 0,38 | 0,46 |
| | | 0,010 | 0,011 | 0,012 | 0,015 | 0,018 |
| K4 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,28 | 0,30 | 0,38 | 0,46 |
| | | 0,010 | 0,011 | 0,012 | 0,015 | 0,018 |
| K5 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,26 | 0,26 | 0,34 | 0,42 |
| | | 0,010 | 0,010 | 0,010 | 0,013 | 0,017 |
| K6 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,28 | 0,30 | 0,38 | 0,46 |
| | | 0,010 | 0,011 | 0,012 | 0,015 | 0,018 |
| K7 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,26 | 0,26 | 0,34 | 0,42 |
| | | 0,010 | 0,010 | 0,010 | 0,013 | 0,017 |
| N1 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,40 | 0,40 | 0,55 | 0,70 |
| | | 0,010 | 0,016 | 0,016 | 0,022 | 0,028 |
| N2 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,40 | 0,40 | 0,55 | 0,70 |
| | | 0,010 | 0,016 | 0,016 | 0,022 | 0,028 |
| N3 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,40 | 0,40 | 0,55 | 0,70 |
| | | 0,010 | 0,016 | 0,016 | 0,022 | 0,028 |
| N11 | MM08-08.40-HF-MD06 F30M | 0,26 | 0,40 | 0,40 | 0,55 | 0,70 |
| | | 0,010 | 0,016 | 0,016 | 0,022 | 0,028 |
| S1 | MM08-08.40-HF-MD06 F30M | 0,16 | 0,20 | 0,20 | 0,26 | 0,32 |
| | | 0,0065 | 0,0080 | 0,0080 | 0,010 | 0,013 |
| S2 | MM08-08.40-HF-MD06 F30M | 0,16 | 0,20 | 0,20 | 0,26 | 0,32 |
| | | 0,0065 | 0,0080 | 0,0080 | 0,010 | 0,013 |
| S3 | MM08-08.40-HF-MD06 F30M | 0,16 | 0,19 | 0,19 | 0,24 | 0,30 |
| | | 0,0065 | 0,0075 | 0,0075 | 0,0095 | 0,012 |
| S11 | MM08-08.40-HF-MD06 F30M | 0,18 | 0,24 | 0,24 | 0,30 | 0,36 |
| | | 0,0070 | 0,0095 | 0,0095 | 0,012 | 0,014 |
| S12 | MM08-08.40-HF-MD06 F30M | 0,18 | 0,24 | 0,24 | 0,30 | 0,36 |
| | | 0,0070 | 0,0095 | 0,0095 | 0,012 | 0,014 |
| S13 | MM08-08.40-HF-MD06 F30M | 0,16 | 0,20 | 0,20 | 0,26 | 0,32 |
| | | 0,0065 | 0,0080 | 0,0080 | 0,010 | 0,013 |
| H5 | MM08-08.40-HF-MD06 F30M | 0,20 | 0,20 | 0,20 | 0,25 | 0,30 |
| | | 0,0080 | 0,0080 | 0,0080 | 0,010 | 0,012 |
| H8 | MM08-08.40-HF-MD06 F30M | 0,18 | 0,16 | 0,15 | 0,19 | 0,24 |
| | | 0,0070 | 0,0065 | 0,0060 | 0,0075 | 0,0095 |
| H11 | MM08-08.40-HF-MD06 F30M | 0,20 | 0,20 | 0,20 | 0,25 | 0,30 |
| | | 0,0080 | 0,0080 | 0,0080 | 0,010 | 0,012 |
| H12 | MM08-08.40-HF-MD06 F30M | 0,18 | 0,16 | 0,15 | 0,19 | 0,24 |
| | | 0,0070 | 0,0065 | 0,0060 | 0,0075 | 0,0095 |
| H21 | MM08-08.40-HF-MD06 F30M | 0,18 | 0,16 | 0,15 | 0,19 | 0,24 |
| | | 0,0070 | 0,0065 | 0,0060 | 0,0075 | 0,0095 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

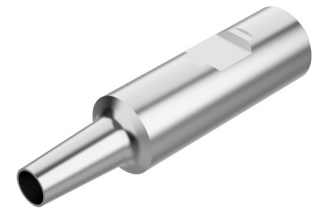
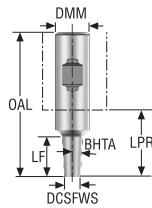
MM08 Hohe Vorschübe Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | F30M | | | | |
|-----|------|------|------|------|-------------------------------|
| | 100% | 70% | 30% | 20% | |
| P1 | 250 | 305 | 350 | 375 | Universell |
| | 820 | 1000 | 1150 | 1225 | |
| P2 | 245 | 300 | 345 | 365 | Stahl und Guss |
| | 800 | 980 | 1125 | 1200 | |
| P3 | 215 | 260 | 300 | 315 | Stahl und Guss |
| | 710 | 850 | 980 | 1025 | |
| P4 | 190 | 230 | 265 | 275 | Stahl und Guss |
| | 620 | 750 | 870 | 900 | |
| P5 | 180 | 220 | 255 | 265 | Stahl und Guss |
| | 590 | 720 | 840 | 870 | |
| P6 | 205 | 250 | 285 | 300 | Stahl und Guss |
| | 670 | 820 | 940 | 980 | |
| P7 | 190 | 235 | 270 | 285 | Rostfrei und ISO-S-Werkstoffe |
| | 620 | 770 | 890 | 940 | |
| P8 | 180 | 220 | 250 | 265 | Rostfrei und ISO-S-Werkstoffe |
| | 590 | 720 | 820 | 870 | |
| P11 | 185 | 230 | 260 | 275 | Rostfrei und ISO-S-Werkstoffe |
| | 610 | 750 | 850 | 900 | |
| P12 | 120 | 145 | 165 | 175 | Rostfrei und ISO-S-Werkstoffe |
| | 395 | 475 | 540 | 570 | |
| M1 | 195 | 240 | 275 | 295 | Rostfrei und ISO-S-Werkstoffe |
| | 640 | 790 | 900 | 970 | |
| M2 | 165 | 195 | 230 | 240 | Rostfrei und ISO-S-Werkstoffe |
| | 540 | 640 | 750 | 790 | |
| M3 | 130 | 155 | 180 | 190 | Rostfrei und ISO-S-Werkstoffe |
| | 425 | 510 | 590 | 620 | |
| M4 | 100 | 120 | 140 | 145 | Rostfrei und ISO-S-Werkstoffe |
| | 330 | 395 | 460 | 475 | |
| M5 | 85 | 100 | 115 | 120 | NE-Metalle |
| | 280 | 330 | 375 | 395 | |
| K1 | 195 | 235 | 270 | 290 | NE-Metalle |
| | 640 | 770 | 890 | 950 | |
| K2 | 170 | 210 | 240 | 255 | NE-Metalle |
| | 560 | 690 | 790 | 840 | |
| K3 | 145 | 175 | 205 | 215 | NE-Metalle |
| | 475 | 570 | 670 | 710 | |
| K4 | 140 | 170 | 195 | 205 | NE-Metalle |
| | 460 | 560 | 640 | 670 | |
| K5 | 85 | 105 | 120 | 125 | Harter |
| | 280 | 345 | 395 | 410 | |
| K6 | 125 | 150 | 170 | 180 | Harter |
| | 410 | 490 | 560 | 590 | |
| K7 | 110 | 130 | 150 | 160 | Harter |
| | 360 | 425 | 490 | 520 | |
| N1 | 1475 | 1800 | 2050 | 2125 | Graphit |
| | 4850 | 5900 | 6725 | 6975 | |
| N2 | 590 | 720 | 820 | 860 | Graphit |
| | 1925 | 2350 | 2700 | 2825 | |
| N3 | 395 | 480 | 550 | 570 | Graphit |
| | 1300 | 1575 | 1800 | 1875 | |
| N11 | 450 | 550 | 630 | 650 | Graphit |
| | 1475 | 1800 | 2075 | 2125 | |
| S1 | 48 | 55 | 65 | 70 | X-Heads |
| | 155 | 180 | 215 | 230 | |
| S2 | 39 | 46 | 50 | 55 | X-Heads |
| | 130 | 150 | 165 | 180 | |
| S3 | 33 | 40 | 46 | 48 | X-Heads |
| | 110 | 130 | 150 | 155 | |
| S11 | 65 | 80 | 90 | 95 | X-Heads |
| | 215 | 260 | 295 | 310 | |
| S12 | 46 | 55 | 65 | 65 | X-Heads |
| | 150 | 180 | 215 | 215 | |
| S13 | 27 | 32 | 36 | 38 | X-Heads |
| | 90 | 105 | 120 | 125 | |
| H5 | 40 | 47 | 55 | 60 | Minimaster Plus |
| | 130 | 155 | 180 | 195 | |
| H8 | 41 | 50 | 55 | 60 | Minimaster Plus |
| | 135 | 165 | 180 | 195 | |
| H11 | 50 | 60 | 70 | 75 | Minimaster Plus |
| | 165 | 195 | 230 | 245 | |
| H12 | 75 | 90 | 100 | 105 | Minimaster Plus |
| | 245 | 295 | 330 | 345 | |
| H21 | 41 | 50 | 55 | 60 | Minimaster |
| | 135 | 165 | 180 | 195 | |

Schaftkonstruktion

| | | |
|-------------------------------|---|--|
| Universell | Ausführung 1, Keilnut-Schaft | Ausführung 2, Zylindrische/Weldon Schnittstelle und 90° Stirnseite |
| |  |  |
| Stahl und Guss | | |
| Rostfrei und ISO-S-Werkstoffe | | |
| | Ausführung 3, Zylindrische/Weldon Schnittstelle und 87°/89° Stirnseite | Konstruktion 4, Zylindrische/Weldon Schnittstelle und 80°/85°/87° Stirnseite |
| NE-Metalle |  |  |
| Harter | | |
| Kunststoffe und Composite | | |
| | Ausführung 5, Zylindrische Schnittstelle und doppelt konische Stirnseite 89°/85° | |
| Graphit |  | |
| X-Heads | | |
| Minimaster Plus | | |



MM10 Schaft



| Bezeichnung | Produkt- nummer | Aufnahme | DCSFWS | DMM | OAL | LF | LPR | BHTA° | Abb. | | RPMX | Gewicht | Ersatzteil Bezeichnung |
|---------------------|--------------------|-------------|--------|------|-------|------|-------|-------|------|---|-------|---------|---------------------------|
| | | | mm | mm | mm | mm | mm | | | | | kg | |
| MM10-20075.3-0010 | 75012787 | Weldon | 9,5 | 20,0 | 75,0 | 10,0 | 25,0 | 0,0 | 2 | ✓ | 80000 | 0,2 | 4 |
| MM10-20085.3-3023 | 75012788 | Weldon | 9,5 | 20,0 | 85,0 | 23,0 | 35,0 | 3,0 | 3 | ✓ | 80000 | 0,2 | 4 |
| MM10-20140.3-5060 | 75012789 | Weldon | 9,5 | 20,0 | 140,0 | 60,0 | 90,0 | 5,0 | 4 | ✓ | 80000 | 0,3 | 5 |
| MM10-10045.0-0007 | 00083979 | Zylindrisch | 9,6 | 10,0 | 45,0 | 7,0 | 7,0 | 0,0 | 2 | ✓ | 80000 | 0,1 | 2 |
| MM10-16065.0-0000 | 75004925 | Zylindrisch | 9,5 | 16,0 | 65,0 | 0,0 | 17,0 | 60,0 | 1 | ✓ | 80000 | 0,1 | 1 |
| MM10-16160.0-1035M | 00094757 | Zylindrisch | 9,5 | 16,0 | 160,0 | 35,0 | 112,0 | 1,0 | 3 | ✓ | 80000 | 0,2 | 6 |
| MM10-16160.0-1055M | 00094758 | Zylindrisch | 9,5 | 16,0 | 160,0 | 55,0 | 112,0 | 1,0 | 3 | ✓ | 80000 | 0,2 | 7 |
| MM10-16160.0-1075M | 00094760 | Zylindrisch | 9,5 | 16,0 | 160,0 | 75,0 | 112,0 | 1,0 | 3 | ✓ | 80000 | 0,2 | 7 |
| MM10-32250.0-10063 | 75069366 | Zylindrisch | 9,5 | 32,0 | 250,0 | 63,8 | 190,0 | 10,0 | 4 | ✓ | 80000 | 1,3 | 5 |
| MM10-12060.0-0007DS | 02580667 | Zylindrisch | 9,6 | 12,0 | 60,0 | 7,0 | 15,0 | 0,0 | 2 | ✓ | 76300 | 0,1 | 3 |
| MM10-12085.0-3024DS | 02580704 | Zylindrisch | 9,5 | 12,0 | 85,0 | 23,8 | 40,0 | 3,0 | 4 | ✓ | 76300 | 0,2 | 3 |
| MM10-12100.0-1035DS | 02580733 | Zylindrisch | 9,5 | 12,0 | 100,0 | 35,0 | 55,0 | 1,0 | 3 | ✓ | 76300 | 0,2 | 3 |
| MM10-14120.0-1050DS | 02580736 | Zylindrisch | 9,5 | 14,0 | 120,0 | 50,0 | 75,0 | 1,0 | 3 | ✓ | 76300 | 0,3 | 3 |
| MM10-16085.0-0020DS | 02580688 | Zylindrisch | 9,5 | 16,0 | 85,0 | 20,0 | 37,0 | 0,0 | 2 | ✓ | 76300 | 0,3 | 3 |
| MM10-16105.0-0040DS | 02580689 | Zylindrisch | 9,5 | 16,0 | 105,0 | 40,0 | 57,0 | 0,0 | 2 | ✓ | 76300 | 0,3 | 3 |
| MM10-16160.0-1055DS | 02580748 | Zylindrisch | 9,5 | 16,0 | 160,0 | 55,0 | 112,0 | 1,0 | 3 | ✓ | 76300 | 0,4 | 3 |
| MM10-16160.0-1075DS | 02580749 | Zylindrisch | 9,5 | 16,0 | 160,0 | 75,0 | 112,0 | 1,0 | 3 | ✓ | 76300 | 0,4 | 3 |
| MM10-20250.0-1055DS | 02580750 | Zylindrisch | 9,5 | 20,0 | 250,0 | 55,0 | 200,0 | 1,0 | 5 | ✓ | 76300 | 1,0 | 3 |

Ersatzteile, im Lieferumfang enthalten

Zubehör

| Für Fräser | Hülse | Spannschraube | Schlüssel |
|------------|---|---|-----------|
| 4 |  MM-06048 |  MM10-0627 | – |
| 5 | MM-06116 | MM10-0627 | – |
| 2 | MM-06020 | MM10-0627 | H05-4 |
| 1 | MM-06032 | MM10-0627 | – |
| 6 | MM-06048 | MM10-0651 | – |
| 7 | MM-06032 | MM10-0688 | – |
| 3 | – | MM10-061027 | – |

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

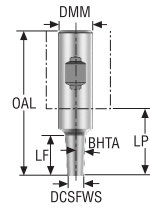
Graphit

X-Heads

Minimaster Plus

Minimaster



MM10 Schaft – Zoll



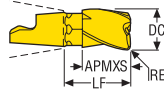
| Bezeichnung | Produkt- nummer | Aufnahme | DCSFMS | DMM | OAL | LF | LPR | BHTA° | Abb. |  | RPMX | Gewicht | Ersatzteil Bezeichnung |
|-------------------------|--------------------|-------------|--------|-------|-------|-------|-------|-------|------|---|-------|---------|---------------------------|
| | | | | | | | | | | | | | |
| MM10-0.75-3.0-3-0004 | 75015052 | Weldon | 0.360 | 0.750 | 2.953 | 0.394 | 0.984 | 0,0 | 2 | ✓ | 80000 | 0.440 | 3 |
| MM10-0.75-3.3-3-3009 | 75015053 | Weldon | 0.374 | 0.750 | 3.346 | 0.906 | 1.378 | 3,0 | 3 | ✓ | 80000 | 0.440 | 3 |
| MM10-0.75-5.5-3-5021 | 75015054 | Weldon | 0.374 | 0.750 | 5.512 | 2.150 | 3.543 | 5,0 | 4 | ✓ | 80000 | 0.660 | 5 |
| MM10-0.38-1.8-0-0002 | 00096126 | Zylindrisch | 0.360 | 0.375 | 1.772 | 0.276 | 0.276 | 0,0 | 2 | ✓ | 80000 | 0.220 | 2 |
| MM10-0.62-2.6-0-0000 | 75005069 | Zylindrisch | 0.374 | 0.625 | 2.559 | 0 | 0.669 | 60,0 | 1 | ✓ | 80000 | 0.220 | 1 |
| MM10-0.62-6.3-0-1021 | 75054608 | Zylindrisch | 0.360 | 0.625 | 6.299 | 2.165 | 4.409 | 1,0 | 3 | ✓ | 80000 | 0.440 | 7 |
| MM10-1.25-10.0-0-10024 | 00096132 | Zylindrisch | 0.374 | 1.250 | 9.843 | 2.484 | 7.480 | 10,0 | 4 | ✓ | 80000 | 2.870 | 5 |
| MM10-0.75-10.0-0-1021DS | 02593420 | Zylindrisch | 0.360 | 0.750 | 9.843 | 2.165 | 7.874 | 1,0 | 5 | ✓ | 76300 | 1.980 | 4 |
| MM10-0.75-4.1-0-0015DS | 02593422 | Zylindrisch | 0.360 | 0.750 | 4.134 | 1.575 | 2.165 | 0,0 | 2 | ✓ | 76300 | 0.660 | 4 |

Ersatzteile, im Lieferumfang enthalten


Zubehör

| Für Fräser | Hülse | Spannschraube | Schlüssel |
|------------|---|---|-----------|
| 3 |  MM-06048 |  MM10-0627 | - |
| 5 | MM-06116 | MM10-0627 | - |
| 2 | MM-06020 | MM10-0627 | H05-4 |
| 1 | MM-06032 | MM10-0627 | - |
| 7 | MM-06032 | MM10-0688 | - |
| 4 | - | MM10-061027 | - |

Nutfräsen/Eckfräsen



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | RE | LF | RMPX° | C min | C max | FHA | ZEFP | Schlüssel | Schlüssel  | Beschichtung | | | |
|-----------------------|----------------|---------------|--------------|----------------|-------|-------|-------|-----|------|-----------|---|--------------|------|------|------|
| | | | | | | | | | | | | Beschichtet | | | |
| | | | | | | | | | | | | T60M | F15M | F30M | F40M |
| MM10-09512-A30-E03 | 9,525 0.375 | 11,8 0.465 | 0,0 - | 15,72 0.619 | 15,0 | 11,6 | 18,8 | 30 | 3 | MM0416 | ✓ | | | ■ | |
| MM10-09512-R03A30-M03 | 9,525 0.375 | 11,8 0.465 | 0,3 0.012 | 15,72 0.619 | 15,0 | 11,6 | 18,2 | 30 | 3 | MM0416 | ✓ | | | | ■ |
| MM10-09512-R04A30-M03 | 9,525 0.375 | 11,8 0.465 | 0,4 0.016 | 15,72 0.619 | 15,0 | 11,6 | 18,0 | 30 | 3 | MM0416 | ✓ | | | | ■ |
| MM10-09512-R08A30-M03 | 9,525 0.375 | 11,8 0.465 | 0,8 0.031 | 15,72 0.619 | 15,0 | 11,6 | 17,2 | 30 | 3 | MM0416 | ✓ | | | | ■ |
| MM10-09512-R16A30-M03 | 9,525 0.375 | 11,8 0.465 | 1,6 0.063 | 15,72 0.619 | 15,0 | 11,6 | 15,6 | 30 | 3 | MM0416 | ✓ | | | | ■ |
| MM10-10012-A30-E03 | 10,0 0.394 | 11,8 0.465 | 0,0 - | 15,72 0.619 | 15,0 | 12,2 | 19,8 | 30 | 3 | MM0416 | ✓ | | | ■ | |
| MM10-10012-R05A30-M03 | 10,0 0.394 | 11,8 0.465 | 0,5 0.020 | 15,72 0.619 | 15,0 | 12,2 | 18,8 | 30 | 3 | MM0416 | ✓ | | | | ■ |
| MM10-10012-R10A30-D03 | 10,0 0.394 | 11,8 0.465 | 1,0 0.039 | 15,72 0.619 | 15,0 | 12,2 | 17,8 | 30 | 3 | MM0416 | ✓ | | | ■ | |
| MM10-10012-R10A30-E03 | 10,0 0.394 | 11,8 0.465 | 1,0 0.039 | 15,72 0.619 | 15,0 | 12,2 | 17,8 | 30 | 3 | MM0416 | ✓ | | | ■ | |
| MM10-10012-R10A30-M03 | 10,0 0.394 | 11,8 0.465 | 1,0 0.039 | 15,72 0.619 | 15,0 | 12,2 | 17,8 | 30 | 3 | MM0416 | ✓ | | | | ■ |
| MM10-10012-R20A30-M03 | 10,0 0.394 | 11,8 0.465 | 2,0 0.079 | 15,72 0.619 | 15,0 | 12,2 | 15,8 | 30 | 3 | MM0416 | ✓ | | | | ■ |
| MM10-10012-R30A30-M03 | 10,0 0.394 | 11,8 0.465 | 3,0 0.118 | 15,72 0.619 | 15,0 | 12,2 | 13,8 | 30 | 3 | MM0416 | ✓ | | | | ■ |

Unversell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

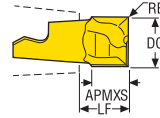
Graphit

X-Heads

Minimaster Plus

Minimaster

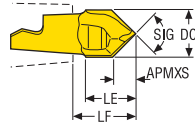
Nutfräsen/Eckfräsen




• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | RE | LF | RMPX° | C min | C max | FHA | ZEPF | Schlüssel | Beschichtung | | | | |
|----------------------|----------------|--------------|--------------|---------------|-------|-------|-------|-----|------|-----------|--------------|------|------|------|--|
| | | | | | | | | | | | Beschichtet | | | | |
| | | | | | | | | | | | T60M | F15M | F30M | F40M | |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | | | | | | | | |
| MM10-09510-M03 | 9,525 0.375 | 6,8 0.268 | 0,0 - | 8,5 0.335 | 15,0 | 11,6 | 18,8 | 0 | 2 | MM0612 | ■ | | | | |
| MM10-09510-R04-MD04 | 9,525 0.375 | 6,8 0.268 | 0,4 0.016 | 8,49 0.334 | 15,0 | 11,6 | 18,0 | 0 | 2 | MM0612 | ■ | | | | |
| MM10-09510-R08A8-E03 | 9,525 0.375 | 6,6 0.260 | 0,8 0.031 | 8,37 0.330 | 15,0 | 11,6 | 17,2 | 8 | 2 | MM0612 | | | ■ | | |
| MM10-09807T-R03-D04 | 9,8 0.386 | 6,8 0.268 | 0,3 0.012 | 8,49 0.334 | 15,0 | 11,9 | 18,8 | 0 | 2 | MM0612 | ■ | | | | |
| MM10-10007-M03 | 10,0 0.394 | 6,9 0.272 | 0,0 - | 8,5 0.335 | 15,0 | 12,2 | 19,8 | 0 | 2 | MM0612 | ■ | | | | |
| MM10-10007-R04A8-E03 | 10,0 0.394 | 6,6 0.260 | 0,4 0.016 | 8,44 0.332 | 15,0 | 12,2 | 19,0 | 8 | 2 | MM0612 | ■ | | ■ | | |
| MM10-10007-R04-MD04 | 10,0 0.394 | 6,8 0.268 | 0,4 0.016 | 8,49 0.334 | 15,0 | 12,2 | 19,0 | 0 | 2 | MM0612 | ■ | | ■ | | |
| MM10-10007-R04P-M03 | 10,0 0.394 | 6,7 0.264 | 0,4 0.016 | 8,38 0.330 | 15,0 | 12,2 | 19,0 | 0 | 2 | MM0612 | | | ■ | | |
| MM10-10007-R10-MD04 | 10,0 0.394 | 6,8 0.268 | 1,0 0.039 | 8,48 0.334 | 15,0 | 12,2 | 17,8 | 0 | 2 | MM0612 | ■ | | ■ | | |
| MM10-10007-R20-MD04 | 10,0 0.394 | 6,8 0.268 | 2,0 0.079 | 8,46 0.333 | 15,0 | 12,2 | 15,8 | 0 | 2 | MM0612 | | | ■ | | |
| MM10-10007-R30-MD04 | 10,0 0.394 | 6,8 0.268 | 3,0 0.118 | 8,44 0.332 | 15,0 | 12,2 | 13,8 | 0 | 2 | MM0612 | | | ■ | | |

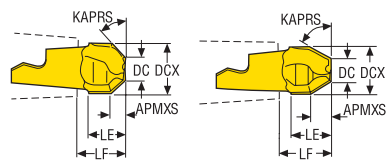
Zentrierbohren




• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | LE | LF | SIG° | ZEFP | Schlüssel  | Beschichtung | | | |
|---------------------|---------------|---------------|---------------|---------------|-------|------|---|--------------|------|------|------|
| | | | | | | | | T60M | F15M | F30M | F40M |
| MM10-10005-C90-M03 | 10,0 0.394 | 4,69 0.185 | 10,0 0.394 | 11,8 0.465 | 90,0 | 2 | MM0612 | ■ | | | |
| MM10-10007-C120-M03 | 10,0 0.394 | 2,7 0.106 | 10,4 0.409 | 11,8 0.465 | 120,0 | 2 | MM0612 | ■ | | | |

Anfasen



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DCX | DC | APMXS | LE | LF | KAPRS° | ZEFP | Schlüssel  | Beschichtung | | | |
|---------------------|---------------|---------------|--------------|---------------|---------------|--------|------|---|--------------|------|------|------|
| | | | | | | | | | T60M | F15M | F30M | F40M |
| MM10-10007-4525-E03 | 10,0 0.394 | 4,82 0.190 | 2,6 0.102 | 6,94 0.273 | 8,48 0.334 | 45,0 | 2 | MM0612 | ■ | | | |
| MM10-10008-6040-E03 | 10,0 0.394 | 5,24 0.206 | 4,0 0.157 | 8,05 0.317 | 9,6 0.378 | 60,0 | 2 | MM0612 | ■ | | | |

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NE-Metalle

Harter

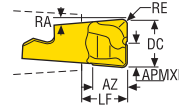
Graphit

X-Heads

Minimaster Plus

Minimaster

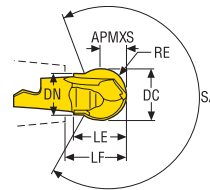
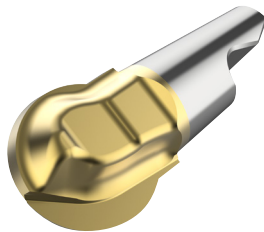
Tauchfräser



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXE | RE | AZ | LF | RA° | ZEFP | Schlüssel | Beschichtung | | | |
|------------------------|---------------|--------------|--------------|--------------|---------------|-----|------|-----------|--------------|------|------|------|
| | | | | | | | | | T60M | F15M | F30M | F40M |
| MM10-10007-R10-PL-MD04 | 10,0 0.394 | 5,0 0.197 | 1,0 0.039 | 7,1 0.280 | 8,48 0.334 | 5,0 | 2 | MM0612 | | | ■ | |

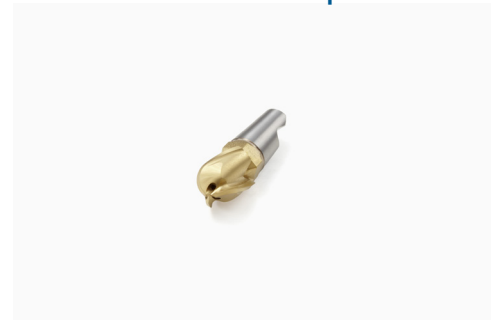
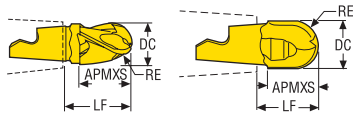
Präzisionswendeschneidplatten zum Vorschlichten in allen Werkstoffen



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | RE | LE | LF | DN | SA | ZEFP | Schlüssel | Beschichtung | | | |
|-----------------------|---------------|---------------|---------------|---------------|----------------|---------------|-------|------|-----------|--------------|------|------|------|
| | | | | | | | | | | T60M | F15M | F30M | F40M |
| MM10-12012-B120P-M05 | 12,0 0.472 | 6,0 0.236 | 6,0 0.236 | 12,0 0.472 | 13,2 0.520 | 10,0 0.394 | 247,0 | 2 | MM0612 | | | ■ | |
| MM10-12712-B120PF-M03 | 12,7 0.500 | 6,35 0.250 | 6,35 0.250 | 12,4 0.488 | 13,56 0.534 | 10,0 0.394 | 256,0 | 2 | MM1420 | | ■ | | |
| MM10-12712-B120P-M05 | 12,7 0.500 | 6,35 0.250 | 6,35 0.250 | 12,4 0.488 | 13,56 0.534 | 10,0 0.394 | 256,0 | 2 | MM1420 | | | ■ | |

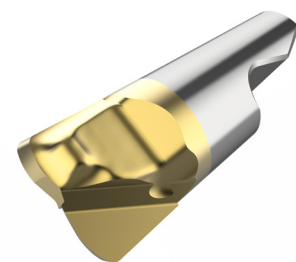
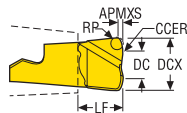
Kopierfräser



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | RE | LF | FHA | ZEFP | Schlüssel | Beschichtung | | | |
|-----------------------|----------------|---------------|----------------|----------------|------|------|-----------|--------------|------|------|------|
| | | | | | | | | Beschichtet | | | |
| | | | | | | | | T60M | F15M | F30M | F40M |
| MM10-09510-B90P-M04 | 9,525 0.375 | 8,7 0.343 | 4,763 0.188 | 11,74 0.462 | 0,0 | 2 | MM0612 | ■ | | ■ | |
| MM10-10010-B90-MD04 | 10,0 0.394 | 10,2 0.402 | 5,0 0.197 | 11,77 0.463 | 0,0 | 2 | MM0612 | ■ | | ■ | |
| MM10-10010-B90PF-M02 | 10,0 0.394 | 8,73 0.344 | 5,0 0.197 | 11,74 0.462 | 0,0 | 2 | MM0612 | | ■ | | |
| MM10-10010-B90P-M04 | 10,0 0.394 | 8,73 0.344 | 5,0 0.197 | 11,74 0.462 | 0,0 | 2 | MM0612 | | | ■ | |
| MM10-10010-B90S-E04 | 10,0 0.394 | 10,2 0.402 | 5,0 0.197 | 11,77 0.463 | 0,0 | 2 | MM0612 | | | ■ | |
| MM10-10012-B90A30-D03 | 10,0 0.394 | 11,8 0.465 | 5,0 0.197 | 15,72 0.619 | 30,0 | 3 | MM0416 | ✓ | | ■ | |
| MM10-10012-B90A30-E03 | 10,0 0.394 | 11,8 0.465 | 5,0 0.197 | 15,72 0.619 | 30,0 | 3 | MM0416 | ✓ | | ■ | |
| MM10-10012-B90A30-M03 | 10,0 0.394 | 11,8 0.465 | 5,0 0.197 | 15,72 0.619 | 30,0 | 3 | MM0416 | ✓ | | | ■ |

Hochvorschubfräser



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DCX | DC | APMXS | RP | CCER | LF | RMPX° | C min | C max | ZEFP | Schlüssel | Beschichtung | | | |
|--------------------|---------------|--------------|---------------|---------------|--------------|--------------|-------|-------|-------|------|-----------|--------------|------|------|------|
| | | | | | | | | | | | | Beschichtet | | | |
| | | | | | | | | | | | | T60M | F15M | F30M | F40M |
| MM10-10.50-HF-MD08 | 10,0 0.394 | 5,0 0.197 | 0,44 0.017 | 1,13 0.044 | 5,0 0.197 | 8,5 0.335 | 5,0 | 12,2 | 18,2 | 2 | MM0612 | | ■ | ■ | |

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Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Graphit

X-Heads

Minimaster Plus

Minimaster

MM10 - Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|----------------------------|----------------|----------------|---------|--------|--------|
| | | | 100% | 40% | 20% | 10% |
| P1 | MM10-10012-R05A30-M03 F40M | 2,0 | 0,044 | 0,044 | 0,055 | 0,070 |
| | | 0,080 | 0,0017 | 0,0017 | 0,0022 | 0,0028 |
| P2 | MM10-10012-R05A30-M03 F40M | 2,0 | 0,044 | 0,044 | 0,055 | 0,070 |
| | | 0,080 | 0,0017 | 0,0017 | 0,0022 | 0,0028 |
| P3 | MM10-10012-R05A30-M03 F40M | 2,0 | 0,042 | 0,042 | 0,050 | 0,070 |
| | | 0,080 | 0,0017 | 0,0017 | 0,0020 | 0,0028 |
| P4 | MM10-10012-R05A30-M03 F40M | 2,0 | 0,042 | 0,042 | 0,050 | 0,065 |
| | | 0,080 | 0,0017 | 0,0017 | 0,0020 | 0,0026 |
| P5 | MM10-10012-R05A30-M03 F40M | 2,0 | 0,040 | 0,040 | 0,050 | 0,065 |
| | | 0,080 | 0,0016 | 0,0016 | 0,0020 | 0,0026 |
| P6 | MM10-10012-R05A30-M03 F40M | 2,0 | 0,040 | 0,040 | 0,048 | 0,065 |
| | | 0,080 | 0,0016 | 0,0016 | 0,0019 | 0,0026 |
| P7 | MM10-10012-R05A30-M03 F40M | 2,0 | 0,040 | 0,040 | 0,048 | 0,065 |
| | | 0,080 | 0,0016 | 0,0016 | 0,0019 | 0,0026 |
| P8 | MM10-10012-R05A30-M03 F40M | 2,0 | 0,042 | 0,042 | 0,050 | 0,070 |
| | | 0,080 | 0,0017 | 0,0017 | 0,0020 | 0,0028 |
| P11 | MM10-10012-R05A30-M03 F40M | 2,0 | 0,040 | 0,040 | 0,048 | 0,065 |
| | | 0,080 | 0,0016 | 0,0016 | 0,0019 | 0,0026 |
| P12 | MM10-10012-R05A30-M03 F40M | 1,7 | 0,028 | 0,028 | 0,034 | 0,044 |
| | | 0,065 | 0,0011 | 0,0011 | 0,0013 | 0,0017 |
| M1 | MM10-10012-R05A30-M03 F40M | 2,0 | 0,044 | 0,044 | 0,055 | 0,070 |
| | | 0,080 | 0,0017 | 0,0017 | 0,0022 | 0,0028 |
| M2 | MM10-10012-R05A30-M03 F40M | 2,0 | 0,040 | 0,040 | 0,050 | 0,065 |
| | | 0,080 | 0,0016 | 0,0016 | 0,0020 | 0,0026 |
| M3 | MM10-10012-R05A30-M03 F40M | 1,7 | 0,032 | 0,032 | 0,040 | 0,050 |
| | | 0,065 | 0,0013 | 0,0013 | 0,0016 | 0,0020 |
| M4 | MM10-10012-R05A30-M03 F40M | 1,2 | 0,030 | 0,030 | 0,034 | 0,046 |
| | | 0,048 | 0,0012 | 0,0012 | 0,0013 | 0,0018 |
| M5 | MM10-10012-R05A30-M03 F40M | 1,2 | 0,030 | 0,030 | 0,034 | 0,046 |
| | | 0,048 | 0,0012 | 0,0012 | 0,0013 | 0,0018 |
| K1 | MM10-10012-R10A30-E03 F30M | 2,0 | 0,048 | 0,048 | 0,055 | 0,075 |
| | | 0,080 | 0,0019 | 0,0019 | 0,0022 | 0,0030 |
| K2 | MM10-10012-R10A30-E03 F30M | 2,0 | 0,044 | 0,044 | 0,050 | 0,065 |
| | | 0,080 | 0,0017 | 0,0017 | 0,0020 | 0,0026 |
| K3 | MM10-10012-R10A30-E03 F30M | 2,0 | 0,044 | 0,042 | 0,050 | 0,065 |
| | | 0,080 | 0,0017 | 0,0017 | 0,0020 | 0,0026 |
| K4 | MM10-10012-R10A30-E03 F30M | 2,0 | 0,044 | 0,042 | 0,050 | 0,065 |
| | | 0,080 | 0,0017 | 0,0017 | 0,0020 | 0,0026 |
| K5 | MM10-10012-R10A30-D03 F30M | 2,0 | 0,040 | 0,038 | 0,044 | 0,060 |
| | | 0,080 | 0,0016 | 0,0015 | 0,0017 | 0,0024 |
| K6 | MM10-10012-R10A30-D03 F30M | 2,0 | 0,044 | 0,042 | 0,050 | 0,065 |
| | | 0,080 | 0,0017 | 0,0017 | 0,0020 | 0,0026 |
| K7 | MM10-10012-R10A30-D03 F30M | 2,0 | 0,040 | 0,038 | 0,044 | 0,060 |
| | | 0,080 | 0,0016 | 0,0015 | 0,0017 | 0,0024 |
| N1 | MM10-10012-R10A30-E03 F30M | 2,0 | 0,060 | 0,060 | 0,070 | 0,095 |
| | | 0,080 | 0,0024 | 0,0024 | 0,0028 | 0,0038 |
| N2 | MM10-10012-R10A30-E03 F30M | 2,0 | 0,060 | 0,060 | 0,070 | 0,095 |
| | | 0,080 | 0,0024 | 0,0024 | 0,0028 | 0,0038 |
| N3 | MM10-10012-R10A30-E03 F30M | 2,0 | 0,060 | 0,060 | 0,070 | 0,095 |
| | | 0,080 | 0,0024 | 0,0024 | 0,0028 | 0,0038 |
| N11 | MM10-10012-R10A30-E03 F30M | 2,0 | 0,060 | 0,060 | 0,070 | 0,095 |
| | | 0,080 | 0,0024 | 0,0024 | 0,0028 | 0,0038 |
| S1 | MM10-10012-R10A30-D03 F30M | 1,2 | 0,036 | 0,034 | 0,036 | 0,046 |
| | | 0,048 | 0,0014 | 0,0013 | 0,0014 | 0,0018 |
| S2 | MM10-10012-R10A30-D03 F30M | 1,2 | 0,036 | 0,034 | 0,036 | 0,046 |
| | | 0,048 | 0,0014 | 0,0013 | 0,0014 | 0,0018 |
| S3 | MM10-10012-R10A30-D03 F30M | 1,2 | 0,032 | 0,032 | 0,034 | 0,042 |
| | | 0,048 | 0,0013 | 0,0013 | 0,0013 | 0,0017 |
| S11 | MM10-10012-R05A30-M03 F40M | 1,4 | 0,034 | 0,034 | 0,040 | 0,050 |
| | | 0,055 | 0,0013 | 0,0013 | 0,0016 | 0,0020 |
| S12 | MM10-10012-R05A30-M03 F40M | 1,4 | 0,034 | 0,034 | 0,040 | 0,050 |
| | | 0,055 | 0,0013 | 0,0013 | 0,0016 | 0,0020 |
| S13 | MM10-10012-R05A30-M03 F40M | 1,2 | 0,030 | 0,030 | 0,034 | 0,046 |
| | | 0,048 | 0,0012 | 0,0012 | 0,0013 | 0,0018 |
| H5 | MM10-10012-R10A30-D03 F30M | 1,7 | 0,030 | 0,030 | 0,034 | 0,044 |
| | | 0,065 | 0,0012 | 0,0012 | 0,0013 | 0,0017 |
| H8 | MM10-10012-R10A30-D03 F30M | 1,4 | 0,025 | 0,024 | 0,026 | 0,034 |
| | | 0,055 | 0,0010 | 0,00095 | 0,0010 | 0,0013 |
| H11 | MM10-10012-R10A30-D03 F30M | 1,7 | 0,030 | 0,030 | 0,034 | 0,044 |
| | | 0,065 | 0,0012 | 0,0012 | 0,0013 | 0,0017 |
| H12 | MM10-10012-R10A30-D03 F30M | 1,4 | 0,025 | 0,024 | 0,026 | 0,034 |
| | | 0,055 | 0,0010 | 0,00095 | 0,0010 | 0,0013 |
| H21 | MM10-10012-R10A30-D03 F30M | 1,4 | 0,025 | 0,024 | 0,026 | 0,034 |
| | | 0,055 | 0,0010 | 0,00095 | 0,0010 | 0,0013 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MM10 - Nut- und Eckfräsen – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | F30M | | | | F40M | | | | T60M | | | |
|-----|------|------|------|------|------|------|------|------|------|------|------|------|
| | 100% | 40% | 20% | 10% | 100% | 40% | 20% | 10% | 100% | 40% | 20% | 10% |
| P1 | 265 | 330 | 365 | 405 | 250 | 315 | 345 | 385 | 190 | 240 | 270 | 295 |
| | 870 | 1075 | 1200 | 1325 | 820 | 1025 | 1125 | 1275 | 620 | 790 | 890 | 970 |
| P2 | 260 | 320 | 360 | 390 | 245 | 305 | 340 | 375 | 185 | 235 | 260 | 290 |
| | 850 | 1050 | 1175 | 1275 | 800 | 1000 | 1125 | 1225 | 610 | 770 | 850 | 950 |
| P3 | 225 | 280 | 315 | 340 | 215 | 265 | 295 | 325 | 165 | 205 | 230 | 250 |
| | 740 | 920 | 1025 | 1125 | 710 | 870 | 970 | 1075 | 540 | 670 | 750 | 820 |
| P4 | 200 | 245 | 275 | 305 | 190 | 235 | 260 | 290 | 145 | 180 | 200 | 225 |
| | 660 | 800 | 900 | 1000 | 620 | 770 | 850 | 950 | 475 | 590 | 660 | 740 |
| P5 | 190 | 235 | 265 | 290 | 180 | 225 | 250 | 275 | 140 | 175 | 195 | 215 |
| | 620 | 770 | 870 | 950 | 590 | 740 | 820 | 900 | 460 | 570 | 640 | 710 |
| P6 | 215 | 265 | 295 | 325 | 205 | 250 | 280 | 310 | 155 | 195 | 220 | 240 |
| | 710 | 870 | 970 | 1075 | 670 | 820 | 920 | 1025 | 510 | 640 | 720 | 790 |
| P7 | 200 | 250 | 280 | 310 | 190 | 240 | 265 | 290 | 145 | 185 | 205 | 225 |
| | 660 | 820 | 920 | 1025 | 620 | 790 | 870 | 950 | 475 | 610 | 670 | 740 |
| P8 | 190 | 235 | 265 | 285 | 180 | 225 | 250 | 270 | 140 | 175 | 190 | 210 |
| | 620 | 770 | 870 | 940 | 590 | 740 | 820 | 890 | 460 | 570 | 620 | 690 |
| P11 | 195 | 245 | 270 | 300 | 185 | 230 | 260 | 285 | 140 | 180 | 200 | 220 |
| | 640 | 800 | 890 | 980 | 610 | 750 | 850 | 940 | 460 | 590 | 660 | 720 |
| P12 | 125 | 150 | 170 | 185 | 115 | 145 | 160 | 175 | 90 | 115 | 125 | 140 |
| | 410 | 490 | 560 | 610 | 375 | 475 | 520 | 570 | 295 | 375 | 410 | 460 |
| M1 | — | — | — | — | 200 | 245 | 275 | 305 | 150 | 190 | 210 | 235 |
| | — | — | — | — | 660 | 800 | 900 | 1000 | 490 | 620 | 690 | 770 |
| M2 | — | — | — | — | 165 | 200 | 225 | 250 | 125 | 155 | 175 | 190 |
| | — | — | — | — | 540 | 660 | 740 | 820 | 410 | 510 | 570 | 620 |
| M3 | — | — | — | — | 130 | 160 | 175 | 195 | 100 | 125 | 140 | 155 |
| | — | — | — | — | 425 | 520 | 570 | 640 | 330 | 410 | 460 | 510 |
| M4 | — | — | — | — | 100 | 120 | 135 | 150 | 75 | 95 | 105 | 115 |
| | — | — | — | — | 330 | 395 | 445 | 490 | 245 | 310 | 345 | 375 |
| M5 | — | — | — | — | 80 | 100 | 115 | 125 | 65 | 80 | 90 | 95 |
| | — | — | — | — | 260 | 330 | 375 | 410 | 215 | 260 | 295 | 310 |
| K1 | 205 | 255 | 285 | 310 | 195 | 240 | 270 | 300 | 150 | 185 | 205 | 230 |
| | 670 | 840 | 940 | 1025 | 640 | 790 | 890 | 980 | 490 | 610 | 670 | 750 |
| K2 | 180 | 225 | 250 | 275 | 170 | 215 | 235 | 260 | 130 | 165 | 185 | 200 |
| | 590 | 740 | 820 | 900 | 560 | 710 | 770 | 850 | 425 | 540 | 610 | 660 |
| K3 | 150 | 190 | 210 | 235 | 145 | 180 | 200 | 220 | 110 | 140 | 155 | 170 |
| | 490 | 620 | 690 | 770 | 475 | 590 | 660 | 720 | 360 | 460 | 510 | 560 |
| K4 | 145 | 180 | 200 | 225 | 140 | 170 | 190 | 210 | 105 | 130 | 150 | 165 |
| | 475 | 590 | 660 | 740 | 460 | 560 | 620 | 690 | 345 | 425 | 490 | 540 |
| K5 | 90 | 110 | 125 | 135 | 85 | 105 | 115 | 125 | 65 | 80 | 90 | 100 |
| | 295 | 360 | 410 | 445 | 280 | 345 | 375 | 410 | 215 | 260 | 295 | 330 |
| K6 | 130 | 160 | 180 | 195 | 120 | 150 | 170 | 185 | 95 | 115 | 130 | 145 |
| | 425 | 520 | 590 | 640 | 395 | 490 | 560 | 610 | 310 | 375 | 425 | 475 |
| K7 | 110 | 140 | 155 | 170 | 105 | 135 | 150 | 165 | 85 | 105 | 115 | 125 |
| | 360 | 460 | 510 | 560 | 345 | 445 | 490 | 540 | 280 | 345 | 375 | 410 |
| N1 | 1550 | 1925 | 2150 | 2350 | 1475 | 1825 | 2025 | 2250 | 1125 | 1400 | 1550 | 1725 |
| | 5075 | 6325 | 7050 | 7700 | 4850 | 6000 | 6650 | 7375 | 3700 | 4600 | 5075 | 5650 |
| N2 | 630 | 780 | 870 | 950 | 600 | 740 | 820 | 910 | 450 | 570 | 630 | 690 |
| | 2075 | 2550 | 2850 | 3125 | 1975 | 2425 | 2700 | 2975 | 1475 | 1875 | 2075 | 2275 |
| N3 | 415 | 520 | 580 | 630 | 395 | 495 | 550 | 610 | 300 | 380 | 420 | 460 |
| | 1350 | 1700 | 1900 | 2075 | 1300 | 1625 | 1800 | 2000 | 980 | 1250 | 1375 | 1500 |
| N11 | 475 | 590 | 660 | 720 | 455 | 570 | 620 | 690 | 345 | 430 | 480 | 530 |
| | 1550 | 1925 | 2175 | 2350 | 1500 | 1875 | 2025 | 2275 | 1125 | 1400 | 1575 | 1750 |
| S1 | 48 | 60 | 65 | 75 | 46 | 55 | 65 | 70 | 36 | 45 | 50 | 55 |
| | 155 | 195 | 215 | 245 | 150 | 180 | 215 | 230 | 120 | 150 | 165 | 180 |
| S2 | 38 | 48 | 55 | 60 | 37 | 46 | 50 | 55 | 29 | 36 | 40 | 44 |
| | 125 | 155 | 180 | 195 | 120 | 150 | 165 | 180 | 95 | 120 | 130 | 145 |
| S3 | 34 | 42 | 47 | 50 | 32 | 40 | 45 | 49 | 25 | 32 | 35 | 38 |
| | 110 | 140 | 155 | 165 | 105 | 130 | 150 | 160 | 80 | 105 | 115 | 125 |
| S11 | — | — | — | — | 65 | 80 | 90 | 100 | 50 | 65 | 70 | 75 |
| | — | — | — | — | 215 | 260 | 295 | 330 | 165 | 215 | 230 | 245 |
| S12 | — | — | — | — | 45 | 55 | 60 | 70 | 35 | 43 | 49 | 55 |
| | — | — | — | — | 150 | 180 | 195 | 230 | 115 | 140 | 160 | 180 |
| S13 | — | — | — | — | 26 | 32 | 36 | 39 | 20 | 25 | 28 | 30 |
| | — | — | — | — | 85 | 105 | 120 | 130 | 65 | 80 | 90 | 100 |
| H5 | 41 | 50 | 55 | 60 | 39 | 48 | 55 | 60 | 30 | 38 | 42 | 46 |
| | 135 | 165 | 180 | 195 | 130 | 155 | 180 | 195 | 100 | 125 | 140 | 150 |
| H8 | 42 | 50 | 60 | 65 | 40 | 50 | 55 | 60 | 31 | 39 | 44 | 48 |
| | 140 | 165 | 195 | 215 | 130 | 165 | 180 | 195 | 100 | 130 | 145 | 155 |
| H11 | 50 | 65 | 70 | 80 | 49 | 60 | 70 | 75 | 38 | 48 | 55 | 60 |
| | 165 | 215 | 230 | 260 | 160 | 195 | 230 | 245 | 125 | 155 | 180 | 195 |
| H12 | 75 | 95 | 105 | 115 | 70 | 90 | 100 | 110 | 55 | 70 | 80 | 85 |
| | 245 | 310 | 345 | 375 | 230 | 295 | 330 | 360 | 180 | 230 | 260 | 280 |
| H21 | 42 | 50 | 60 | 65 | 40 | 50 | 55 | 60 | 31 | 39 | 44 | 48 |
| | 140 | 165 | 195 | 215 | 130 | 165 | 180 | 195 | 100 | 130 | 145 | 155 |

Unversell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE- Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MM10 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|----------------------------|----------------|----------------|--------|--------|--------|
| | | | 100% | 40% | 20% | 10% |
| P1 | MM10-10012-B90A30-M03 F40M | 2,0 | 0,055 | 0,050 | 0,055 | 0,070 |
| | | 0,080 | 0,0022 | 0,0020 | 0,0022 | 0,0028 |
| P2 | MM10-10012-B90A30-M03 F40M | 2,0 | 0,055 | 0,050 | 0,055 | 0,075 |
| | | 0,080 | 0,0022 | 0,0020 | 0,0022 | 0,0030 |
| P3 | MM10-10012-B90A30-M03 F40M | 2,0 | 0,050 | 0,050 | 0,050 | 0,070 |
| | | 0,080 | 0,0020 | 0,0020 | 0,0020 | 0,0028 |
| P4 | MM10-10012-B90A30-M03 F40M | 2,0 | 0,050 | 0,048 | 0,050 | 0,065 |
| | | 0,080 | 0,0020 | 0,0019 | 0,0020 | 0,0026 |
| P5 | MM10-10012-B90A30-M03 F40M | 2,0 | 0,050 | 0,048 | 0,050 | 0,065 |
| | | 0,080 | 0,0020 | 0,0019 | 0,0020 | 0,0026 |
| P6 | MM10-10012-B90A30-M03 F40M | 2,0 | 0,050 | 0,048 | 0,050 | 0,065 |
| | | 0,080 | 0,0020 | 0,0019 | 0,0020 | 0,0026 |
| P7 | MM10-10012-B90A30-M03 F40M | 2,0 | 0,050 | 0,048 | 0,050 | 0,065 |
| | | 0,080 | 0,0020 | 0,0019 | 0,0020 | 0,0026 |
| P8 | MM10-10012-B90A30-M03 F40M | 2,0 | 0,050 | 0,050 | 0,050 | 0,070 |
| | | 0,080 | 0,0020 | 0,0020 | 0,0020 | 0,0028 |
| P11 | MM10-10012-B90A30-M03 F40M | 2,0 | 0,050 | 0,048 | 0,050 | 0,065 |
| | | 0,080 | 0,0020 | 0,0019 | 0,0020 | 0,0026 |
| P12 | MM10-10012-B90A30-M03 F40M | 1,7 | 0,034 | 0,034 | 0,034 | 0,044 |
| | | 0,065 | 0,0013 | 0,0013 | 0,0013 | 0,0018 |
| M1 | MM10-10012-B90A30-M03 F40M | 2,0 | 0,055 | 0,050 | 0,055 | 0,075 |
| | | 0,080 | 0,0022 | 0,0020 | 0,0022 | 0,0030 |
| M2 | MM10-10012-B90A30-M03 F40M | 2,0 | 0,050 | 0,048 | 0,050 | 0,065 |
| | | 0,080 | 0,0020 | 0,0019 | 0,0020 | 0,0026 |
| M3 | MM10-10012-B90A30-M03 F40M | 1,7 | 0,042 | 0,040 | 0,042 | 0,055 |
| | | 0,065 | 0,0017 | 0,0016 | 0,0017 | 0,0022 |
| M4 | MM10-10012-B90A30-M03 F40M | 1,2 | 0,038 | 0,036 | 0,036 | 0,046 |
| | | 0,048 | 0,0015 | 0,0014 | 0,0014 | 0,0019 |
| M5 | MM10-10012-B90A30-M03 F40M | 1,2 | 0,038 | 0,036 | 0,036 | 0,046 |
| | | 0,048 | 0,0015 | 0,0014 | 0,0014 | 0,0019 |
| K1 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,055 | 0,050 | 0,055 | 0,075 |
| | | 0,080 | 0,0022 | 0,0020 | 0,0022 | 0,0030 |
| K2 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,050 | 0,048 | 0,050 | 0,065 |
| | | 0,080 | 0,0020 | 0,0019 | 0,0020 | 0,0026 |
| K3 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,050 | 0,048 | 0,050 | 0,065 |
| | | 0,080 | 0,0020 | 0,0019 | 0,0020 | 0,0026 |
| K4 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,050 | 0,048 | 0,050 | 0,065 |
| | | 0,080 | 0,0020 | 0,0019 | 0,0020 | 0,0026 |
| K5 | MM10-10012-B90A30-D03 F30M | 2,0 | 0,044 | 0,042 | 0,046 | 0,060 |
| | | 0,080 | 0,0017 | 0,0017 | 0,0018 | 0,0024 |
| K6 | MM10-10012-B90A30-D03 F30M | 2,0 | 0,050 | 0,048 | 0,050 | 0,065 |
| | | 0,080 | 0,0020 | 0,0019 | 0,0020 | 0,0026 |
| K7 | MM10-10012-B90A30-D03 F30M | 2,0 | 0,044 | 0,042 | 0,046 | 0,060 |
| | | 0,080 | 0,0017 | 0,0017 | 0,0018 | 0,0024 |
| N1 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,070 | 0,065 | 0,070 | 0,095 |
| | | 0,080 | 0,0028 | 0,0026 | 0,0028 | 0,0038 |
| N2 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,070 | 0,065 | 0,070 | 0,095 |
| | | 0,080 | 0,0028 | 0,0026 | 0,0028 | 0,0038 |
| N3 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,070 | 0,065 | 0,070 | 0,095 |
| | | 0,080 | 0,0028 | 0,0026 | 0,0028 | 0,0038 |
| N11 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,070 | 0,065 | 0,070 | 0,095 |
| | | 0,080 | 0,0028 | 0,0026 | 0,0028 | 0,0038 |
| S1 | MM10-10012-B90A30-D03 F30M | 1,2 | 0,038 | 0,036 | 0,036 | 0,046 |
| | | 0,048 | 0,0015 | 0,0014 | 0,0014 | 0,0019 |
| S2 | MM10-10012-B90A30-D03 F30M | 1,2 | 0,038 | 0,036 | 0,036 | 0,046 |
| | | 0,048 | 0,0015 | 0,0014 | 0,0014 | 0,0019 |
| S3 | MM10-10012-B90A30-D03 F30M | 1,2 | 0,036 | 0,034 | 0,034 | 0,042 |
| | | 0,048 | 0,0014 | 0,0013 | 0,0013 | 0,0017 |
| S11 | MM10-10012-B90A30-M03 F40M | 1,4 | 0,042 | 0,042 | 0,042 | 0,055 |
| | | 0,055 | 0,0017 | 0,0017 | 0,0017 | 0,0022 |
| S12 | MM10-10012-B90A30-M03 F40M | 1,4 | 0,042 | 0,042 | 0,042 | 0,055 |
| | | 0,055 | 0,0017 | 0,0017 | 0,0017 | 0,0022 |
| S13 | MM10-10012-B90A30-M03 F40M | 1,2 | 0,038 | 0,036 | 0,036 | 0,046 |
| | | 0,048 | 0,0015 | 0,0014 | 0,0014 | 0,0019 |
| H5 | MM10-10012-B90A30-D03 F30M | 1,7 | 0,034 | 0,034 | 0,034 | 0,044 |
| | | 0,065 | 0,0013 | 0,0013 | 0,0013 | 0,0018 |
| H8 | MM10-10012-B90A30-D03 F30M | 1,4 | 0,028 | 0,026 | 0,026 | 0,034 |
| | | 0,055 | 0,0011 | 0,0010 | 0,0010 | 0,0013 |
| H11 | MM10-10012-B90A30-D03 F30M | 1,7 | 0,034 | 0,034 | 0,034 | 0,044 |
| | | 0,065 | 0,0013 | 0,0013 | 0,0013 | 0,0018 |
| H12 | MM10-10012-B90A30-D03 F30M | 1,4 | 0,028 | 0,026 | 0,026 | 0,034 |
| | | 0,055 | 0,0011 | 0,0010 | 0,0010 | 0,0013 |
| H21 | MM10-10012-B90A30-D03 F30M | 1,4 | 0,028 | 0,026 | 0,026 | 0,034 |
| | | 0,055 | 0,0011 | 0,0010 | 0,0010 | 0,0013 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MM10 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|----------------------------|----------------|----------------|--------|--------|--------|
| | | | 15% | 10% | 5% | 2% |
| P1 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,060 | 0,070 | 0,10 | 0,16 |
| | | 0,080 | 0,0024 | 0,0028 | 0,0040 | 0,0065 |
| P2 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,060 | 0,075 | 0,10 | 0,16 |
| | | 0,080 | 0,0024 | 0,0030 | 0,0040 | 0,0065 |
| P3 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,060 | 0,070 | 0,095 | 0,15 |
| | | 0,080 | 0,0024 | 0,0028 | 0,0038 | 0,0060 |
| P4 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,055 | 0,065 | 0,095 | 0,15 |
| | | 0,080 | 0,0022 | 0,0026 | 0,0038 | 0,0060 |
| P5 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,055 | 0,065 | 0,090 | 0,15 |
| | | 0,080 | 0,0022 | 0,0026 | 0,0036 | 0,0060 |
| P6 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,055 | 0,065 | 0,090 | 0,15 |
| | | 0,080 | 0,0022 | 0,0026 | 0,0036 | 0,0060 |
| P7 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,055 | 0,065 | 0,090 | 0,15 |
| | | 0,080 | 0,0022 | 0,0026 | 0,0036 | 0,0060 |
| P8 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,060 | 0,070 | 0,095 | 0,15 |
| | | 0,080 | 0,0024 | 0,0028 | 0,0038 | 0,0060 |
| P11 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,055 | 0,065 | 0,090 | 0,15 |
| | | 0,080 | 0,0022 | 0,0026 | 0,0036 | 0,0060 |
| P12 | MM10-10012-B90A30-E03 F30M | 1,7 | 0,038 | 0,044 | 0,060 | 0,10 |
| | | 0,065 | 0,0015 | 0,0018 | 0,0024 | 0,0040 |
| M1 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,060 | 0,075 | 0,10 | 0,16 |
| | | 0,080 | 0,0024 | 0,0030 | 0,0040 | 0,0065 |
| M2 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,055 | 0,065 | 0,090 | 0,15 |
| | | 0,080 | 0,0022 | 0,0026 | 0,0036 | 0,0060 |
| M3 | MM10-10012-B90A30-E03 F30M | 1,7 | 0,046 | 0,055 | 0,075 | 0,12 |
| | | 0,065 | 0,0018 | 0,0022 | 0,0030 | 0,0048 |
| M4 | MM10-10012-B90A30-E03 F30M | 1,2 | 0,040 | 0,046 | 0,065 | 0,10 |
| | | 0,048 | 0,0016 | 0,0019 | 0,0026 | 0,0040 |
| M5 | MM10-10012-B90A30-E03 F30M | 1,2 | 0,040 | 0,046 | 0,065 | 0,10 |
| | | 0,048 | 0,0016 | 0,0019 | 0,0026 | 0,0040 |
| K1 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,060 | 0,075 | 0,10 | 0,16 |
| | | 0,080 | 0,0024 | 0,0030 | 0,0040 | 0,0065 |
| K2 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,055 | 0,065 | 0,090 | 0,15 |
| | | 0,080 | 0,0022 | 0,0026 | 0,0036 | 0,0060 |
| K3 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,055 | 0,065 | 0,090 | 0,15 |
| | | 0,080 | 0,0022 | 0,0026 | 0,0036 | 0,0060 |
| K4 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,055 | 0,065 | 0,090 | 0,15 |
| | | 0,080 | 0,0022 | 0,0026 | 0,0036 | 0,0060 |
| K5 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,050 | 0,060 | 0,080 | 0,13 |
| | | 0,080 | 0,0020 | 0,0024 | 0,0032 | 0,0050 |
| K6 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,055 | 0,065 | 0,090 | 0,15 |
| | | 0,080 | 0,0022 | 0,0026 | 0,0036 | 0,0060 |
| K7 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,050 | 0,060 | 0,080 | 0,13 |
| | | 0,080 | 0,0020 | 0,0024 | 0,0032 | 0,0050 |
| N1 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,080 | 0,095 | 0,13 | 0,22 |
| | | 0,080 | 0,0032 | 0,0038 | 0,0050 | 0,0085 |
| N2 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,080 | 0,095 | 0,13 | 0,22 |
| | | 0,080 | 0,0032 | 0,0038 | 0,0050 | 0,0085 |
| N3 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,080 | 0,095 | 0,13 | 0,22 |
| | | 0,080 | 0,0032 | 0,0038 | 0,0050 | 0,0085 |
| N11 | MM10-10012-B90A30-E03 F30M | 2,0 | 0,080 | 0,095 | 0,13 | 0,22 |
| | | 0,080 | 0,0032 | 0,0038 | 0,0050 | 0,0085 |
| S1 | MM10-10012-B90A30-E03 F30M | 1,2 | 0,040 | 0,046 | 0,065 | 0,10 |
| | | 0,048 | 0,0016 | 0,0019 | 0,0026 | 0,0040 |
| S2 | MM10-10012-B90A30-E03 F30M | 1,2 | 0,040 | 0,046 | 0,065 | 0,10 |
| | | 0,048 | 0,0016 | 0,0019 | 0,0026 | 0,0040 |
| S3 | MM10-10012-B90A30-E03 F30M | 1,2 | 0,038 | 0,042 | 0,060 | 0,095 |
| | | 0,048 | 0,0015 | 0,0017 | 0,0024 | 0,0038 |
| S11 | MM10-10012-B90A30-E03 F30M | 1,4 | 0,046 | 0,055 | 0,075 | 0,12 |
| | | 0,055 | 0,0018 | 0,0022 | 0,0030 | 0,0048 |
| S12 | MM10-10012-B90A30-E03 F30M | 1,4 | 0,046 | 0,055 | 0,075 | 0,12 |
| | | 0,055 | 0,0018 | 0,0022 | 0,0030 | 0,0048 |
| S13 | MM10-10012-B90A30-E03 F30M | 1,2 | 0,040 | 0,046 | 0,065 | 0,10 |
| | | 0,048 | 0,0016 | 0,0019 | 0,0026 | 0,0040 |
| H5 | MM10-10012-B90A30-E03 F30M | 1,7 | 0,038 | 0,044 | 0,060 | 0,10 |
| | | 0,065 | 0,0015 | 0,0018 | 0,0024 | 0,0040 |
| H8 | MM10-10012-B90A30-E03 F30M | 1,4 | 0,030 | 0,034 | 0,048 | 0,075 |
| | | 0,055 | 0,0012 | 0,0013 | 0,0019 | 0,0030 |
| H11 | MM10-10012-B90A30-E03 F30M | 1,7 | 0,038 | 0,044 | 0,060 | 0,10 |
| | | 0,065 | 0,0015 | 0,0018 | 0,0024 | 0,0040 |
| H12 | MM10-10012-B90A30-E03 F30M | 1,4 | 0,030 | 0,034 | 0,048 | 0,075 |
| | | 0,055 | 0,0012 | 0,0013 | 0,0019 | 0,0030 |
| H21 | MM10-10012-B90A30-E03 F30M | 1,4 | 0,030 | 0,034 | 0,048 | 0,075 |
| | | 0,055 | 0,0012 | 0,0013 | 0,0019 | 0,0030 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

Universell
Stahl und Guss
Stahl und Guss
Rostrfrei und ISO-S-Werkstoffe
Rostrfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MM10 Z3 – Kopierfräser – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | F30M | | | | | F40M | | | | |
|-----|------|------|------|------|------|------|------|------|------|------|
| | 100% | 20% | 10% | 5% | 2% | 100% | 20% | 10% | 5% | 2% |
| P1 | 280 | 330 | 355 | 380 | 380 | 270 | 310 | 335 | 365 | 360 |
| | 920 | 1075 | 1175 | 1250 | 1250 | 890 | 1025 | 1100 | 1200 | 1175 |
| P2 | 275 | 320 | 340 | 370 | 370 | 260 | 305 | 325 | 355 | 355 |
| | 900 | 1050 | 1125 | 1225 | 1225 | 850 | 1000 | 1075 | 1175 | 1175 |
| P3 | 240 | 280 | 295 | 320 | 320 | 230 | 265 | 280 | 305 | 305 |
| | 790 | 920 | 970 | 1050 | 1050 | 750 | 870 | 920 | 1000 | 1000 |
| P4 | 210 | 245 | 265 | 285 | 285 | 200 | 235 | 250 | 270 | 270 |
| | 690 | 800 | 870 | 940 | 940 | 660 | 770 | 820 | 890 | 890 |
| P5 | 200 | 235 | 250 | 275 | 270 | 190 | 225 | 240 | 260 | 260 |
| | 660 | 770 | 820 | 900 | 890 | 620 | 740 | 790 | 850 | 850 |
| P6 | 225 | 265 | 285 | 305 | 305 | 215 | 250 | 270 | 290 | 290 |
| | 740 | 870 | 940 | 1000 | 1000 | 710 | 820 | 890 | 950 | 950 |
| P7 | 215 | 250 | 265 | 290 | 285 | 205 | 235 | 255 | 275 | 275 |
| | 710 | 820 | 870 | 950 | 940 | 670 | 770 | 840 | 900 | 900 |
| P8 | 200 | 235 | 250 | 270 | 270 | 190 | 225 | 235 | 260 | 260 |
| | 660 | 770 | 820 | 890 | 890 | 620 | 740 | 770 | 850 | 850 |
| P11 | 205 | 240 | 260 | 280 | 280 | 195 | 230 | 245 | 265 | 265 |
| | 670 | 790 | 850 | 920 | 920 | 640 | 750 | 800 | 870 | 870 |
| P12 | 130 | 160 | 160 | 175 | 175 | 125 | 150 | 155 | 165 | 165 |
| | 425 | 520 | 520 | 570 | 570 | 410 | 490 | 510 | 540 | 540 |
| M1 | 220 | 255 | 275 | 300 | 300 | 210 | 245 | 260 | 285 | 285 |
| | 720 | 840 | 900 | 980 | 980 | 690 | 800 | 850 | 940 | 940 |
| M2 | 180 | 210 | 225 | 245 | 245 | 175 | 200 | 215 | 235 | 230 |
| | 590 | 690 | 740 | 800 | 800 | 570 | 660 | 710 | 770 | 750 |
| M3 | 145 | 175 | 175 | 190 | 190 | 135 | 165 | 170 | 185 | 180 |
| | 475 | 570 | 590 | 620 | 620 | 445 | 540 | 560 | 610 | 590 |
| M4 | 95 | 140 | 135 | 145 | 145 | 95 | 130 | 130 | 140 | 140 |
| | 310 | 460 | 475 | 475 | 475 | 310 | 425 | 445 | 460 | 460 |
| M5 | 80 | 115 | 115 | 120 | 120 | 75 | 110 | 105 | 115 | 115 |
| | 260 | 375 | 395 | 395 | 395 | 245 | 360 | 375 | 375 | 375 |
| K1 | 220 | 255 | 270 | 295 | 295 | 205 | 240 | 255 | 280 | 280 |
| | 720 | 840 | 890 | 970 | 970 | 670 | 790 | 840 | 920 | 920 |
| K2 | 190 | 220 | 240 | 260 | 255 | 180 | 210 | 230 | 245 | 245 |
| | 620 | 720 | 790 | 850 | 840 | 590 | 690 | 750 | 800 | 800 |
| K3 | 160 | 190 | 200 | 220 | 215 | 155 | 180 | 195 | 210 | 205 |
| | 520 | 620 | 660 | 720 | 710 | 510 | 590 | 640 | 690 | 670 |
| K4 | 155 | 180 | 195 | 210 | 205 | 145 | 170 | 185 | 200 | 195 |
| | 510 | 590 | 640 | 690 | 670 | 475 | 560 | 610 | 660 | 640 |
| K5 | 95 | 110 | 115 | 125 | 125 | 90 | 105 | 110 | 120 | 120 |
| | 310 | 360 | 375 | 410 | 410 | 295 | 345 | 360 | 395 | 395 |
| K6 | 135 | 160 | 170 | 185 | 185 | 130 | 150 | 160 | 175 | 175 |
| | 445 | 520 | 560 | 610 | 610 | 425 | 490 | 520 | 570 | 570 |
| K7 | 120 | 140 | 150 | 160 | 160 | 115 | 130 | 140 | 155 | 155 |
| | 395 | 460 | 490 | 520 | 520 | 375 | 425 | 460 | 510 | 510 |
| N1 | 1650 | 1925 | 2050 | 2225 | 2200 | 1575 | 1825 | 1950 | 2125 | 2100 |
| | 5425 | 6325 | 6725 | 7300 | 7225 | 5175 | 6000 | 6400 | 6975 | 6900 |
| N2 | 670 | 780 | 830 | 900 | 890 | 640 | 740 | 790 | 860 | 850 |
| | 2200 | 2550 | 2725 | 2950 | 2925 | 2100 | 2425 | 2600 | 2825 | 2800 |
| N3 | 445 | 520 | 550 | 600 | 590 | 425 | 495 | 530 | 570 | 560 |
| | 1450 | 1700 | 1800 | 1975 | 1925 | 1400 | 1625 | 1750 | 1875 | 1825 |
| N11 | 510 | 590 | 630 | 690 | 680 | 485 | 560 | 600 | 650 | 650 |
| | 1675 | 1925 | 2075 | 2275 | 2225 | 1600 | 1825 | 1975 | 2125 | 2125 |
| S1 | 45 | 65 | 65 | 70 | 70 | 43 | 60 | 60 | 65 | 65 |
| | 150 | 215 | 215 | 230 | 230 | 140 | 195 | 215 | 215 | 215 |
| S2 | 37 | 50 | 50 | 55 | 55 | 35 | 49 | 48 | 50 | 50 |
| | 120 | 165 | 180 | 180 | 180 | 115 | 160 | 165 | 165 | 165 |
| S3 | 32 | 45 | 44 | 48 | 48 | 30 | 43 | 42 | 46 | 45 |
| | 105 | 150 | 155 | 155 | 155 | 100 | 140 | 150 | 150 | 150 |
| S11 | 70 | 90 | 90 | 95 | 95 | 65 | 85 | 85 | 90 | 90 |
| | 230 | 295 | 295 | 310 | 310 | 215 | 280 | 280 | 295 | 295 |
| S12 | 48 | 60 | 60 | 65 | 65 | 45 | 60 | 60 | 65 | 65 |
| | 155 | 195 | 215 | 215 | 215 | 150 | 195 | 195 | 215 | 215 |
| S13 | 26 | 36 | 36 | 38 | 38 | 24 | 34 | 34 | 37 | 37 |
| | 85 | 120 | 125 | 125 | 125 | 80 | 110 | 120 | 120 | 120 |
| H5 | 43 | 55 | 55 | 60 | 55 | 41 | 50 | 50 | 55 | 55 |
| | 140 | 180 | 180 | 195 | 180 | 135 | 165 | 165 | 180 | 180 |
| H8 | 41 | 55 | 55 | 60 | 60 | 39 | 50 | 50 | 55 | 55 |
| | 135 | 180 | 180 | 195 | 195 | 130 | 165 | 180 | 180 | 180 |
| H11 | 55 | 65 | 70 | 75 | 75 | 50 | 65 | 65 | 70 | 70 |
| | 180 | 215 | 230 | 245 | 245 | 165 | 215 | 215 | 230 | 230 |
| H12 | 75 | 100 | 100 | 105 | 105 | 70 | 95 | 95 | 100 | 100 |
| | 245 | 330 | 330 | 345 | 345 | 230 | 310 | 310 | 330 | 330 |
| H21 | 41 | 55 | 55 | 60 | 60 | 39 | 50 | 50 | 55 | 55 |
| | 135 | 180 | 180 | 195 | 195 | 130 | 165 | 180 | 180 | 180 |

MM10 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|--------------------------|----------------|----------------|--------|--------|--------|
| | | | 100% | 40% | 20% | 10% |
| P1 | MM10-10010-B90S-E04 F30M | 4,0 | 0,060 | 0,060 | 0,070 | 0,095 |
| | | 0.16 | 0.0024 | 0.0024 | 0.0028 | 0.0038 |
| P2 | MM10-10010-B90S-E04 F30M | 4,0 | 0,065 | 0,065 | 0,075 | 0,095 |
| | | 0.16 | 0.0026 | 0.0026 | 0.0030 | 0.0038 |
| P3 | MM10-10010-B90S-E04 F30M | 4,0 | 0,060 | 0,060 | 0,070 | 0,090 |
| | | 0.16 | 0.0024 | 0.0024 | 0.0028 | 0.0036 |
| P4 | MM10-10010-B90-MD04 F30M | 4,0 | 0,060 | 0,060 | 0,070 | 0,090 |
| | | 0.16 | 0.0024 | 0.0024 | 0.0028 | 0.0036 |
| P5 | MM10-10010-B90-MD04 F30M | 4,0 | 0,060 | 0,055 | 0,065 | 0,090 |
| | | 0.16 | 0.0024 | 0.0022 | 0.0026 | 0.0036 |
| P6 | MM10-10010-B90-MD04 F30M | 4,0 | 0,055 | 0,055 | 0,065 | 0,085 |
| | | 0.16 | 0.0022 | 0.0022 | 0.0026 | 0.0034 |
| P7 | MM10-10010-B90-MD04 F30M | 4,0 | 0,055 | 0,055 | 0,065 | 0,085 |
| | | 0.16 | 0.0022 | 0.0022 | 0.0026 | 0.0034 |
| P8 | MM10-10010-B90-MD04 F30M | 4,0 | 0,060 | 0,060 | 0,070 | 0,090 |
| | | 0.16 | 0.0024 | 0.0024 | 0.0028 | 0.0036 |
| P11 | MM10-10010-B90-MD04 F30M | 4,0 | 0,055 | 0,055 | 0,065 | 0,085 |
| | | 0.16 | 0.0022 | 0.0022 | 0.0026 | 0.0034 |
| P12 | MM10-10010-B90-MD04 F30M | 3,5 | 0,040 | 0,040 | 0,046 | 0,060 |
| | | 0.14 | 0.0016 | 0.0016 | 0.0018 | 0.0024 |
| M1 | MM10-10010-B90S-E04 F30M | 4,0 | 0,065 | 0,065 | 0,075 | 0,095 |
| | | 0.16 | 0.0026 | 0.0026 | 0.0030 | 0.0038 |
| M2 | MM10-10010-B90S-E04 F30M | 4,0 | 0,060 | 0,055 | 0,065 | 0,090 |
| | | 0.16 | 0.0024 | 0.0022 | 0.0026 | 0.0036 |
| M3 | MM10-10010-B90S-E04 F30M | 3,5 | 0,048 | 0,048 | 0,055 | 0,070 |
| | | 0.14 | 0.0019 | 0.0019 | 0.0022 | 0.0028 |
| M4 | MM10-10010-B90-MD04 F30M | 2,5 | 0,044 | 0,044 | 0,048 | 0,060 |
| | | 0.10 | 0.0017 | 0.0017 | 0.0019 | 0.0026 |
| M5 | MM10-10010-B90-MD04 F30M | 2,5 | 0,044 | 0,044 | 0,048 | 0,060 |
| | | 0.10 | 0.0017 | 0.0017 | 0.0019 | 0.0026 |
| K1 | MM10-10010-B90S-E04 F30M | 4,0 | 0,065 | 0,065 | 0,075 | 0,095 |
| | | 0.16 | 0.0026 | 0.0026 | 0.0030 | 0.0038 |
| K2 | MM10-10010-B90S-E04 F30M | 4,0 | 0,060 | 0,055 | 0,065 | 0,090 |
| | | 0.16 | 0.0024 | 0.0022 | 0.0026 | 0.0036 |
| K3 | MM10-10010-B90S-E04 F30M | 4,0 | 0,060 | 0,055 | 0,065 | 0,090 |
| | | 0.16 | 0.0024 | 0.0022 | 0.0026 | 0.0036 |
| K4 | MM10-10010-B90S-E04 F30M | 4,0 | 0,060 | 0,055 | 0,065 | 0,090 |
| | | 0.16 | 0.0024 | 0.0022 | 0.0026 | 0.0036 |
| K5 | MM10-10010-B90-MD04 F30M | 4,0 | 0,050 | 0,050 | 0,060 | 0,080 |
| | | 0.16 | 0.0020 | 0.0020 | 0.0024 | 0.0032 |
| K6 | MM10-10010-B90-MD04 F30M | 4,0 | 0,060 | 0,055 | 0,065 | 0,090 |
| | | 0.16 | 0.0024 | 0.0022 | 0.0026 | 0.0036 |
| K7 | MM10-10010-B90-MD04 F30M | 4,0 | 0,050 | 0,050 | 0,060 | 0,080 |
| | | 0.16 | 0.0020 | 0.0020 | 0.0024 | 0.0032 |
| N1 | MM10-10010-B90S-E04 F30M | 4,0 | 0,080 | 0,080 | 0,095 | 0,12 |
| | | 0.16 | 0.0032 | 0.0032 | 0.0038 | 0.0048 |
| N2 | MM10-10010-B90S-E04 F30M | 4,0 | 0,080 | 0,080 | 0,095 | 0,12 |
| | | 0.16 | 0.0032 | 0.0032 | 0.0038 | 0.0048 |
| N3 | MM10-10010-B90S-E04 F30M | 4,0 | 0,080 | 0,080 | 0,095 | 0,12 |
| | | 0.16 | 0.0032 | 0.0032 | 0.0038 | 0.0048 |
| N11 | MM10-10010-B90S-E04 F30M | 4,0 | 0,080 | 0,080 | 0,095 | 0,12 |
| | | 0.16 | 0.0032 | 0.0032 | 0.0038 | 0.0048 |
| S1 | MM10-10010-B90S-E04 F30M | 2,5 | 0,044 | 0,044 | 0,048 | 0,060 |
| | | 0.10 | 0.0017 | 0.0017 | 0.0019 | 0.0026 |
| S2 | MM10-10010-B90S-E04 F30M | 2,5 | 0,044 | 0,044 | 0,048 | 0,060 |
| | | 0.10 | 0.0017 | 0.0017 | 0.0019 | 0.0026 |
| S3 | MM10-10010-B90S-E04 F30M | 2,5 | 0,042 | 0,042 | 0,044 | 0,055 |
| | | 0.10 | 0.0017 | 0.0017 | 0.0017 | 0.0024 |
| S11 | MM10-10010-B90S-E04 F30M | 3,0 | 0,048 | 0,048 | 0,055 | 0,070 |
| | | 0.12 | 0.0019 | 0.0019 | 0.0022 | 0.0028 |
| S12 | MM10-10010-B90S-E04 F30M | 3,0 | 0,048 | 0,048 | 0,055 | 0,070 |
| | | 0.12 | 0.0019 | 0.0019 | 0.0022 | 0.0028 |
| S13 | MM10-10010-B90S-E04 F30M | 2,5 | 0,044 | 0,044 | 0,048 | 0,060 |
| | | 0.10 | 0.0017 | 0.0017 | 0.0019 | 0.0026 |
| H5 | MM10-10010-B90-MD04 F30M | 3,5 | 0,040 | 0,040 | 0,046 | 0,060 |
| | | 0.14 | 0.0016 | 0.0016 | 0.0018 | 0.0024 |
| H8 | MM10-10010-B90-MD04 F30M | 3,0 | 0,032 | 0,032 | 0,036 | 0,046 |
| | | 0.12 | 0.0013 | 0.0013 | 0.0014 | 0.0018 |
| H11 | MM10-10010-B90-MD04 F30M | 3,5 | 0,040 | 0,040 | 0,046 | 0,060 |
| | | 0.14 | 0.0016 | 0.0016 | 0.0018 | 0.0024 |
| H12 | MM10-10010-B90-MD04 F30M | 3,0 | 0,032 | 0,032 | 0,036 | 0,046 |
| | | 0.12 | 0.0013 | 0.0013 | 0.0014 | 0.0018 |
| H21 | MM10-10010-B90-MD04 F30M | 3,0 | 0,032 | 0,032 | 0,036 | 0,046 |
| | | 0.12 | 0.0013 | 0.0013 | 0.0014 | 0.0018 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

Univerrsell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MM10 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|---------------------------|----------------|----------------|---------|--------|--------|
| | | | 15% | 10% | 5% | 2% |
| P1 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,040 | 0,048 | 0,065 | 0,11 |
| | | 0,14 | 0,0016 | 0,0019 | 0,0026 | 0,0044 |
| P2 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,042 | 0,048 | 0,070 | 0,11 |
| | | 0,14 | 0,0017 | 0,0019 | 0,0028 | 0,0044 |
| P3 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,038 | 0,046 | 0,065 | 0,10 |
| | | 0,14 | 0,0015 | 0,0018 | 0,0026 | 0,0040 |
| P4 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,038 | 0,046 | 0,065 | 0,10 |
| | | 0,14 | 0,0015 | 0,0018 | 0,0026 | 0,0040 |
| P5 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,038 | 0,044 | 0,060 | 0,10 |
| | | 0,14 | 0,0015 | 0,0017 | 0,0024 | 0,0040 |
| P6 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,038 | 0,044 | 0,060 | 0,095 |
| | | 0,14 | 0,0015 | 0,0017 | 0,0024 | 0,0038 |
| P7 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,038 | 0,044 | 0,060 | 0,095 |
| | | 0,14 | 0,0015 | 0,0017 | 0,0024 | 0,0038 |
| P8 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,038 | 0,046 | 0,065 | 0,10 |
| | | 0,14 | 0,0015 | 0,0018 | 0,0026 | 0,0040 |
| P11 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,038 | 0,044 | 0,060 | 0,095 |
| | | 0,14 | 0,0015 | 0,0017 | 0,0024 | 0,0038 |
| P12 | MM10-10010-B90PF-M02 F15M | 3,0 | 0,026 | 0,030 | 0,042 | 0,065 |
| | | 0,12 | 0,0010 | 0,0012 | 0,0017 | 0,0026 |
| M1 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,042 | 0,048 | 0,070 | 0,11 |
| | | 0,14 | 0,0017 | 0,0019 | 0,0028 | 0,0044 |
| M2 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,038 | 0,044 | 0,060 | 0,10 |
| | | 0,14 | 0,0015 | 0,0017 | 0,0024 | 0,0040 |
| M3 | MM10-10010-B90PF-M02 F15M | 3,0 | 0,030 | 0,036 | 0,048 | 0,075 |
| | | 0,12 | 0,0012 | 0,0014 | 0,0019 | 0,0030 |
| M4 | MM10-10010-B90PF-M02 F15M | 2,0 | 0,028 | 0,030 | 0,042 | 0,070 |
| | | 0,080 | 0,0011 | 0,0013 | 0,0017 | 0,0028 |
| M5 | MM10-10010-B90PF-M02 F15M | 2,0 | 0,028 | 0,030 | 0,042 | 0,070 |
| | | 0,080 | 0,0011 | 0,0013 | 0,0017 | 0,0028 |
| K1 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,042 | 0,048 | 0,070 | 0,11 |
| | | 0,14 | 0,0017 | 0,0019 | 0,0028 | 0,0044 |
| K2 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,038 | 0,044 | 0,060 | 0,10 |
| | | 0,14 | 0,0015 | 0,0017 | 0,0024 | 0,0040 |
| K3 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,038 | 0,044 | 0,060 | 0,10 |
| | | 0,14 | 0,0015 | 0,0017 | 0,0024 | 0,0040 |
| K4 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,038 | 0,044 | 0,060 | 0,10 |
| | | 0,14 | 0,0015 | 0,0017 | 0,0024 | 0,0040 |
| K5 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,034 | 0,040 | 0,055 | 0,085 |
| | | 0,14 | 0,0013 | 0,0016 | 0,0022 | 0,0034 |
| K6 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,038 | 0,044 | 0,060 | 0,10 |
| | | 0,14 | 0,0015 | 0,0017 | 0,0024 | 0,0040 |
| K7 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,034 | 0,040 | 0,055 | 0,085 |
| | | 0,14 | 0,0013 | 0,0016 | 0,0022 | 0,0034 |
| N1 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,050 | 0,060 | 0,085 | 0,14 |
| | | 0,14 | 0,0020 | 0,0024 | 0,0034 | 0,0055 |
| N2 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,050 | 0,060 | 0,085 | 0,14 |
| | | 0,14 | 0,0020 | 0,0024 | 0,0034 | 0,0055 |
| N3 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,050 | 0,060 | 0,085 | 0,14 |
| | | 0,14 | 0,0020 | 0,0024 | 0,0034 | 0,0055 |
| N11 | MM10-10010-B90PF-M02 F15M | 3,5 | 0,050 | 0,060 | 0,085 | 0,14 |
| | | 0,14 | 0,0020 | 0,0024 | 0,0034 | 0,0055 |
| S1 | MM10-10010-B90PF-M02 F15M | 2,0 | 0,028 | 0,030 | 0,042 | 0,070 |
| | | 0,080 | 0,0011 | 0,0013 | 0,0017 | 0,0028 |
| S2 | MM10-10010-B90PF-M02 F15M | 2,0 | 0,028 | 0,030 | 0,042 | 0,070 |
| | | 0,080 | 0,0011 | 0,0013 | 0,0017 | 0,0028 |
| S3 | MM10-10010-B90PF-M02 F15M | 2,0 | 0,025 | 0,028 | 0,040 | 0,065 |
| | | 0,080 | 0,0010 | 0,0012 | 0,0016 | 0,0026 |
| S11 | MM10-10010-B90PF-M02 F15M | 2,5 | 0,030 | 0,036 | 0,048 | 0,075 |
| | | 0,10 | 0,0012 | 0,0014 | 0,0019 | 0,0030 |
| S12 | MM10-10010-B90PF-M02 F15M | 2,5 | 0,030 | 0,036 | 0,048 | 0,075 |
| | | 0,10 | 0,0012 | 0,0014 | 0,0019 | 0,0030 |
| S13 | MM10-10010-B90PF-M02 F15M | 2,0 | 0,028 | 0,030 | 0,042 | 0,070 |
| | | 0,080 | 0,0011 | 0,0013 | 0,0017 | 0,0028 |
| H5 | MM10-10010-B90PF-M02 F15M | 3,0 | 0,026 | 0,030 | 0,042 | 0,065 |
| | | 0,12 | 0,0010 | 0,0012 | 0,0017 | 0,0026 |
| H8 | MM10-10010-B90PF-M02 F15M | 2,5 | 0,020 | 0,022 | 0,032 | 0,050 |
| | | 0,10 | 0,00080 | 0,00095 | 0,0013 | 0,0020 |
| H11 | MM10-10010-B90PF-M02 F15M | 3,0 | 0,026 | 0,030 | 0,042 | 0,065 |
| | | 0,12 | 0,0010 | 0,0012 | 0,0017 | 0,0026 |
| H12 | MM10-10010-B90PF-M02 F15M | 2,5 | 0,020 | 0,022 | 0,032 | 0,050 |
| | | 0,10 | 0,00080 | 0,00095 | 0,0013 | 0,0020 |
| H21 | MM10-10010-B90PF-M02 F15M | 2,5 | 0,020 | 0,022 | 0,032 | 0,050 |
| | | 0,10 | 0,00080 | 0,00095 | 0,0013 | 0,0020 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MM10 Z2 – Kopierfräser – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | F15M | | | | | F30M | | | | | T60M | | | | |
|-----|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|
| | 100% | 20% | 10% | 5% | 2% | 100% | 20% | 10% | 5% | 2% | 100% | 20% | 10% | 5% | 2% |
| P1 | 305 | 390 | 405 | 440 | 440 | 250 | 320 | 340 | 370 | 365 | 205 | 260 | 275 | 300 | 295 |
| | 1000 | 1275 | 1325 | 1450 | 1450 | 820 | 1050 | 1125 | 1225 | 1200 | 670 | 850 | 900 | 980 | 970 |
| P2 | 295 | 380 | 395 | 425 | 425 | 240 | 305 | 330 | 355 | 355 | 195 | 250 | 270 | 285 | 285 |
| | 970 | 1250 | 1300 | 1400 | 1400 | 790 | 1000 | 1075 | 1175 | 1175 | 640 | 820 | 890 | 940 | 940 |
| P3 | 260 | 330 | 340 | 370 | 370 | 210 | 265 | 285 | 310 | 310 | 170 | 215 | 235 | 250 | 250 |
| | 850 | 1075 | 1125 | 1225 | 1225 | 690 | 870 | 940 | 1025 | 1025 | 560 | 710 | 770 | 820 | 820 |
| P4 | 225 | 290 | 300 | 325 | 325 | 185 | 235 | 255 | 270 | 275 | 150 | 190 | 205 | 220 | 220 |
| | 740 | 950 | 980 | 1075 | 1075 | 610 | 770 | 840 | 890 | 900 | 490 | 620 | 670 | 720 | 720 |
| P5 | 215 | 275 | 290 | 315 | 310 | 175 | 225 | 240 | 265 | 260 | 145 | 185 | 195 | 215 | 210 |
| | 710 | 900 | 950 | 1025 | 1025 | 570 | 740 | 790 | 870 | 850 | 475 | 610 | 640 | 710 | 690 |
| P6 | 245 | 310 | 325 | 350 | 350 | 200 | 255 | 275 | 295 | 295 | 165 | 205 | 220 | 240 | 235 |
| | 800 | 1025 | 1075 | 1150 | 1150 | 660 | 840 | 900 | 970 | 970 | 540 | 670 | 720 | 790 | 770 |
| P7 | 230 | 295 | 305 | 330 | 330 | 190 | 240 | 260 | 280 | 275 | 155 | 195 | 210 | 225 | 225 |
| | 750 | 970 | 1000 | 1075 | 1075 | 620 | 790 | 850 | 920 | 900 | 510 | 640 | 690 | 740 | 740 |
| P8 | 215 | 275 | 290 | 310 | 310 | 175 | 225 | 240 | 260 | 260 | 145 | 180 | 195 | 210 | 210 |
| | 710 | 900 | 950 | 1025 | 1025 | 570 | 740 | 790 | 850 | 850 | 475 | 590 | 640 | 690 | 690 |
| P11 | 225 | 285 | 295 | 325 | 320 | 185 | 235 | 250 | 270 | 270 | 150 | 190 | 205 | 220 | 215 |
| | 740 | 940 | 970 | 1075 | 1050 | 610 | 770 | 820 | 890 | 890 | 490 | 620 | 670 | 720 | 710 |
| P12 | 140 | 175 | 180 | 195 | 195 | 120 | 150 | 155 | 170 | 170 | 95 | 120 | 125 | 135 | 135 |
| | 460 | 570 | 610 | 640 | 640 | 395 | 490 | 510 | 560 | 560 | 310 | 395 | 410 | 445 | 445 |
| M1 | 240 | 305 | 320 | 345 | 345 | 195 | 245 | 265 | 285 | 285 | 160 | 200 | 215 | 230 | 230 |
| | 790 | 1000 | 1050 | 1125 | 1125 | 640 | 800 | 870 | 940 | 940 | 520 | 660 | 710 | 750 | 750 |
| M2 | 195 | 250 | 260 | 280 | 280 | 160 | 205 | 215 | 235 | 235 | 130 | 165 | 175 | 190 | 190 |
| | 640 | 820 | 850 | 920 | 920 | 520 | 670 | 710 | 770 | 770 | 425 | 540 | 570 | 620 | 620 |
| M3 | 155 | 200 | 200 | 220 | 220 | 130 | 165 | 175 | 185 | 185 | 105 | 135 | 140 | 150 | 150 |
| | 510 | 660 | 670 | 720 | 720 | 425 | 540 | 570 | 610 | 610 | 345 | 445 | 460 | 490 | 490 |
| M4 | 120 | 155 | 155 | 165 | 165 | 105 | 135 | 130 | 145 | 140 | 85 | 105 | 105 | 115 | 115 |
| | 395 | 510 | 560 | 540 | 540 | 345 | 445 | 460 | 475 | 460 | 280 | 345 | 375 | 375 | 375 |
| M5 | 100 | 130 | 130 | 140 | 140 | 85 | 110 | 110 | 120 | 120 | 70 | 90 | 90 | 95 | 95 |
| | 330 | 425 | 460 | 460 | 460 | 280 | 360 | 375 | 395 | 395 | 230 | 295 | 310 | 310 | 310 |
| K1 | 235 | 300 | 315 | 335 | 335 | 190 | 245 | 260 | 280 | 280 | 155 | 195 | 210 | 225 | 225 |
| | 770 | 980 | 1025 | 1100 | 1100 | 620 | 800 | 850 | 920 | 920 | 510 | 640 | 690 | 740 | 740 |
| K2 | 205 | 265 | 275 | 295 | 295 | 170 | 215 | 230 | 250 | 250 | 135 | 175 | 185 | 200 | 200 |
| | 670 | 870 | 900 | 970 | 970 | 560 | 710 | 750 | 820 | 820 | 445 | 570 | 610 | 660 | 660 |
| K3 | 175 | 225 | 230 | 250 | 250 | 140 | 180 | 195 | 210 | 210 | 115 | 150 | 155 | 170 | 170 |
| | 570 | 740 | 750 | 820 | 820 | 460 | 590 | 640 | 690 | 690 | 375 | 490 | 510 | 560 | 560 |
| K4 | 165 | 215 | 220 | 240 | 240 | 135 | 175 | 185 | 200 | 200 | 110 | 140 | 150 | 165 | 160 |
| | 540 | 710 | 720 | 790 | 790 | 445 | 570 | 610 | 660 | 660 | 360 | 460 | 490 | 540 | 520 |
| K5 | 100 | 130 | 135 | 145 | 145 | 85 | 105 | 110 | 120 | 120 | 70 | 85 | 90 | 100 | 100 |
| | 330 | 425 | 445 | 475 | 475 | 280 | 345 | 360 | 395 | 395 | 230 | 280 | 295 | 330 | 330 |
| K6 | 145 | 185 | 195 | 210 | 210 | 120 | 155 | 165 | 180 | 175 | 95 | 125 | 130 | 145 | 145 |
| | 475 | 610 | 640 | 690 | 690 | 395 | 510 | 540 | 590 | 570 | 310 | 410 | 425 | 475 | 475 |
| K7 | 130 | 165 | 170 | 185 | 185 | 105 | 135 | 145 | 155 | 155 | 85 | 110 | 115 | 125 | 125 |
| | 425 | 540 | 560 | 610 | 610 | 345 | 445 | 475 | 510 | 510 | 280 | 360 | 375 | 410 | 410 |
| N1 | 1800 | 2300 | 2425 | 2600 | 2600 | 1450 | 1825 | 1975 | 2150 | 2100 | 1175 | 1475 | 1600 | 1725 | 1700 |
| | 5900 | 7550 | 7950 | 8525 | 8525 | 4750 | 6000 | 6475 | 7050 | 6900 | 3850 | 4850 | 5250 | 5650 | 5575 |
| N2 | 730 | 930 | 970 | 1050 | 1050 | 590 | 740 | 800 | 870 | 850 | 475 | 600 | 650 | 700 | 680 |
| | 2400 | 3050 | 3175 | 3450 | 3450 | 1925 | 2425 | 2625 | 2850 | 2800 | 1550 | 1975 | 2125 | 2300 | 2225 |
| N3 | 485 | 620 | 650 | 700 | 700 | 390 | 495 | 530 | 580 | 560 | 315 | 400 | 435 | 465 | 455 |
| | 1600 | 2025 | 2125 | 2300 | 2300 | 1275 | 1625 | 1750 | 1900 | 1825 | 1025 | 1300 | 1425 | 1525 | 1500 |
| N11 | 550 | 710 | 740 | 800 | 800 | 450 | 570 | 610 | 660 | 640 | 360 | 460 | 495 | 530 | 520 |
| | 1800 | 2325 | 2425 | 2625 | 2625 | 1475 | 1875 | 2000 | 2175 | 2100 | 1175 | 1500 | 1625 | 1750 | 1700 |
| S1 | 55 | 70 | 70 | 80 | 75 | 48 | 60 | 60 | 65 | 65 | 39 | 50 | 50 | 55 | 55 |
| | 180 | 230 | 260 | 260 | 245 | 155 | 195 | 215 | 215 | 215 | 130 | 165 | 180 | 180 | 180 |
| S2 | 46 | 60 | 60 | 65 | 60 | 39 | 50 | 50 | 55 | 55 | 32 | 40 | 40 | 43 | 43 |
| | 150 | 195 | 215 | 215 | 195 | 130 | 165 | 180 | 180 | 180 | 105 | 130 | 140 | 140 | 140 |
| S3 | 40 | 50 | 50 | 55 | 55 | 34 | 43 | 43 | 47 | 46 | 27 | 35 | 35 | 38 | 38 |
| | 130 | 165 | 180 | 180 | 180 | 110 | 140 | 150 | 155 | 150 | 90 | 115 | 120 | 125 | 125 |
| S11 | 80 | 100 | 100 | 110 | 110 | 65 | 85 | 85 | 95 | 95 | 55 | 70 | 70 | 75 | 75 |
| | 260 | 330 | 360 | 360 | 360 | 215 | 280 | 295 | 310 | 310 | 180 | 230 | 245 | 245 | 245 |
| S12 | 55 | 70 | 70 | 75 | 75 | 47 | 60 | 60 | 65 | 65 | 38 | 48 | 49 | 55 | 55 |
| | 180 | 230 | 245 | 245 | 245 | 155 | 195 | 195 | 215 | 215 | 125 | 155 | 165 | 180 | 180 |
| S13 | 32 | 41 | 40 | 44 | 43 | 27 | 35 | 35 | 37 | 37 | 22 | 28 | 28 | 30 | 30 |
| | 105 | 135 | 145 | 145 | 140 | 90 | 115 | 120 | 120 | 120 | 70 | 90 | 100 | 100 | 100 |
| H5 | 46 | 60 | 60 | 65 | 65 | 39 | 50 | 50 | 55 | 55 | 32 | 41 | 42 | 45 | 45 |
| | 150 | 195 | 195 | 215 | 215 | 130 | 165 | 165 | 180 | 180 | 105 | 135 | 140 | 150 | 150 |
| H8 | 48 | 60 | 60 | 65 | 65 | 41 | 55 | 55 | 60 | 60 | 33 | 43 | 43 | 47 | 47 |
| | 155 | 195 | 215 | 215 | 215 | 135 | 180 | 180 | 195 | 195 | 110 | 140 | 150 | 155 | 155 |
| H11 | 60 | 75 | 75 | 85 | 85 | 50 | 65 | 65 | 70 | 70 | 40 | 50 | 55 | 60 | 60 |
| | 195 | 245 | 260 | 280 | 280 | 165 | 215 | 215 | 230 | 230 | 130 | 165 | 180 | 195 | 195 |
| H12 | 85 | 110 | 110 | 120 | 120 | 75 | 95 | 95 | 105 | 105 | 60 | 75 | 80 | 85 | 85 |
| | 280 | 360 | 375 | 395 | 395 | 245 | 310 | 330 | 345 | 345 | 195 | 245 | 260 | 280 | 280 |
| H21 | 48 | 60 | 60 | 65 | 65 | 41 | 55 | 55 | 60 | 60 | 33 | 43 | 43 | 47 | 47 |
| | 155 | 195 | 215 | 215 | 215 | 135 | 180 | 180 | 195 | 195 | 110 | 140 | 150 | 155 | 155 |

Univerrsell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MM10 Hohe Vorschübe - Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | | |
|---------------------------|----------------|-------------------------|-------------------------|----------------|----------------|---------------|---------------|
| | | | 100% | 70% | 30% | 20% | |
| Universell | P1 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,48 0.019 | 0,48 0.019 | 0,65 0.026 | 0,80 0.032 |
| | P2 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,50 0.020 | 0,50 0.020 | 0,65 0.026 | 0,80 0.032 |
| | P3 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,46 0.018 | 0,46 0.018 | 0,60 0.024 | 0,75 0.030 |
| | | | 0,30 0.012 | 0,46 0.018 | 0,46 0.018 | 0,60 0.024 | 0,75 0.030 |
| | P4 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,44 0.017 | 0,44 0.017 | 0,60 0.024 | 0,75 0.030 |
| | P5 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,44 0.017 | 0,44 0.017 | 0,60 0.024 | 0,75 0.030 |
| | P6 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,44 0.017 | 0,44 0.017 | 0,60 0.024 | 0,75 0.030 |
| | P7 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,44 0.017 | 0,44 0.017 | 0,60 0.024 | 0,75 0.030 |
| | P8 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,46 0.018 | 0,46 0.018 | 0,60 0.024 | 0,75 0.030 |
| | P11 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,44 0.017 | 0,44 0.017 | 0,60 0.024 | 0,75 0.030 |
| | P12 | MM10-10.50-HF-MD08 F30M | 0,25 0.010 | 0,30 0.012 | 0,30 0.012 | 0,40 0.016 | 0,48 0.019 |
| | Stahl und Guss | M1 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,50 0.020 | 0,50 0.020 | 0,65 0.026 |
| M2 | | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,44 0.017 | 0,46 0.018 | 0,60 0.024 | 0,75 0.030 |
| M3 | | MM10-10.50-HF-MD08 F30M | 0,25 0.010 | 0,36 0.014 | 0,36 0.014 | 0,46 0.018 | 0,55 0.022 |
| M4 | | MM10-10.50-HF-MD08 F30M | 0,18 0.0070 | 0,32 0.013 | 0,32 0.013 | 0,40 0.016 | 0,50 0.020 |
| M5 | | MM10-10.50-HF-MD08 F30M | 0,18 0.0070 | 0,32 0.013 | 0,32 0.013 | 0,40 0.016 | 0,50 0.020 |
| NE-Metalle | K1 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,50 0.020 | 0,50 0.020 | 0,65 0.026 | 0,80 0.032 |
| | K2 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,44 0.017 | 0,46 0.018 | 0,60 0.024 | 0,75 0.030 |
| | K3 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,44 0.017 | 0,46 0.018 | 0,60 0.024 | 0,75 0.030 |
| | K4 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,44 0.017 | 0,46 0.018 | 0,60 0.024 | 0,75 0.030 |
| | K5 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,40 0.016 | 0,40 0.016 | 0,55 0.022 | 0,65 0.026 |
| | K6 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,44 0.017 | 0,46 0.018 | 0,60 0.024 | 0,75 0.030 |
| | K7 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,40 0.016 | 0,40 0.016 | 0,55 0.022 | 0,65 0.026 |
| Harter | N1 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,65 0.026 | 0,65 0.026 | 0,85 0.034 | 1,1 0.044 |
| | N2 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,65 0.026 | 0,65 0.026 | 0,85 0.034 | 1,1 0.044 |
| | N3 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,65 0.026 | 0,65 0.026 | 0,85 0.034 | 1,1 0.044 |
| | N11 | MM10-10.50-HF-MD08 F30M | 0,30 0.012 | 0,65 0.026 | 0,65 0.026 | 0,85 0.034 | 1,1 0.044 |
| | S1 | MM10-10.50-HF-MD08 F30M | 0,18 0.0070 | 0,32 0.013 | 0,32 0.013 | 0,40 0.016 | 0,50 0.020 |
| Kunststoffe und Composite | S2 | MM10-10.50-HF-MD08 F30M | 0,18 0.0070 | 0,32 0.013 | 0,32 0.013 | 0,40 0.016 | 0,50 0.020 |
| | S3 | MM10-10.50-HF-MD08 F30M | 0,18 0.0070 | 0,30 0.012 | 0,30 0.012 | 0,38 0.015 | 0,46 0.018 |
| | S11 | MM10-10.50-HF-MD08 F30M | 0,22 0.0085 | 0,36 0.014 | 0,36 0.014 | 0,46 0.018 | 0,55 0.022 |
| | S12 | MM10-10.50-HF-MD08 F30M | 0,22 0.0085 | 0,36 0.014 | 0,36 0.014 | 0,46 0.018 | 0,55 0.022 |
| | S13 | MM10-10.50-HF-MD08 F30M | 0,18 0.0070 | 0,32 0.013 | 0,32 0.013 | 0,40 0.016 | 0,50 0.020 |
| | S12 | MM10-10.50-HF-MD08 F30M | 0,22 0.0085 | 0,36 0.014 | 0,36 0.014 | 0,46 0.018 | 0,55 0.022 |
| Graphit | H5 | MM10-10.50-HF-MD08 F15M | 0,25 0.010 | 0,30 0.012 | 0,30 0.012 | 0,40 0.016 | 0,48 0.019 |
| | H8 | MM10-10.50-HF-MD08 F15M | 0,22 0.0085 | 0,24 0.0095 | 0,24 0.0095 | 0,30 0.012 | 0,36 0.014 |
| | H11 | MM10-10.50-HF-MD08 F15M | 0,25 0.010 | 0,30 0.012 | 0,30 0.012 | 0,40 0.016 | 0,48 0.019 |
| | H12 | MM10-10.50-HF-MD08 F15M | 0,22 0.0085 | 0,24 0.0095 | 0,24 0.0095 | 0,30 0.012 | 0,36 0.014 |
| X-Heads | H21 | MM10-10.50-HF-MD08 F15M | 0,22 0.0085 | 0,24 0.0095 | 0,24 0.0095 | 0,30 0.012 | 0,36 0.014 |
| | H11 | MM10-10.50-HF-MD08 F15M | 0,25 0.010 | 0,30 0.012 | 0,30 0.012 | 0,40 0.016 | 0,48 0.019 |
| | H12 | MM10-10.50-HF-MD08 F15M | 0,22 0.0085 | 0,24 0.0095 | 0,24 0.0095 | 0,30 0.012 | 0,36 0.014 |
| Minimaster Plus | H21 | MM10-10.50-HF-MD08 F15M | 0,22 0.0085 | 0,24 0.0095 | 0,24 0.0095 | 0,30 0.012 | 0,36 0.014 |
| | H11 | MM10-10.50-HF-MD08 F15M | 0,25 0.010 | 0,30 0.012 | 0,30 0.012 | 0,40 0.016 | 0,48 0.019 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MM10 Hohe Vorschübe Schnittdaten $v_c = (m/min)/(sf/min)$

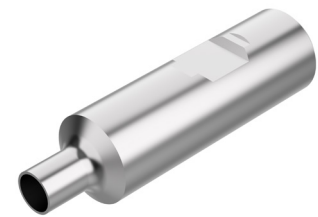
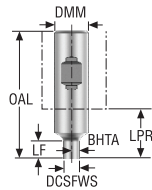
| SMG | F15M | | | | F30M | | | |
|-----|------|-----|-----|-----|------|------|------|------|
| | 100% | 70% | 30% | 20% | 100% | 70% | 30% | 20% |
| P1 | — | — | — | — | 230 | 280 | 325 | 340 |
| | — | — | — | — | 750 | 920 | 1075 | 1125 |
| P2 | — | — | — | — | 225 | 270 | 315 | 330 |
| | — | — | — | — | 740 | 890 | 1025 | 1075 |
| P3 | — | — | — | — | 195 | 240 | 275 | 290 |
| | — | — | — | — | 640 | 790 | 900 | 950 |
| P4 | — | — | — | — | 170 | 210 | 240 | 255 |
| | — | — | — | — | 560 | 690 | 790 | 840 |
| P5 | — | — | — | — | 165 | 200 | 230 | 240 |
| | — | — | — | — | 540 | 660 | 750 | 790 |
| P6 | — | — | — | — | 185 | 225 | 260 | 270 |
| | — | — | — | — | 610 | 740 | 850 | 890 |
| P7 | — | — | — | — | 175 | 215 | 245 | 255 |
| | — | — | — | — | 570 | 710 | 800 | 840 |
| P8 | — | — | — | — | 165 | 200 | 230 | 240 |
| | — | — | — | — | 540 | 660 | 750 | 790 |
| P11 | — | — | — | — | 170 | 210 | 240 | 250 |
| | — | — | — | — | 560 | 690 | 790 | 820 |
| P12 | — | — | — | — | 110 | 135 | 150 | 160 |
| | — | — | — | — | 360 | 445 | 490 | 520 |
| M1 | — | — | — | — | 180 | 220 | 255 | 265 |
| | — | — | — | — | 590 | 720 | 840 | 870 |
| M2 | — | — | — | — | 150 | 180 | 210 | 220 |
| | — | — | — | — | 490 | 590 | 690 | 720 |
| M3 | — | — | — | — | 120 | 145 | 165 | 175 |
| | — | — | — | — | 395 | 475 | 540 | 570 |
| M4 | — | — | — | — | 95 | 110 | 130 | 135 |
| | — | — | — | — | 310 | 360 | 425 | 445 |
| M5 | — | — | — | — | 80 | 95 | 110 | 115 |
| | — | — | — | — | 260 | 310 | 360 | 375 |
| K1 | 190 | 230 | 270 | 280 | 175 | 215 | 250 | 260 |
| | 620 | 750 | 890 | 920 | 570 | 710 | 820 | 850 |
| K2 | 170 | 205 | 235 | 245 | 160 | 190 | 220 | 230 |
| | 560 | 670 | 770 | 800 | 520 | 620 | 720 | 750 |
| K3 | 145 | 175 | 200 | 210 | 135 | 160 | 185 | 195 |
| | 475 | 570 | 660 | 690 | 445 | 520 | 610 | 640 |
| K4 | 135 | 165 | 190 | 200 | 125 | 155 | 175 | 185 |
| | 445 | 540 | 620 | 660 | 410 | 510 | 570 | 610 |
| K5 | 85 | 100 | 115 | 125 | 75 | 95 | 105 | 115 |
| | 280 | 330 | 375 | 410 | 245 | 310 | 345 | 375 |
| K6 | 120 | 145 | 170 | 175 | 110 | 135 | 155 | 165 |
| | 395 | 475 | 560 | 570 | 360 | 445 | 510 | 540 |
| K7 | 105 | 130 | 150 | 155 | 100 | 120 | 140 | 145 |
| | 345 | 425 | 490 | 510 | 330 | 395 | 460 | 475 |
| N1 | — | — | — | — | 1325 | 1600 | 1850 | 1925 |
| | — | — | — | — | 4350 | 5250 | 6075 | 6325 |
| N2 | — | — | — | — | 530 | 650 | 750 | 780 |
| | — | — | — | — | 1750 | 2125 | 2450 | 2550 |
| N3 | — | — | — | — | 355 | 430 | 500 | 520 |
| | — | — | — | — | 1175 | 1400 | 1650 | 1700 |
| N11 | — | — | — | — | 405 | 495 | 570 | 590 |
| | — | — | — | — | 1325 | 1625 | 1875 | 1925 |
| S1 | — | — | — | — | 45 | 50 | 60 | 65 |
| | — | — | — | — | 150 | 165 | 195 | 215 |
| S2 | — | — | — | — | 36 | 42 | 49 | 50 |
| | — | — | — | — | 120 | 140 | 160 | 165 |
| S3 | — | — | — | — | 31 | 37 | 42 | 45 |
| | — | — | — | — | 100 | 120 | 140 | 150 |
| S11 | — | — | — | — | 60 | 75 | 85 | 90 |
| | — | — | — | — | 195 | 245 | 280 | 295 |
| S12 | — | — | — | — | 43 | 50 | 60 | 60 |
| | — | — | — | — | 140 | 165 | 195 | 195 |
| S13 | — | — | — | — | 25 | 29 | 34 | 36 |
| | — | — | — | — | 80 | 95 | 110 | 120 |
| H5 | 40 | 48 | 55 | 60 | 37 | 44 | 50 | 55 |
| | 130 | 155 | 180 | 195 | 120 | 145 | 165 | 180 |
| H8 | 42 | 50 | 55 | 60 | 39 | 46 | 55 | 55 |
| | 140 | 165 | 180 | 195 | 130 | 150 | 180 | 180 |
| H11 | 50 | 60 | 70 | 75 | 47 | 55 | 65 | 70 |
| | 165 | 195 | 230 | 245 | 155 | 180 | 215 | 230 |
| H12 | 75 | 90 | 105 | 110 | 70 | 85 | 95 | 100 |
| | 245 | 295 | 345 | 360 | 230 | 280 | 310 | 330 |
| H21 | 42 | 50 | 55 | 60 | 39 | 46 | 55 | 55 |
| | 140 | 165 | 180 | 195 | 130 | 150 | 180 | 180 |

Universell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

Schaftkonstruktion

| | | |
|-------------------------------|---|---|
| Universell | Ausführung 1, Keilnut-Schaft | Ausführung 2, Zylindrische/Weldon Schnittstelle und 90° Stirnseite |
| Stahl und Guss | | |
| Rostfrei und ISO-S-Werkstoffe | Ausführung 3, Zylindrische/Weldon Schnittstelle und 87°/89° Stirnseite | Konstruktion 4, Zylindrische/Weldon Schnittstelle und 80°/85°/87° Stirnseite |
| NE-Metalle | | |
| Harter | Ausführung 5, Zylindrische Schnittstelle und doppelt konische Stirnseite 89°/85° | |
| Kunststoffe und Composite | | |
| Graphit | | |
| X-Heads | | |
| Minimaster Plus | | |

MM12 Schaft



| Bezeichnung | Produkt- nummer | Aufnahme | DCSFWS | DMM | OAL | LF | LPR | BHTA° | Abb. | | RPMX | Gewicht | Ersatzteil Bezeichnung |
|---------------------|--------------------|-------------|--------|------|-------|------|-------|-------|------|---|-------|---------|---------------------------|
| | | | mm | mm | mm | mm | mm | | | | | kg | |
| MM12-20080.3-0012 | 75012864 | Weldon | 11,4 | 20,0 | 80,0 | 12,0 | 30,0 | 0,0 | 2 | ✓ | 80000 | 0,2 | 4 |
| MM12-20095.3-3027 | 75012865 | Weldon | 11,4 | 20,0 | 95,0 | 27,0 | 45,0 | 3,0 | 3 | ✓ | 80000 | 0,2 | 4 |
| MM12-20150.3-5049 | 75012866 | Weldon | 11,4 | 20,0 | 150,0 | 49,1 | 100,0 | 5,0 | 4 | ✓ | 80000 | 0,3 | 5 |
| MM12-12055.0-0008 | 00083978 | Zylindrisch | 11,5 | 12,0 | 55,0 | 8,5 | 10,0 | 0,0 | 2 | ✓ | 80000 | 0,1 | 2 |
| MM12-16065.0-0000 | 75004926 | Zylindrisch | 11,4 | 16,0 | 65,0 | 0,0 | 17,0 | 60,0 | 1 | ✓ | 80000 | 0,1 | 1 |
| MM12-16170.0-1040 | 75034505 | Zylindrisch | 11,4 | 16,0 | 170,0 | 40,0 | 122,0 | 1,0 | 3 | ✓ | 80000 | 0,2 | 5 |
| MM12-16170.0-1060 | 75034506 | Zylindrisch | 11,4 | 16,0 | 170,0 | 60,0 | 122,0 | 1,0 | 3 | ✓ | 80000 | 0,2 | 5 |
| MM12-16170.0-1080 | 75034507 | Zylindrisch | 11,4 | 16,0 | 170,0 | 80,0 | 122,0 | 1,0 | 3 | ✓ | 80000 | 0,2 | 5 |
| MM12-12070.0-0008DS | 02580668 | Zylindrisch | 11,5 | 12,0 | 70,0 | 8,5 | 25,0 | 0,0 | 2 | ✓ | 63600 | 0,1 | 3 |
| MM12-16095.0-0024DS | 02580690 | Zylindrisch | 11,4 | 16,0 | 95,0 | 24,0 | 47,0 | 0,0 | 2 | ✓ | 63600 | 0,3 | 3 |
| MM12-16090.0-3044DS | 02580705 | Zylindrisch | 11,4 | 16,0 | 90,0 | 43,9 | 42,0 | 3,0 | 4 | ✓ | 63600 | 0,3 | 3 |
| MM12-16120.0-1045DS | 02580752 | Zylindrisch | 11,4 | 16,0 | 120,0 | 45,0 | 72,0 | 1,0 | 3 | ✓ | 63600 | 0,3 | 3 |
| MM12-16115.0-0048DS | 02580691 | Zylindrisch | 11,4 | 16,0 | 115,0 | 48,0 | 67,0 | 0,0 | 2 | ✓ | 63600 | 0,3 | 3 |
| MM12-16170.0-1060DS | 02580753 | Zylindrisch | 11,4 | 16,0 | 170,0 | 60,0 | 122,0 | 1,0 | 3 | ✓ | 63600 | 0,5 | 3 |
| MM12-16170.0-1080DS | 02580755 | Zylindrisch | 11,4 | 16,0 | 170,0 | 80,0 | 122,0 | 1,0 | 3 | ✓ | 63600 | 0,5 | 3 |
| MM12-20250.0-1060DS | 02580756 | Zylindrisch | 11,4 | 20,0 | 250,0 | 60,0 | 200,0 | 1,0 | 5 | ✓ | 63600 | 1,0 | 3 |

Ersatzteile, im Lieferumfang enthalten

Zubehör

| Für Fräser | Hülse | Spannschraube | Schlüssel |
|------------|--------------|---------------|-----------|
| 4 | MM-06048 | MM12-0637 | – |
| 5 | MM-06116 | MM12-0637 | – |
| 2 | MM-06020 | MM12-0637 | H05-4 |
| 1 | MM-06032 | MM12-0637 | – |
| 3 | – | MM12-061037 | – |

Universell

Stahl und Guss

Rostfrei und
ISO-S-Werkstoffe

Rostfrei und
ISO-S-Werkstoffe

NE-Metalle

Harter

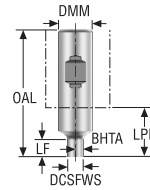
Graphit

X-Heads

Minimaster Plus

Minimaster

MM12 Schaft – Zoll



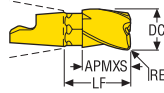
| Bezeichnung | Produkt- nummer | Aufnahme | | | | | | Abb. | RPMX | Gewicht | Ersatzteil Bezeichnung | | |
|-------------------------|--------------------|-------------|--------|-------|-------|-------|-------|------|------|---------|---------------------------|-------|---|
| | | | DCSFMS | DMM | OAL | LF | LPR | | | | | | |
| | | | Zoll | Zoll | Zoll | Zoll | Zoll | | | | | | |
| MM12-0.75-3.1-3-0004 | 75015055 | Weldon | 0.449 | 0.750 | 3.150 | 0.472 | 1.181 | 0,0 | 2 | ✓ | 80000 | 0.440 | 3 |
| MM12-0.75-3.7-3-3010 | 75015056 | Weldon | 0.449 | 0.750 | 3.740 | 1.063 | 1.772 | 3,0 | 3 | ✓ | 80000 | 0.440 | 3 |
| MM12-0.75-5.9-3-5017 | 75015057 | Weldon | 0.449 | 0.750 | 5.906 | 1.720 | 3.937 | 5,0 | 4 | ✓ | 80000 | 0.660 | 5 |
| MM12-0.50-2.2-0-0003 | 00096133 | Zylindrisch | 0.453 | 0.500 | 2.165 | 0.335 | 0.394 | 0,0 | 2 | ✓ | 80000 | 0.220 | 2 |
| MM12-0.62-2.6-0-0000 | 75005070 | Zylindrisch | 0.449 | 0.625 | 2.559 | 0 | 0.669 | 60,0 | 1 | ✓ | 80000 | 0.220 | 1 |
| MM12-0.62-6.7-0-1015 | 75054728 | Zylindrisch | 0.449 | 0.625 | 6.693 | 1.575 | 4.803 | 1,0 | 3 | ✓ | 80000 | 0.440 | 5 |
| MM12-0.62-6.7-0-1023 | 75054729 | Zylindrisch | 0.449 | 0.625 | 6.693 | 2.362 | 4.803 | 1,0 | 3 | ✓ | 80000 | 0.440 | 5 |
| MM12-0.62-6.7-0-1023DS | 02593423 | Zylindrisch | 0.449 | 0.625 | 6.693 | 2.362 | 4.803 | 1,0 | 3 | ✓ | 63600 | 1.100 | 4 |
| MM12-0.62-6.7-0-1031DS | 02593426 | Zylindrisch | 0.449 | 0.625 | 6.693 | 3.150 | 4.803 | 1,0 | 3 | ✓ | 63600 | 0.880 | 4 |
| MM12-0.75-10.0-0-1023DS | 02593427 | Zylindrisch | 0.449 | 0.750 | 9.843 | 2.362 | 7.874 | 1,0 | 5 | ✓ | 63600 | 1.980 | 4 |
| MM12-0.75-3.8-0-0009DS | 02593428 | Zylindrisch | 0.449 | 0.750 | 3.740 | 0.945 | 1.772 | 0,0 | 2 | ✓ | 63600 | 0.880 | 4 |
| MM12-0.75-4.5-0-0018DS | 02593430 | Zylindrisch | 0.449 | 0.750 | 4.528 | 1.890 | 2.559 | 0,0 | 2 | ✓ | 63600 | 0.880 | 4 |

Ersatzteile, im Lieferumfang enthalten

Zubehör

| Für Fräser | Hülse | Spannschraube | Schlüssel |
|------------|----------|---------------|-----------|
| 3 | MM-06048 | MM12-0637 | - |
| 5 | MM-06116 | MM12-0637 | - |
| 2 | MM-06020 | MM12-0637 | H05-4 |
| 1 | MM-06032 | MM12-0637 | - |
| 4 | - | MM12-061037 | - |

Nutfräsen/Eckfräsen



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | RE | LF | RMPX° | C min | C max | FHA | ZEFP | Schlüssel | Schlüssel | Beschichtung | | | |
|-----------------------|---------------|----------------|--------------|---------------|-------|-------|-------|-----|------|-----------|-----------|--------------|------|------|------|
| | | | | | | | | | | | | Beschichtet | | | |
| | | | | | | | | | | | | T60M | F15M | F30M | F40M |
| MM12-11715-R03A30-M04 | 11,7 0.461 | 15,35 0.604 | 0,3 0.012 | 19,9 0.783 | 15,0 | 14,2 | 22,6 | 30 | 3 | MM0416 | ✓ | | | | ■ |
| MM12-12015-A30-E04 | 12,0 0.472 | 15,35 0.604 | 0,0 - | 19,9 0.783 | 15,0 | 14,6 | 23,8 | 30 | 3 | MM0416 | ✓ | | | ■ | |
| MM12-12015-R05A30-M04 | 12,0 0.472 | 15,35 0.604 | 0,5 0.020 | 19,9 0.783 | 15,0 | 14,6 | 22,8 | 30 | 3 | MM0416 | ✓ | | | | ■ |
| MM12-12015-R10A30-E04 | 12,0 0.472 | 15,35 0.604 | 1,0 0.039 | 19,9 0.783 | 15,0 | 14,6 | 21,8 | 30 | 3 | MM0416 | ✓ | | | ■ | |
| MM12-12015-R10A30-M04 | 12,0 0.472 | 15,35 0.604 | 1,0 0.039 | 19,9 0.783 | 15,0 | 14,6 | 21,8 | 30 | 3 | MM0416 | ✓ | | | | ■ |
| MM12-12015-R15A30-D04 | 12,0 0.472 | 15,35 0.604 | 1,5 0.059 | 19,9 0.783 | 15,0 | 14,6 | 20,8 | 30 | 3 | MM0416 | ✓ | | | ■ | |
| MM12-12015-R20A30-M04 | 12,0 0.472 | 15,35 0.604 | 2,0 0.079 | 19,9 0.783 | 15,0 | 14,6 | 19,8 | 30 | 3 | MM0416 | ✓ | | | | ■ |
| MM12-12015-R30A30-E04 | 12,0 0.472 | 15,3 0.602 | 3,0 0.118 | 19,9 0.783 | 15,0 | 14,6 | 17,8 | 30 | 3 | MM0416 | ✓ | | | ■ | |
| MM12-12015-R30A30-M04 | 12,0 0.472 | 15,35 0.604 | 3,0 0.118 | 19,9 0.783 | 15,0 | 14,6 | 17,8 | 30 | 3 | MM0416 | ✓ | | | | ■ |
| MM12-12015-R40A30-M04 | 12,0 0.472 | 15,35 0.604 | 4,0 0.157 | 19,9 0.783 | 15,0 | 14,6 | 15,8 | 30 | 3 | MM0416 | ✓ | | | | ■ |
| MM12-12715-A30-E04 | 12,7 0.500 | 15,35 0.604 | 0,0 - | 19,9 0.783 | 15,0 | 15,4 | 25,2 | 30 | 3 | MM0416 | ✓ | | | ■ | |
| MM12-12715-R08A30-M04 | 12,7 0.500 | 15,35 0.604 | 0,8 0.031 | 19,9 0.783 | 15,0 | 15,4 | 23,6 | 30 | 3 | MM0416 | ✓ | | | | ■ |
| MM12-12715-R16A30-M04 | 12,7 0.500 | 15,35 0.604 | 1,6 0.063 | 19,9 0.783 | 15,0 | 15,4 | 22,0 | 30 | 3 | MM0416 | ✓ | | | | ■ |

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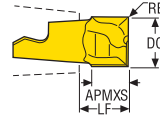
Graphit

X-Heads

Minimaster Plus

Minimaster

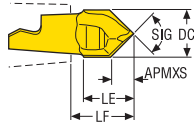
Nutfräsen/Eckfräsen




• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | RE | LF | RMPX° | C min | C max | FHA | ZEPF | Schlüssel | Beschichtung | | | | |
|----------------------|---------------|--------------|--------------|----------------|-------|-------|-------|-----|------|-----------|--------------|------|------|------|--|
| | | | | | | | | | | | Beschichtet | | | | |
| | | | | | | | | | | | T60M | F15M | F30M | F40M | |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | | | | | | | | |
| MM12-11708T-R03-D05 | 11,7 0.461 | 8,2 0.323 | 0,3 0.012 | 10,18 0.401 | 15,0 | 14,2 | 22,6 | 0 | 2 | MM0612 | ■ | | | | |
| MM12-12008-M04 | 12,0 0.472 | 8,2 0.323 | 0,0 – | 10,2 0.402 | 15,0 | 14,6 | 23,8 | 0 | 2 | MM0612 | ■ | | | | |
| MM12-12008-R08A8-E04 | 12,0 0.472 | 8,1 0.319 | 0,8 0.031 | 10,15 0.400 | 15,0 | 14,6 | 22,2 | 8 | 2 | MM0612 | ■ | | | | |
| MM12-12008-R08-MD05 | 12,0 0.472 | 8,2 0.323 | 0,8 0.031 | 10,18 0.401 | 15,0 | 14,6 | 22,2 | 0 | 2 | MM0612 | ■ | | ■ | | |
| MM12-12008-R08P-M04 | 12,0 0.472 | 8,1 0.319 | 0,8 0.031 | 10,05 0.396 | 15,0 | 14,6 | 22,2 | 0 | 2 | MM0612 | | | ■ | | |
| MM12-12008-R20-MD05 | 12,0 0.472 | 8,2 0.323 | 2,0 0.079 | 10,16 0.400 | 15,0 | 14,6 | 19,8 | 0 | 2 | MM0612 | | | ■ | | |
| MM12-12008-R30-MD05 | 12,0 0.472 | 8,2 0.323 | 3,0 0.118 | 10,14 0.399 | 15,0 | 14,6 | 17,8 | 0 | 2 | MM0612 | | | ■ | | |
| MM12-12708-M04 | 12,7 0.500 | 9,3 0.366 | 0,0 – | 11,25 0.443 | 15,0 | 15,4 | 25,2 | 0 | 2 | MM1420 | ■ | | | | |
| MM12-12708-R08-MD05 | 12,7 0.500 | 9,3 0.366 | 0,8 0.031 | 11,23 0.442 | 15,0 | 15,4 | 23,6 | 0 | 2 | MM1420 | ■ | | | | |
| MM12-12708-R08P-M04 | 12,7 0.500 | 9,3 0.366 | 0,8 0.031 | 11,23 0.442 | 15,0 | 15,4 | 23,6 | 0 | 2 | MM1420 | | | ■ | | |
| MM12-13709T-R03-D05 | 13,7 0.539 | 9,3 0.366 | 0,3 0.012 | 11,25 0.443 | 15,0 | 16,6 | 26,6 | 0 | 2 | MM1420 | ■ | | | | |
| MM12-14009-M04 | 14,0 0.551 | 9,3 0.366 | 0,0 – | 11,26 0.443 | 15,0 | 17,0 | 27,8 | 0 | 2 | MM1420 | ■ | | | | |
| MM12-14009-R08A8-E04 | 14,0 0.551 | 9,2 0.362 | 0,8 0.031 | 11,06 0.435 | 15,0 | 17,0 | 26,2 | 8 | 2 | MM1420 | ■ | | ■ | | |
| MM12-14009-R08-MD05 | 14,0 0.551 | 9,3 0.366 | 0,8 0.031 | 11,26 0.443 | 15,0 | 17,0 | 26,2 | 0 | 2 | MM1420 | ■ | | ■ | | |

Zentrierbohren



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | LE | LF | SIG° | ZEFP | Schlüssel  | Beschichtung | | | | | |
|--------------------|---------------|---------------|----------------|----------------|------|------|---|-------------------------------------|------|------|------|------|--|
| | | | | | | | | Beschichtet | T60M | F15M | F30M | F40M | |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | | | | | | |
| MM12-12006-C90-M04 | 12,0 0.472 | 5,65 0.222 | 12,65 0.498 | 14,64 0.576 | 90,0 | 2 | MM0612 | <input checked="" type="checkbox"/> | | | | | |

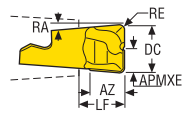
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ISO-S-Werkstoffe

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ISO-S-Werkstoffe

Tauchfräser



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXE | RE | AZ | LF | RA° | ZEFP | Schlüssel  | Beschichtung | | | |
|------------------------|---------------|--------------|--------------|--------------|---------------|-----|------|---|--------------|------|-------------------------------------|------|
| | | | | | | | | | Beschichtet | T60M | F15M | F30M |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | | | | |
| MM12-12008-R10-PL-MD05 | 12,0 0.472 | 6,0 0.236 | 1,0 0.039 | 8,5 0.335 | 10,2 0.402 | 5,0 | 2 | MM0612 | | | <input checked="" type="checkbox"/> | |

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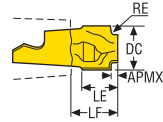
Graphit

X-Heads

Minimaster Plus

Minimaster

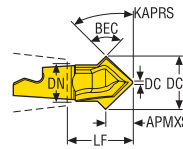
Konvexradienfräsen



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | RE | LF | ZEFP | Schlüssel | Beschichtung | | | |
|----------------------|---------------|--------------|--------------|----------------|------|-----------|--------------|------|------|------|
| | | | | | | | T60M | F15M | F30M | F40M |
| MM12-12010-CR10-MD05 | 12,0 0.472 | 2,2 0.087 | 1,0 0.039 | 12,14 0.478 | 2 | MM0612 | ■ | | | |
| MM12-12010-CR20-MD05 | 12,0 0.472 | 2,4 0.094 | 2,0 0.079 | 12,25 0.482 | 2 | MM0612 | ■ | | | |
| MM12-12010-CR30-MD05 | 12,0 0.472 | 3,3 0.130 | 3,0 0.118 | 12,2 0.480 | 2 | MM0612 | ■ | | | |

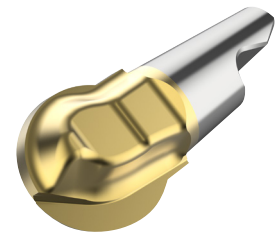
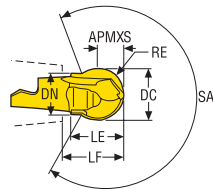
Anfasen



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DCX | DC | APMXS | LF | DN | BEC° | KAPRS° | ZEFP | Schlüssel | Beschichtung | | | |
|-----------------------|---------------|--------------|--------------|---------------|---------------|------|--------|------|-----------|--------------|------|------|------|
| | | | | | | | | | | T60M | F15M | F30M | F40M |
| MM12-16016-D3020P-M02 | 16,0 0.630 | 1,0 0.039 | 4,3 0.169 | 15,2 0.598 | 11,5 0.453 | 60,0 | 30,0 | 2 | MM1420 | | ■ | | |
| MM12-16016-D4520P-M02 | 16,0 0.630 | 1,0 0.039 | 7,5 0.295 | 17,2 0.677 | 11,5 0.453 | 90,0 | 45,0 | 2 | MM1420 | | ■ | | |

Präzisionswendeschneidplatten zum Vorschlichten in allen Werkstoffen



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | RE | LE | LF | DN | SA | ZEFP | Schlüssel | Beschichtung | | | |
|-----------------------|---------------|--------------|--------------|---------------|----------------|---------------|-------|------|-----------|--------------|------|------|------|
| | | | | | | | | | | T60M | F15M | F30M | F40M |
| MM12-14014-B120P-M05 | 14,0 0.551 | 7,0 0.276 | 7,0 0.276 | 14,0 0.551 | 15,45 0.608 | 12,0 0.472 | 242,0 | 2 | MM1420 | | | ■ | |
| MM12-16016-B120PF-M03 | 16,0 0.630 | 8,0 0.315 | 8,0 0.315 | 16,0 0.630 | 17,46 0.687 | 12,0 0.472 | 263,0 | 2 | MM1420 | | ■ | | |
| MM12-16016-B120P-M07 | 16,0 0.630 | 8,0 0.315 | 8,0 0.315 | 16,0 0.630 | 17,46 0.687 | 12,0 0.472 | 263,0 | 2 | MM1420 | | | ■ | |

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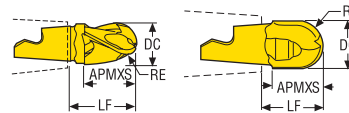
Graphit

X-Heads

Minimaster Plus

Minimaster

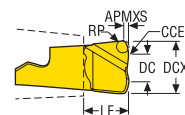
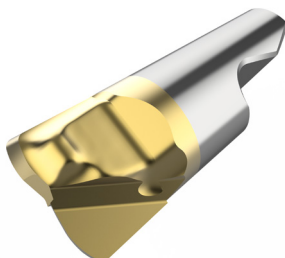
Kopierfräser



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | RE | LF | FHA | ZEFP | Schlüssel | Beschichtung | | | |
|-----------------------|---------------|---------------|---------------|----------------|------|------|-----------|--------------|------|------|------|
| | | | | | | | | T60M | F15M | F30M | F40M |
| MM12-12012-B90-MD05 | 12,0 0.472 | 12,2 0.480 | 6,0 0.236 | 14,12 0.556 | 0,0 | 2 | MM0612 | ■ | | ■ | |
| MM12-12012-B90PF-M02 | 12,0 0.472 | 10,4 0.409 | 6,0 0.236 | 14,09 0.555 | 0,0 | 2 | MM0612 | | ■ | | |
| MM12-12012-B90P-M05 | 12,0 0.472 | 10,4 0.409 | 6,0 0.236 | 14,09 0.555 | 0,0 | 2 | MM0612 | | | ■ | |
| MM12-12012-B90S-E05 | 12,0 0.472 | 12,3 0.484 | 6,0 0.236 | 14,12 0.556 | 0,0 | 2 | MM0612 | | | ■ | |
| MM12-12015-B90A30-E04 | 12,0 0.472 | 15,3 0.602 | 6,0 0.236 | 19,9 0.783 | 30,0 | 3 | MM0416 ✓ | | | ■ | |
| MM12-12015-B90A30-M04 | 12,0 0.472 | 15,3 0.602 | 6,0 0.236 | 19,9 0.783 | 30,0 | 3 | MM0416 ✓ | | | | ■ |
| MM12-12713-B90P-M05 | 12,7 0.500 | 12,2 0.480 | 6,35 0.250 | 15,92 0.627 | 0,0 | 2 | MM1420 | ■ | | ■ | |
| MM12-12715-B90A30-M04 | 12,7 0.500 | 15,3 0.602 | 6,35 0.250 | 19,75 0.778 | 30,0 | 3 | MM0416 ✓ | | | | ■ |
| MM12-14014-B90S-E05 | 14,0 0.551 | 14,1 0.555 | 7,0 0.276 | 15,92 0.627 | 0,0 | 2 | MM1420 | | | ■ | |

Hochvorschubfräser



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DCX | DC | APMXS | RP | CCER | LF | RMPX° | C min | C max | ZEFP | Schlüssel | Beschichtung | | | |
|--------------------|---------------|--------------|---------------|---------------|--------------|----------------|-------|-------|-------|------|-----------|--------------|------|------|------|
| | | | | | | | | | | | | T60M | F15M | F30M | F40M |
| MM12-12.60-HF-MD10 | 12,0 0.472 | 6,0 0.236 | 0,51 0.020 | 1,21 0.048 | 6,5 0.256 | 10,25 0.404 | 5,0 | 14,6 | 22,2 | 2 | MM0612 | | ■ | ■ | |

MM12 - Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|----------------------------|----------------|----------------|--------|--------|--------|
| | | | 100% | 40% | 20% | 10% |
| P1 | MM12-12015-R05A30-M04 F40M | 2,5 | 0,055 | 0,060 | 0,070 | 0,095 |
| | | 0.10 | 0.0022 | 0.0024 | 0.0028 | 0.0038 |
| P2 | MM12-12015-R05A30-M04 F40M | 2,5 | 0,060 | 0,060 | 0,070 | 0,095 |
| | | 0.10 | 0.0024 | 0.0024 | 0.0028 | 0.0038 |
| P3 | MM12-12015-R05A30-M04 F40M | 2,5 | 0,055 | 0,055 | 0,070 | 0,090 |
| | | 0.10 | 0.0022 | 0.0022 | 0.0028 | 0.0036 |
| P4 | MM12-12015-R05A30-M04 F40M | 2,5 | 0,055 | 0,055 | 0,065 | 0,090 |
| | | 0.10 | 0.0022 | 0.0022 | 0.0026 | 0.0036 |
| P5 | MM12-12015-R05A30-M04 F40M | 2,5 | 0,055 | 0,055 | 0,065 | 0,085 |
| | | 0.10 | 0.0022 | 0.0022 | 0.0026 | 0.0034 |
| P6 | MM12-12015-R05A30-M04 F40M | 2,5 | 0,050 | 0,055 | 0,065 | 0,085 |
| | | 0.10 | 0.0020 | 0.0022 | 0.0026 | 0.0034 |
| P7 | MM12-12015-R05A30-M04 F40M | 2,5 | 0,050 | 0,055 | 0,065 | 0,085 |
| | | 0.10 | 0.0020 | 0.0022 | 0.0026 | 0.0034 |
| P8 | MM12-12015-R05A30-M04 F40M | 2,5 | 0,055 | 0,055 | 0,070 | 0,090 |
| | | 0.10 | 0.0022 | 0.0022 | 0.0028 | 0.0036 |
| P11 | MM12-12015-R05A30-M04 F40M | 2,5 | 0,050 | 0,055 | 0,065 | 0,085 |
| | | 0.10 | 0.0020 | 0.0022 | 0.0026 | 0.0034 |
| P12 | MM12-12015-R05A30-M04 F40M | 2,0 | 0,036 | 0,036 | 0,044 | 0,060 |
| | | 0.080 | 0.0014 | 0.0014 | 0.0017 | 0.0024 |
| M1 | MM12-12015-R05A30-M04 F40M | 2,5 | 0,060 | 0,060 | 0,070 | 0,095 |
| | | 0.10 | 0.0024 | 0.0024 | 0.0028 | 0.0038 |
| M2 | MM12-12015-R05A30-M04 F40M | 2,5 | 0,055 | 0,055 | 0,065 | 0,085 |
| | | 0.10 | 0.0022 | 0.0022 | 0.0026 | 0.0034 |
| M3 | MM12-12015-R05A30-M04 F40M | 2,0 | 0,042 | 0,044 | 0,050 | 0,070 |
| | | 0.080 | 0.0017 | 0.0017 | 0.0020 | 0.0028 |
| M4 | MM12-12015-R05A30-M04 F40M | 1,6 | 0,038 | 0,038 | 0,046 | 0,060 |
| | | 0.065 | 0.0015 | 0.0015 | 0.0018 | 0.0024 |
| M5 | MM12-12015-R05A30-M04 F40M | 1,6 | 0,038 | 0,038 | 0,046 | 0,060 |
| | | 0.065 | 0.0015 | 0.0015 | 0.0018 | 0.0024 |
| K1 | MM12-12015-R10A30-E04 F30M | 2,5 | 0,060 | 0,060 | 0,070 | 0,095 |
| | | 0.10 | 0.0024 | 0.0024 | 0.0028 | 0.0038 |
| K2 | MM12-12015-R10A30-E04 F30M | 2,5 | 0,055 | 0,055 | 0,065 | 0,090 |
| | | 0.10 | 0.0022 | 0.0022 | 0.0026 | 0.0036 |
| K3 | MM12-12015-R10A30-E04 F30M | 2,5 | 0,055 | 0,055 | 0,065 | 0,090 |
| | | 0.10 | 0.0022 | 0.0022 | 0.0026 | 0.0036 |
| K4 | MM12-12015-R10A30-E04 F30M | 2,5 | 0,055 | 0,055 | 0,065 | 0,090 |
| | | 0.10 | 0.0022 | 0.0022 | 0.0026 | 0.0036 |
| K5 | MM12-12015-R15A30-D04 F30M | 2,5 | 0,055 | 0,055 | 0,060 | 0,080 |
| | | 0.10 | 0.0022 | 0.0022 | 0.0024 | 0.0032 |
| K6 | MM12-12015-R15A30-D04 F30M | 2,5 | 0,060 | 0,060 | 0,065 | 0,090 |
| | | 0.10 | 0.0024 | 0.0024 | 0.0026 | 0.0036 |
| K7 | MM12-12015-R15A30-D04 F30M | 2,5 | 0,055 | 0,055 | 0,060 | 0,080 |
| | | 0.10 | 0.0022 | 0.0022 | 0.0024 | 0.0032 |
| N1 | MM12-12015-R10A30-E04 F30M | 2,5 | 0,080 | 0,080 | 0,090 | 0,12 |
| | | 0.10 | 0.0032 | 0.0032 | 0.0036 | 0.0048 |
| N2 | MM12-12015-R10A30-E04 F30M | 2,5 | 0,080 | 0,080 | 0,090 | 0,12 |
| | | 0.10 | 0.0032 | 0.0032 | 0.0036 | 0.0048 |
| N3 | MM12-12015-R10A30-E04 F30M | 2,5 | 0,080 | 0,080 | 0,090 | 0,12 |
| | | 0.10 | 0.0032 | 0.0032 | 0.0036 | 0.0048 |
| N11 | MM12-12015-R10A30-E04 F30M | 2,5 | 0,080 | 0,080 | 0,090 | 0,12 |
| | | 0.10 | 0.0032 | 0.0032 | 0.0036 | 0.0048 |
| S1 | MM12-12015-R15A30-D04 F30M | 1,6 | 0,050 | 0,048 | 0,048 | 0,060 |
| | | 0.065 | 0.0020 | 0.0019 | 0.0019 | 0.0026 |
| S2 | MM12-12015-R15A30-D04 F30M | 1,6 | 0,050 | 0,048 | 0,048 | 0,060 |
| | | 0.065 | 0.0020 | 0.0019 | 0.0019 | 0.0026 |
| S3 | MM12-12015-R15A30-D04 F30M | 1,6 | 0,046 | 0,044 | 0,044 | 0,055 |
| | | 0.065 | 0.0018 | 0.0017 | 0.0017 | 0.0024 |
| S11 | MM12-12015-R05A30-M04 F40M | 1,9 | 0,044 | 0,044 | 0,050 | 0,070 |
| | | 0.075 | 0.0017 | 0.0017 | 0.0020 | 0.0028 |
| S12 | MM12-12015-R05A30-M04 F40M | 1,9 | 0,044 | 0,044 | 0,050 | 0,070 |
| | | 0.075 | 0.0017 | 0.0017 | 0.0020 | 0.0028 |
| S13 | MM12-12015-R05A30-M04 F40M | 1,6 | 0,038 | 0,038 | 0,046 | 0,060 |
| | | 0.065 | 0.0015 | 0.0015 | 0.0018 | 0.0024 |
| H5 | MM12-12015-R15A30-D04 F30M | 2,0 | 0,044 | 0,042 | 0,046 | 0,060 |
| | | 0.080 | 0.0017 | 0.0017 | 0.0018 | 0.0024 |
| H8 | MM12-12015-R15A30-D04 F30M | 1,9 | 0,034 | 0,034 | 0,036 | 0,046 |
| | | 0.075 | 0.0013 | 0.0013 | 0.0014 | 0.0018 |
| H11 | MM12-12015-R15A30-D04 F30M | 2,0 | 0,044 | 0,042 | 0,046 | 0,060 |
| | | 0.080 | 0.0017 | 0.0017 | 0.0018 | 0.0024 |
| H12 | MM12-12015-R15A30-D04 F30M | 1,9 | 0,034 | 0,034 | 0,036 | 0,046 |
| | | 0.075 | 0.0013 | 0.0013 | 0.0014 | 0.0018 |
| H21 | MM12-12015-R15A30-D04 F30M | 1,9 | 0,034 | 0,034 | 0,036 | 0,046 |
| | | 0.075 | 0.0013 | 0.0013 | 0.0014 | 0.0018 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

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Graphit
X-Heads
Minimaster Plus
Minimaster

MM12 - Nut- und Eckfräsen – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | F30M | | | | F40M | | | | T60M | | | |
|-----|------|------|------|------|------|------|------|------|------|------|------|------|
| | 100% | 40% | 20% | 10% | 100% | 40% | 20% | 10% | 100% | 40% | 20% | 10% |
| P1 | 250 | 315 | 350 | 385 | 240 | 300 | 335 | 365 | 185 | 225 | 255 | 280 |
| | 820 | 1025 | 1150 | 1275 | 790 | 980 | 1100 | 1200 | 610 | 740 | 840 | 920 |
| P2 | 245 | 305 | 340 | 375 | 235 | 290 | 325 | 355 | 175 | 220 | 250 | 275 |
| | 800 | 1000 | 1125 | 1225 | 770 | 950 | 1075 | 1175 | 570 | 720 | 820 | 900 |
| P3 | 210 | 265 | 295 | 325 | 200 | 250 | 280 | 310 | 155 | 195 | 215 | 235 |
| | 690 | 870 | 970 | 1075 | 660 | 820 | 920 | 1025 | 510 | 640 | 710 | 770 |
| P4 | 190 | 235 | 260 | 285 | 180 | 225 | 250 | 270 | 135 | 170 | 190 | 210 |
| | 620 | 770 | 850 | 940 | 590 | 740 | 820 | 890 | 445 | 560 | 620 | 690 |
| P5 | 180 | 225 | 250 | 275 | 170 | 215 | 240 | 260 | 130 | 160 | 180 | 200 |
| | 590 | 740 | 820 | 900 | 560 | 710 | 790 | 850 | 425 | 520 | 590 | 660 |
| P6 | 205 | 250 | 280 | 310 | 195 | 240 | 270 | 295 | 150 | 185 | 205 | 225 |
| | 670 | 820 | 920 | 1025 | 640 | 790 | 890 | 970 | 490 | 610 | 670 | 740 |
| P7 | 190 | 240 | 265 | 295 | 180 | 225 | 255 | 280 | 140 | 175 | 195 | 215 |
| | 620 | 790 | 870 | 970 | 590 | 740 | 840 | 920 | 460 | 570 | 640 | 710 |
| P8 | 175 | 220 | 245 | 275 | 170 | 210 | 235 | 260 | 130 | 160 | 180 | 200 |
| | 570 | 720 | 800 | 900 | 560 | 690 | 770 | 850 | 425 | 520 | 590 | 660 |
| P11 | 185 | 230 | 260 | 285 | 175 | 220 | 245 | 270 | 135 | 170 | 190 | 210 |
| | 610 | 750 | 850 | 940 | 570 | 720 | 800 | 890 | 445 | 560 | 620 | 690 |
| P12 | 115 | 145 | 165 | 180 | 110 | 140 | 155 | 170 | 85 | 110 | 120 | 130 |
| | 375 | 475 | 540 | 590 | 360 | 460 | 510 | 560 | 280 | 360 | 395 | 425 |
| M1 | 200 | 245 | 275 | 300 | 190 | 235 | 260 | 285 | 140 | 180 | 200 | 220 |
| | 660 | 800 | 900 | 980 | 620 | 770 | 850 | 940 | 460 | 590 | 660 | 720 |
| M2 | 160 | 200 | 225 | 245 | 155 | 195 | 215 | 235 | 120 | 145 | 165 | 180 |
| | 520 | 660 | 740 | 800 | 510 | 640 | 710 | 770 | 395 | 475 | 540 | 590 |
| M3 | 130 | 160 | 175 | 195 | 125 | 150 | 170 | 185 | 95 | 120 | 135 | 145 |
| | 425 | 520 | 570 | 640 | 410 | 490 | 560 | 610 | 310 | 395 | 445 | 475 |
| M4 | 100 | 125 | 140 | 150 | 95 | 115 | 130 | 145 | 75 | 90 | 100 | 110 |
| | 330 | 410 | 460 | 490 | 310 | 375 | 425 | 475 | 245 | 295 | 330 | 360 |
| M5 | 80 | 100 | 115 | 125 | 80 | 95 | 110 | 120 | 60 | 75 | 85 | 95 |
| | 260 | 330 | 375 | 410 | 260 | 310 | 360 | 395 | 195 | 245 | 280 | 310 |
| K1 | 195 | 240 | 270 | 295 | 185 | 230 | 255 | 280 | 140 | 175 | 195 | 220 |
| | 640 | 790 | 890 | 970 | 610 | 750 | 840 | 920 | 460 | 570 | 640 | 720 |
| K2 | 170 | 215 | 240 | 260 | 165 | 205 | 225 | 245 | 125 | 155 | 175 | 190 |
| | 560 | 710 | 790 | 850 | 540 | 670 | 740 | 800 | 410 | 510 | 570 | 620 |
| K3 | 145 | 180 | 200 | 220 | 140 | 170 | 190 | 210 | 105 | 130 | 145 | 160 |
| | 475 | 590 | 660 | 720 | 460 | 560 | 620 | 690 | 345 | 425 | 475 | 520 |
| K4 | 140 | 170 | 190 | 210 | 130 | 165 | 185 | 200 | 100 | 125 | 140 | 155 |
| | 460 | 560 | 620 | 690 | 425 | 540 | 610 | 660 | 330 | 410 | 460 | 510 |
| K5 | 85 | 105 | 115 | 125 | 80 | 100 | 110 | 120 | 60 | 75 | 85 | 95 |
| | 280 | 345 | 375 | 410 | 260 | 330 | 360 | 395 | 195 | 245 | 280 | 310 |
| K6 | 120 | 150 | 170 | 185 | 115 | 145 | 160 | 175 | 90 | 110 | 125 | 135 |
| | 395 | 490 | 560 | 610 | 375 | 475 | 520 | 570 | 295 | 360 | 410 | 445 |
| K7 | 105 | 135 | 150 | 165 | 100 | 125 | 140 | 155 | 80 | 100 | 110 | 120 |
| | 345 | 445 | 490 | 540 | 330 | 410 | 460 | 510 | 260 | 330 | 360 | 395 |
| N1 | 1450 | 1800 | 2025 | 2225 | 1375 | 1725 | 1925 | 2125 | 1050 | 1300 | 1450 | 1600 |
| | 4750 | 5900 | 6650 | 7300 | 4500 | 5650 | 6325 | 6975 | 3450 | 4275 | 4750 | 5250 |
| N2 | 580 | 730 | 820 | 900 | 560 | 690 | 780 | 860 | 420 | 530 | 590 | 650 |
| | 1900 | 2400 | 2700 | 2950 | 1825 | 2275 | 2550 | 2825 | 1375 | 1750 | 1925 | 2125 |
| N3 | 390 | 485 | 550 | 600 | 370 | 460 | 520 | 570 | 280 | 350 | 395 | 435 |
| | 1275 | 1600 | 1800 | 1975 | 1225 | 1500 | 1700 | 1875 | 920 | 1150 | 1300 | 1425 |
| N11 | 445 | 550 | 620 | 690 | 425 | 530 | 590 | 650 | 320 | 405 | 450 | 495 |
| | 1450 | 1800 | 2025 | 2275 | 1400 | 1750 | 1925 | 2125 | 1050 | 1325 | 1475 | 1625 |
| S1 | 46 | 55 | 65 | 70 | 44 | 55 | 60 | 65 | 34 | 43 | 47 | 50 |
| | 150 | 180 | 215 | 230 | 145 | 180 | 195 | 215 | 110 | 140 | 155 | 165 |
| S2 | 37 | 46 | 50 | 55 | 35 | 44 | 49 | 55 | 28 | 34 | 38 | 42 |
| | 120 | 150 | 165 | 180 | 115 | 145 | 160 | 180 | 90 | 110 | 125 | 140 |
| S3 | 32 | 40 | 45 | 50 | 31 | 38 | 43 | 47 | 24 | 30 | 33 | 37 |
| | 105 | 130 | 150 | 165 | 100 | 125 | 140 | 155 | 80 | 100 | 110 | 120 |
| S11 | 65 | 80 | 90 | 100 | 60 | 75 | 85 | 95 | 48 | 60 | 65 | 75 |
| | 215 | 260 | 295 | 330 | 195 | 245 | 280 | 310 | 155 | 195 | 215 | 245 |
| S12 | 45 | 55 | 60 | 70 | 43 | 55 | 60 | 65 | 33 | 41 | 47 | 50 |
| | 150 | 180 | 195 | 230 | 140 | 180 | 195 | 215 | 110 | 135 | 155 | 165 |
| S13 | 26 | 32 | 36 | 40 | 25 | 31 | 34 | 38 | 19 | 24 | 27 | 29 |
| | 85 | 105 | 120 | 130 | 80 | 100 | 110 | 125 | 60 | 80 | 90 | 95 |
| H5 | 39 | 49 | 55 | 60 | 37 | 46 | 50 | 55 | 29 | 36 | 40 | 44 |
| | 130 | 160 | 180 | 195 | 120 | 150 | 165 | 180 | 95 | 120 | 130 | 145 |
| H8 | 41 | 50 | 55 | 60 | 39 | 48 | 55 | 60 | 30 | 37 | 42 | 46 |
| | 135 | 165 | 180 | 195 | 130 | 155 | 180 | 195 | 100 | 120 | 140 | 150 |
| H11 | 49 | 60 | 70 | 75 | 47 | 60 | 65 | 70 | 37 | 46 | 50 | 55 |
| | 160 | 195 | 230 | 245 | 155 | 195 | 215 | 230 | 120 | 150 | 165 | 180 |
| H12 | 75 | 90 | 100 | 110 | 70 | 85 | 95 | 105 | 55 | 65 | 75 | 85 |
| | 245 | 295 | 330 | 360 | 230 | 280 | 310 | 345 | 180 | 215 | 245 | 280 |
| H21 | 41 | 50 | 55 | 60 | 39 | 48 | 55 | 60 | 30 | 37 | 42 | 46 |
| | 135 | 165 | 180 | 195 | 130 | 155 | 180 | 195 | 100 | 120 | 140 | 150 |

MM12 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Schruppen – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|----------------------------|----------------|----------------|--------|--------|--------|
| | | | 100% | 40% | 20% | 10% |
| P1 | MM12-12015-B90A30-M04 F40M | 2,5 | 0,070 | 0,070 | 0,070 | 0,095 |
| | | 0.10 | 0.0028 | 0.0028 | 0.0028 | 0.0038 |
| P2 | MM12-12015-B90A30-M04 F40M | 2,5 | 0,070 | 0,070 | 0,075 | 0,095 |
| | | 0.10 | 0.0028 | 0.0028 | 0.0030 | 0.0038 |
| P3 | MM12-12015-B90A30-M04 F40M | 2,5 | 0,070 | 0,065 | 0,070 | 0,090 |
| | | 0.10 | 0.0028 | 0.0026 | 0.0028 | 0.0036 |
| P4 | MM12-12015-B90A30-M04 F40M | 2,5 | 0,065 | 0,065 | 0,070 | 0,090 |
| | | 0.10 | 0.0026 | 0.0026 | 0.0028 | 0.0036 |
| P5 | MM12-12015-B90A30-M04 F40M | 2,5 | 0,065 | 0,065 | 0,065 | 0,090 |
| | | 0.10 | 0.0026 | 0.0026 | 0.0026 | 0.0036 |
| P6 | MM12-12015-B90A30-M04 F40M | 2,5 | 0,065 | 0,065 | 0,065 | 0,085 |
| | | 0.10 | 0.0026 | 0.0026 | 0.0026 | 0.0034 |
| P7 | MM12-12015-B90A30-M04 F40M | 2,5 | 0,065 | 0,065 | 0,065 | 0,085 |
| | | 0.10 | 0.0026 | 0.0026 | 0.0026 | 0.0034 |
| P8 | MM12-12015-B90A30-M04 F40M | 2,5 | 0,070 | 0,065 | 0,070 | 0,090 |
| | | 0.10 | 0.0028 | 0.0026 | 0.0028 | 0.0036 |
| P11 | MM12-12015-B90A30-M04 F40M | 2,5 | 0,065 | 0,065 | 0,065 | 0,085 |
| | | 0.10 | 0.0026 | 0.0026 | 0.0026 | 0.0034 |
| P12 | MM12-12015-B90A30-M04 F40M | 2,0 | 0,046 | 0,044 | 0,046 | 0,060 |
| | | 0.080 | 0.0018 | 0.0017 | 0.0018 | 0.0024 |
| M1 | MM12-12015-B90A30-M04 F40M | 2,5 | 0,070 | 0,070 | 0,075 | 0,095 |
| | | 0.10 | 0.0028 | 0.0028 | 0.0030 | 0.0038 |
| M2 | MM12-12015-B90A30-M04 F40M | 2,5 | 0,065 | 0,065 | 0,065 | 0,090 |
| | | 0.10 | 0.0026 | 0.0026 | 0.0026 | 0.0036 |
| M3 | MM12-12015-B90A30-M04 F40M | 2,0 | 0,055 | 0,055 | 0,055 | 0,070 |
| | | 0.080 | 0.0022 | 0.0022 | 0.0022 | 0.0028 |
| M4 | MM12-12015-B90A30-M04 F40M | 1,6 | 0,050 | 0,048 | 0,048 | 0,060 |
| | | 0.065 | 0.0020 | 0.0019 | 0.0019 | 0.0026 |
| M5 | MM12-12015-B90A30-M04 F40M | 1,6 | 0,050 | 0,048 | 0,048 | 0,060 |
| | | 0.065 | 0.0020 | 0.0019 | 0.0019 | 0.0026 |
| K1 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,070 | 0,070 | 0,075 | 0,095 |
| | | 0.10 | 0.0028 | 0.0028 | 0.0030 | 0.0038 |
| K2 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,065 | 0,065 | 0,065 | 0,090 |
| | | 0.10 | 0.0026 | 0.0026 | 0.0026 | 0.0036 |
| K3 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,065 | 0,065 | 0,065 | 0,090 |
| | | 0.10 | 0.0026 | 0.0026 | 0.0026 | 0.0036 |
| K4 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,065 | 0,065 | 0,065 | 0,090 |
| | | 0.10 | 0.0026 | 0.0026 | 0.0026 | 0.0036 |
| K5 | MM12-12015-B90A30-M04 F40M | 2,5 | 0,060 | 0,055 | 0,060 | 0,080 |
| | | 0.10 | 0.0024 | 0.0022 | 0.0024 | 0.0032 |
| K6 | MM12-12015-B90A30-M04 F40M | 2,5 | 0,065 | 0,065 | 0,065 | 0,090 |
| | | 0.10 | 0.0026 | 0.0026 | 0.0026 | 0.0036 |
| K7 | MM12-12015-B90A30-M04 F40M | 2,5 | 0,060 | 0,055 | 0,060 | 0,080 |
| | | 0.10 | 0.0024 | 0.0022 | 0.0024 | 0.0032 |
| N1 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,090 | 0,090 | 0,095 | 0,12 |
| | | 0.10 | 0.0036 | 0.0036 | 0.0038 | 0.0048 |
| N2 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,090 | 0,090 | 0,095 | 0,12 |
| | | 0.10 | 0.0036 | 0.0036 | 0.0038 | 0.0048 |
| N3 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,090 | 0,090 | 0,095 | 0,12 |
| | | 0.10 | 0.0036 | 0.0036 | 0.0038 | 0.0048 |
| N11 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,090 | 0,090 | 0,095 | 0,12 |
| | | 0.10 | 0.0036 | 0.0036 | 0.0038 | 0.0048 |
| S1 | MM12-12015-B90A30-M04 F40M | 1,6 | 0,050 | 0,048 | 0,048 | 0,060 |
| | | 0.065 | 0.0020 | 0.0019 | 0.0019 | 0.0026 |
| S2 | MM12-12015-B90A30-M04 F40M | 1,6 | 0,050 | 0,048 | 0,048 | 0,060 |
| | | 0.065 | 0.0020 | 0.0019 | 0.0019 | 0.0026 |
| S3 | MM12-12015-B90A30-M04 F40M | 1,6 | 0,046 | 0,046 | 0,046 | 0,055 |
| | | 0.065 | 0.0018 | 0.0018 | 0.0018 | 0.0024 |
| S11 | MM12-12015-B90A30-M04 F40M | 1,9 | 0,055 | 0,055 | 0,055 | 0,070 |
| | | 0.075 | 0.0022 | 0.0022 | 0.0022 | 0.0028 |
| S12 | MM12-12015-B90A30-M04 F40M | 1,9 | 0,055 | 0,055 | 0,055 | 0,070 |
| | | 0.075 | 0.0022 | 0.0022 | 0.0022 | 0.0028 |
| S13 | MM12-12015-B90A30-M04 F40M | 1,6 | 0,050 | 0,048 | 0,048 | 0,060 |
| | | 0.065 | 0.0020 | 0.0019 | 0.0019 | 0.0026 |
| H5 | MM12-12015-B90A30-E04 F30M | 2,0 | 0,046 | 0,044 | 0,046 | 0,060 |
| | | 0.080 | 0.0018 | 0.0017 | 0.0018 | 0.0024 |
| H8 | MM12-12015-B90A30-E04 F30M | 1,9 | 0,036 | 0,036 | 0,036 | 0,046 |
| | | 0.075 | 0.0014 | 0.0014 | 0.0014 | 0.0018 |
| H11 | MM12-12015-B90A30-E04 F30M | 2,0 | 0,046 | 0,044 | 0,046 | 0,060 |
| | | 0.080 | 0.0018 | 0.0017 | 0.0018 | 0.0024 |
| H12 | MM12-12015-B90A30-E04 F30M | 1,9 | 0,036 | 0,036 | 0,036 | 0,046 |
| | | 0.075 | 0.0014 | 0.0014 | 0.0014 | 0.0018 |
| H21 | MM12-12015-B90A30-E04 F30M | 1,9 | 0,036 | 0,036 | 0,036 | 0,046 |
| | | 0.075 | 0.0014 | 0.0014 | 0.0014 | 0.0018 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

Universell
Stahl und Guss
Stahl und Guss
Rostrfrei und ISO-S-Werkstoffe
Rostrfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MM12 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Schichten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|----------------------------|----------------|----------------|--------|--------|--------|
| | | | 15% | 10% | 5% | 2% |
| P1 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,080 | 0,095 | 0,13 | 0,22 |
| | | 0,10 | 0,0032 | 0,0038 | 0,0050 | 0,0085 |
| P2 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,080 | 0,095 | 0,13 | 0,22 |
| | | 0,10 | 0,0032 | 0,0038 | 0,0050 | 0,0085 |
| P3 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,075 | 0,090 | 0,13 | 0,20 |
| | | 0,10 | 0,0030 | 0,0036 | 0,0050 | 0,0080 |
| P4 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,075 | 0,090 | 0,12 | 0,20 |
| | | 0,10 | 0,0030 | 0,0036 | 0,0048 | 0,0080 |
| P5 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,075 | 0,090 | 0,12 | 0,20 |
| | | 0,10 | 0,0030 | 0,0036 | 0,0048 | 0,0080 |
| P6 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,075 | 0,085 | 0,12 | 0,19 |
| | | 0,10 | 0,0030 | 0,0034 | 0,0048 | 0,0075 |
| P7 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,075 | 0,085 | 0,12 | 0,19 |
| | | 0,10 | 0,0030 | 0,0034 | 0,0048 | 0,0075 |
| P8 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,075 | 0,090 | 0,13 | 0,20 |
| | | 0,10 | 0,0030 | 0,0036 | 0,0050 | 0,0080 |
| P11 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,075 | 0,085 | 0,12 | 0,19 |
| | | 0,10 | 0,0030 | 0,0034 | 0,0048 | 0,0075 |
| P12 | MM12-12015-B90A30-E04 F30M | 2,0 | 0,050 | 0,060 | 0,080 | 0,13 |
| | | 0,080 | 0,0020 | 0,0024 | 0,0032 | 0,0050 |
| M1 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,080 | 0,095 | 0,13 | 0,22 |
| | | 0,10 | 0,0032 | 0,0038 | 0,0050 | 0,0085 |
| M2 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,075 | 0,090 | 0,12 | 0,20 |
| | | 0,10 | 0,0030 | 0,0036 | 0,0048 | 0,0080 |
| M3 | MM12-12015-B90A30-E04 F30M | 2,0 | 0,060 | 0,070 | 0,095 | 0,16 |
| | | 0,080 | 0,0024 | 0,0028 | 0,0038 | 0,0065 |
| M4 | MM12-12015-B90A30-E04 F30M | 1,6 | 0,055 | 0,060 | 0,085 | 0,14 |
| | | 0,065 | 0,0022 | 0,0026 | 0,0034 | 0,0055 |
| M5 | MM12-12015-B90A30-E04 F30M | 1,6 | 0,055 | 0,060 | 0,085 | 0,14 |
| | | 0,065 | 0,0022 | 0,0026 | 0,0034 | 0,0055 |
| K1 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,080 | 0,095 | 0,13 | 0,22 |
| | | 0,10 | 0,0032 | 0,0038 | 0,0050 | 0,0085 |
| K2 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,075 | 0,090 | 0,12 | 0,20 |
| | | 0,10 | 0,0030 | 0,0036 | 0,0048 | 0,0080 |
| K3 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,075 | 0,090 | 0,12 | 0,20 |
| | | 0,10 | 0,0030 | 0,0036 | 0,0048 | 0,0080 |
| K4 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,075 | 0,090 | 0,12 | 0,20 |
| | | 0,10 | 0,0030 | 0,0036 | 0,0048 | 0,0080 |
| K5 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,065 | 0,080 | 0,11 | 0,18 |
| | | 0,10 | 0,0026 | 0,0032 | 0,0044 | 0,0070 |
| K6 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,075 | 0,090 | 0,12 | 0,20 |
| | | 0,10 | 0,0030 | 0,0036 | 0,0048 | 0,0080 |
| K7 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,065 | 0,080 | 0,11 | 0,18 |
| | | 0,10 | 0,0026 | 0,0032 | 0,0044 | 0,0070 |
| N1 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,10 | 0,12 | 0,17 | 0,28 |
| | | 0,10 | 0,0040 | 0,0048 | 0,0065 | 0,011 |
| N2 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,10 | 0,12 | 0,17 | 0,28 |
| | | 0,10 | 0,0040 | 0,0048 | 0,0065 | 0,011 |
| N3 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,10 | 0,12 | 0,17 | 0,28 |
| | | 0,10 | 0,0040 | 0,0048 | 0,0065 | 0,011 |
| N11 | MM12-12015-B90A30-E04 F30M | 2,5 | 0,10 | 0,12 | 0,17 | 0,28 |
| | | 0,10 | 0,0040 | 0,0048 | 0,0065 | 0,011 |
| S1 | MM12-12015-B90A30-E04 F30M | 1,6 | 0,055 | 0,060 | 0,085 | 0,14 |
| | | 0,065 | 0,0022 | 0,0026 | 0,0034 | 0,0055 |
| S2 | MM12-12015-B90A30-E04 F30M | 1,6 | 0,055 | 0,060 | 0,085 | 0,14 |
| | | 0,065 | 0,0022 | 0,0026 | 0,0034 | 0,0055 |
| S3 | MM12-12015-B90A30-E04 F30M | 1,6 | 0,050 | 0,055 | 0,080 | 0,13 |
| | | 0,065 | 0,0020 | 0,0024 | 0,0032 | 0,0050 |
| S11 | MM12-12015-B90A30-E04 F30M | 1,9 | 0,060 | 0,070 | 0,095 | 0,16 |
| | | 0,075 | 0,0024 | 0,0028 | 0,0038 | 0,0065 |
| S12 | MM12-12015-B90A30-E04 F30M | 1,9 | 0,060 | 0,070 | 0,095 | 0,16 |
| | | 0,075 | 0,0024 | 0,0028 | 0,0038 | 0,0065 |
| S13 | MM12-12015-B90A30-E04 F30M | 1,6 | 0,055 | 0,060 | 0,085 | 0,14 |
| | | 0,065 | 0,0022 | 0,0026 | 0,0034 | 0,0055 |
| H5 | MM12-12015-B90A30-E04 F30M | 2,0 | 0,050 | 0,060 | 0,080 | 0,13 |
| | | 0,080 | 0,0020 | 0,0024 | 0,0032 | 0,0050 |
| H8 | MM12-12015-B90A30-E04 F30M | 1,9 | 0,040 | 0,046 | 0,065 | 0,10 |
| | | 0,075 | 0,0016 | 0,0018 | 0,0026 | 0,0040 |
| H11 | MM12-12015-B90A30-E04 F30M | 2,0 | 0,050 | 0,060 | 0,080 | 0,13 |
| | | 0,080 | 0,0020 | 0,0024 | 0,0032 | 0,0050 |
| H12 | MM12-12015-B90A30-E04 F30M | 1,9 | 0,040 | 0,046 | 0,065 | 0,10 |
| | | 0,075 | 0,0016 | 0,0018 | 0,0026 | 0,0040 |
| H21 | MM12-12015-B90A30-E04 F30M | 1,9 | 0,040 | 0,046 | 0,065 | 0,10 |
| | | 0,075 | 0,0016 | 0,0018 | 0,0026 | 0,0040 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MM12 Z3 – Kopierfräser – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | F30M | | | | | F40M | | | | |
|-----|------|------|------|------|------|------|------|------|------|------|
| | 100% | 20% | 10% | 5% | 2% | 100% | 20% | 10% | 5% | 2% |
| P1 | 270 | 315 | 335 | 365 | 360 | 255 | 300 | 320 | 345 | 340 |
| | 890 | 1025 | 1100 | 1200 | 1175 | 840 | 980 | 1050 | 1125 | 1125 |
| P2 | 265 | 305 | 325 | 355 | 350 | 250 | 290 | 310 | 335 | 330 |
| | 870 | 1000 | 1075 | 1175 | 1150 | 820 | 950 | 1025 | 1100 | 1075 |
| P3 | 225 | 265 | 285 | 305 | 305 | 215 | 255 | 270 | 290 | 290 |
| | 740 | 870 | 940 | 1000 | 1000 | 710 | 840 | 890 | 950 | 950 |
| P4 | 200 | 235 | 250 | 270 | 270 | 190 | 225 | 235 | 260 | 255 |
| | 660 | 770 | 820 | 890 | 890 | 620 | 740 | 770 | 850 | 840 |
| P5 | 195 | 225 | 240 | 260 | 255 | 185 | 215 | 225 | 245 | 245 |
| | 640 | 740 | 790 | 850 | 840 | 610 | 710 | 740 | 800 | 800 |
| P6 | 215 | 255 | 270 | 290 | 290 | 205 | 240 | 255 | 275 | 275 |
| | 710 | 840 | 890 | 950 | 950 | 670 | 790 | 840 | 900 | 900 |
| P7 | 205 | 240 | 255 | 275 | 275 | 195 | 230 | 240 | 260 | 260 |
| | 670 | 790 | 840 | 900 | 900 | 640 | 750 | 790 | 850 | 850 |
| P8 | 190 | 225 | 240 | 255 | 255 | 180 | 215 | 225 | 245 | 245 |
| | 620 | 740 | 790 | 840 | 840 | 590 | 710 | 740 | 800 | 800 |
| P11 | 200 | 235 | 245 | 265 | 265 | 190 | 220 | 235 | 255 | 255 |
| | 660 | 770 | 800 | 870 | 870 | 620 | 720 | 770 | 840 | 840 |
| P12 | 125 | 150 | 155 | 170 | 165 | 120 | 140 | 145 | 160 | 160 |
| | 410 | 490 | 510 | 560 | 540 | 395 | 460 | 490 | 520 | 520 |
| M1 | 210 | 245 | 265 | 285 | 280 | 200 | 235 | 250 | 270 | 270 |
| | 690 | 800 | 870 | 940 | 920 | 660 | 770 | 820 | 890 | 890 |
| M2 | 175 | 205 | 215 | 235 | 230 | 165 | 195 | 205 | 220 | 220 |
| | 570 | 670 | 710 | 770 | 750 | 540 | 640 | 670 | 720 | 720 |
| M3 | 140 | 165 | 170 | 185 | 185 | 130 | 155 | 160 | 175 | 175 |
| | 460 | 540 | 560 | 610 | 610 | 425 | 510 | 540 | 570 | 570 |
| M4 | 100 | 130 | 130 | 140 | 140 | 95 | 125 | 125 | 135 | 135 |
| | 330 | 425 | 460 | 460 | 460 | 310 | 410 | 425 | 445 | 445 |
| M5 | 80 | 110 | 110 | 115 | 115 | 80 | 105 | 105 | 110 | 110 |
| | 260 | 360 | 375 | 375 | 375 | 260 | 345 | 360 | 360 | 360 |
| K1 | 210 | 240 | 260 | 280 | 275 | 200 | 230 | 245 | 265 | 265 |
| | 690 | 790 | 850 | 920 | 900 | 660 | 750 | 800 | 870 | 870 |
| K2 | 185 | 215 | 225 | 245 | 245 | 175 | 205 | 215 | 235 | 230 |
| | 610 | 710 | 740 | 800 | 800 | 570 | 670 | 710 | 770 | 750 |
| K3 | 155 | 180 | 190 | 210 | 205 | 145 | 175 | 180 | 200 | 195 |
| | 510 | 590 | 620 | 690 | 670 | 475 | 570 | 590 | 660 | 640 |
| K4 | 150 | 175 | 180 | 200 | 195 | 140 | 165 | 175 | 190 | 185 |
| | 490 | 570 | 590 | 660 | 640 | 460 | 540 | 570 | 620 | 610 |
| K5 | 90 | 105 | 110 | 120 | 120 | 85 | 100 | 105 | 115 | 115 |
| | 295 | 345 | 360 | 395 | 395 | 280 | 330 | 345 | 375 | 375 |
| K6 | 130 | 155 | 160 | 175 | 175 | 125 | 145 | 155 | 165 | 165 |
| | 425 | 510 | 520 | 570 | 570 | 410 | 475 | 510 | 540 | 540 |
| K7 | 115 | 135 | 140 | 155 | 155 | 110 | 125 | 135 | 145 | 145 |
| | 375 | 445 | 460 | 510 | 510 | 360 | 410 | 445 | 475 | 475 |
| N1 | 1575 | 1825 | 1950 | 2100 | 2100 | 1500 | 1750 | 1850 | 2000 | 2000 |
| | 5175 | 6000 | 6400 | 6900 | 6900 | 4925 | 5750 | 6075 | 6550 | 6550 |
| N2 | 640 | 740 | 790 | 850 | 840 | 610 | 700 | 750 | 810 | 800 |
| | 2100 | 2425 | 2600 | 2800 | 2750 | 2000 | 2300 | 2450 | 2650 | 2625 |
| N3 | 425 | 495 | 530 | 570 | 560 | 405 | 470 | 500 | 540 | 540 |
| | 1400 | 1625 | 1750 | 1875 | 1825 | 1325 | 1550 | 1650 | 1775 | 1775 |
| N11 | 485 | 560 | 600 | 650 | 640 | 460 | 540 | 570 | 620 | 610 |
| | 1600 | 1825 | 1975 | 2125 | 2100 | 1500 | 1775 | 1875 | 2025 | 2000 |
| S1 | 46 | 60 | 60 | 65 | 65 | 44 | 60 | 60 | 65 | 60 |
| | 150 | 195 | 215 | 215 | 215 | 145 | 195 | 195 | 215 | 195 |
| S2 | 37 | 50 | 49 | 55 | 55 | 35 | 47 | 47 | 50 | 50 |
| | 120 | 165 | 165 | 180 | 180 | 115 | 155 | 165 | 165 | 165 |
| S3 | 32 | 43 | 43 | 46 | 46 | 31 | 41 | 41 | 44 | 44 |
| | 105 | 140 | 150 | 150 | 150 | 100 | 135 | 140 | 145 | 145 |
| S11 | 70 | 85 | 85 | 95 | 90 | 65 | 80 | 80 | 90 | 90 |
| | 230 | 280 | 295 | 310 | 295 | 215 | 260 | 280 | 295 | 295 |
| S12 | 48 | 60 | 60 | 65 | 65 | 46 | 55 | 55 | 60 | 60 |
| | 155 | 195 | 195 | 215 | 215 | 150 | 180 | 195 | 195 | 195 |
| S13 | 26 | 35 | 34 | 37 | 37 | 25 | 33 | 33 | 35 | 35 |
| | 85 | 115 | 120 | 120 | 120 | 80 | 110 | 115 | 115 | 115 |
| H5 | 42 | 50 | 50 | 55 | 55 | 40 | 47 | 49 | 55 | 55 |
| | 140 | 165 | 165 | 180 | 180 | 130 | 155 | 160 | 180 | 180 |
| H8 | 42 | 55 | 55 | 55 | 55 | 40 | 50 | 50 | 55 | 55 |
| | 140 | 180 | 180 | 180 | 180 | 130 | 165 | 165 | 180 | 180 |
| H11 | 55 | 65 | 65 | 70 | 70 | 50 | 60 | 60 | 65 | 65 |
| | 180 | 215 | 215 | 230 | 230 | 165 | 195 | 195 | 215 | 215 |
| H12 | 75 | 95 | 95 | 105 | 105 | 75 | 90 | 90 | 100 | 100 |
| | 245 | 310 | 330 | 345 | 345 | 245 | 295 | 310 | 330 | 330 |
| H21 | 42 | 55 | 55 | 55 | 55 | 40 | 50 | 50 | 55 | 55 |
| | 140 | 180 | 180 | 180 | 180 | 130 | 165 | 165 | 180 | 180 |

Universell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MM12 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Schruppen – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|--------------------------|----------------|----------------|--------|--------|--------|
| | | | 100% | 40% | 20% | 10% |
| P1 | MM12-12012-B90S-E05 F30M | 5,0 | 0,075 | 0,080 | 0,090 | 0,12 |
| | | 0,20 | 0,0030 | 0,0032 | 0,0036 | 0,0048 |
| P2 | MM12-12012-B90S-E05 F30M | 5,0 | 0,080 | 0,080 | 0,090 | 0,12 |
| | | 0,20 | 0,0032 | 0,0032 | 0,0036 | 0,0048 |
| P3 | MM12-12012-B90S-E05 F30M | 5,0 | 0,075 | 0,075 | 0,085 | 0,11 |
| | | 0,20 | 0,0030 | 0,0030 | 0,0034 | 0,0044 |
| P4 | MM12-12012-B90-MD05 F30M | 5,0 | 0,075 | 0,075 | 0,085 | 0,11 |
| | | 0,20 | 0,0030 | 0,0030 | 0,0034 | 0,0044 |
| P5 | MM12-12012-B90-MD05 F30M | 5,0 | 0,070 | 0,070 | 0,085 | 0,11 |
| | | 0,20 | 0,0028 | 0,0028 | 0,0034 | 0,0044 |
| P6 | MM12-12012-B90-MD05 F30M | 5,0 | 0,070 | 0,070 | 0,080 | 0,11 |
| | | 0,20 | 0,0028 | 0,0028 | 0,0032 | 0,0044 |
| P7 | MM12-12012-B90-MD05 F30M | 5,0 | 0,070 | 0,070 | 0,080 | 0,11 |
| | | 0,20 | 0,0028 | 0,0028 | 0,0032 | 0,0044 |
| P8 | MM12-12012-B90-MD05 F30M | 5,0 | 0,075 | 0,075 | 0,085 | 0,11 |
| | | 0,20 | 0,0030 | 0,0030 | 0,0034 | 0,0044 |
| P11 | MM12-12012-B90-MD05 F30M | 5,0 | 0,070 | 0,070 | 0,080 | 0,11 |
| | | 0,20 | 0,0028 | 0,0028 | 0,0032 | 0,0044 |
| P12 | MM12-12012-B90-MD05 F30M | 4,0 | 0,050 | 0,050 | 0,060 | 0,075 |
| | | 0,16 | 0,0020 | 0,0020 | 0,0024 | 0,0030 |
| M1 | MM12-12012-B90S-E05 F30M | 5,0 | 0,080 | 0,080 | 0,090 | 0,12 |
| | | 0,20 | 0,0032 | 0,0032 | 0,0036 | 0,0048 |
| M2 | MM12-12012-B90S-E05 F30M | 5,0 | 0,070 | 0,070 | 0,085 | 0,11 |
| | | 0,20 | 0,0028 | 0,0028 | 0,0034 | 0,0044 |
| M3 | MM12-12012-B90S-E05 F30M | 4,0 | 0,060 | 0,060 | 0,070 | 0,090 |
| | | 0,16 | 0,0024 | 0,0024 | 0,0028 | 0,0036 |
| M4 | MM12-12012-B90-MD05 F30M | 3,0 | 0,055 | 0,055 | 0,060 | 0,075 |
| | | 0,12 | 0,0022 | 0,0022 | 0,0024 | 0,0032 |
| M5 | MM12-12012-B90-MD05 F30M | 3,0 | 0,055 | 0,055 | 0,060 | 0,075 |
| | | 0,12 | 0,0022 | 0,0022 | 0,0024 | 0,0032 |
| K1 | MM12-12012-B90S-E05 F30M | 5,0 | 0,080 | 0,080 | 0,090 | 0,12 |
| | | 0,20 | 0,0032 | 0,0032 | 0,0036 | 0,0048 |
| K2 | MM12-12012-B90S-E05 F30M | 5,0 | 0,070 | 0,070 | 0,085 | 0,11 |
| | | 0,20 | 0,0028 | 0,0028 | 0,0034 | 0,0044 |
| K3 | MM12-12012-B90S-E05 F30M | 5,0 | 0,070 | 0,070 | 0,085 | 0,11 |
| | | 0,20 | 0,0028 | 0,0028 | 0,0034 | 0,0044 |
| K4 | MM12-12012-B90S-E05 F30M | 5,0 | 0,070 | 0,070 | 0,085 | 0,11 |
| | | 0,20 | 0,0028 | 0,0028 | 0,0034 | 0,0044 |
| K5 | MM12-12012-B90-MD05 F30M | 5,0 | 0,065 | 0,065 | 0,075 | 0,10 |
| | | 0,20 | 0,0026 | 0,0026 | 0,0030 | 0,0040 |
| K6 | MM12-12012-B90-MD05 F30M | 5,0 | 0,070 | 0,070 | 0,085 | 0,11 |
| | | 0,20 | 0,0028 | 0,0028 | 0,0034 | 0,0044 |
| K7 | MM12-12012-B90-MD05 F30M | 5,0 | 0,065 | 0,065 | 0,075 | 0,10 |
| | | 0,20 | 0,0026 | 0,0026 | 0,0030 | 0,0040 |
| N1 | MM12-12012-B90S-E05 F30M | 5,0 | 0,10 | 0,10 | 0,12 | 0,15 |
| | | 0,20 | 0,0040 | 0,0040 | 0,0048 | 0,0060 |
| N2 | MM12-12012-B90S-E05 F30M | 5,0 | 0,10 | 0,10 | 0,12 | 0,15 |
| | | 0,20 | 0,0040 | 0,0040 | 0,0048 | 0,0060 |
| N3 | MM12-12012-B90S-E05 F30M | 5,0 | 0,10 | 0,10 | 0,12 | 0,15 |
| | | 0,20 | 0,0040 | 0,0040 | 0,0048 | 0,0060 |
| N11 | MM12-12012-B90S-E05 F30M | 5,0 | 0,10 | 0,10 | 0,12 | 0,15 |
| | | 0,20 | 0,0040 | 0,0040 | 0,0048 | 0,0060 |
| S1 | MM12-12012-B90-MD05 F30M | 3,0 | 0,055 | 0,055 | 0,060 | 0,075 |
| | | 0,12 | 0,0022 | 0,0022 | 0,0024 | 0,0032 |
| S2 | MM12-12012-B90-MD05 F30M | 3,0 | 0,055 | 0,055 | 0,060 | 0,075 |
| | | 0,12 | 0,0022 | 0,0022 | 0,0024 | 0,0032 |
| S3 | MM12-12012-B90-MD05 F30M | 3,0 | 0,050 | 0,050 | 0,055 | 0,070 |
| | | 0,12 | 0,0020 | 0,0020 | 0,0022 | 0,0030 |
| S11 | MM12-12012-B90-MD05 F30M | 3,5 | 0,060 | 0,060 | 0,070 | 0,090 |
| | | 0,14 | 0,0024 | 0,0024 | 0,0028 | 0,0036 |
| S12 | MM12-12012-B90-MD05 F30M | 3,5 | 0,060 | 0,060 | 0,070 | 0,090 |
| | | 0,14 | 0,0024 | 0,0024 | 0,0028 | 0,0036 |
| S13 | MM12-12012-B90-MD05 F30M | 3,0 | 0,055 | 0,055 | 0,060 | 0,075 |
| | | 0,12 | 0,0022 | 0,0022 | 0,0024 | 0,0032 |
| H5 | MM12-12012-B90-MD05 F30M | 4,0 | 0,050 | 0,050 | 0,060 | 0,075 |
| | | 0,16 | 0,0020 | 0,0020 | 0,0024 | 0,0030 |
| H8 | MM12-12012-B90-MD05 F30M | 3,5 | 0,040 | 0,040 | 0,044 | 0,055 |
| | | 0,14 | 0,0016 | 0,0016 | 0,0017 | 0,0024 |
| H11 | MM12-12012-B90-MD05 F30M | 4,0 | 0,050 | 0,050 | 0,060 | 0,075 |
| | | 0,16 | 0,0020 | 0,0020 | 0,0024 | 0,0030 |
| H12 | MM12-12012-B90-MD05 F30M | 3,5 | 0,040 | 0,040 | 0,044 | 0,055 |
| | | 0,14 | 0,0016 | 0,0016 | 0,0017 | 0,0024 |
| H21 | MM12-12012-B90-MD05 F30M | 3,5 | 0,040 | 0,040 | 0,044 | 0,055 |
| | | 0,14 | 0,0016 | 0,0016 | 0,0017 | 0,0024 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MM12 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|---------------------------|----------------|----------------|---------|--------|--------|
| | | | 15% | 10% | 5% | 2% |
| P1 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,040 | 0,048 | 0,065 | 0,11 |
| | | 0.16 | 0.0016 | 0.0019 | 0.0026 | 0.0044 |
| P2 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,042 | 0,048 | 0,070 | 0,11 |
| | | 0.16 | 0.0017 | 0.0019 | 0.0028 | 0.0044 |
| P3 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,040 | 0,046 | 0,065 | 0,10 |
| | | 0.16 | 0.0016 | 0.0018 | 0.0026 | 0.0040 |
| P4 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,038 | 0,046 | 0,065 | 0,10 |
| | | 0.16 | 0.0015 | 0.0018 | 0.0026 | 0.0040 |
| P5 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,038 | 0,044 | 0,060 | 0,095 |
| | | 0.16 | 0.0015 | 0.0017 | 0.0024 | 0.0038 |
| P6 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,038 | 0,044 | 0,060 | 0,095 |
| | | 0.16 | 0.0015 | 0.0017 | 0.0024 | 0.0038 |
| P7 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,038 | 0,044 | 0,060 | 0,095 |
| | | 0.16 | 0.0015 | 0.0017 | 0.0024 | 0.0038 |
| P8 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,040 | 0,046 | 0,065 | 0,10 |
| | | 0.16 | 0.0016 | 0.0018 | 0.0026 | 0.0040 |
| P11 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,038 | 0,044 | 0,060 | 0,095 |
| | | 0.16 | 0.0015 | 0.0017 | 0.0024 | 0.0038 |
| P12 | MM12-12012-B90PF-M02 F15M | 3,5 | 0,026 | 0,030 | 0,042 | 0,065 |
| | | 0.14 | 0.0010 | 0.0012 | 0.0017 | 0.0026 |
| M1 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,042 | 0,048 | 0,070 | 0,11 |
| | | 0.16 | 0.0017 | 0.0019 | 0.0028 | 0.0044 |
| M2 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,038 | 0,044 | 0,060 | 0,095 |
| | | 0.16 | 0.0015 | 0.0017 | 0.0024 | 0.0038 |
| M3 | MM12-12012-B90PF-M02 F15M | 3,5 | 0,030 | 0,036 | 0,050 | 0,075 |
| | | 0.14 | 0.0012 | 0.0014 | 0.0020 | 0.0030 |
| M4 | MM12-12012-B90PF-M02 F15M | 2,5 | 0,028 | 0,032 | 0,042 | 0,065 |
| | | 0.10 | 0.0011 | 0.0013 | 0.0017 | 0.0026 |
| M5 | MM12-12012-B90PF-M02 F15M | 2,5 | 0,028 | 0,032 | 0,042 | 0,065 |
| | | 0.10 | 0.0011 | 0.0013 | 0.0017 | 0.0026 |
| K1 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,042 | 0,048 | 0,070 | 0,11 |
| | | 0.16 | 0.0017 | 0.0019 | 0.0028 | 0.0044 |
| K2 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,038 | 0,044 | 0,060 | 0,095 |
| | | 0.16 | 0.0015 | 0.0017 | 0.0024 | 0.0038 |
| K3 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,038 | 0,044 | 0,060 | 0,095 |
| | | 0.16 | 0.0015 | 0.0017 | 0.0024 | 0.0038 |
| K4 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,038 | 0,044 | 0,060 | 0,095 |
| | | 0.16 | 0.0015 | 0.0017 | 0.0024 | 0.0038 |
| K5 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,034 | 0,040 | 0,055 | 0,085 |
| | | 0.16 | 0.0013 | 0.0016 | 0.0022 | 0.0034 |
| K6 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,038 | 0,044 | 0,060 | 0,095 |
| | | 0.16 | 0.0015 | 0.0017 | 0.0024 | 0.0038 |
| K7 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,034 | 0,040 | 0,055 | 0,085 |
| | | 0.16 | 0.0013 | 0.0016 | 0.0022 | 0.0034 |
| N1 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,055 | 0,060 | 0,085 | 0,14 |
| | | 0.16 | 0.0022 | 0.0024 | 0.0034 | 0.0055 |
| N2 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,055 | 0,060 | 0,085 | 0,14 |
| | | 0.16 | 0.0022 | 0.0024 | 0.0034 | 0.0055 |
| N3 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,055 | 0,060 | 0,085 | 0,14 |
| | | 0.16 | 0.0022 | 0.0024 | 0.0034 | 0.0055 |
| N11 | MM12-12012-B90PF-M02 F15M | 4,0 | 0,055 | 0,060 | 0,085 | 0,14 |
| | | 0.16 | 0.0022 | 0.0024 | 0.0034 | 0.0055 |
| S1 | MM12-12012-B90PF-M02 F15M | 2,5 | 0,028 | 0,032 | 0,042 | 0,065 |
| | | 0.10 | 0.0011 | 0.0013 | 0.0017 | 0.0026 |
| S2 | MM12-12012-B90PF-M02 F15M | 2,5 | 0,028 | 0,032 | 0,042 | 0,065 |
| | | 0.10 | 0.0011 | 0.0013 | 0.0017 | 0.0026 |
| S3 | MM12-12012-B90PF-M02 F15M | 2,5 | 0,025 | 0,028 | 0,040 | 0,065 |
| | | 0.10 | 0.0010 | 0.0012 | 0.0016 | 0.0026 |
| S11 | MM12-12012-B90PF-M02 F15M | 3,0 | 0,030 | 0,036 | 0,050 | 0,075 |
| | | 0.12 | 0.0012 | 0.0014 | 0.0020 | 0.0030 |
| S12 | MM12-12012-B90PF-M02 F15M | 3,0 | 0,030 | 0,036 | 0,050 | 0,075 |
| | | 0.12 | 0.0012 | 0.0014 | 0.0020 | 0.0030 |
| S13 | MM12-12012-B90PF-M02 F15M | 2,5 | 0,028 | 0,032 | 0,042 | 0,065 |
| | | 0.10 | 0.0011 | 0.0013 | 0.0017 | 0.0026 |
| H5 | MM12-12012-B90PF-M02 F15M | 3,5 | 0,026 | 0,030 | 0,042 | 0,065 |
| | | 0.14 | 0.0010 | 0.0012 | 0.0017 | 0.0026 |
| H8 | MM12-12012-B90PF-M02 F15M | 3,0 | 0,020 | 0,024 | 0,032 | 0,050 |
| | | 0.12 | 0.00080 | 0.00095 | 0.0013 | 0.0020 |
| H11 | MM12-12012-B90PF-M02 F15M | 3,5 | 0,026 | 0,030 | 0,042 | 0,065 |
| | | 0.14 | 0.0010 | 0.0012 | 0.0017 | 0.0026 |
| H12 | MM12-12012-B90PF-M02 F15M | 3,0 | 0,020 | 0,024 | 0,032 | 0,050 |
| | | 0.12 | 0.00080 | 0.00095 | 0.0013 | 0.0020 |
| H21 | MM12-12012-B90PF-M02 F15M | 3,0 | 0,020 | 0,024 | 0,032 | 0,050 |
| | | 0.12 | 0.00080 | 0.00095 | 0.0013 | 0.0020 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

Unversell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MM12 Z2 – Kopierfräser – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | F15M | | | | | F30M | | | | | T60M | | | | |
|-----|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|
| | 100% | 20% | 10% | 5% | 2% | 100% | 20% | 10% | 5% | 2% | 100% | 20% | 10% | 5% | 2% |
| P1 | 310 | 390 | 410 | 445 | 440 | 240 | 300 | 325 | 350 | 345 | 195 | 240 | 265 | 285 | 280 |
| | 1025 | 1275 | 1350 | 1450 | 1450 | 790 | 980 | 1075 | 1150 | 1125 | 640 | 790 | 870 | 940 | 920 |
| P2 | 300 | 380 | 400 | 430 | 430 | 230 | 290 | 315 | 340 | 340 | 185 | 235 | 255 | 275 | 275 |
| | 980 | 1250 | 1300 | 1400 | 1400 | 750 | 950 | 1025 | 1125 | 1125 | 610 | 770 | 840 | 900 | 900 |
| P3 | 260 | 330 | 345 | 370 | 370 | 200 | 255 | 275 | 295 | 295 | 160 | 205 | 225 | 240 | 240 |
| | 850 | 1075 | 1125 | 1225 | 1225 | 660 | 840 | 900 | 970 | 970 | 520 | 670 | 740 | 790 | 790 |
| P4 | 230 | 290 | 305 | 325 | 330 | 175 | 225 | 245 | 260 | 260 | 145 | 180 | 195 | 210 | 210 |
| | 750 | 950 | 1000 | 1075 | 1075 | 570 | 740 | 800 | 850 | 850 | 475 | 590 | 640 | 690 | 690 |
| P5 | 220 | 275 | 290 | 315 | 315 | 170 | 215 | 235 | 255 | 250 | 140 | 170 | 190 | 205 | 200 |
| | 720 | 900 | 950 | 1025 | 1025 | 560 | 710 | 770 | 840 | 820 | 460 | 560 | 620 | 670 | 660 |
| P6 | 245 | 310 | 325 | 355 | 355 | 190 | 240 | 260 | 285 | 280 | 155 | 195 | 210 | 230 | 225 |
| | 800 | 1025 | 1075 | 1175 | 1175 | 620 | 790 | 850 | 940 | 920 | 510 | 640 | 690 | 750 | 740 |
| P7 | 230 | 295 | 310 | 335 | 335 | 180 | 230 | 245 | 270 | 265 | 145 | 185 | 200 | 215 | 215 |
| | 750 | 970 | 1025 | 1100 | 1100 | 590 | 750 | 800 | 890 | 870 | 475 | 610 | 660 | 710 | 710 |
| P8 | 215 | 275 | 290 | 310 | 315 | 170 | 215 | 235 | 250 | 250 | 135 | 170 | 190 | 200 | 200 |
| | 710 | 900 | 950 | 1025 | 1025 | 560 | 710 | 770 | 820 | 820 | 445 | 560 | 620 | 660 | 660 |
| P11 | 225 | 285 | 300 | 325 | 325 | 175 | 220 | 240 | 260 | 255 | 140 | 180 | 195 | 210 | 210 |
| | 740 | 940 | 980 | 1075 | 1075 | 570 | 720 | 790 | 850 | 840 | 460 | 590 | 640 | 690 | 690 |
| P12 | 140 | 180 | 180 | 195 | 200 | 115 | 145 | 150 | 165 | 160 | 95 | 120 | 120 | 135 | 130 |
| | 460 | 590 | 610 | 640 | 660 | 375 | 475 | 510 | 540 | 520 | 310 | 395 | 410 | 445 | 425 |
| M1 | 240 | 305 | 320 | 345 | 345 | 185 | 235 | 255 | 275 | 270 | 150 | 190 | 205 | 225 | 220 |
| | 790 | 1000 | 1050 | 1125 | 1125 | 610 | 770 | 840 | 900 | 890 | 490 | 620 | 670 | 740 | 720 |
| M2 | 195 | 250 | 260 | 285 | 285 | 155 | 190 | 210 | 225 | 225 | 125 | 155 | 170 | 185 | 180 |
| | 640 | 820 | 850 | 940 | 940 | 510 | 620 | 690 | 740 | 740 | 410 | 510 | 560 | 610 | 590 |
| M3 | 155 | 200 | 205 | 220 | 220 | 125 | 160 | 165 | 180 | 180 | 100 | 130 | 135 | 145 | 145 |
| | 510 | 660 | 670 | 720 | 720 | 410 | 520 | 560 | 590 | 590 | 330 | 425 | 445 | 475 | 475 |
| M4 | 120 | 155 | 155 | 165 | 165 | 100 | 130 | 130 | 135 | 140 | 80 | 105 | 105 | 110 | 110 |
| | 395 | 510 | 540 | 540 | 540 | 330 | 425 | 445 | 445 | 460 | 260 | 345 | 360 | 360 | 360 |
| M5 | 100 | 130 | 130 | 140 | 140 | 85 | 110 | 105 | 115 | 115 | 70 | 85 | 85 | 95 | 95 |
| | 330 | 425 | 460 | 460 | 460 | 280 | 360 | 375 | 375 | 375 | 230 | 280 | 295 | 310 | 310 |
| K1 | 235 | 300 | 315 | 340 | 340 | 180 | 230 | 250 | 270 | 270 | 145 | 185 | 205 | 220 | 215 |
| | 770 | 980 | 1025 | 1125 | 1125 | 590 | 750 | 820 | 890 | 890 | 475 | 610 | 670 | 720 | 710 |
| K2 | 205 | 265 | 275 | 300 | 300 | 160 | 200 | 220 | 240 | 235 | 130 | 165 | 180 | 195 | 190 |
| | 670 | 870 | 900 | 980 | 980 | 520 | 660 | 720 | 790 | 770 | 425 | 540 | 590 | 640 | 620 |
| K3 | 175 | 225 | 235 | 255 | 255 | 135 | 170 | 185 | 205 | 200 | 110 | 140 | 150 | 165 | 165 |
| | 570 | 740 | 770 | 840 | 840 | 445 | 560 | 610 | 670 | 660 | 360 | 460 | 490 | 540 | 540 |
| K4 | 165 | 215 | 225 | 240 | 240 | 130 | 165 | 180 | 195 | 190 | 105 | 130 | 145 | 155 | 155 |
| | 540 | 710 | 740 | 790 | 790 | 425 | 540 | 590 | 640 | 620 | 345 | 425 | 475 | 510 | 510 |
| K5 | 100 | 130 | 135 | 145 | 145 | 80 | 100 | 110 | 115 | 115 | 65 | 80 | 85 | 95 | 95 |
| | 330 | 425 | 445 | 475 | 475 | 260 | 330 | 360 | 375 | 375 | 215 | 260 | 280 | 310 | 310 |
| K6 | 145 | 185 | 195 | 215 | 215 | 115 | 145 | 155 | 170 | 170 | 95 | 115 | 125 | 140 | 135 |
| | 475 | 610 | 640 | 710 | 710 | 375 | 475 | 510 | 560 | 560 | 310 | 375 | 410 | 460 | 445 |
| K7 | 130 | 165 | 170 | 185 | 185 | 100 | 125 | 140 | 150 | 150 | 80 | 105 | 110 | 120 | 120 |
| | 425 | 540 | 560 | 610 | 610 | 330 | 410 | 460 | 490 | 490 | 260 | 345 | 360 | 395 | 395 |
| N1 | 1825 | 2300 | 2425 | 2625 | 2600 | 1375 | 1725 | 1900 | 2025 | 2000 | 1100 | 1400 | 1525 | 1650 | 1625 |
| | 6000 | 7550 | 7950 | 8600 | 8525 | 4500 | 5650 | 6225 | 6650 | 6550 | 3600 | 4600 | 5000 | 5425 | 5325 |
| N2 | 730 | 930 | 980 | 1050 | 1050 | 550 | 690 | 760 | 820 | 810 | 450 | 560 | 620 | 660 | 660 |
| | 2400 | 3050 | 3225 | 3450 | 3450 | 1800 | 2275 | 2500 | 2700 | 2650 | 1475 | 1825 | 2025 | 2175 | 2175 |
| N3 | 490 | 620 | 650 | 710 | 700 | 370 | 465 | 510 | 550 | 540 | 300 | 375 | 410 | 440 | 440 |
| | 1600 | 2025 | 2125 | 2325 | 2300 | 1225 | 1525 | 1675 | 1800 | 1775 | 980 | 1225 | 1350 | 1450 | 1450 |
| N11 | 560 | 710 | 750 | 810 | 800 | 425 | 530 | 580 | 620 | 620 | 340 | 430 | 470 | 500 | 500 |
| | 1825 | 2325 | 2450 | 2650 | 2625 | 1400 | 1750 | 1900 | 2025 | 2025 | 1125 | 1400 | 1550 | 1650 | 1650 |
| S1 | 55 | 70 | 70 | 80 | 80 | 47 | 60 | 60 | 65 | 65 | 38 | 49 | 48 | 50 | 50 |
| | 180 | 230 | 260 | 260 | 260 | 155 | 195 | 215 | 215 | 215 | 125 | 160 | 165 | 165 | 165 |
| S2 | 45 | 60 | 60 | 65 | 65 | 38 | 49 | 48 | 50 | 50 | 31 | 39 | 39 | 42 | 42 |
| | 150 | 195 | 215 | 215 | 215 | 125 | 160 | 165 | 165 | 165 | 100 | 130 | 135 | 140 | 140 |
| S3 | 39 | 50 | 50 | 55 | 55 | 33 | 43 | 42 | 45 | 45 | 27 | 34 | 34 | 37 | 36 |
| | 130 | 165 | 180 | 180 | 180 | 110 | 140 | 145 | 150 | 150 | 90 | 110 | 120 | 120 | 120 |
| S11 | 80 | 105 | 105 | 110 | 110 | 65 | 85 | 85 | 90 | 90 | 55 | 70 | 70 | 75 | 75 |
| | 260 | 345 | 360 | 360 | 360 | 215 | 280 | 280 | 295 | 295 | 180 | 230 | 230 | 245 | 245 |
| S12 | 55 | 70 | 70 | 75 | 75 | 45 | 60 | 60 | 65 | 60 | 37 | 47 | 47 | 50 | 50 |
| | 180 | 230 | 245 | 245 | 245 | 150 | 195 | 195 | 215 | 195 | 120 | 155 | 160 | 165 | 165 |
| S13 | 32 | 41 | 40 | 44 | 44 | 26 | 34 | 34 | 36 | 36 | 21 | 28 | 27 | 29 | 29 |
| | 105 | 135 | 145 | 145 | 145 | 85 | 110 | 120 | 120 | 120 | 70 | 90 | 95 | 95 | 95 |
| H5 | 46 | 60 | 60 | 65 | 65 | 38 | 48 | 50 | 55 | 55 | 31 | 39 | 41 | 44 | 44 |
| | 150 | 195 | 195 | 215 | 215 | 125 | 155 | 165 | 180 | 180 | 100 | 130 | 135 | 145 | 145 |
| H8 | 48 | 60 | 60 | 65 | 65 | 40 | 50 | 50 | 55 | 55 | 33 | 42 | 42 | 46 | 45 |
| | 155 | 195 | 215 | 215 | 215 | 130 | 165 | 180 | 180 | 180 | 110 | 140 | 140 | 150 | 150 |
| H11 | 60 | 75 | 75 | 85 | 85 | 49 | 60 | 65 | 70 | 70 | 39 | 50 | 50 | 55 | 55 |
| | 195 | 245 | 260 | 280 | 280 | 160 | 195 | 215 | 230 | 230 | 130 | 165 | 165 | 180 | 180 |
| H12 | 85 | 110 | 110 | 120 | 120 | 70 | 95 | 95 | 100 | 100 | 60 | 75 | 75 | 80 | 80 |
| | 280 | 360 | 375 | 395 | 395 | 230 | 310 | 310 | 330 | 330 | 195 | 245 | 260 | 260 | 260 |
| H21 | 48 | 60 | 60 | 65 | 65 | 40 | 50 | 50 | 55 | 55 | 33 | 42 | 42 | 46 | 45 |
| | 155 | 195 | 215 | 215 | 215 | 130 | 165 | 180 | 180 | 180 | 110 | 140 | 140 | 150 | 150 |

MM12 Hohe Vorschübe – Auswahl der Wendeschneidplatten – Schlichten – mm/Zoll

| SMG | | a _p | f _z | | | |
|-----|-------------------------|----------------|----------------|-------|-------|-------|
| | | | 100% | 70% | 30% | 20% |
| P1 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,55 | 0,55 | 0,75 | 0,95 |
| | | 0,014 | 0,022 | 0,022 | 0,030 | 0,038 |
| P2 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,55 | 0,60 | 0,75 | 0,95 |
| | | 0,014 | 0,022 | 0,024 | 0,030 | 0,038 |
| P3 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,55 | 0,55 | 0,70 | 0,90 |
| | | 0,014 | 0,022 | 0,022 | 0,028 | 0,036 |
| P4 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,55 | 0,55 | 0,70 | 0,90 |
| | | 0,014 | 0,022 | 0,022 | 0,028 | 0,036 |
| P5 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,50 | 0,55 | 0,70 | 0,85 |
| | | 0,014 | 0,020 | 0,022 | 0,028 | 0,034 |
| P6 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,50 | 0,50 | 0,70 | 0,85 |
| | | 0,014 | 0,020 | 0,020 | 0,028 | 0,034 |
| P7 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,50 | 0,50 | 0,70 | 0,85 |
| | | 0,014 | 0,020 | 0,020 | 0,028 | 0,034 |
| P8 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,55 | 0,55 | 0,70 | 0,90 |
| | | 0,014 | 0,022 | 0,022 | 0,028 | 0,036 |
| P11 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,50 | 0,50 | 0,70 | 0,85 |
| | | 0,014 | 0,020 | 0,020 | 0,028 | 0,034 |
| P12 | MM12-12.60-HF-MD10 F30M | 0,28 | 0,36 | 0,36 | 0,46 | 0,55 |
| | | 0,011 | 0,014 | 0,014 | 0,018 | 0,022 |
| M1 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,55 | 0,60 | 0,75 | 0,95 |
| | | 0,014 | 0,022 | 0,024 | 0,030 | 0,038 |
| M2 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,50 | 0,55 | 0,70 | 0,85 |
| | | 0,014 | 0,020 | 0,022 | 0,028 | 0,034 |
| M3 | MM12-12.60-HF-MD10 F30M | 0,28 | 0,42 | 0,42 | 0,55 | 0,65 |
| | | 0,011 | 0,017 | 0,017 | 0,022 | 0,026 |
| M4 | MM12-12.60-HF-MD10 F30M | 0,22 | 0,36 | 0,36 | 0,48 | 0,60 |
| | | 0,0085 | 0,014 | 0,014 | 0,019 | 0,024 |
| M5 | MM12-12.60-HF-MD10 F30M | 0,22 | 0,36 | 0,36 | 0,48 | 0,60 |
| | | 0,0085 | 0,014 | 0,014 | 0,019 | 0,024 |
| K1 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,55 | 0,60 | 0,75 | 0,95 |
| | | 0,014 | 0,022 | 0,024 | 0,030 | 0,038 |
| K2 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,50 | 0,55 | 0,70 | 0,85 |
| | | 0,014 | 0,020 | 0,022 | 0,028 | 0,034 |
| K3 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,50 | 0,55 | 0,70 | 0,85 |
| | | 0,014 | 0,020 | 0,022 | 0,028 | 0,034 |
| K4 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,50 | 0,55 | 0,70 | 0,85 |
| | | 0,014 | 0,020 | 0,022 | 0,028 | 0,034 |
| K5 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,48 | 0,48 | 0,60 | 0,75 |
| | | 0,014 | 0,019 | 0,019 | 0,024 | 0,030 |
| K6 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,50 | 0,55 | 0,70 | 0,85 |
| | | 0,014 | 0,020 | 0,022 | 0,028 | 0,034 |
| K7 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,48 | 0,48 | 0,60 | 0,75 |
| | | 0,014 | 0,019 | 0,019 | 0,024 | 0,030 |
| N1 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,75 | 0,75 | 1,0 | 1,3 |
| | | 0,014 | 0,030 | 0,030 | 0,040 | 0,050 |
| N2 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,75 | 0,75 | 1,0 | 1,3 |
| | | 0,014 | 0,030 | 0,030 | 0,040 | 0,050 |
| N3 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,75 | 0,75 | 1,0 | 1,3 |
| | | 0,014 | 0,030 | 0,030 | 0,040 | 0,050 |
| N11 | MM12-12.60-HF-MD10 F30M | 0,36 | 0,75 | 0,75 | 1,0 | 1,3 |
| | | 0,014 | 0,030 | 0,030 | 0,040 | 0,050 |
| S1 | MM12-12.60-HF-MD10 F30M | 0,22 | 0,36 | 0,36 | 0,48 | 0,60 |
| | | 0,0085 | 0,014 | 0,014 | 0,019 | 0,024 |
| S2 | MM12-12.60-HF-MD10 F30M | 0,22 | 0,36 | 0,36 | 0,48 | 0,60 |
| | | 0,0085 | 0,014 | 0,014 | 0,019 | 0,024 |
| S3 | MM12-12.60-HF-MD10 F30M | 0,22 | 0,34 | 0,34 | 0,44 | 0,55 |
| | | 0,0085 | 0,013 | 0,013 | 0,017 | 0,022 |
| S11 | MM12-12.60-HF-MD10 F30M | 0,25 | 0,42 | 0,42 | 0,55 | 0,65 |
| | | 0,010 | 0,017 | 0,017 | 0,022 | 0,026 |
| S12 | MM12-12.60-HF-MD10 F30M | 0,25 | 0,42 | 0,42 | 0,55 | 0,65 |
| | | 0,010 | 0,017 | 0,017 | 0,022 | 0,026 |
| S13 | MM12-12.60-HF-MD10 F30M | 0,22 | 0,36 | 0,36 | 0,48 | 0,60 |
| | | 0,0085 | 0,014 | 0,014 | 0,019 | 0,024 |
| H5 | MM12-12.60-HF-MD10 F15M | 0,28 | 0,36 | 0,36 | 0,46 | 0,55 |
| | | 0,011 | 0,014 | 0,014 | 0,018 | 0,022 |
| H8 | MM12-12.60-HF-MD10 F15M | 0,25 | 0,28 | 0,28 | 0,36 | 0,42 |
| | | 0,010 | 0,011 | 0,011 | 0,014 | 0,017 |
| H11 | MM12-12.60-HF-MD10 F15M | 0,28 | 0,36 | 0,36 | 0,46 | 0,55 |
| | | 0,011 | 0,014 | 0,014 | 0,018 | 0,022 |
| H12 | MM12-12.60-HF-MD10 F15M | 0,25 | 0,28 | 0,28 | 0,36 | 0,42 |
| | | 0,010 | 0,011 | 0,011 | 0,014 | 0,017 |
| H21 | MM12-12.60-HF-MD10 F15M | 0,25 | 0,28 | 0,28 | 0,36 | 0,42 |
| | | 0,010 | 0,011 | 0,011 | 0,014 | 0,017 |

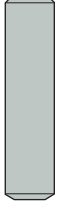
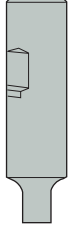
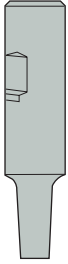
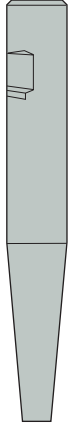

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

Universell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MM12 Hohe Vorschübe Schnittdaten $v_c = (m/min)/(sf/min)$

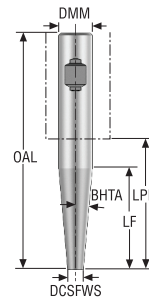
| | SMG | F15M | | | | F30M | | | |
|-------------------------------|-----|------|-----|-----|-----|------|------|------|------|
| | | 100% | 70% | 30% | 20% | 100% | 70% | 30% | 20% |
| Universell | P1 | — | — | — | — | 225 | 275 | 315 | 330 |
| | | — | — | — | — | 740 | 900 | 1025 | 1075 |
| Stahl und Guss | P2 | — | — | — | — | 220 | 265 | 310 | 320 |
| | | — | — | — | — | 720 | 870 | 1025 | 1050 |
| Rostfrei und ISO-S-Werkstoffe | P3 | — | — | — | — | 190 | 230 | 270 | 280 |
| | | — | — | — | — | 620 | 750 | 890 | 920 |
| NE-Metalle | P4 | — | — | — | — | 165 | 205 | 235 | 245 |
| | | — | — | — | — | 540 | 670 | 770 | 800 |
| Harter | P5 | — | — | — | — | 165 | 195 | 225 | 240 |
| | | — | — | — | — | 540 | 640 | 740 | 790 |
| Kunststoffe und Composite | P6 | — | — | — | — | 185 | 225 | 255 | 270 |
| | | — | — | — | — | 610 | 740 | 840 | 890 |
| Graphit | P7 | — | — | — | — | 170 | 210 | 240 | 255 |
| | | — | — | — | — | 560 | 690 | 790 | 840 |
| X-Heads | P8 | — | — | — | — | 160 | 195 | 225 | 235 |
| | | — | — | — | — | 520 | 640 | 740 | 770 |
| Minimaster Plus | P11 | — | — | — | — | 165 | 205 | 235 | 245 |
| | | — | — | — | — | 540 | 670 | 770 | 800 |
| Minimaster | P12 | — | — | — | — | 110 | 130 | 150 | 160 |
| | | — | — | — | — | 360 | 425 | 490 | 520 |
| Minimaster Plus | M1 | — | — | — | — | 175 | 215 | 250 | 260 |
| | | — | — | — | — | 570 | 710 | 820 | 850 |
| Minimaster Plus | M2 | — | — | — | — | 145 | 175 | 205 | 215 |
| | | — | — | — | — | 475 | 570 | 670 | 710 |
| Minimaster Plus | M3 | — | — | — | — | 120 | 140 | 165 | 175 |
| | | — | — | — | — | 395 | 460 | 540 | 570 |
| Minimaster Plus | M4 | — | — | — | — | 95 | 110 | 125 | 130 |
| | | — | — | — | — | 310 | 360 | 410 | 425 |
| Minimaster Plus | M5 | — | — | — | — | 80 | 90 | 105 | 110 |
| | | — | — | — | — | 260 | 295 | 345 | 360 |
| Minimaster Plus | K1 | 185 | 225 | 260 | 275 | 175 | 210 | 245 | 255 |
| | | 610 | 740 | 850 | 900 | 570 | 690 | 800 | 840 |
| Minimaster Plus | K2 | 165 | 200 | 230 | 245 | 155 | 185 | 215 | 225 |
| | | 540 | 660 | 750 | 800 | 510 | 610 | 710 | 740 |
| Minimaster Plus | K3 | 140 | 170 | 195 | 205 | 130 | 155 | 180 | 190 |
| | | 460 | 560 | 640 | 670 | 425 | 510 | 590 | 620 |
| Minimaster Plus | K4 | 135 | 160 | 185 | 195 | 125 | 150 | 175 | 185 |
| | | 445 | 520 | 610 | 640 | 410 | 490 | 570 | 610 |
| Minimaster Plus | K5 | 80 | 100 | 115 | 120 | 75 | 90 | 105 | 110 |
| | | 260 | 330 | 375 | 395 | 245 | 295 | 345 | 360 |
| Minimaster Plus | K6 | 120 | 140 | 165 | 175 | 110 | 130 | 155 | 160 |
| | | 395 | 460 | 540 | 570 | 360 | 425 | 510 | 520 |
| Minimaster Plus | K7 | 105 | 125 | 145 | 155 | 95 | 115 | 135 | 145 |
| | | 345 | 410 | 475 | 510 | 310 | 375 | 445 | 475 |
| Minimaster Plus | N1 | — | — | — | — | 1275 | 1575 | 1800 | 1875 |
| | | — | — | — | — | 4175 | 5175 | 5900 | 6150 |
| Minimaster Plus | N2 | — | — | — | — | 520 | 630 | 730 | 750 |
| | | — | — | — | — | 1700 | 2075 | 2400 | 2450 |
| Minimaster Plus | N3 | — | — | — | — | 345 | 420 | 485 | 500 |
| | | — | — | — | — | 1125 | 1375 | 1600 | 1650 |
| Minimaster Plus | N11 | — | — | — | — | 395 | 480 | 550 | 570 |
| | | — | — | — | — | 1300 | 1575 | 1800 | 1875 |
| Minimaster Plus | S1 | — | — | — | — | 44 | 50 | 60 | 60 |
| | | — | — | — | — | 145 | 165 | 195 | 195 |
| Minimaster Plus | S2 | — | — | — | — | 35 | 41 | 47 | 50 |
| | | — | — | — | — | 115 | 135 | 155 | 165 |
| Minimaster Plus | S3 | — | — | — | — | 31 | 36 | 42 | 44 |
| | | — | — | — | — | 100 | 120 | 140 | 145 |
| Minimaster Plus | S11 | — | — | — | — | 60 | 70 | 85 | 90 |
| | | — | — | — | — | 195 | 230 | 280 | 295 |
| Minimaster Plus | S12 | — | — | — | — | 42 | 50 | 55 | 60 |
| | | — | — | — | — | 140 | 165 | 180 | 195 |
| Minimaster Plus | S13 | — | — | — | — | 25 | 29 | 33 | 35 |
| | | — | — | — | — | 80 | 95 | 110 | 115 |
| Minimaster Plus | H5 | 39 | 46 | 55 | 55 | 36 | 43 | 50 | 55 |
| | | 130 | 150 | 180 | 180 | 120 | 140 | 165 | 180 |
| Minimaster Plus | H8 | 41 | 49 | 55 | 60 | 38 | 45 | 50 | 55 |
| | | 135 | 160 | 180 | 195 | 125 | 150 | 165 | 180 |
| Minimaster Plus | H11 | 49 | 60 | 70 | 70 | 46 | 55 | 65 | 65 |
| | | 160 | 195 | 230 | 230 | 150 | 180 | 215 | 215 |
| Minimaster Plus | H12 | 75 | 90 | 100 | 105 | 70 | 80 | 95 | 100 |
| | | 245 | 295 | 330 | 345 | 230 | 260 | 310 | 330 |
| Minimaster Plus | H21 | 41 | 49 | 55 | 60 | 38 | 45 | 50 | 55 |
| | | 135 | 160 | 180 | 195 | 125 | 150 | 165 | 180 |

Schaftkonstruktion

| Ausführung 1, Keilnut-Schaft | Ausführung 2, Zylindrische/Weldon Schnittstelle und 90° Stirnseite |
|---|--|
|  |  |
| Ausführung 3, Zylindrische/Weldon Schnittstelle und 87°/89° Stirnseite | Konstruktion 4, Zylindrische/Weldon Schnittstelle und 80°/85°/87° Stirnseite |
|  |  |
| Ausführung 5, Zylindrische Schnittstelle und doppelt konische Stirnseite 89°/85° | |
|  | |

| |
|-------------------------------|
| Unversell |
| Stahl und Guss |
| Rostfrei und ISO-S-Werkstoffe |
| Rostfrei und ISO-S-Werkstoffe |
| NE-Metalle |
| Harter |
| Graphit |
| X-Heads |
| Minimaster Plus |
| Minimaster |

MM16 Schaft

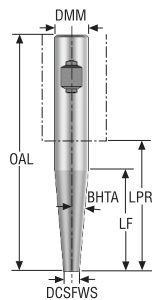


| Bezeichnung | Produkt- nummer | Aufnahme | DCSFWS | DMM | OAL | LF | LPR | BHTA° | Abb. | | RPMX | Gewicht | Ersatzteil |
|---------------------|--------------------|-------------|--------|------|-------|------|-------|-------|------|---|-------|---------|-------------|
| | | | | | | | | | | | | | Bezeichnung |
| | | | | | | | | | | | | | kg |
| MM16-20115.3-3045 | 75014109 | Weldon | 15,2 | 20,0 | 115,0 | 45,8 | 65,0 | 3,0 | 4 | ✓ | 63600 | 0,2 | 3 |
| MM16-25100.3-0019 | 75012790 | Weldon | 15,2 | 25,0 | 100,0 | 19,0 | 40,0 | 0,0 | 2 | ✓ | 63600 | 0,3 | 3 |
| MM16-25115.3-3035 | 75012791 | Weldon | 15,2 | 25,0 | 115,0 | 35,0 | 59,0 | 3,0 | 3 | ✓ | 63600 | 0,3 | 3 |
| MM16-25170.3-5056 | 75012792 | Weldon | 15,2 | 25,0 | 170,0 | 56,0 | 114,0 | 5,0 | 4 | ✓ | 63600 | 0,6 | 4 |
| MM16-16070.0-0011M | 00023547 | Zylindrisch | 15,2 | 16,0 | 70,0 | 11,3 | 22,0 | 0,0 | 2 | ✓ | 63600 | 0,1 | 1 |
| MM16-20070.0-0000 | 00023548 | Zylindrisch | 15,2 | 20,0 | 70,0 | 0,0 | 20,0 | 60,0 | 1 | ✓ | 63600 | 0,2 | 1 |
| MM16-20190.0-1055M | 00094766 | Zylindrisch | 15,2 | 20,0 | 190,0 | 55,0 | 140,0 | 1,0 | 3 | ✓ | 63600 | 0,4 | 5 |
| MM16-20190.0-1075M | 00094768 | Zylindrisch | 15,2 | 20,0 | 190,0 | 75,0 | 140,0 | 1,0 | 3 | ✓ | 63600 | 0,4 | 5 |
| MM16-20190.0-1095M | 00094770 | Zylindrisch | 15,2 | 20,0 | 190,0 | 95,0 | 140,0 | 1,0 | 3 | ✓ | 63600 | 0,4 | 6 |
| MM16-25170.0-1060 | 00094767 | Zylindrisch | 19,0 | 25,0 | 170,0 | 60,0 | 114,0 | 1,0 | 3 | ✓ | 63600 | 0,5 | 5 |
| MM16-32250.0-10047 | 75069368 | Zylindrisch | 15,2 | 32,0 | 250,0 | 47,6 | 190,0 | 10,0 | 4 | ✓ | 63600 | 1,3 | 4 |
| MM16-16150.0-0080DS | 02580692 | Zylindrisch | 15,2 | 16,0 | 150,0 | 80,0 | 102,0 | 0,0 | 2 | ✓ | 47600 | 0,4 | 2 |
| MM16-20080.0-0011DS | 02580669 | Zylindrisch | 15,2 | 20,0 | 80,0 | 11,3 | 30,0 | 0,0 | 2 | ✓ | 47600 | 0,3 | 2 |
| MM16-20150.0-0038DS | 02580695 | Zylindrisch | 15,2 | 20,0 | 150,0 | 38,0 | 100,0 | 0,0 | 2 | ✓ | 47600 | 0,6 | 2 |
| MM16-20160.0-0076DS | 02580699 | Zylindrisch | 15,2 | 20,0 | 160,0 | 76,0 | 110,0 | 0,0 | 2 | ✓ | 47600 | 0,6 | 2 |
| MM16-20130.0-1045DS | 02580757 | Zylindrisch | 15,2 | 20,0 | 130,0 | 45,0 | 80,0 | 1,0 | 3 | ✓ | 47600 | 0,5 | 2 |
| MM16-20190.0-1075DS | 02580758 | Zylindrisch | 15,2 | 20,0 | 190,0 | 75,0 | 140,0 | 1,0 | 3 | ✓ | 47600 | 0,8 | 2 |
| MM16-20190.0-1095DS | 02580760 | Zylindrisch | 15,2 | 20,0 | 190,0 | 95,0 | 140,0 | 1,0 | 3 | ✓ | 47600 | 0,8 | 2 |
| MM16-25250.0-1075DS | 02580761 | Zylindrisch | 15,2 | 25,0 | 250,0 | 75,0 | 194,0 | 1,0 | 5 | ✓ | 47600 | 1,5 | 2 |

Ersatzteile, im Lieferumfang enthalten

| Für Fräser | Hülse | Spannschraube |
|------------|--------------|---------------|
| 3 | MM-10062 | MM16-1045 |
| 4 | MM-10132 | MM16-1045 |
| 1 | MM-10030 | MM16-1045 |
| 5 | MM-10062 | MM16-1093 |
| 6 | MM-10062 | MM16-10113 |
| 2 | - | MM16-1045 |

MM16 Schaft – Zoll



| Bezeichnung | Produkt- nummer | Aufnahme | DCSFMS | DMM | OAL | LF | LPR | BHTA° | Abb. | | RPMX | Gewicht | Ersatzteil Bezeichnung |
|------------------------|--------------------|-------------|--------|-------|-------|-------|-------|-------|------|---|-------|---------|---------------------------|
| | | | Zoll | Zoll | Zoll | Zoll | Zoll | | | | | lbs | |
| MM16-0.75-4.5-3-3018 | 75054603 | Weldon | 0.598 | 0.750 | 4.528 | 1.445 | 2.559 | 3,0 | 3 | ✓ | 63600 | 0.440 | 4 |
| MM16-1.00-3.9-3-0007 | 75015058 | Weldon | 0.598 | 1.000 | 3.937 | 0.748 | 1.732 | 0,0 | 2 | ✓ | 63600 | 0.660 | 4 |
| MM16-1.00-4.5-3-3013 | 75015059 | Weldon | 0.598 | 1.000 | 4.528 | 1.378 | 2.323 | 3,0 | 3 | ✓ | 63600 | 0.660 | 4 |
| MM16-1.00-6.7-3-5022 | 75015060 | Weldon | 0.598 | 1.000 | 6.693 | 2.295 | 4.488 | 5,0 | 4 | ✓ | 63600 | 1.320 | 5 |
| MM16-0.62-2.8-0M-0004 | 00037209 | Zylindrisch | 0.598 | 0.625 | 2.756 | 0.445 | 0.866 | 0,0 | 2 | ✓ | 63600 | 0.220 | 1 |
| MM16-0.75-2.8-0-0000 | 00037175 | Zylindrisch | 0.598 | 0.750 | 2.756 | 0 | 0.787 | 60,0 | 1 | ✓ | 63600 | 0.440 | 1 |
| MM16-0.75-7.5-0-1021 | 75054731 | Zylindrisch | 0.598 | 0.750 | 7.480 | 2.165 | 5.512 | 1,0 | 3 | ✓ | 63600 | 0.660 | 6 |
| MM16-0.75-7.5-0-1037 | 75054733 | Zylindrisch | 0.598 | 0.750 | 7.480 | 3.740 | 5.512 | 1,0 | 3 | ✓ | 63600 | 0.880 | 7 |
| MM16-0.75-7.5-0-1029DS | 02567719 | Zylindrisch | 0.598 | 0.750 | 7.480 | 2.953 | 5.512 | 1,0 | 3 | ✓ | 47600 | 1.760 | 3 |
| MM16-0.75-7.5-0-1037DS | 02593431 | Zylindrisch | 0.598 | 0.750 | 7.480 | 3.740 | 5.512 | 1,0 | 3 | ✓ | 47600 | 1.540 | 3 |
| MM16-1.00-5.9-0-0015DS | 02593433 | Zylindrisch | 0.598 | 1.000 | 5.906 | 1.496 | 3.701 | 0,0 | 2 | ✓ | 47600 | 2.200 | 3 |
| MM16-1.00-6.3-0-0030DS | 02593434 | Zylindrisch | 0.598 | 1.000 | 6.299 | 2.992 | 4.094 | 0,0 | 2 | ✓ | 47600 | 1.980 | 3 |

Ersatzteile, im Lieferumfang enthalten

| Für Fräser | Hülse | Spannschraube |
|------------|--------------|---------------|
| 4 | MM-10062 | MM16-1045 |
| 5 | MM-10132 | MM16-1045 |
| 1 | MM-10030 | MM16-1045 |
| 6 | MM-10062 | MM16-1093 |
| 7 | MM-10062 | MM16-10113 |
| 3 | - | MM16-1045 |

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NE-Metalle

Harter

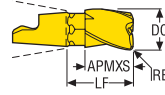
Graphit

X-Heads

Minimaster Plus

Minimaster

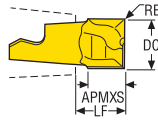
Nutfräsen/Eckfräsen




• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | RE | LF | RMPX° | C min | C max | FHA | ZEPF | Schlüssel | Beschichtung | | | | | | |
|-----------------------|-----------------|----------------|--------------|----------------|-------|-------|-------|-----|------|-----------|--------------|------|------|------|--|---|---|
| | | | | | | | | | | | Beschichtet | | | | | | |
| | | | | | | | | | | | T60M | F15M | F30M | F40M | | | |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | | | | | | | | | | |
| MM16-15719-R03A30-M06 | 15,7 0.618 | 19,05 0.750 | 0,3 0.012 | 24,5 0.965 | 15,0 | 19,0 | 30,6 | 30 | 3 | MM0416 | ✓ | | | | | | ■ |
| MM16-15919-R08A30-M06 | 15,875 0.625 | 19,05 0.750 | 0,8 0.031 | 24,5 0.965 | 15,0 | 19,2 | 29,9 | 30 | 3 | MM0416 | ✓ | | | | | | ■ |
| MM16-16019-A30-E06 | 16,0 0.630 | 19,05 0.750 | 0,0 - | 24,5 0.965 | 15,0 | 19,4 | 31,8 | 30 | 3 | MM0416 | ✓ | | | | | ■ | |
| MM16-16019-R05A30-M06 | 16,0 0.630 | 19,05 0.750 | 0,5 0.020 | 24,5 0.965 | 15,0 | 19,4 | 30,8 | 30 | 3 | MM0416 | ✓ | | | | | | ■ |
| MM16-16019-R10A30-E06 | 16,0 0.630 | 19,05 0.750 | 1,0 0.039 | 24,5 0.965 | 15,0 | 19,4 | 29,8 | 30 | 3 | MM0416 | ✓ | | | | | ■ | |
| MM16-16019-R10A30-M06 | 16,0 0.630 | 19,05 0.750 | 1,0 0.039 | 24,5 0.965 | 15,0 | 19,4 | 29,8 | 30 | 3 | MM0416 | ✓ | | | | | | ■ |
| MM16-16019-R20A30-M06 | 16,0 0.630 | 19,05 0.750 | 2,0 0.079 | 24,5 0.965 | 15,0 | 19,4 | 27,8 | 30 | 3 | MM0416 | ✓ | | | | | | ■ |
| MM16-16019-R30A30-E06 | 16,0 0.630 | 19,05 0.750 | 3,0 0.118 | 24,5 0.965 | 15,0 | 19,4 | 25,8 | 30 | 3 | MM0416 | ✓ | | | | | ■ | |
| MM16-16019-R30A30-M06 | 16,0 0.630 | 19,05 0.750 | 3,0 0.118 | 24,5 0.965 | 15,0 | 19,4 | 25,8 | 30 | 3 | MM0416 | ✓ | | | | | | ■ |
| MM16-16019-R40A30-M06 | 16,0 0.630 | 19,05 0.750 | 4,0 0.157 | 24,5 0.965 | 15,0 | 19,4 | 23,8 | 30 | 3 | MM0416 | ✓ | | | | | | ■ |
| MM16-16019-R50A30-M06 | 16,0 0.630 | 19,05 0.750 | 5,0 0.197 | 24,5 0.965 | 15,0 | 19,4 | 21,8 | 30 | 3 | MM0416 | ✓ | | | | | | ■ |
| MM16-16019-R60A30-M06 | 16,0 0.630 | 19,05 0.750 | 6,0 0.236 | 24,5 0.965 | 15,0 | 19,4 | 19,8 | 30 | 3 | MM0416 | ✓ | | | | | | ■ |
| MM16-20015-A30-E06 | 20,0 0.787 | 15,0 0.591 | 0,0 - | 20,15 0.793 | 15,0 | 24,2 | 39,8 | 30 | 3 | MM0416 | ✓ | | | | | ■ | |
| MM16-20015-R05A30-M06 | 20,0 0.787 | 15,0 0.591 | 0,5 0.020 | 20,15 0.793 | 15,0 | 24,2 | 38,8 | 30 | 3 | MM0416 | ✓ | | | | | | ■ |
| MM16-20015-R10A30-M06 | 20,0 0.787 | 15,0 0.591 | 1,0 0.039 | 20,15 0.793 | 15,0 | 24,2 | 37,8 | 30 | 3 | MM0416 | ✓ | | | | | | ■ |
| MM16-20015-R20A30-D06 | 20,0 0.787 | 15,0 0.591 | 2,0 0.079 | 20,15 0.793 | 15,0 | 24,2 | 35,8 | 30 | 3 | MM0416 | ✓ | | | | | ■ | |
| MM16-20015-R30A30-M06 | 20,0 0.787 | 15,0 0.591 | 3,0 0.118 | 20,15 0.793 | 15,0 | 24,2 | 33,8 | 30 | 3 | MM0416 | ✓ | | | | | | ■ |
| MM16-20015-R50A30-M06 | 20,0 0.787 | 15,0 0.591 | 5,0 0.197 | 20,15 0.793 | 15,0 | 24,2 | 29,8 | 30 | 3 | MM0416 | ✓ | | | | | | ■ |

Nutfräsen/Eckfräsen



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | RE | LF | RMPX° | C min | C max | FHA | ZEFP | Schlüssel  | Beschichtung | | | |
|----------------------|----------------|---------------|--------------|----------------|-------|-------|-------|-----|------|---|--------------|------|------|------|
| | | | | | | | | | | | Beschichtet | | | |
| | | | | | | | | | | | T60M | F15M | F30M | F40M |
| | mm Zoll | mm Zoll | mm Zoll | mm Zoll | | | | | | | | | | |
| MM16-15711T-R03-D07 | 15,7 0.618 | 11,0 0.433 | 0,3 0.012 | 13,6 0.535 | 15,0 | 19,0 | 30,6 | 0 | 2 | MM1420 | ■ | | | |
| MM16-16011-M06 | 16,0 0.630 | 11,0 0.433 | 0,0 - | 13,6 0.535 | 15,0 | 19,4 | 31,8 | 0 | 2 | MM1420 | ■ | | | |
| MM16-16011-R08A8-E06 | 16,0 0.630 | 10,5 0.413 | 0,8 0.031 | 13,62 0.536 | 15,0 | 19,4 | 30,2 | 8 | 2 | MM1420 | ■ | | ■ | |
| MM16-16011-R08-MD07 | 16,0 0.630 | 11,0 0.433 | 0,8 0.031 | 13,58 0.535 | 15,0 | 19,4 | 30,2 | 0 | 2 | MM1420 | ■ | | ■ | |
| MM16-16011-R08P-M05 | 16,0 0.630 | 10,8 0.425 | 0,8 0.031 | 13,41 0.528 | 15,0 | 19,4 | 30,2 | 0 | 2 | MM1420 | | | ■ | |
| MM16-16011-R20-MD07 | 16,0 0.630 | 10,9 0.429 | 2,0 0.079 | 13,55 0.533 | 15,0 | 19,4 | 27,8 | 0 | 2 | MM1420 | | | ■ | |
| MM16-16011-R30-MD07 | 16,0 0.630 | 10,9 0.429 | 3,0 0.118 | 13,54 0.533 | 15,0 | 19,4 | 25,8 | 0 | 2 | MM1420 | | | ■ | |
| MM16-16011-R40-MD07 | 16,0 0.630 | 10,9 0.429 | 4,0 0.157 | 13,52 0.532 | 15,0 | 19,4 | 23,8 | 0 | 2 | MM1420 | ■ | | | |
| MM16-16011-R50-MD07 | 16,0 0.630 | 10,9 0.429 | 5,0 0.197 | 13,5 0.531 | 15,0 | 19,4 | 21,8 | 0 | 2 | MM1420 | ■ | | | |
| MM16-19013-R08A8-E06 | 19,05 0.750 | 12,7 0.500 | 0,8 0.031 | 15,39 0.606 | 15,0 | 23,1 | 36,3 | 8 | 2 | MM1420 | | | ■ | |
| MM16-20013-R08A8-E06 | 20,0 0.787 | 12,7 0.500 | 0,8 0.031 | 15,42 0.607 | 15,0 | 24,2 | 38,2 | 8 | 2 | MM1420 | ■ | | ■ | |

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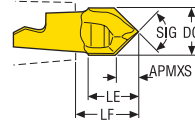
Graphit

X-Heads

Minimaster Plus

Minimaster

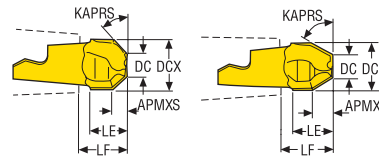
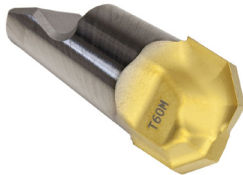
Zentrierbohren



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | LE | LF | SIG° | ZEFP | Schlüssel | Beschichtung | | | |
|---------------------|----------------|---------------|----------------|----------------|-------|------|-----------|--------------|------|------|------|
| | | | | | | | | T60M | F15M | F30M | F40M |
| MM16-16008-C90-M06 | 16,0 0.630 | 7,53 0.296 | 16,7 0.657 | 19,2 0.756 | 90,0 | 2 | MM1420 | ■ | | | |
| MM16-16011-C120-M06 | 16,0 0.630 | 4,3 0.169 | 16,64 0.655 | 18,9 0.744 | 120,0 | 2 | MM1420 | ■ | | | |
| MM16-19019-C90 | 19,05 0.750 | 9,6 0.378 | 20,3 0.799 | 22,15 0.872 | 90,0 | 2 | MM1420 | ■ | | | |

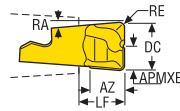
Anfasen




• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DCX | DC | APMXS | LE | LF | KAPRS° | ZEFP | Schlüssel | Beschichtung | | | |
|---------------------|---------------|---------------|--------------|---------------|----------------|--------|------|-----------|--------------|------|------|------|
| | | | | | | | | | T60M | F15M | F30M | F40M |
| MM16-16011-4540-E06 | 16,0 0.630 | 7,69 0.303 | 3,9 0.154 | 10,9 0.429 | 13,25 0.522 | 45,0 | 2 | MM1420 | ■ | | | |
| MM16-16012-6060-E06 | 16,0 0.630 | 8,38 0.330 | 6,7 0.264 | 12,9 0.508 | 15,3 0.602 | 60,0 | 2 | MM1420 | ■ | | | |

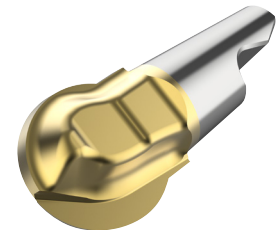
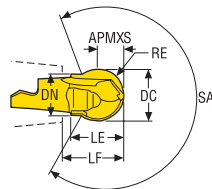
Tauchfräser




• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXE | RE | AZ | LF | RA° | ZEFP | Schlüssel  | Beschichtung | | | |
|------------------------|---------------|--------------|--------------|---------------|---------------|-----|------|---|--------------|------|------|------|
| | | | | | | | | | T60M | F15M | F30M | F40M |
| MM16-16011-R10-PL-MD07 | 16,0 0.630 | 8,0 0.315 | 1,0 0.039 | 11,3 0.445 | 11,3 0.445 | 5,0 | 2 | MM1420 | | | ■ | |
| MM16-16011-R20-PL-MD07 | 16,0 0.630 | 8,0 0.315 | 2,0 0.079 | 11,3 0.445 | 11,3 0.445 | 5,0 | 2 | MM1420 | | | ■ | |

Präzisionswendeschneidplatten zum Vorschlichten in allen Werkstoffen



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | RE | LE | LF | DN | SA | ZEFP | Schlüssel  | Beschichtung | | | |
|-----------------------|---------------|---------------|---------------|---------------|----------------|---------------|-------|------|---|--------------|------|------|------|
| | | | | | | | | | | T60M | F15M | F30M | F40M |
| MM16-20020-B120PF-M04 | 20,0 0.787 | 10,0 0.394 | 10,0 0.394 | 20,0 0.787 | 21,94 0.864 | 15,9 0.626 | 254,0 | 2 | MM1420 | | ■ | | |
| MM16-20020-B120P-M07 | 20,0 0.787 | 10,0 0.394 | 10,0 0.394 | 20,0 0.787 | 21,94 0.864 | 15,9 0.626 | 254,0 | 2 | MM1420 | | | ■ | |

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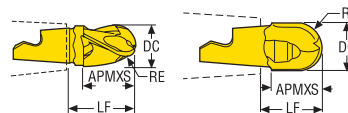
Graphit

X-Heads

Minimaster Plus

Minimaster

Kopierfräser



• Drehmomentschlüssel und Drehmomente, siehe Seite 725

| Bezeichnung | DC | APMXS | RE | LF | FHA | ZEFP | Schlüssel | Beschichtung | | | |
|-----------------------|-----------------|---------------|----------------|----------------|------|------|-----------|--------------|------|------|------|
| | | | | | | | | T60M | F15M | F30M | F40M |
| MM16-15916-B90P-M07 | 15,875 0.625 | 13,8 0.543 | 7,938 0.313 | 18,4 0.724 | 0,0 | 2 | MM1420 | | | ■ | |
| MM16-16016-B90-MD07 | 16,0 0.630 | 16,2 0.638 | 8,0 0.315 | 18,4 0.724 | 0,0 | 2 | MM1420 | ■ | | ■ | |
| MM16-16016-B90PF-M03 | 16,0 0.630 | 13,8 0.543 | 8,0 0.315 | 18,4 0.724 | 0,0 | 2 | MM1420 | | ■ | | |
| MM16-16016-B90P-M07 | 16,0 0.630 | 13,8 0.543 | 8,0 0.315 | 18,4 0.724 | 0,0 | 2 | MM1420 | | | ■ | |
| MM16-16019-B90A30-E06 | 16,0 0.630 | 19,0 0.748 | 8,0 0.315 | 24,5 0.965 | 30,0 | 3 | MM1420 ✓ | | | ■ | |
| MM16-16019-B90A30-M06 | 16,0 0.630 | 19,0 0.748 | 8,0 0.315 | 24,5 0.965 | 30,0 | 3 | MM1420 ✓ | | | | ■ |
| MM16-19020-B90P-M07 | 19,05 0.750 | 7,4 0.291 | 9,525 0.375 | 22,12 0.871 | 0,0 | 2 | MM1420 | ■ | | | |
| MM16-20015-B90A30-E06 | 20,0 0.787 | 15,0 0.591 | 10,0 0.394 | 20,15 0.793 | 30,0 | 3 | MM1420 ✓ | | | ■ | |
| MM16-20015-B90A30-M06 | 20,0 0.787 | 15,0 0.591 | 10,0 0.394 | 20,15 0.793 | 30,0 | 3 | MM1420 ✓ | | | | ■ |
| MM16-20020-B90-MD07 | 20,0 0.787 | 20,3 0.799 | 10,0 0.394 | 22,15 0.872 | 0,0 | 2 | MM1420 | ■ | | ■ | |
| MM16-20020-B90P-M07 | 20,0 0.787 | 17,4 0.685 | 10,0 0.394 | 22,12 0.871 | 0,0 | 2 | MM1420 | | | ■ | |

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Kunststoffe und Composite

Graphit

X-Heads

Minimaster Plus

Minimaster

MM16 - Nut- und Eckfräsen – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|----------------------------|----------------|----------------|--------|--------|--------|
| | | | 100% | 40% | 20% | 10% |
| P1 | MM16-16019-R05A30-M06 F40M | 3,5 | 0,085 | 0,085 | 0,11 | 0,14 |
| | | 0.14 | 0.0034 | 0.0034 | 0.0044 | 0.0055 |
| P2 | MM16-16019-R05A30-M06 F40M | 3,5 | 0,085 | 0,090 | 0,11 | 0,14 |
| | | 0.14 | 0.0034 | 0.0036 | 0.0044 | 0.0055 |
| P3 | MM16-16019-R05A30-M06 F40M | 3,5 | 0,080 | 0,085 | 0,10 | 0,14 |
| | | 0.14 | 0.0032 | 0.0034 | 0.0040 | 0.0055 |
| P4 | MM16-16019-R05A30-M06 F40M | 3,5 | 0,080 | 0,080 | 0,10 | 0,13 |
| | | 0.14 | 0.0032 | 0.0032 | 0.0040 | 0.0050 |
| P5 | MM16-16019-R05A30-M06 F40M | 3,5 | 0,080 | 0,080 | 0,10 | 0,13 |
| | | 0.14 | 0.0032 | 0.0032 | 0.0040 | 0.0050 |
| P6 | MM16-16019-R05A30-M06 F40M | 3,5 | 0,080 | 0,080 | 0,095 | 0,13 |
| | | 0.14 | 0.0032 | 0.0032 | 0.0038 | 0.0050 |
| P7 | MM16-16019-R05A30-M06 F40M | 3,5 | 0,080 | 0,080 | 0,095 | 0,13 |
| | | 0.14 | 0.0032 | 0.0032 | 0.0038 | 0.0050 |
| P8 | MM16-16019-R05A30-M06 F40M | 3,5 | 0,080 | 0,085 | 0,10 | 0,14 |
| | | 0.14 | 0.0032 | 0.0034 | 0.0040 | 0.0055 |
| P11 | MM16-16019-R05A30-M06 F40M | 3,5 | 0,080 | 0,080 | 0,095 | 0,13 |
| | | 0.14 | 0.0032 | 0.0032 | 0.0038 | 0.0050 |
| P12 | MM16-16019-R05A30-M06 F40M | 2,5 | 0,055 | 0,055 | 0,065 | 0,090 |
| | | 0.10 | 0.0022 | 0.0022 | 0.0026 | 0.0036 |
| M1 | MM16-16019-R05A30-M06 F40M | 3,5 | 0,085 | 0,090 | 0,11 | 0,14 |
| | | 0.14 | 0.0034 | 0.0036 | 0.0044 | 0.0055 |
| M2 | MM16-16019-R05A30-M06 F40M | 3,5 | 0,080 | 0,080 | 0,10 | 0,13 |
| | | 0.14 | 0.0032 | 0.0032 | 0.0040 | 0.0050 |
| M3 | MM16-16019-R05A30-M06 F40M | 2,5 | 0,065 | 0,065 | 0,080 | 0,10 |
| | | 0.10 | 0.0026 | 0.0026 | 0.0032 | 0.0040 |
| M4 | MM16-16019-R05A30-M06 F40M | 2,0 | 0,055 | 0,055 | 0,070 | 0,090 |
| | | 0.080 | 0.0022 | 0.0022 | 0.0028 | 0.0036 |
| M5 | MM16-16019-R05A30-M06 F40M | 2,0 | 0,055 | 0,055 | 0,070 | 0,090 |
| | | 0.080 | 0.0022 | 0.0022 | 0.0028 | 0.0036 |
| K1 | MM16-16019-R10A30-E06 F30M | 3,5 | 0,090 | 0,090 | 0,11 | 0,14 |
| | | 0.14 | 0.0036 | 0.0036 | 0.0044 | 0.0055 |
| K2 | MM16-16019-R10A30-E06 F30M | 3,5 | 0,080 | 0,080 | 0,10 | 0,13 |
| | | 0.14 | 0.0032 | 0.0032 | 0.0040 | 0.0050 |
| K3 | MM16-16019-R10A30-E06 F30M | 3,5 | 0,080 | 0,080 | 0,10 | 0,13 |
| | | 0.14 | 0.0032 | 0.0032 | 0.0040 | 0.0050 |
| K4 | MM16-16019-R10A30-E06 F30M | 3,5 | 0,080 | 0,080 | 0,10 | 0,13 |
| | | 0.14 | 0.0032 | 0.0032 | 0.0040 | 0.0050 |
| K5 | MM16-16019-R10A30-M06 F40M | 3,5 | 0,075 | 0,075 | 0,090 | 0,12 |
| | | 0.14 | 0.0030 | 0.0030 | 0.0036 | 0.0048 |
| K6 | MM16-16019-R10A30-M06 F40M | 3,5 | 0,080 | 0,080 | 0,10 | 0,13 |
| | | 0.14 | 0.0032 | 0.0032 | 0.0040 | 0.0050 |
| K7 | MM16-16019-R10A30-M06 F40M | 3,5 | 0,075 | 0,075 | 0,090 | 0,12 |
| | | 0.14 | 0.0030 | 0.0030 | 0.0036 | 0.0048 |
| N1 | MM16-16019-R10A30-E06 F30M | 3,5 | 0,11 | 0,11 | 0,14 | 0,18 |
| | | 0.14 | 0.0044 | 0.0044 | 0.0055 | 0.0070 |
| N2 | MM16-16019-R10A30-E06 F30M | 3,5 | 0,11 | 0,11 | 0,14 | 0,18 |
| | | 0.14 | 0.0044 | 0.0044 | 0.0055 | 0.0070 |
| N3 | MM16-16019-R10A30-E06 F30M | 3,5 | 0,11 | 0,11 | 0,14 | 0,18 |
| | | 0.14 | 0.0044 | 0.0044 | 0.0055 | 0.0070 |
| N11 | MM16-16019-R10A30-E06 F30M | 3,5 | 0,11 | 0,11 | 0,14 | 0,18 |
| | | 0.14 | 0.0044 | 0.0044 | 0.0055 | 0.0070 |
| S1 | MM16-16019-R05A30-M06 F40M | 2,0 | 0,055 | 0,055 | 0,070 | 0,090 |
| | | 0.080 | 0.0022 | 0.0022 | 0.0028 | 0.0036 |
| S2 | MM16-16019-R05A30-M06 F40M | 2,0 | 0,055 | 0,055 | 0,070 | 0,090 |
| | | 0.080 | 0.0022 | 0.0022 | 0.0028 | 0.0036 |
| S3 | MM16-16019-R05A30-M06 F40M | 2,0 | 0,050 | 0,055 | 0,065 | 0,085 |
| | | 0.080 | 0.0020 | 0.0022 | 0.0026 | 0.0034 |
| S11 | MM16-16019-R05A30-M06 F40M | 2,5 | 0,065 | 0,065 | 0,080 | 0,10 |
| | | 0.10 | 0.0026 | 0.0026 | 0.0032 | 0.0040 |
| S12 | MM16-16019-R05A30-M06 F40M | 2,5 | 0,065 | 0,065 | 0,080 | 0,10 |
| | | 0.10 | 0.0026 | 0.0026 | 0.0032 | 0.0040 |
| S13 | MM16-16019-R05A30-M06 F40M | 2,0 | 0,055 | 0,055 | 0,070 | 0,090 |
| | | 0.080 | 0.0022 | 0.0022 | 0.0028 | 0.0036 |
| H5 | MM16-16019-R10A30-E06 F30M | 2,5 | 0,055 | 0,055 | 0,065 | 0,090 |
| | | 0.10 | 0.0022 | 0.0022 | 0.0026 | 0.0036 |
| H8 | MM16-16019-R10A30-E06 F30M | 2,5 | 0,044 | 0,044 | 0,050 | 0,070 |
| | | 0.10 | 0.0017 | 0.0017 | 0.0020 | 0.0028 |
| H11 | MM16-16019-R10A30-E06 F30M | 2,5 | 0,055 | 0,055 | 0,065 | 0,090 |
| | | 0.10 | 0.0022 | 0.0022 | 0.0026 | 0.0036 |
| H12 | MM16-16019-R10A30-E06 F30M | 2,5 | 0,044 | 0,044 | 0,050 | 0,070 |
| | | 0.10 | 0.0017 | 0.0017 | 0.0020 | 0.0028 |
| H21 | MM16-16019-R10A30-E06 F30M | 2,5 | 0,044 | 0,044 | 0,050 | 0,070 |
| | | 0.10 | 0.0017 | 0.0017 | 0.0020 | 0.0028 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

Universell
Stahl und Guss
Stahl und Guss
Rostrfrei und ISO-S-Werkstoffe
Rostrfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MM16 - Nut- und Eckfräsen – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | F30M | | | | F40M | | | | T60M | | | |
|-----|------|------|------|------|------|------|------|------|------|------|------|------|
| | 100% | 40% | 20% | 10% | 100% | 40% | 20% | 10% | 100% | 40% | 20% | 10% |
| P1 | 230 | 285 | 315 | 350 | 215 | 270 | 300 | 335 | 200 | 250 | 275 | 310 |
| | 750 | 940 | 1025 | 1150 | 710 | 890 | 980 | 1100 | 660 | 820 | 900 | 1025 |
| P2 | 220 | 275 | 310 | 345 | 210 | 260 | 290 | 325 | 195 | 240 | 270 | 295 |
| | 720 | 900 | 1025 | 1125 | 690 | 850 | 950 | 1075 | 640 | 790 | 890 | 970 |
| P3 | 195 | 240 | 270 | 295 | 185 | 225 | 255 | 280 | 170 | 210 | 235 | 260 |
| | 640 | 790 | 890 | 970 | 610 | 740 | 840 | 920 | 560 | 690 | 770 | 850 |
| P4 | 170 | 215 | 240 | 265 | 160 | 205 | 225 | 250 | 150 | 185 | 205 | 225 |
| | 560 | 710 | 790 | 870 | 520 | 670 | 740 | 820 | 490 | 610 | 670 | 740 |
| P5 | 165 | 205 | 230 | 250 | 155 | 195 | 215 | 240 | 140 | 175 | 200 | 220 |
| | 540 | 670 | 750 | 820 | 510 | 640 | 710 | 790 | 460 | 570 | 660 | 720 |
| P6 | 185 | 230 | 260 | 285 | 175 | 215 | 245 | 270 | 160 | 200 | 220 | 245 |
| | 610 | 750 | 850 | 940 | 570 | 710 | 800 | 890 | 520 | 660 | 720 | 800 |
| P7 | 175 | 220 | 245 | 265 | 165 | 205 | 230 | 255 | 150 | 190 | 210 | 235 |
| | 570 | 720 | 800 | 870 | 540 | 670 | 750 | 840 | 490 | 620 | 690 | 770 |
| P8 | 160 | 205 | 230 | 250 | 155 | 190 | 215 | 235 | 140 | 175 | 200 | 215 |
| | 520 | 670 | 750 | 820 | 510 | 620 | 710 | 770 | 460 | 570 | 660 | 710 |
| P11 | 170 | 210 | 235 | 260 | 160 | 200 | 225 | 245 | 145 | 185 | 205 | 225 |
| | 560 | 690 | 770 | 850 | 520 | 660 | 740 | 800 | 475 | 610 | 670 | 740 |
| P12 | 110 | 135 | 150 | 165 | 105 | 130 | 145 | 155 | 95 | 120 | 130 | 145 |
| | 360 | 445 | 490 | 540 | 345 | 425 | 475 | 510 | 310 | 395 | 425 | 475 |
| M1 | 180 | 225 | 250 | 275 | 170 | 210 | 235 | 260 | 155 | 190 | 215 | 240 |
| | 590 | 740 | 820 | 900 | 560 | 690 | 770 | 850 | 510 | 620 | 710 | 790 |
| M2 | 150 | 185 | 205 | 225 | 140 | 175 | 195 | 215 | 125 | 160 | 180 | 200 |
| | 490 | 610 | 670 | 740 | 460 | 570 | 640 | 710 | 410 | 520 | 590 | 660 |
| M3 | 120 | 150 | 165 | 180 | 110 | 140 | 155 | 175 | 105 | 130 | 145 | 155 |
| | 395 | 490 | 540 | 590 | 360 | 460 | 510 | 570 | 345 | 425 | 475 | 510 |
| M4 | 90 | 115 | 130 | 140 | 85 | 110 | 120 | 135 | 80 | 100 | 110 | 120 |
| | 295 | 375 | 425 | 460 | 280 | 360 | 395 | 445 | 260 | 330 | 360 | 395 |
| M5 | 75 | 95 | 105 | 115 | 75 | 90 | 100 | 110 | 65 | 85 | 95 | 100 |
| | 245 | 310 | 345 | 375 | 245 | 295 | 330 | 360 | 215 | 280 | 310 | 330 |
| K1 | 175 | 220 | 245 | 270 | 165 | 205 | 230 | 260 | 150 | 190 | 210 | 235 |
| | 570 | 720 | 800 | 890 | 540 | 670 | 750 | 850 | 490 | 620 | 690 | 770 |
| K2 | 155 | 195 | 215 | 240 | 145 | 185 | 205 | 225 | 135 | 170 | 190 | 210 |
| | 510 | 640 | 710 | 790 | 475 | 610 | 670 | 740 | 445 | 560 | 620 | 690 |
| K3 | 130 | 165 | 185 | 205 | 125 | 155 | 175 | 190 | 115 | 145 | 160 | 175 |
| | 425 | 540 | 610 | 670 | 410 | 510 | 570 | 620 | 375 | 475 | 520 | 570 |
| K4 | 125 | 160 | 175 | 195 | 120 | 150 | 165 | 185 | 110 | 135 | 150 | 170 |
| | 410 | 520 | 570 | 640 | 395 | 490 | 540 | 610 | 360 | 445 | 490 | 560 |
| K5 | 75 | 95 | 105 | 115 | 75 | 90 | 100 | 110 | 65 | 80 | 95 | 100 |
| | 245 | 310 | 345 | 375 | 245 | 295 | 330 | 360 | 215 | 260 | 310 | 330 |
| K6 | 110 | 140 | 155 | 170 | 105 | 130 | 145 | 160 | 95 | 120 | 135 | 150 |
| | 360 | 460 | 510 | 560 | 345 | 425 | 475 | 520 | 310 | 395 | 445 | 490 |
| K7 | 100 | 120 | 135 | 150 | 95 | 115 | 130 | 140 | 85 | 105 | 120 | 130 |
| | 330 | 395 | 445 | 490 | 310 | 375 | 425 | 460 | 280 | 345 | 395 | 425 |
| N1 | 1325 | 1650 | 1825 | 2025 | 1225 | 1550 | 1725 | 1925 | 1125 | 1425 | 1575 | 1750 |
| | 4350 | 5425 | 6000 | 6650 | 4025 | 5075 | 5650 | 6325 | 3700 | 4675 | 5175 | 5750 |
| N2 | 530 | 670 | 730 | 820 | 500 | 630 | 690 | 770 | 455 | 570 | 640 | 700 |
| | 1750 | 2200 | 2400 | 2700 | 1650 | 2075 | 2275 | 2525 | 1500 | 1875 | 2100 | 2300 |
| N3 | 355 | 445 | 490 | 540 | 335 | 420 | 465 | 520 | 305 | 385 | 425 | 470 |
| | 1175 | 1450 | 1600 | 1775 | 1100 | 1375 | 1525 | 1700 | 1000 | 1275 | 1400 | 1550 |
| N11 | 405 | 510 | 560 | 620 | 380 | 475 | 530 | 590 | 345 | 435 | 485 | 540 |
| | 1325 | 1675 | 1825 | 2025 | 1250 | 1550 | 1750 | 1925 | 1125 | 1425 | 1600 | 1775 |
| S1 | 43 | 55 | 60 | 65 | 41 | 50 | 55 | 60 | 38 | 46 | 50 | 55 |
| | 140 | 180 | 195 | 215 | 135 | 165 | 180 | 195 | 125 | 150 | 165 | 180 |
| S2 | 35 | 43 | 48 | 55 | 33 | 41 | 45 | 50 | 30 | 37 | 42 | 46 |
| | 115 | 140 | 155 | 180 | 110 | 135 | 150 | 165 | 100 | 120 | 140 | 150 |
| S3 | 30 | 38 | 42 | 46 | 29 | 35 | 40 | 44 | 27 | 33 | 37 | 40 |
| | 100 | 125 | 140 | 150 | 95 | 115 | 130 | 145 | 90 | 110 | 120 | 130 |
| S11 | 60 | 75 | 85 | 90 | 55 | 70 | 80 | 90 | 50 | 65 | 75 | 80 |
| | 195 | 245 | 280 | 295 | 180 | 230 | 260 | 295 | 165 | 215 | 245 | 260 |
| S12 | 42 | 50 | 60 | 65 | 39 | 49 | 55 | 60 | 36 | 45 | 50 | 55 |
| | 140 | 165 | 195 | 215 | 130 | 160 | 180 | 195 | 120 | 150 | 165 | 180 |
| S13 | 24 | 30 | 34 | 37 | 23 | 29 | 32 | 35 | 21 | 26 | 29 | 32 |
| | 80 | 100 | 110 | 120 | 75 | 95 | 105 | 115 | 70 | 85 | 95 | 105 |
| H5 | 36 | 45 | 50 | 55 | 34 | 43 | 48 | 50 | 31 | 39 | 44 | 48 |
| | 120 | 150 | 165 | 180 | 110 | 140 | 155 | 165 | 100 | 130 | 145 | 155 |
| H8 | 38 | 47 | 55 | 60 | 36 | 45 | 50 | 55 | 33 | 41 | 46 | 50 |
| | 125 | 155 | 180 | 195 | 120 | 150 | 165 | 180 | 110 | 135 | 150 | 165 |
| H11 | 46 | 60 | 65 | 70 | 43 | 55 | 60 | 65 | 40 | 50 | 55 | 60 |
| | 150 | 195 | 215 | 230 | 140 | 180 | 195 | 215 | 130 | 165 | 180 | 195 |
| H12 | 70 | 85 | 95 | 105 | 65 | 80 | 90 | 100 | 60 | 75 | 85 | 90 |
| | 230 | 280 | 310 | 345 | 215 | 260 | 295 | 330 | 195 | 245 | 280 | 295 |
| H21 | 38 | 47 | 55 | 60 | 36 | 45 | 50 | 55 | 33 | 41 | 46 | 50 |
| | 125 | 155 | 180 | 195 | 120 | 150 | 165 | 180 | 110 | 135 | 150 | 165 |

MM16 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|----------------------------|----------------|----------------|--------|--------|--------|
| | | | 100% | 40% | 20% | 10% |
| P1 | MM16-16019-B90A30-M06 F40M | 3,5 | 0,11 | 0,10 | 0,11 | 0,14 |
| | | 0,14 | 0,0044 | 0,0040 | 0,0044 | 0,0055 |
| P2 | MM16-16019-B90A30-M06 F40M | 3,5 | 0,11 | 0,10 | 0,11 | 0,15 |
| | | 0,14 | 0,0044 | 0,0040 | 0,0044 | 0,0060 |
| P3 | MM16-16019-B90A30-M06 F40M | 3,5 | 0,10 | 0,10 | 0,10 | 0,14 |
| | | 0,14 | 0,0040 | 0,0040 | 0,0040 | 0,0055 |
| P4 | MM16-16019-B90A30-M06 F40M | 3,5 | 0,10 | 0,095 | 0,10 | 0,13 |
| | | 0,14 | 0,0040 | 0,0038 | 0,0040 | 0,0050 |
| P5 | MM16-16019-B90A30-M06 F40M | 3,5 | 0,10 | 0,095 | 0,10 | 0,13 |
| | | 0,14 | 0,0040 | 0,0038 | 0,0040 | 0,0050 |
| P6 | MM16-16019-B90A30-M06 F40M | 3,5 | 0,095 | 0,095 | 0,10 | 0,13 |
| | | 0,14 | 0,0038 | 0,0038 | 0,0040 | 0,0050 |
| P7 | MM16-16019-B90A30-M06 F40M | 3,5 | 0,095 | 0,095 | 0,10 | 0,13 |
| | | 0,14 | 0,0038 | 0,0038 | 0,0040 | 0,0050 |
| P8 | MM16-16019-B90A30-M06 F40M | 3,5 | 0,10 | 0,10 | 0,10 | 0,14 |
| | | 0,14 | 0,0040 | 0,0040 | 0,0040 | 0,0055 |
| P11 | MM16-16019-B90A30-M06 F40M | 3,5 | 0,095 | 0,095 | 0,10 | 0,13 |
| | | 0,14 | 0,0038 | 0,0038 | 0,0040 | 0,0050 |
| P12 | MM16-16019-B90A30-M06 F40M | 2,5 | 0,070 | 0,070 | 0,070 | 0,090 |
| | | 0,10 | 0,0028 | 0,0028 | 0,0028 | 0,0036 |
| M1 | MM16-16019-B90A30-M06 F40M | 3,5 | 0,11 | 0,10 | 0,11 | 0,15 |
| | | 0,14 | 0,0044 | 0,0040 | 0,0044 | 0,0060 |
| M2 | MM16-16019-B90A30-M06 F40M | 3,5 | 0,10 | 0,095 | 0,10 | 0,13 |
| | | 0,14 | 0,0040 | 0,0038 | 0,0040 | 0,0050 |
| M3 | MM16-16019-B90A30-M06 F40M | 2,5 | 0,085 | 0,080 | 0,080 | 0,11 |
| | | 0,10 | 0,0034 | 0,0032 | 0,0032 | 0,0044 |
| M4 | MM16-16019-B90A30-M06 F40M | 2,0 | 0,075 | 0,075 | 0,075 | 0,090 |
| | | 0,080 | 0,0030 | 0,0030 | 0,0030 | 0,0038 |
| M5 | MM16-16019-B90A30-M06 F40M | 2,0 | 0,075 | 0,075 | 0,075 | 0,090 |
| | | 0,080 | 0,0030 | 0,0030 | 0,0030 | 0,0038 |
| K1 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,11 | 0,10 | 0,11 | 0,15 |
| | | 0,14 | 0,0044 | 0,0040 | 0,0044 | 0,0060 |
| K2 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,10 | 0,095 | 0,10 | 0,13 |
| | | 0,14 | 0,0040 | 0,0038 | 0,0040 | 0,0050 |
| K3 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,10 | 0,095 | 0,10 | 0,13 |
| | | 0,14 | 0,0040 | 0,0038 | 0,0040 | 0,0050 |
| K4 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,10 | 0,095 | 0,10 | 0,13 |
| | | 0,14 | 0,0040 | 0,0038 | 0,0040 | 0,0050 |
| K5 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,090 | 0,085 | 0,090 | 0,12 |
| | | 0,14 | 0,0036 | 0,0034 | 0,0036 | 0,0048 |
| K6 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,10 | 0,095 | 0,10 | 0,13 |
| | | 0,14 | 0,0040 | 0,0038 | 0,0040 | 0,0050 |
| K7 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,090 | 0,085 | 0,090 | 0,12 |
| | | 0,14 | 0,0036 | 0,0034 | 0,0036 | 0,0048 |
| N1 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,14 | 0,13 | 0,14 | 0,19 |
| | | 0,14 | 0,0055 | 0,0050 | 0,0055 | 0,0075 |
| N2 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,14 | 0,13 | 0,14 | 0,19 |
| | | 0,14 | 0,0055 | 0,0050 | 0,0055 | 0,0075 |
| N3 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,14 | 0,13 | 0,14 | 0,19 |
| | | 0,14 | 0,0055 | 0,0050 | 0,0055 | 0,0075 |
| N11 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,14 | 0,13 | 0,14 | 0,19 |
| | | 0,14 | 0,0055 | 0,0050 | 0,0055 | 0,0075 |
| S1 | MM16-16019-B90A30-M06 F40M | 2,0 | 0,075 | 0,075 | 0,075 | 0,090 |
| | | 0,080 | 0,0030 | 0,0030 | 0,0030 | 0,0038 |
| S2 | MM16-16019-B90A30-M06 F40M | 2,0 | 0,075 | 0,075 | 0,075 | 0,090 |
| | | 0,080 | 0,0030 | 0,0030 | 0,0030 | 0,0038 |
| S3 | MM16-16019-B90A30-M06 F40M | 2,0 | 0,070 | 0,070 | 0,070 | 0,085 |
| | | 0,080 | 0,0028 | 0,0028 | 0,0028 | 0,0036 |
| S11 | MM16-16019-B90A30-M06 F40M | 2,5 | 0,085 | 0,080 | 0,085 | 0,11 |
| | | 0,10 | 0,0034 | 0,0032 | 0,0034 | 0,0044 |
| S12 | MM16-16019-B90A30-M06 F40M | 2,5 | 0,085 | 0,080 | 0,085 | 0,11 |
| | | 0,10 | 0,0034 | 0,0032 | 0,0034 | 0,0044 |
| S13 | MM16-16019-B90A30-M06 F40M | 2,0 | 0,075 | 0,075 | 0,075 | 0,090 |
| | | 0,080 | 0,0030 | 0,0030 | 0,0030 | 0,0038 |
| H5 | MM16-16019-B90A30-E06 F30M | 2,5 | 0,070 | 0,070 | 0,070 | 0,090 |
| | | 0,10 | 0,0028 | 0,0028 | 0,0028 | 0,0036 |
| H8 | MM16-16019-B90A30-E06 F30M | 2,5 | 0,055 | 0,050 | 0,055 | 0,070 |
| | | 0,10 | 0,0022 | 0,0020 | 0,0022 | 0,0028 |
| H11 | MM16-16019-B90A30-E06 F30M | 2,5 | 0,070 | 0,070 | 0,070 | 0,090 |
| | | 0,10 | 0,0028 | 0,0028 | 0,0028 | 0,0036 |
| H12 | MM16-16019-B90A30-E06 F30M | 2,5 | 0,055 | 0,050 | 0,055 | 0,070 |
| | | 0,10 | 0,0022 | 0,0020 | 0,0022 | 0,0028 |
| H21 | MM16-16019-B90A30-E06 F30M | 2,5 | 0,055 | 0,050 | 0,055 | 0,070 |
| | | 0,10 | 0,0022 | 0,0020 | 0,0022 | 0,0028 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

Unversell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MM16 Z3 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|----------------------------|----------------|----------------|--------|--------|--------|
| | | | 15% | 10% | 5% | 2% |
| P1 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,12 | 0,14 | 0,20 | 0,32 |
| | | 0,14 | 0,0048 | 0,0055 | 0,0080 | 0,013 |
| P2 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,12 | 0,15 | 0,20 | 0,34 |
| | | 0,14 | 0,0048 | 0,0060 | 0,0080 | 0,013 |
| P3 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,12 | 0,14 | 0,19 | 0,32 |
| | | 0,14 | 0,0048 | 0,0055 | 0,0075 | 0,013 |
| P4 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,11 | 0,13 | 0,19 | 0,30 |
| | | 0,14 | 0,0044 | 0,0050 | 0,0075 | 0,012 |
| P5 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,11 | 0,13 | 0,18 | 0,30 |
| | | 0,14 | 0,0044 | 0,0050 | 0,0070 | 0,012 |
| P6 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,11 | 0,13 | 0,18 | 0,30 |
| | | 0,14 | 0,0044 | 0,0050 | 0,0070 | 0,012 |
| P7 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,11 | 0,13 | 0,18 | 0,30 |
| | | 0,14 | 0,0044 | 0,0050 | 0,0070 | 0,012 |
| P8 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,12 | 0,14 | 0,19 | 0,32 |
| | | 0,14 | 0,0048 | 0,0055 | 0,0075 | 0,013 |
| P11 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,11 | 0,13 | 0,18 | 0,30 |
| | | 0,14 | 0,0044 | 0,0050 | 0,0070 | 0,012 |
| P12 | MM16-16019-B90A30-E06 F30M | 2,5 | 0,075 | 0,090 | 0,12 | 0,20 |
| | | 0,10 | 0,0030 | 0,0036 | 0,0048 | 0,0080 |
| M1 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,12 | 0,15 | 0,20 | 0,34 |
| | | 0,14 | 0,0048 | 0,0060 | 0,0080 | 0,013 |
| M2 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,11 | 0,13 | 0,18 | 0,30 |
| | | 0,14 | 0,0044 | 0,0050 | 0,0070 | 0,012 |
| M3 | MM16-16019-B90A30-E06 F30M | 2,5 | 0,090 | 0,11 | 0,15 | 0,24 |
| | | 0,10 | 0,0036 | 0,0044 | 0,0060 | 0,0095 |
| M4 | MM16-16019-B90A30-E06 F30M | 2,0 | 0,080 | 0,090 | 0,13 | 0,20 |
| | | 0,080 | 0,0032 | 0,0038 | 0,0050 | 0,0080 |
| M5 | MM16-16019-B90A30-E06 F30M | 2,0 | 0,080 | 0,090 | 0,13 | 0,20 |
| | | 0,080 | 0,0032 | 0,0038 | 0,0050 | 0,0080 |
| K1 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,12 | 0,15 | 0,20 | 0,34 |
| | | 0,14 | 0,0048 | 0,0060 | 0,0080 | 0,013 |
| K2 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,11 | 0,13 | 0,18 | 0,30 |
| | | 0,14 | 0,0044 | 0,0050 | 0,0070 | 0,012 |
| K3 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,11 | 0,13 | 0,18 | 0,30 |
| | | 0,14 | 0,0044 | 0,0050 | 0,0070 | 0,012 |
| K4 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,11 | 0,13 | 0,18 | 0,30 |
| | | 0,14 | 0,0044 | 0,0050 | 0,0070 | 0,012 |
| K5 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,10 | 0,12 | 0,17 | 0,26 |
| | | 0,14 | 0,0040 | 0,0048 | 0,0065 | 0,010 |
| K6 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,11 | 0,13 | 0,18 | 0,30 |
| | | 0,14 | 0,0044 | 0,0050 | 0,0070 | 0,012 |
| K7 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,10 | 0,12 | 0,17 | 0,26 |
| | | 0,14 | 0,0040 | 0,0048 | 0,0065 | 0,010 |
| N1 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,16 | 0,19 | 0,26 | 0,44 |
| | | 0,14 | 0,0065 | 0,0075 | 0,010 | 0,017 |
| N2 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,16 | 0,19 | 0,26 | 0,44 |
| | | 0,14 | 0,0065 | 0,0075 | 0,010 | 0,017 |
| N3 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,16 | 0,19 | 0,26 | 0,44 |
| | | 0,14 | 0,0065 | 0,0075 | 0,010 | 0,017 |
| N11 | MM16-16019-B90A30-E06 F30M | 3,5 | 0,16 | 0,19 | 0,26 | 0,44 |
| | | 0,14 | 0,0065 | 0,0075 | 0,010 | 0,017 |
| S1 | MM16-16019-B90A30-E06 F30M | 2,0 | 0,080 | 0,090 | 0,13 | 0,20 |
| | | 0,080 | 0,0032 | 0,0038 | 0,0050 | 0,0080 |
| S2 | MM16-16019-B90A30-E06 F30M | 2,0 | 0,080 | 0,090 | 0,13 | 0,20 |
| | | 0,080 | 0,0032 | 0,0038 | 0,0050 | 0,0080 |
| S3 | MM16-16019-B90A30-E06 F30M | 2,0 | 0,075 | 0,085 | 0,12 | 0,19 |
| | | 0,080 | 0,0030 | 0,0036 | 0,0048 | 0,0075 |
| S11 | MM16-16019-B90A30-E06 F30M | 2,5 | 0,090 | 0,11 | 0,15 | 0,24 |
| | | 0,10 | 0,0036 | 0,0044 | 0,0060 | 0,0095 |
| S12 | MM16-16019-B90A30-E06 F30M | 2,5 | 0,090 | 0,11 | 0,15 | 0,24 |
| | | 0,10 | 0,0036 | 0,0044 | 0,0060 | 0,0095 |
| S13 | MM16-16019-B90A30-E06 F30M | 2,0 | 0,080 | 0,090 | 0,13 | 0,20 |
| | | 0,080 | 0,0032 | 0,0038 | 0,0050 | 0,0080 |
| H5 | MM16-16019-B90A30-E06 F30M | 2,5 | 0,075 | 0,090 | 0,12 | 0,20 |
| | | 0,10 | 0,0030 | 0,0036 | 0,0048 | 0,0080 |
| H8 | MM16-16019-B90A30-E06 F30M | 2,5 | 0,060 | 0,070 | 0,095 | 0,15 |
| | | 0,10 | 0,0024 | 0,0028 | 0,0038 | 0,0060 |
| H11 | MM16-16019-B90A30-E06 F30M | 2,5 | 0,075 | 0,090 | 0,12 | 0,20 |
| | | 0,10 | 0,0030 | 0,0036 | 0,0048 | 0,0080 |
| H12 | MM16-16019-B90A30-E06 F30M | 2,5 | 0,060 | 0,070 | 0,095 | 0,15 |
| | | 0,10 | 0,0024 | 0,0028 | 0,0038 | 0,0060 |
| H21 | MM16-16019-B90A30-E06 F30M | 2,5 | 0,060 | 0,070 | 0,095 | 0,15 |
| | | 0,10 | 0,0024 | 0,0028 | 0,0038 | 0,0060 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MM16 Z3 – Kopierfräser – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | F30M | | | | | F40M | | | | |
|-----|------|------|------|------|------|------|------|------|------|------|
| | 100% | 20% | 10% | 5% | 2% | 100% | 20% | 10% | 5% | 2% |
| P1 | 245 | 295 | 310 | 335 | 335 | 235 | 280 | 295 | 320 | 320 |
| | 800 | 970 | 1025 | 1100 | 1100 | 770 | 920 | 970 | 1050 | 1050 |
| P2 | 240 | 285 | 300 | 325 | 320 | 230 | 270 | 285 | 310 | 305 |
| | 790 | 940 | 980 | 1075 | 1050 | 750 | 890 | 940 | 1025 | 1000 |
| P3 | 210 | 250 | 260 | 285 | 280 | 200 | 240 | 250 | 270 | 265 |
| | 690 | 820 | 850 | 940 | 920 | 660 | 790 | 820 | 890 | 870 |
| P4 | 185 | 220 | 235 | 250 | 250 | 175 | 210 | 225 | 240 | 240 |
| | 610 | 720 | 770 | 820 | 820 | 570 | 690 | 740 | 790 | 790 |
| P5 | 175 | 210 | 225 | 240 | 240 | 170 | 200 | 215 | 230 | 230 |
| | 570 | 690 | 740 | 790 | 790 | 560 | 660 | 710 | 750 | 750 |
| P6 | 200 | 235 | 250 | 270 | 270 | 190 | 225 | 240 | 260 | 255 |
| | 660 | 770 | 820 | 890 | 890 | 620 | 740 | 790 | 850 | 840 |
| P7 | 190 | 225 | 235 | 255 | 255 | 180 | 210 | 225 | 245 | 240 |
| | 620 | 740 | 770 | 840 | 840 | 590 | 690 | 740 | 800 | 790 |
| P8 | 175 | 210 | 220 | 240 | 235 | 170 | 200 | 210 | 230 | 225 |
| | 570 | 690 | 720 | 790 | 770 | 560 | 660 | 690 | 750 | 740 |
| P11 | 185 | 215 | 230 | 250 | 245 | 175 | 205 | 220 | 235 | 235 |
| | 610 | 710 | 750 | 820 | 800 | 570 | 670 | 720 | 770 | 770 |
| P12 | 115 | 145 | 145 | 160 | 155 | 110 | 140 | 140 | 150 | 150 |
| | 375 | 475 | 475 | 520 | 510 | 360 | 460 | 460 | 490 | 490 |
| M1 | 195 | 230 | 240 | 265 | 260 | 185 | 220 | 230 | 250 | 245 |
| | 640 | 750 | 790 | 870 | 850 | 610 | 720 | 750 | 820 | 800 |
| M2 | 160 | 190 | 200 | 220 | 215 | 150 | 180 | 190 | 205 | 205 |
| | 520 | 620 | 660 | 720 | 710 | 490 | 590 | 620 | 670 | 670 |
| M3 | 130 | 160 | 160 | 170 | 170 | 120 | 150 | 150 | 165 | 165 |
| | 425 | 520 | 520 | 560 | 560 | 395 | 490 | 490 | 540 | 540 |
| M4 | 90 | 125 | 125 | 130 | 135 | 85 | 120 | 115 | 125 | 125 |
| | 295 | 410 | 425 | 425 | 445 | 280 | 395 | 410 | 410 | 410 |
| M5 | 75 | 105 | 100 | 110 | 110 | 70 | 100 | 100 | 105 | 105 |
| | 245 | 345 | 360 | 360 | 360 | 230 | 330 | 345 | 345 | 345 |
| K1 | 190 | 225 | 235 | 260 | 255 | 180 | 215 | 225 | 245 | 245 |
| | 620 | 740 | 770 | 850 | 840 | 590 | 710 | 740 | 800 | 800 |
| K2 | 170 | 200 | 210 | 230 | 225 | 160 | 190 | 200 | 220 | 215 |
| | 560 | 660 | 690 | 750 | 740 | 520 | 620 | 660 | 720 | 710 |
| K3 | 140 | 170 | 180 | 195 | 190 | 135 | 160 | 170 | 185 | 185 |
| | 460 | 560 | 590 | 640 | 620 | 445 | 520 | 560 | 610 | 610 |
| K4 | 135 | 160 | 170 | 185 | 185 | 130 | 155 | 165 | 175 | 175 |
| | 445 | 520 | 560 | 610 | 610 | 425 | 510 | 540 | 570 | 570 |
| K5 | 85 | 100 | 105 | 110 | 110 | 80 | 95 | 100 | 105 | 105 |
| | 280 | 330 | 345 | 360 | 360 | 260 | 310 | 330 | 345 | 345 |
| K6 | 120 | 140 | 150 | 165 | 160 | 115 | 135 | 145 | 155 | 155 |
| | 395 | 460 | 490 | 540 | 520 | 375 | 445 | 475 | 510 | 510 |
| K7 | 105 | 125 | 130 | 145 | 145 | 100 | 120 | 125 | 135 | 135 |
| | 345 | 410 | 425 | 475 | 475 | 330 | 395 | 410 | 445 | 445 |
| N1 | 1425 | 1700 | 1775 | 1925 | 1900 | 1350 | 1625 | 1700 | 1850 | 1800 |
| | 4675 | 5575 | 5825 | 6325 | 6225 | 4425 | 5325 | 5575 | 6075 | 5900 |
| N2 | 580 | 690 | 720 | 780 | 770 | 550 | 650 | 680 | 740 | 730 |
| | 1900 | 2275 | 2350 | 2550 | 2525 | 1800 | 2125 | 2225 | 2425 | 2400 |
| N3 | 385 | 455 | 480 | 520 | 510 | 365 | 435 | 455 | 495 | 485 |
| | 1275 | 1500 | 1575 | 1700 | 1675 | 1200 | 1425 | 1500 | 1625 | 1600 |
| N11 | 440 | 520 | 550 | 600 | 580 | 420 | 495 | 520 | 570 | 560 |
| | 1450 | 1700 | 1800 | 1975 | 1900 | 1375 | 1625 | 1700 | 1875 | 1825 |
| S1 | 42 | 60 | 55 | 60 | 60 | 40 | 55 | 55 | 60 | 60 |
| | 140 | 195 | 195 | 195 | 195 | 130 | 180 | 195 | 195 | 195 |
| S2 | 34 | 48 | 46 | 50 | 50 | 33 | 45 | 44 | 47 | 48 |
| | 110 | 155 | 160 | 165 | 165 | 110 | 150 | 155 | 155 | 155 |
| S3 | 30 | 41 | 40 | 43 | 43 | 28 | 39 | 38 | 41 | 41 |
| | 100 | 135 | 140 | 140 | 140 | 90 | 130 | 135 | 135 | 135 |
| S11 | 65 | 80 | 80 | 85 | 85 | 60 | 80 | 75 | 85 | 80 |
| | 215 | 260 | 280 | 280 | 280 | 195 | 260 | 260 | 280 | 260 |
| S12 | 45 | 55 | 55 | 60 | 60 | 43 | 55 | 55 | 55 | 55 |
| | 150 | 180 | 195 | 195 | 195 | 140 | 180 | 180 | 180 | 180 |
| S13 | 24 | 33 | 32 | 35 | 35 | 23 | 32 | 31 | 33 | 33 |
| | 80 | 110 | 110 | 115 | 115 | 75 | 105 | 110 | 110 | 110 |
| H5 | 39 | 48 | 48 | 55 | 50 | 37 | 46 | 46 | 50 | 50 |
| | 130 | 155 | 160 | 180 | 165 | 120 | 150 | 150 | 165 | 165 |
| H8 | 40 | 50 | 50 | 55 | 55 | 38 | 49 | 48 | 50 | 50 |
| | 130 | 165 | 165 | 180 | 180 | 125 | 160 | 165 | 165 | 165 |
| H11 | 50 | 60 | 60 | 65 | 65 | 47 | 60 | 60 | 65 | 65 |
| | 165 | 195 | 195 | 215 | 215 | 155 | 195 | 195 | 215 | 215 |
| H12 | 70 | 90 | 90 | 100 | 100 | 70 | 85 | 85 | 95 | 95 |
| | 230 | 295 | 310 | 330 | 330 | 230 | 280 | 295 | 310 | 310 |
| H21 | 40 | 50 | 50 | 55 | 55 | 38 | 49 | 48 | 50 | 50 |
| | 130 | 165 | 165 | 180 | 180 | 125 | 160 | 165 | 165 | 165 |

Universell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster

MM16 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Metrisch/ Zoll

| SMG | | a _p | f _z | | | |
|-----|---------------------------|----------------|----------------|--------|--------|--------|
| | | | 100% | 40% | 20% | 10% |
| P1 | MM16-16016-B90-MD07 F30M | 6,0 | 0,11 | 0,11 | 0,13 | 0,17 |
| | | 0,24 | 0,0044 | 0,0044 | 0,0050 | 0,0065 |
| P2 | MM16-16016-B90-MD07 F30M | 6,0 | 0,11 | 0,11 | 0,13 | 0,17 |
| | | 0,24 | 0,0044 | 0,0044 | 0,0050 | 0,0065 |
| P3 | MM16-16016-B90-MD07 F30M | 6,0 | 0,11 | 0,10 | 0,12 | 0,16 |
| | | 0,24 | 0,0044 | 0,0040 | 0,0048 | 0,0065 |
| P4 | MM16-16016-B90-MD07 F30M | 6,0 | 0,10 | 0,10 | 0,12 | 0,16 |
| | | 0,24 | 0,0040 | 0,0040 | 0,0048 | 0,0065 |
| P5 | MM16-16016-B90-MD07 F30M | 6,0 | 0,10 | 0,10 | 0,12 | 0,15 |
| | | 0,24 | 0,0040 | 0,0040 | 0,0048 | 0,0060 |
| P6 | MM16-16016-B90-MD07 F30M | 6,0 | 0,10 | 0,10 | 0,12 | 0,15 |
| | | 0,24 | 0,0040 | 0,0040 | 0,0048 | 0,0060 |
| P7 | MM16-16016-B90-MD07 F30M | 6,0 | 0,10 | 0,10 | 0,12 | 0,15 |
| | | 0,24 | 0,0040 | 0,0040 | 0,0048 | 0,0060 |
| P8 | MM16-16016-B90-MD07 F30M | 6,0 | 0,11 | 0,10 | 0,12 | 0,16 |
| | | 0,24 | 0,0044 | 0,0040 | 0,0048 | 0,0065 |
| P11 | MM16-16016-B90-MD07 F30M | 6,0 | 0,10 | 0,10 | 0,12 | 0,15 |
| | | 0,24 | 0,0040 | 0,0040 | 0,0048 | 0,0060 |
| P12 | MM16-16016-B90-MD07 F30M | 5,0 | 0,070 | 0,070 | 0,080 | 0,10 |
| | | 0,20 | 0,0028 | 0,0028 | 0,0032 | 0,0044 |
| M1 | MM16-16016-B90-MD07 F30M | 6,0 | 0,11 | 0,11 | 0,13 | 0,17 |
| | | 0,24 | 0,0044 | 0,0044 | 0,0050 | 0,0065 |
| M2 | MM16-16016-B90-MD07 F30M | 6,0 | 0,10 | 0,10 | 0,12 | 0,15 |
| | | 0,24 | 0,0040 | 0,0040 | 0,0048 | 0,0060 |
| M3 | MM16-16016-B90-MD07 F30M | 5,0 | 0,085 | 0,080 | 0,095 | 0,12 |
| | | 0,20 | 0,0034 | 0,0032 | 0,0038 | 0,0050 |
| M4 | MM16-16016-B90-MD07 F30M | 4,0 | 0,080 | 0,080 | 0,085 | 0,11 |
| | | 0,16 | 0,0032 | 0,0032 | 0,0034 | 0,0044 |
| M5 | MM16-16016-B90-MD07 F30M | 4,0 | 0,080 | 0,080 | 0,085 | 0,11 |
| | | 0,16 | 0,0032 | 0,0032 | 0,0034 | 0,0044 |
| K1 | MM16-16016-B90-MD07 F30M | 6,0 | 0,11 | 0,11 | 0,13 | 0,17 |
| | | 0,24 | 0,0044 | 0,0044 | 0,0050 | 0,0065 |
| K2 | MM16-16016-B90-MD07 F30M | 6,0 | 0,10 | 0,10 | 0,12 | 0,15 |
| | | 0,24 | 0,0040 | 0,0040 | 0,0048 | 0,0060 |
| K3 | MM16-16016-B90-MD07 F30M | 6,0 | 0,10 | 0,10 | 0,12 | 0,15 |
| | | 0,24 | 0,0040 | 0,0040 | 0,0048 | 0,0060 |
| K4 | MM16-16016-B90-MD07 F30M | 6,0 | 0,10 | 0,10 | 0,12 | 0,15 |
| | | 0,24 | 0,0040 | 0,0040 | 0,0048 | 0,0060 |
| K5 | MM16-16016-B90-MD07 F30M | 6,0 | 0,090 | 0,090 | 0,11 | 0,14 |
| | | 0,24 | 0,0036 | 0,0036 | 0,0044 | 0,0055 |
| K6 | MM16-16016-B90-MD07 F30M | 6,0 | 0,10 | 0,10 | 0,12 | 0,15 |
| | | 0,24 | 0,0040 | 0,0040 | 0,0048 | 0,0060 |
| K7 | MM16-16016-B90-MD07 F30M | 6,0 | 0,090 | 0,090 | 0,11 | 0,14 |
| | | 0,24 | 0,0036 | 0,0036 | 0,0044 | 0,0055 |
| N1 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,060 | 0,060 | 0,070 | 0,095 |
| | | 0,24 | 0,0024 | 0,0024 | 0,0028 | 0,0038 |
| N2 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,060 | 0,060 | 0,070 | 0,095 |
| | | 0,24 | 0,0024 | 0,0024 | 0,0028 | 0,0038 |
| N3 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,060 | 0,060 | 0,070 | 0,095 |
| | | 0,24 | 0,0024 | 0,0024 | 0,0028 | 0,0038 |
| N11 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,060 | 0,060 | 0,070 | 0,095 |
| | | 0,24 | 0,0024 | 0,0024 | 0,0028 | 0,0038 |
| S1 | MM16-16016-B90-MD07 F30M | 4,0 | 0,080 | 0,080 | 0,085 | 0,11 |
| | | 0,16 | 0,0032 | 0,0032 | 0,0034 | 0,0044 |
| S2 | MM16-16016-B90-MD07 F30M | 4,0 | 0,080 | 0,080 | 0,085 | 0,11 |
| | | 0,16 | 0,0032 | 0,0032 | 0,0034 | 0,0044 |
| S3 | MM16-16016-B90-MD07 F30M | 4,0 | 0,070 | 0,070 | 0,080 | 0,10 |
| | | 0,16 | 0,0028 | 0,0028 | 0,0032 | 0,0040 |
| S11 | MM16-16016-B90-MD07 F30M | 4,5 | 0,085 | 0,085 | 0,095 | 0,12 |
| | | 0,18 | 0,0034 | 0,0034 | 0,0038 | 0,0050 |
| S12 | MM16-16016-B90-MD07 F30M | 4,5 | 0,085 | 0,085 | 0,095 | 0,12 |
| | | 0,18 | 0,0034 | 0,0034 | 0,0038 | 0,0050 |
| S13 | MM16-16016-B90-MD07 F30M | 4,0 | 0,080 | 0,080 | 0,085 | 0,11 |
| | | 0,16 | 0,0032 | 0,0032 | 0,0034 | 0,0044 |
| H5 | MM16-16016-B90-MD07 F30M | 5,0 | 0,070 | 0,070 | 0,080 | 0,10 |
| | | 0,20 | 0,0028 | 0,0028 | 0,0032 | 0,0044 |
| H8 | MM16-16016-B90-MD07 F30M | 4,5 | 0,055 | 0,055 | 0,060 | 0,080 |
| | | 0,18 | 0,0022 | 0,0022 | 0,0024 | 0,0032 |
| H11 | MM16-16016-B90-MD07 F30M | 5,0 | 0,070 | 0,070 | 0,080 | 0,10 |
| | | 0,20 | 0,0028 | 0,0028 | 0,0032 | 0,0044 |
| H12 | MM16-16016-B90-MD07 F30M | 4,5 | 0,055 | 0,055 | 0,060 | 0,080 |
| | | 0,18 | 0,0022 | 0,0022 | 0,0024 | 0,0032 |
| H21 | MM16-16016-B90-MD07 F30M | 4,5 | 0,055 | 0,055 | 0,060 | 0,080 |
| | | 0,18 | 0,0022 | 0,0022 | 0,0024 | 0,0032 |

SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

MM16 Z2 – Kopierfräser – Auswahl der Wendeschneidplatten – Schichten – mm/Zoll

| SMG | | a _p | f _z | | | |
|-----|---------------------------|----------------|----------------|--------|--------|--------|
| | | | 15% | 10% | 5% | 2% |
| P1 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,060 | 0,070 | 0,10 | 0,16 |
| | | 0.24 | 0.0024 | 0.0028 | 0.0040 | 0.0065 |
| P2 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,060 | 0,075 | 0,10 | 0,16 |
| | | 0.24 | 0.0024 | 0.0030 | 0.0040 | 0.0065 |
| P3 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,060 | 0,070 | 0,095 | 0,15 |
| | | 0.24 | 0.0024 | 0.0028 | 0.0038 | 0.0060 |
| P4 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,055 | 0,070 | 0,095 | 0,15 |
| | | 0.24 | 0.0022 | 0.0028 | 0.0038 | 0.0060 |
| P5 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,055 | 0,065 | 0,090 | 0,15 |
| | | 0.24 | 0.0022 | 0.0026 | 0.0036 | 0.0060 |
| P6 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,055 | 0,065 | 0,090 | 0,14 |
| | | 0.24 | 0.0022 | 0.0026 | 0.0036 | 0.0055 |
| P7 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,055 | 0,065 | 0,090 | 0,14 |
| | | 0.24 | 0.0022 | 0.0026 | 0.0036 | 0.0055 |
| P8 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,060 | 0,070 | 0,095 | 0,15 |
| | | 0.24 | 0.0024 | 0.0028 | 0.0038 | 0.0060 |
| P11 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,055 | 0,065 | 0,090 | 0,14 |
| | | 0.24 | 0.0022 | 0.0026 | 0.0036 | 0.0055 |
| P12 | MM16-16016-B90PF-M03 F15M | 4,5 | 0,038 | 0,046 | 0,060 | 0,10 |
| | | 0.18 | 0.0015 | 0.0018 | 0.0024 | 0.0040 |
| M1 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,060 | 0,075 | 0,10 | 0,16 |
| | | 0.24 | 0.0024 | 0.0030 | 0.0040 | 0.0065 |
| M2 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,055 | 0,065 | 0,090 | 0,15 |
| | | 0.24 | 0.0022 | 0.0026 | 0.0036 | 0.0060 |
| M3 | MM16-16016-B90PF-M03 F15M | 4,5 | 0,046 | 0,055 | 0,075 | 0,12 |
| | | 0.18 | 0.0018 | 0.0022 | 0.0030 | 0.0048 |
| M4 | MM16-16016-B90PF-M03 F15M | 3,5 | 0,040 | 0,046 | 0,065 | 0,10 |
| | | 0.14 | 0.0016 | 0.0019 | 0.0026 | 0.0040 |
| M5 | MM16-16016-B90PF-M03 F15M | 3,5 | 0,040 | 0,046 | 0,065 | 0,10 |
| | | 0.14 | 0.0016 | 0.0019 | 0.0026 | 0.0040 |
| K1 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,060 | 0,075 | 0,10 | 0,16 |
| | | 0.24 | 0.0024 | 0.0030 | 0.0040 | 0.0065 |
| K2 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,055 | 0,065 | 0,090 | 0,15 |
| | | 0.24 | 0.0022 | 0.0026 | 0.0036 | 0.0060 |
| K3 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,055 | 0,065 | 0,090 | 0,15 |
| | | 0.24 | 0.0022 | 0.0026 | 0.0036 | 0.0060 |
| K4 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,055 | 0,065 | 0,090 | 0,15 |
| | | 0.24 | 0.0022 | 0.0026 | 0.0036 | 0.0060 |
| K5 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,050 | 0,060 | 0,085 | 0,13 |
| | | 0.24 | 0.0020 | 0.0024 | 0.0034 | 0.0050 |
| K6 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,055 | 0,065 | 0,090 | 0,15 |
| | | 0.24 | 0.0022 | 0.0026 | 0.0036 | 0.0060 |
| K7 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,050 | 0,060 | 0,085 | 0,13 |
| | | 0.24 | 0.0020 | 0.0024 | 0.0034 | 0.0050 |
| N1 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,080 | 0,095 | 0,13 | 0,20 |
| | | 0.24 | 0.0032 | 0.0038 | 0.0050 | 0.0080 |
| N2 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,080 | 0,095 | 0,13 | 0,20 |
| | | 0.24 | 0.0032 | 0.0038 | 0.0050 | 0.0080 |
| N3 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,080 | 0,095 | 0,13 | 0,20 |
| | | 0.24 | 0.0032 | 0.0038 | 0.0050 | 0.0080 |
| N11 | MM16-16016-B90PF-M03 F15M | 6,0 | 0,080 | 0,095 | 0,13 | 0,20 |
| | | 0.24 | 0.0032 | 0.0038 | 0.0050 | 0.0080 |
| S1 | MM16-16016-B90PF-M03 F15M | 3,5 | 0,040 | 0,046 | 0,065 | 0,10 |
| | | 0.14 | 0.0016 | 0.0019 | 0.0026 | 0.0040 |
| S2 | MM16-16016-B90PF-M03 F15M | 3,5 | 0,040 | 0,046 | 0,065 | 0,10 |
| | | 0.14 | 0.0016 | 0.0019 | 0.0026 | 0.0040 |
| S3 | MM16-16016-B90PF-M03 F15M | 3,5 | 0,038 | 0,044 | 0,060 | 0,095 |
| | | 0.14 | 0.0015 | 0.0017 | 0.0024 | 0.0038 |
| S11 | MM16-16016-B90PF-M03 F15M | 4,0 | 0,046 | 0,055 | 0,075 | 0,12 |
| | | 0.16 | 0.0018 | 0.0022 | 0.0030 | 0.0048 |
| S12 | MM16-16016-B90PF-M03 F15M | 4,0 | 0,046 | 0,055 | 0,075 | 0,12 |
| | | 0.16 | 0.0018 | 0.0022 | 0.0030 | 0.0048 |
| S13 | MM16-16016-B90PF-M03 F15M | 3,5 | 0,040 | 0,046 | 0,065 | 0,10 |
| | | 0.14 | 0.0016 | 0.0019 | 0.0026 | 0.0040 |
| H5 | MM16-16016-B90PF-M03 F15M | 4,5 | 0,038 | 0,046 | 0,060 | 0,10 |
| | | 0.18 | 0.0015 | 0.0018 | 0.0024 | 0.0040 |
| H8 | MM16-16016-B90PF-M03 F15M | 4,0 | 0,030 | 0,034 | 0,048 | 0,075 |
| | | 0.16 | 0.0012 | 0.0014 | 0.0019 | 0.0030 |
| H11 | MM16-16016-B90PF-M03 F15M | 4,5 | 0,038 | 0,046 | 0,060 | 0,10 |
| | | 0.18 | 0.0015 | 0.0018 | 0.0024 | 0.0040 |
| H12 | MM16-16016-B90PF-M03 F15M | 4,0 | 0,030 | 0,034 | 0,048 | 0,075 |
| | | 0.16 | 0.0012 | 0.0014 | 0.0019 | 0.0030 |
| H21 | MM16-16016-B90PF-M03 F15M | 4,0 | 0,030 | 0,034 | 0,048 | 0,075 |
| | | 0.16 | 0.0012 | 0.0014 | 0.0019 | 0.0030 |


SMG = Seco Werkstoff-Gruppe
f_z = mm/Zahn (Zoll/Zahn), v_c = m/min (sf/min), a_p/DC = %
Alle Schnittdaten sind Startwerte

Unversell
Stahl und Guss
Stahl und Guss
Rostfrei und ISO-S-Werkstoffe
Rostfrei und ISO-S-Werkstoffe
NE-Metalle
Harter
Graphit
X-Heads
Minimaster Plus
Minimaster



MM16 Z2 – Kopierfräser – Schnittdaten $v_c = (m/min)/(sf/min)$

| SMG | F15M | | | | | F30M | | | | | T60M | | | | |
|-----|------|------|------|------|------|------|------|------|------|------|------|------|------|------|------|
| | 100% | 20% | 10% | 5% | 2% | 100% | 20% | 10% | 5% | 2% | 100% | 20% | 10% | 5% | 2% |
| P1 | 285 | 360 | 390 | 420 | 415 | 225 | 280 | 300 | 325 | 325 | 185 | 225 | 245 | 265 | 265 |
| | 940 | 1175 | 1275 | 1375 | 1350 | 740 | 920 | 980 | 1075 | 1075 | 610 | 740 | 800 | 870 | 870 |
| P2 | 275 | 350 | 375 | 405 | 405 | 220 | 270 | 295 | 315 | 315 | 180 | 220 | 240 | 255 | 255 |
| | 900 | 1150 | 1225 | 1325 | 1325 | 720 | 890 | 970 | 1025 | 1025 | 590 | 720 | 790 | 840 | 840 |
| P3 | 240 | 305 | 325 | 355 | 355 | 190 | 240 | 255 | 280 | 275 | 155 | 195 | 210 | 225 | 225 |
| | 790 | 1000 | 1075 | 1175 | 1175 | 620 | 790 | 840 | 920 | 900 | 510 | 640 | 690 | 740 | 740 |
| P4 | 215 | 270 | 285 | 310 | 310 | 170 | 210 | 225 | 245 | 245 | 140 | 170 | 185 | 200 | 195 |
| | 710 | 890 | 940 | 1025 | 1025 | 560 | 690 | 740 | 800 | 800 | 460 | 560 | 610 | 660 | 640 |
| P5 | 205 | 255 | 275 | 300 | 295 | 165 | 200 | 220 | 235 | 230 | 130 | 160 | 175 | 190 | 190 |
| | 670 | 840 | 900 | 980 | 970 | 540 | 660 | 720 | 770 | 750 | 425 | 520 | 570 | 620 | 620 |
| P6 | 230 | 290 | 310 | 335 | 335 | 180 | 225 | 245 | 265 | 265 | 150 | 180 | 200 | 215 | 215 |
| | 750 | 950 | 1025 | 1100 | 1100 | 590 | 740 | 800 | 870 | 870 | 490 | 590 | 660 | 710 | 710 |
| P7 | 215 | 275 | 290 | 315 | 315 | 170 | 210 | 230 | 250 | 250 | 140 | 170 | 190 | 200 | 200 |
| | 710 | 900 | 950 | 1025 | 1025 | 560 | 690 | 750 | 820 | 820 | 460 | 560 | 620 | 660 | 660 |
| P8 | 200 | 255 | 275 | 295 | 295 | 160 | 200 | 215 | 235 | 230 | 130 | 160 | 175 | 190 | 190 |
| | 660 | 840 | 900 | 970 | 970 | 520 | 660 | 710 | 770 | 750 | 425 | 520 | 570 | 620 | 620 |
| P11 | 210 | 265 | 285 | 310 | 310 | 165 | 205 | 225 | 240 | 240 | 135 | 165 | 180 | 195 | 195 |
| | 690 | 870 | 940 | 1025 | 1025 | 540 | 670 | 740 | 790 | 790 | 445 | 540 | 590 | 640 | 640 |
| P12 | 135 | 175 | 175 | 190 | 190 | 110 | 140 | 145 | 155 | 155 | 90 | 110 | 115 | 125 | 125 |
| | 445 | 570 | 590 | 620 | 620 | 360 | 460 | 475 | 510 | 510 | 295 | 360 | 375 | 410 | 410 |
| M1 | 225 | 285 | 300 | 330 | 325 | 175 | 220 | 235 | 255 | 250 | 145 | 180 | 190 | 205 | 205 |
| | 740 | 940 | 980 | 1075 | 1075 | 570 | 720 | 770 | 840 | 820 | 475 | 590 | 620 | 670 | 670 |
| M2 | 185 | 230 | 250 | 270 | 265 | 145 | 180 | 195 | 210 | 210 | 120 | 145 | 160 | 170 | 170 |
| | 610 | 750 | 820 | 890 | 870 | 475 | 590 | 640 | 690 | 690 | 395 | 475 | 520 | 560 | 560 |
| M3 | 150 | 190 | 195 | 210 | 210 | 120 | 150 | 155 | 170 | 170 | 95 | 125 | 125 | 135 | 135 |
| | 490 | 620 | 660 | 690 | 690 | 395 | 490 | 520 | 560 | 560 | 310 | 410 | 425 | 445 | 445 |
| M4 | 115 | 150 | 150 | 160 | 160 | 95 | 125 | 120 | 130 | 130 | 75 | 100 | 95 | 105 | 105 |
| | 375 | 490 | 520 | 520 | 520 | 310 | 410 | 425 | 425 | 425 | 245 | 330 | 345 | 345 | 345 |
| M5 | 95 | 125 | 125 | 135 | 135 | 80 | 100 | 100 | 110 | 110 | 65 | 85 | 80 | 90 | 85 |
| | 310 | 410 | 445 | 445 | 445 | 260 | 330 | 345 | 360 | 360 | 215 | 280 | 280 | 295 | 280 |
| K1 | 220 | 280 | 295 | 320 | 320 | 175 | 215 | 235 | 250 | 250 | 140 | 175 | 190 | 205 | 200 |
| | 720 | 920 | 970 | 1050 | 1050 | 570 | 710 | 770 | 820 | 820 | 460 | 570 | 620 | 670 | 660 |
| K2 | 195 | 245 | 260 | 285 | 280 | 155 | 190 | 210 | 220 | 220 | 125 | 155 | 170 | 180 | 180 |
| | 640 | 800 | 850 | 940 | 920 | 510 | 620 | 690 | 720 | 720 | 410 | 510 | 560 | 590 | 590 |
| K3 | 165 | 205 | 220 | 240 | 240 | 130 | 160 | 175 | 190 | 185 | 105 | 130 | 140 | 150 | 150 |
| | 540 | 670 | 720 | 790 | 790 | 425 | 520 | 570 | 620 | 610 | 345 | 425 | 460 | 490 | 490 |
| K4 | 155 | 195 | 210 | 230 | 225 | 125 | 155 | 170 | 180 | 180 | 100 | 125 | 135 | 145 | 145 |
| | 510 | 640 | 690 | 750 | 740 | 410 | 510 | 560 | 590 | 590 | 330 | 410 | 445 | 475 | 475 |
| K5 | 95 | 120 | 125 | 135 | 140 | 75 | 95 | 100 | 110 | 110 | 60 | 75 | 80 | 90 | 90 |
| | 310 | 395 | 410 | 445 | 460 | 245 | 310 | 330 | 360 | 360 | 195 | 245 | 260 | 295 | 295 |
| K6 | 135 | 175 | 185 | 200 | 200 | 110 | 135 | 150 | 160 | 155 | 90 | 110 | 120 | 130 | 125 |
| | 445 | 570 | 610 | 660 | 660 | 360 | 445 | 490 | 520 | 510 | 295 | 360 | 395 | 425 | 410 |
| K7 | 120 | 150 | 165 | 175 | 175 | 95 | 120 | 130 | 140 | 140 | 80 | 95 | 105 | 115 | 115 |
| | 395 | 490 | 540 | 570 | 570 | 310 | 395 | 425 | 460 | 460 | 260 | 310 | 345 | 375 | 375 |
| N1 | 1675 | 2125 | 2250 | 2450 | 2450 | 1300 | 1625 | 1725 | 1875 | 1850 | 1050 | 1325 | 1400 | 1525 | 1500 |
| | 5500 | 6975 | 7375 | 8050 | 8050 | 4275 | 5325 | 5650 | 6150 | 6075 | 3450 | 4350 | 4600 | 5000 | 4925 |
| N2 | 680 | 860 | 910 | 990 | 990 | 530 | 660 | 700 | 760 | 750 | 425 | 530 | 570 | 620 | 610 |
| | 2225 | 2825 | 2975 | 3250 | 3250 | 1750 | 2175 | 2300 | 2500 | 2450 | 1400 | 1750 | 1875 | 2025 | 2000 |
| N3 | 450 | 570 | 610 | 660 | 660 | 350 | 435 | 465 | 510 | 500 | 285 | 355 | 380 | 410 | 405 |
| | 1475 | 1875 | 2000 | 2175 | 2175 | 1150 | 1425 | 1525 | 1675 | 1650 | 940 | 1175 | 1250 | 1350 | 1325 |
| N11 | 520 | 650 | 690 | 750 | 760 | 400 | 500 | 530 | 580 | 570 | 325 | 405 | 430 | 470 | 465 |
| | 1700 | 2125 | 2275 | 2450 | 2500 | 1300 | 1650 | 1750 | 1900 | 1875 | 1075 | 1325 | 1400 | 1550 | 1525 |
| S1 | 55 | 70 | 70 | 75 | 75 | 44 | 55 | 55 | 60 | 60 | 36 | 46 | 45 | 49 | 49 |
| | 180 | 230 | 245 | 245 | 245 | 145 | 180 | 195 | 195 | 195 | 120 | 150 | 160 | 160 | 160 |
| S2 | 44 | 55 | 55 | 60 | 60 | 35 | 46 | 45 | 49 | 49 | 29 | 37 | 36 | 40 | 39 |
| | 145 | 180 | 195 | 195 | 195 | 115 | 150 | 155 | 160 | 160 | 95 | 120 | 130 | 130 | 130 |
| S3 | 38 | 49 | 48 | 50 | 50 | 31 | 40 | 39 | 43 | 43 | 25 | 32 | 32 | 35 | 35 |
| | 125 | 160 | 165 | 165 | 165 | 100 | 130 | 140 | 140 | 140 | 80 | 105 | 110 | 115 | 115 |
| S11 | 75 | 100 | 100 | 105 | 105 | 60 | 80 | 80 | 85 | 85 | 50 | 65 | 65 | 70 | 70 |
| | 245 | 330 | 345 | 345 | 345 | 195 | 260 | 260 | 280 | 280 | 165 | 215 | 215 | 230 | 230 |
| S12 | 55 | 70 | 70 | 75 | 75 | 43 | 55 | 55 | 60 | 60 | 35 | 44 | 44 | 48 | 48 |
| | 180 | 230 | 230 | 245 | 245 | 140 | 180 | 180 | 195 | 195 | 115 | 145 | 150 | 155 | 155 |
| S13 | 31 | 39 | 39 | 42 | 42 | 25 | 32 | 31 | 34 | 34 | 20 | 26 | 25 | 28 | 28 |
| | 100 | 130 | 140 | 140 | 140 | 80 | 105 | 110 | 110 | 110 | 65 | 85 | 90 | 90 | 90 |
| H5 | 45 | 55 | 60 | 65 | 65 | 36 | 46 | 48 | 50 | 50 | 30 | 37 | 39 | 41 | 41 |
| | 150 | 180 | 195 | 215 | 215 | 120 | 150 | 155 | 165 | 165 | 100 | 120 | 130 | 135 | 135 |
| H8 | 46 | 60 | 60 | 65 | 65 | 39 | 50 | 50 | 55 | 55 | 31 | 40 | 40 | 44 | 43 |
| | 150 | 195 | 215 | 215 | 215 | 130 | 165 | 165 | 180 | 180 | 100 | 130 | 140 | 145 | 140 |
| H11 | 55 | 75 | 75 | 80 | 80 | 46 | 60 | 60 | 65 | 65 | 38 | 47 | 49 | 55 | 50 |
| | 180 | 245 | 245 | 260 | 260 | 150 | 195 | 195 | 215 | 215 | 125 | 155 | 165 | 180 | 165 |
| H12 | 85 | 105 | 105 | 115 | 115 | 70 | 90 | 90 | 95 | 95 | 55 | 70 | 70 | 80 | 80 |
| | 280 | 345 | 375 | 375 | 375 | 230 | 295 | 310 | 310 | 310 | 180 | 230 | 245 | 260 | 260 |
| H21 | 46 | 60 | 60 | 65 | 65 | 39 | 50 | 50 | 55 | 55 | 31 | 40 | 40 | 44 | 43 |
| | 150 | 195 | 215 | 215 | 215 | 130 | 165 | 165 | 180 | 180 | 100 | 130 | 140 | 145 | 140 |

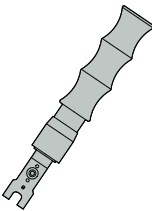
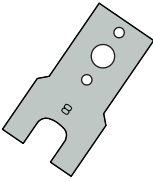
Drehmomentschlüssel und maximale Drehzahl

| Drehmomentschlüssel | |
|--|---|
| <p>Die empfohlene Maximaldrehzahl, die aus Sicherheitsgründen nicht überschritten werden darf, ist auf jeder Produktseite angegeben. Normalerweise ist es nicht notwendig, Werkzeuge bis 10.000 U/min auszuwuchten.</p> <p>Trotzdem kann eine Auswuchtung in einigen Fällen erforderlich sein, z. B. wenn schwere Werkzeuge und Aufnahmen auf kleinen Maschinen eingesetzt werden.</p> |  |
| <p>Drehmomentschlüssel für feste Drehmomente generieren automatisch die richtige Klemmkraft beim Einsatz des Minimaster-Schneidkopfes in die Aufnahme.</p> <p>Drehmomentschlüssel sind gemäß ISO 6789 voreingestellt.</p> <p>Code-Schlüssel: MM02-4006</p> <p>MM02 = 2-schneidig (MM03 = 3-schneidig)</p> <p>40 = Drehmoment 4,0 Nm</p> <p>06 = Schneidkopf-Größe</p> | <p>Über 10.000 U/min: Wir empfehlen, Werkzeug und Aufnahme separat auszuwuchten.</p> <p>Über 20.000 U/min: Werkzeug und Aufnahme müssen als Einheit ausgewuchtet werden.</p> <p>Über 30.000 U/min: Werkzeug und Aufnahme müssen als Einheit ausgewuchtet werden.</p> <p>Die maximale Drehzahl laut Tabelle muss eingehalten werden.</p> |

Schneidkopf 2-schneidig

| Wendeplattengröße | Drehmoment-schlüssel (einschließlich Schlüsselkopf) | Austausch-barer Schlüsselkopf | Drehmoment |
|-------------------------------|--|---|------------|
| |  |  | |
| MM06 | MM02-4006 | MM02-06 | 4 Nm |
| MM08 | MM02-8008 | MM02-08 | 8 Nm |
| MM10 | MM02-1201012 | MM02-1012 | 12 Nm |
| MM12 | MM02-1201012 | MM02-1012 | 12 Nm |
| MM12 DC = \varnothing 14,0 | MM02-16014 | MM02-14 | 16 Nm |
| MM12 DCX = \varnothing 16,0 | MM02-1601620 | MM02-1620 | 16 Nm |
| MM16 | MM02-1601620 | MM02-1620 | 16 Nm |

Schneidkopf 3-schneidig

| Wendeplattengröße | Drehmoment-schlüssel (einschließlich Schlüsselkopf) | Austausch-barer Schlüsselkopf | Drehmoment |
|-------------------|---|---|------------|
| |  |  | |
| MM06 | MM03-4006 | MM03-06 | 4 Nm |
| MM08 | MM03-8008 | MM03-08 | 8 Nm |
| MM10 | MM03-1201012 | MM03-1012 | 12 Nm |
| MM12 | MM03-1201012 | MM03-1012 | 12 Nm |
| MM16 | MM03-16016 | MM03-16 | 16 Nm |

Universell

Stahl und Guss

Rostfrei und ISO-S-Werkstoffe

Rostfrei und ISO-S-Werkstoffe

NE-Metalle

Harter

Graphit

X-Heads

Minimaster Plus

Minimaster



SMG – Einführung



Die Basis für SMG ist eine Klassifizierung der Werkstoffe auf der Grundlage ihres Typs und nicht ihrer relativen Zerspanbarkeit; sie enthält folglich Werkstoffe wie beispielsweise Verbundwerkstoffe. Sie ist umfangreich und dabei gleichzeitig übersichtlich, so dass es einfach ist, zu ermitteln, zu welcher Seco Werkstoff-Gruppe ein Werkstoff gehört. Jede Werkstoffgruppe verfügt über einen spezifischen Werkstoffstandard in einer speziellen Ausführung als Referenz. So sind die Schnittdaten für jeden vorhandenen Werkstoff im Vergleich zu jedem Seco Referenz-Werkstoff leicht anzupassen, siehe Seite 728 - 731.

Als Beispiel werden die Referenzwerkstoffe EN C45E für SMG P4 und EN 42 CrMo 4 für die beiden Materialgruppen SMG P5 und SMG H5 in der nachstehenden Tabelle dargestellt. Die entsprechenden Materialeigenschaften sind mit aufgeführt.

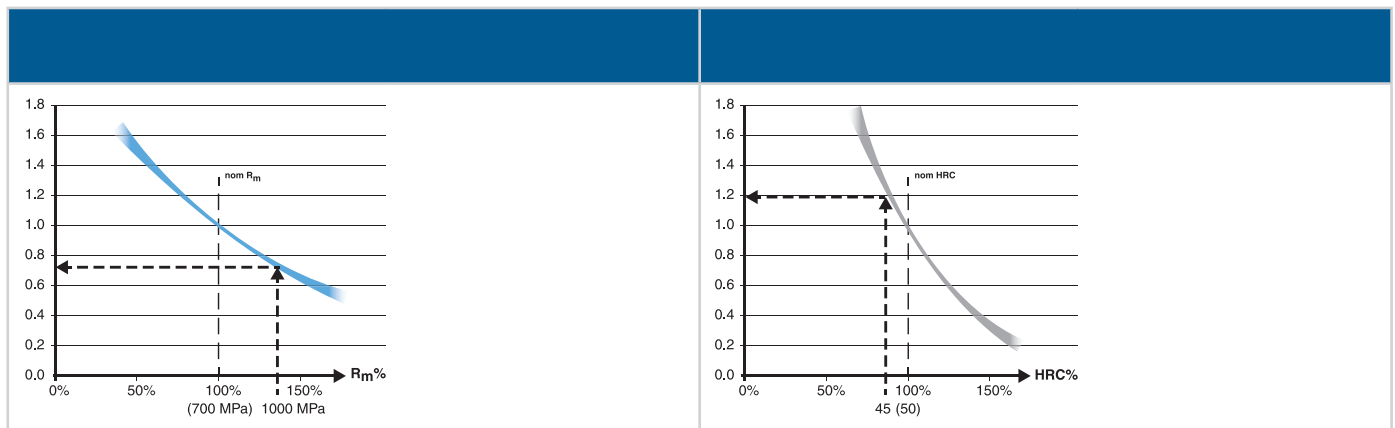
| SMG | Bezeichnung | Bezeichnung | Referenz |
|-----|---|-----------------------------|---|
| P4 | Niedrig legierte Baustähle mit 0,25% < C < 0,67%wt Niedrig legierte Vergütungsstähle | 520 < R _m < 1200 | C 45E R _m = 660 N/mm ² |
| P5 | Baustähle mit 0,25% < C < 0,67%wt Vergütungsstähle | 550 < R _m < 1200 | 42 CrMo 4 R _m = 700 N/mm ² |

Bei dem Werkstoff EN 42 CrMo 4 in lösungsgeglühtem Zustand liegt die Bruchfestigkeit R_m typischerweise zwischen R_m = 630 N/mm² und R_m = 780 N/mm² und bietet damit einen Referenzbereich für SMG P5. Im geglühten Zustand liegt die Bruchfestigkeit R_m typischerweise zwischen R_m = 900 N/mm² und R_m = 1100 N/mm². Damit wird dieser Werkstoff immer noch der Materialgruppe SMG P5 zugeordnet.

| SMG | EN | W.-Nr | AFNOR | BS | UNI | JIS | AISI / ASTM | GOST | Zustand | R _{m,nom} | HRC _{nom} |
|-----|-----------|--------|---------|----------|-----------|-------------|-------------|------|-----------------------|--------------------|--------------------|
| P5 | 42 CrMo 4 | 1,1201 | 42 CD 4 | 708 M 40 | 42 CrMo 4 | SCM 440 (H) | 4142, 4140 | 38HM | Geglüht | 700 | |
| | 42 CrMo 4 | 1,1201 | 42 CD 4 | 708 M 40 | 42 CrMo 4 | SCM 440 (H) | 4142, 4140 | 38HM | Angelassen & vergütet | 1000 | |
| H5 | 42 CrMo 4 | 1,1201 | 42 CD 4 | 708 M 40 | 42 CrMo 4 | SCM 440 (H) | 4142, 4140 | 38HM | Angelassen & vergütet | | 45 |
| | 42 CrMo 4 | 1,1201 | 42 CD 4 | 708 M 40 | 42 CrMo 4 | SCM 440 (H) | 4142, 4140 | 38HM | Angelassen & vergütet | | 50 |

Ab einer Zugfestigkeit von R_m = 1200 N/mm² gehört EN 42 CrMo 4 zur Materialgruppe SMG H5. Am Beispiel des Werkstoffes vergüteter Stahl EN 42CrMo4 wird die Abhängigkeit der Bearbeitbarkeit der Werkstoffe von den Werkstoffeigenschaften erläutert und die Ermittlung des Schnittdatenfaktors dargestellt.

Die nachstehenden Graphiken zeigen, wie die Schnittdatenempfehlung für nominelle Werkstoffausführungen an entsprechende R_m (linkes Diagramm für ISO-P) und an entsprechende HRC (für ISO-H) angepasst werden kann.



Ermittlung der Schnittdaten für EN 42 CrMo4 BIS R_m = 1200 N/mm²: Um darzustellen, wie in der SMG die nominelle Schnittgeschwindigkeit der SMG P5 genauer berechnet werden kann, benötigen wir die Zugfestigkeit R_m. In diesem Falle verwenden wir EN 42 CrMo 4 vergütet auf R_m = 1000 N/mm² gemäß der obigen Tabelle.

Bei der SMG P5 beträgt die nominelle Schnittgeschwindigkeit für ein Produkt z.B. v_c = 280 m/min. Bei einer Zugfestigkeit R_m = 1000 N/mm² ergibt sich ein Schnittdatenfaktor von 0,75 (siehe Abbildung links). Daraus errechnet sich die empfohlene Schnittgeschwindigkeit v_c = 280 m/min x 0,75 = 210 m/min.

Ermittlung der Schnittdaten für EN 42 CrMo4 AB R_m = 1200 N/mm² (entsprechen 38 HRC). Die Anpassung der nominellen Schnittgeschwindigkeit des gehärteten Werkstoffes EN 42 CrMo 4 mit einer Härte von HRC 45 erfolgt auf die gleiche Weise (siehe dazu Darstellung mit grauer Kurve rechts). Wir gehen davon aus, dass die nominelle Schnittgeschwindigkeit für SMG H5 v_c = 50 m/min für ein bestimmtes Produkt und eine bestimmte Bearbeitung beträgt. Daraus errechnet sich der Schnittdatenfaktor 1,2. Die tatsächliche Schnittgeschwindigkeit beträgt dann v_c = 50 m/min x 1,2 = 60 m/min.

Weitere Werkstoffdetails finden Sie auf Seite(n) 266-273, weitere Schnittdatenempfehlungen auf den entsprechenden Katalogseiten.

Auf www.secotools.com können Sie die Schnittdaten für Ihre individuelle Anwendung ganz einfach berechnen.

Stahl, ferritische und martensitisch rostfreie Stähle

| SMG | Bezeichnung | Bezeichnung | Referenz | $k_{c1.1}$ | m_c |
|-----|---|--------------------|--|------------|-------|
| P1 | Automatenstähle mit niedrigem Kohlenstoffgehalt | $360 < R_m < 880$ | 11 SMn30 $R_m = 385 \text{ N/mm}^2$ | 1500 | 0,14 |
| P2 | Niedrig legierte ferritische Stähle mit $C < 0,25\%wt$ Niedrig legierte normale Baustähle | $320 < R_m < 600$ | S235JRG2 $R_m = 420 \text{ N/mm}^2$ | 1600 | 0,23 |
| P3 | Ferritische und ferritisch/perlitische Stähle mit $C < 0,25\%wt$ schweißbare Baustähle Einsatzstähle | $430 < R_m < 610$ | 16 MnCr 5 $R_m = 550 \text{ N/mm}^2$ | 1800 | 0,14 |
| P4 | Niedrig legierte Baustähle mit $0,25\% < C < 0,67\%wt$ Niedrig legierte Vergütungs- stähle | $520 < R_m < 1200$ | C 45E $R_m = 660 \text{ N/mm}^2$ | 2000 | 0,15 |
| P5 | Baustähle mit $0,25\% < C < 0,67\%wt$ Vergütungsstähle | $550 < R_m < 1200$ | 42 CrMo 4 $R_m = 700 \text{ N/mm}^2$ | 2020 | 0,18 |
| P6 | Niedrig legierte härtbare Stähle mit $C > 0,67\%wt$ Niedrig legierte Feder- und Lagerstähle | $520 < R_m < 1200$ | C 100S $R_m = 600 \text{ N/mm}^2$ | 2100 | 0,17 |
| P7 | Härtbare Stähle mit $C > 0,67\%wt$ Feder- und Lagerstähle | $600 < R_m < 1200$ | 100 Cr 6 $R_m = 650 \text{ N/mm}^2$ | 2160 | 0,17 |
| P8 | Werkzeugstähle Schnellarbeitsstähle (HSS) | $600 < R_m < 1200$ | X 40 CrMoV 5 1 $R_m = 700 \text{ N/mm}^2$ | 2400 | 0,20 |
| P11 | Ferritische und martensitische Stähle | $415 < R_m < 1200$ | X 20 Cr 13 $R_m = 675 \text{ N/mm}^2$ | 2000 | 0,15 |
| P12 | Martensitahärtbares und lösungsbehandeltes Rostfrei | $500 < R_m < 1200$ | X 5 CrNiCuNb 16 4 $R_m = 1100 \text{ N/mm}^2$ | 2100 | 0,17 |

Austenitisch rostfreie Stähle

| SMG | Bezeichnung | Bezeichnung | Referenz | $k_{c1.1}$ | m_c |
|-----|--|-------------|--------------------|------------|-------|
| M1 | Leicht schneidendes Rostfrei | | X 10 CrNiS 18 9 | 1700 | 0,14 |
| M2 | Niedrig legierte austenitische rostfreie Stähle | | X 5 CrNi 18 10 | 1920 | 0,18 |
| M3 | Legierte austenitische rostfreie Stähle | | X 2 CrNiMo 18 14 3 | 2070 | 0,17 |
| M4 | Hoch legierte rostfreie Stähle (Austenit und Duplex) | | X 2 CrNiMoN 22 5 3 | 2230 | 0,16 |
| M5 | Austenit und Duplex, sehr schwierig zerspanbar | | X 2 CrNiMoN 25 7 4 | 2510 | 0,13 |

Guss

| SMG | Bezeichnung | Bezeichnung | Referenz | $k_{c1.1}$ | m_c |
|-----|--|-------------|-----------------------|------------|-------|
| K1 | Grauguss (GCI) | | EN-GJL-250 | 930 | 0,32 |
| K2 | Vermikularguss (CGI) | | EN-GJV-400 | 1000 | 0,35 |
| K3 | Temperguss (MCI) | | EN-GJMB-550-4 | 1050 | 0,37 |
| K4 | Sphäroguss, Kugelgrafitguss (SGI) | | EN-GJS-500-7 | 1160 | 0,37 |
| K5 | Wärmebehandelter Kugelgrafitguss (ADI) | | EN-GJS-1000-5 | | |
| K6 | Austenitischer Guss mit Lamellengrafit | | EN-GJLA-XNiCuCr15-6-2 | | |
| K7 | Austenitischer Sphäroguss | | EN-GJSA-XNiMn23-4 | | |

Nicht-Eisen-Metalle

| SMG | Bezeichnung | Bezeichnung | Referenz | $k_{c1.1}$ | m_c |
|-----|-------------------------------------|-------------|----------------------|------------|-------|
| N1 | Aluminiumlegierungen, Si < 9% | | AW-7075 | | |
| N2 | Aluminiumlegierungen, 9% < Si < 16% | | AC-44200 Si = 12% | | |
| N3 | Aluminiumlegierungen, Si > 16% | | AlSi17Cu5 | | |
| N11 | Kupferlegierungen | | CW614N | 740 | 0,26 |

Superlegierungen und Titan

| SMG | Bezeichnung | Bezeichnung | Referenz | $k_{c1.1}$ | m_c |
|-----|--|-------------|-------------|------------|-------|
| S1 | Superlegierungen auf Fe-Basis | | Discalloy | | |
| S2 | Superlegierungen auf Co-Basis | | Stellite 21 | | |
| S3 | Superlegierungen auf Ni-Basis | | Inconel 718 | 2530 | 0,21 |
| S11 | Titan, niedrig legiert, (α) | | Ti | | |
| S12 | Titan, mittlere Legierung, ($\alpha+\beta$) | | TiAl6V4 | 1500 | 0,24 |
| S13 | Titan, hoch legiert, (nahe β und β) | | Ti10V2Fe3Al | | |

Harte Werkstoffe

| SMG | Bezeichnung | Bezeichnung | Referenz | $k_{c1.1}$ | m_c |
|-----|---|---------------------|--|------------|-------|
| H3 | Einsatzstahl gehärtet | 58 < HRC < 62 | 16 MnCr 5 60 HRC | 2070 | 0,14 |
| H5 | Vergütungsstähle | 38 < HRC < 56 | 42 CrMo 4 50 HRC | 2320 | 0,18 |
| H7 | Vergütungsstähle Lagerstähle | 56 < HRC < 64 | 100 Cr 6 60 HRC | 2480 | 0,17 |
| H8 | Werkzeugstähle Schnellarbeitsstähle (HSS) | 38 < HRC < 64 | X 40 CrMoV 5 1 50 HRC | 2750 | 0,20 |
| H11 | Martensitische, rostfreie Stähle | 38 < HRC < 50 | X 20 Cr 13 45 HRC | 2300 | 0,15 |
| H12 | Martensitisch gehärtetes und lösungsbehandeltes Rostfrei | 1200 < R_m < 1650 | X 5 CrNiCuNb 16 4 $R_m = 1450 \text{ N/mm}^2$ | 2410 | 0,17 |
| H21 | Manganstahl | 23 < HRC < 64 | X 120 Mn 12 50 HRC | | |
| H31 | Weißhartguss | 50 < HRC < 64 | EN-GJN-HV600(XCr11) 55 HRC | | |

Andere Werkstoffe

| SMG | Bezeichnung | Bezeichnung | Referenz | $k_{c1.1}$ | m_c |
|-----|---|-------------|--|------------|-------|
| PM1 | Niedrig legierte Pulvermetall- Werkstoffe | | F-0008 Fe-0.7C | | |
| PM2 | PM-Werkstofflegierungen im mittleren Bereich | | FLC-4608 Fe2Cu1.8Ni 0.5Mo0.2Mn0.8C | | |
| PM3 | Hoch legierte PM-Werkstoffe Werkstoffe für Abgasventilsitze, etc. | | | | |
| HF1 | Aufschweißlegierungen Geschweißte oder Plasma-beschichtete Legierungen auf Eisen-Basis | | | | |
| HF2 | Aufschweißlegierungen Geschweißte oder Plasma- beschichtete Kobalt- und Nickel-basis-Legierungen | | | | |
| CC1 | Gesintertes Wolfram-Hartmetall | | G50 | | |

Kunststoffe und Composite

| SMG | Bezeichnung | Bezeichnung | Referenz | $k_{c1.1}$ | m_c |
|-----|--|-------------|--|------------|-------|
| TS1 | Duroplaste | | Urea Formaldehyde (UF) | | |
| TS2 | Duroplastische Kohlenstoff- faser-Verbundwerkstoffe | | T300 T700 T800 HTA-S IMA - Epoxy (M21)... | | |
| TS3 | Duroplastische Glasfaser- Verbundwerkstoffe | | Epoxy - HX..(42..)E-Glas (7781...)... | | |
| TS4 | Duroplastische Aramidfaser- Verbundwerkstoffe | | Kevlar 49 | | |
| TP1 | Thermoplastische Polymere | | Polycarbonat (PC) | | |
| TP2 | Thermoplastische Kohlenstofffaser- Verbundwerkstoffe | | PPS/PEEK - T300.. | | |
| TP3 | Thermoplastische Glasfaser- Verbundwerkstoffe | | PPS/PEEK - E-Glas oder A-Glas... | | |
| TP4 | Thermoplastische Aramidfaser- Verbundwerkstoffe | | | | |

Graphit

| SMG | Bezeichnung | Bezeichnung | Referenz | $k_{c1.1}$ | m_c |
|-----|-------------|-------------|----------|------------|-------|
| GR1 | Graphit | | R 8500 | | |

SMG

| SMG | EN | EN-Nr | W.-Nr | DIN | AFNOR | BS | UNI | JIS | SS | UNS |
|----------------|---------------|--------|--------------|---------------|-------------------|-----------------|------------------|-----------------|------------|--------|
| P1 | 11 SMn 30 | 1.0715 | 1.0715 | 9 SMn 28 | S 250 | 230 M 07 | CF 9 SMn 28 | SUM 22 | 1912 | G12130 |
| | 11 SMnPb 30 | 1.0718 | 1.0718 | 9 SMnPb 28 | S 250 Pb | | CF 9 SMnPb 28 | SUM 22 L | 1914 | G12134 |
| | 10 S 20 | 1.0721 | 1.0721 | 10 S 20 | 10 F 1 | 210 M 15 | CF 10 S 20 | | | |
| | | | 1.0722 | 10 SPb 20 | 10 PbF 2 | | CF 10 SPb 20 | | | |
| | 15 SMn 13 | 1.0725 | 1.0723 | 15 S 20 | | 210 A 15 | | SUM 32 | 1922 | |
| | 35 S20 | 1.0726 | 1.0726 | 35 S 20 | 35 MF 4 | 212 M 36 | | | 1957 | G11400 |
| | 46 S20 | 1.0727 | 1.0727 | 46 S 20 | 45 MF 4 | 212 M 44 | | | 1973 | G11460 |
| | 11 SMn 37 | 1.0736 | 1.0736 | 9 SMn 36 | S 300 | 240 M 07 | CF 9 SMn 36 | | | G12150 |
| 11 SMn 37 | 1.0736 | 1.0736 | 9 SMn 36 | S 300 | 240 M 07 | CF 9 SMn 36 | | | G12150 | |
| P2 | S235JR | 1.0037 | 1.0037 | St 37-2 | E 24-2 | | Fe 360 B | STKM 12 C | 1311 | |
| | S235JRG2 | 1.0038 | 1.0116 | St 37-3 | E 24-3, E 24-4 | 4360-40 C | Fe 360 D FF | | 1312, 1313 | |
| | S275J2G3 | 1.0144 | 1.0144 | St 44-3 N | E 28-3, E 28-4 | 4360-43 C | Fe 430 D FF | SM 41 C | 1412, 1414 | |
| | C 10 | 1.0301 | 1.0301 | C 10 | AF 34 C 10, XC 10 | 045 M 10 | C 10 | S 10 C | | G10100 |
| | | | 1.0401 | C 15 | AF 37 C 12, XC 18 | 080 M 15 | C 15, C 16 | | 1350 | G10170 |
| | C22 | 1.0402 | 1.0402 | C 22 | C 20 | 050 A 20 | C 20, C 21 | | 1450 | G10200 |
| | S355JR | 1.0570 | 1.0570 | St 52-3 | E 36-3, E 36-4 | 4360-50 C | Fe 510 B | SM 50 YA | 2172, 2132 | |
| | C 15R | 1.1141 | 1.1141 | Ck 15 | XC 15, XC 18 | 080 M 15 | C 15, C 16 | S 15 C, S 15 CK | 1370 | G10170 |
| | | 1.1158 | Ck 25 | XC 25 | 060 A 25 | C 25 | S 25 C | | G10250 | |
| | | 1.2162 | 21 MnCr 5 | 20 NC 5 | | | SCR 420 H | | | |
| P3 | 16 Mo 3 | 1.5415 | 1.5415 | 15 Mo 3 | 15 D 3 | 1501-240 | 16 Mo 3 | | 2912 | |
| | | | 1.5423 | 16 Mo 5 | | 1503-245-420 | 16 Mo 5 | SB 450 M | | G45200 |
| | 14 NiCr 14 | 1.5752 | 1.5752 | 14 NiCr 14 | 12 NC 15 | 655 M 13 | | SNC 815 (H) | | G33106 |
| | | | 1.5919 | 15 CrNi 6 | 16 NC 6 | S 107 | 16 CrNi 4 | | | |
| | 18 NiCrMo 7 6 | 1.6587 | 1.6587 | 18 CrNiMo 7 6 | 16 NCD 6 | 820 A 16 | 18 NiCrMo 7 | | | |
| | 16 MnCr 5 | 1.7131 | 1.7131 | 16 MnCr 5 | 16 MC 5 | 527 M 17 | 16 MnCr 5 | SCR 415 | 2511 | G51170 |
| | 16 MnCrS 5 | 1.7139 | 1.7139 | 16 MnCrS 5 | | | | | | |
| | 20 MnCr 5 | 1.7147 | 1.7147 | 20 MnCr 5 | 20 MC 5 | | 20 MnCr 5 | SMnC 420 (H) | | G51200 |
| | 20 MnCrS 5 | 1.7149 | 1.7149 | 20 MnCrS 5 | 20 MnCrS 5 | | | SMnC 21 H | | |
| | 13 CrMo 4 5 | 1.7335 | 1.7335 | 13 CrMo 4 4 | 15 CD 3,5 | 1501-620 Gr. 27 | 14 CrMo 4 5 | | 2216 | |
| | | 1.7337 | 16 CrMo 4 4 | 15 CD 4,5 | 1501-620 Gr. 27 | 14 CrMo 4 5 | | 2216 | | |
| 10 CrMo 9 10 | 1.7380 | 1.7380 | 10 CrMo 9 10 | 10 CD 9,10 | 1501-622 Gr. 31 | 12 CrMo 9 10 | | 2218 | J21890 | |
| P4 | C35 | | 1.0501 | C 35 | 55 C 35 | 060 A 35 | C 35 | | 1550 | G10350 |
| | E 335 | 1.0503 | 1.0503 | C 45 | 65 C 45 | 80 M 46 | C 45 | S 45 C | 1650 | G10430 |
| | C40 | | 1.0511 | C 40 | 60 C 40 | 080 M 40 | C 40 | S 40 C | | |
| | E 360 | 1.0070 | 1.0535 | St 70-2 | A 70-2 | | Fe 690 | | 1655 | |
| | C60 | 1.0601 | 1.0601 | C 60 | CC 55 | 080 A 62 | C 60 | | | G10600 |
| | | | 1.1157 | 40 Mn 4 | 35 M 5 | 150 M 36 | | | | G10390 |
| | G 28 Mn6 | 1.1165 | 1.1165 | 30 Mn 5 | | 120 M 36 | | SMn 1 H, SCMn 2 | | G13300 |
| | C 35E | 1.1181 | 1.1181 | Ck 35 | XC 38 H1 | 080 M 36 | C 35 | S 35 C | 1572 | G10340 |
| | C 45E | 1.1191 | 1.1191 | Ck 45 | XC 42 | 080 M 46 | C 45 | S 45 C | 1672 | G10420 |
| | C 60E | 1.1221 | 1.1221 | Ck 60 | XC 60 | 080 A 62 | C 60 | S 58 C | 1665, 1678 | G10640 |
| | | 1.1740 | C 60 W | Y3 55 | | | SK 7 | | | |
| P5 | 55 SiCr7 | 1.7100 | 1.0904 | 55 Si 7 | 55 S 7 | 250 A 53 | 55 Si 8 | | 2085, 2090 | |
| | | | 1.2330 | 35 CrMo 4 | 34 CD 4 | 708 A 37 | 35 CrMo 4 | | 2234 | T51620 |
| | | | 1.2542 | 45 WCrV 7 | | BS 1 | 45 WCrV 8 KU | | 2710 | T41901 |
| | | | 1.2714 | 56 NiCrMoV 7 | | BH 224-5 | 56 NiCrMoV7-KU | SKT 4 | | T61206 |
| | | | 1.5121 | 46 MnSi 4 | | | | | | |
| | | | 1.5710 | 36 NiCr 6 | 35 NC 6 | 640 A 35 | | SNC 236 | | |
| | | | 1.5736 | 36 NiCr 10 | 35 NC 11 | | 35 NiCr 9 | SNC 631 (H) | | |
| | 36 CrNiMo 4 | | 1.6511 | 36 CrNiMo 4 | 40 NCD 3 | 816 M 40 | 38 NiCrMo 4 (KB) | | | G98400 |
| | 34 CrNiMo 6 | 1.6582 | 1.6582 | 34 CrNiMo 6 | 35 NCD 6 | 817 M 40 | 35 NiCrMo 6 (KW) | SNCM 447 | 2541 | G43400 |
| | 34 Cr 4 | 1.7033 | 1.7033 | 34 Cr 4 | 32 C 4 | 530 A 32 | 34 Cr 4 (KB) | SCR 430 (H) | | G51320 |
| | 41 Cr 4 | 1.7035 | 1.7035 | 41 Cr 4 | 42 C 4 | 530 M 40 | 41 Cr 4 | SCR 440 (H) | | G51400 |
| | 25 CrMo 4 | 1.7218 | 1.7218 | 25 CrMo 4 | 25 CD 4 S | 708 M 25 | 25 CrMo 4 (KB) | SCM 425 | 2225 | G41300 |
| | 42 CrMo 4 | 1.7225 | 1.7225 | 42 CrMo 4 | 42 CD 4 | 708 M 40 | 42 CrMo 4 | SCM 440 (H) | 2244 | G41400 |
| 42 CrMo 4 | 1.7225 | 1.7225 | 42 CrMo 4 | 42 CD 4 | 708 M 40 | 42 CrMo 4 | SCM 440 (H) | 2244 | G41400 | |
| | | 1.7361 | 32 CrMo 12 | 30 CD 12 | 722 M 24 | 32 CrMo 12 | | 2240 | | |
| 50 CrV 4 | 1.8159 | 1.8159 | 50 CrV 4 | 50 CV 4 | 735 A 50 | 51 CrV 4 | SUP 10 | 2230 | H61500 | |
| 41 CrAlMo 7 10 | 1.8509 | 1.8509 | 41 CrAlMo 7 | 40 CAD 6.12 | 905 M 39 | 41 CrAlMo 7 | SACM 645 | 2940 | K24065 | |
| P6 | C 67S | 1.1231 | 1.1231 | Ck 67 | XC 68 | 060 A 67 | C 70 | | 1770 | G10700 |
| | C 100S | 1.1274 | 1.1274 | Ck 101 | | 060 A 96 | | SUP 4 | 1870 | G10950 |
| | C 105U | 1.1545 | 1.1545 | C 105 W1 | Y1 105 | | C 100 KU | | 1880 | |
| | | | 1.1645 | C 105 W2 | Y1 105 | | C 100 KU | SK 3 | | |
| | | 1.1663 | C 125 W | Y2 120 | | | C 120 KU | SK 2 | | |

SMG

| U.N.E./ I.H.A. | AISI / ASTM | GOST | ČSN | Div. Marken | Ausführung | Struktur |
|----------------|---------------------|----------|--------|-------------|------------|----------|
| | 1213 | | | | geglüht | |
| | 12 L 13 | | | | geglüht | |
| | 1108 | | | | geglüht | |
| | 11 L 08 | | | | geglüht | |
| | | | | | geglüht | |
| | 1140 | 40 | | | geglüht | |
| | 1146 | | | | geglüht | |
| | 1215 | | | | geglüht | |
| | 12 L 14 | | | | geglüht | |
| | | 16D | | | geglüht | |
| | ASTM Grade 58 | 18kp | 11 378 | | geglüht | |
| | ASTM Grade 70 | St14kP | 11 448 | | geglüht | |
| | 1010 | 10 | | | geglüht | |
| F.1110 | 1015 | 15 | | | geglüht | |
| | 1020, 1023 | 20 | 12 024 | | geglüht | |
| | | 17G1S | 11 523 | | geglüht | |
| F.1511 | 1015 | 15 | | | geglüht | |
| F.1120 | 1025 | 25 | | | geglüht | |
| | | | | | geglüht | |
| | A204 Grade A | | 15 020 | | geglüht | |
| | 4520 | | | | geglüht | |
| | 3310, 9314 | 20X2H4A | 16 420 | | geglüht | |
| | 4320 | | 16 220 | | geglüht | |
| | | | | | geglüht | |
| F.1516 | 5115 | 12KHN2 | 14 220 | | geglüht | |
| | | 18HG | | | geglüht | |
| | 5120 | 20KH | 14 221 | | geglüht | |
| | 5120 H | 20KH | | | geglüht | |
| | A182-F11, A182-F12 | 12KHM | 15 121 | | geglüht | |
| | A387 Grade 12 Cl. 2 | | | | geglüht | |
| F.155 | A182-F22 | 12KH8 | 15 313 | | geglüht | |
| F.1130 | 1035 | 35 | 12 040 | | geglüht | |
| F.5110 | 1045 | 45 | 12 050 | | geglüht | |
| | 1040 | 40 | 12 041 | | geglüht | |
| F.1150 | 1055 | 55 | | | geglüht | |
| | 1060 | 60 | 12 061 | | geglüht | |
| | 1039 | 40G | | | geglüht | |
| | 1330 | 30G2 | | | geglüht | |
| F.1135 | 1035 | 35 | | | geglüht | |
| F.1140 | 1045 | 45 | 12 050 | | geglüht | |
| F.1150 | 1064 | 60 | | | geglüht | |
| | 1060 | 60 | | | geglüht | |
| F.144 | 9255 | 55S2 | | | geglüht | |
| F.1250 | 4135 | 35KHM | | | geglüht | |
| F.5241 | S1 | 5KHV2S | | | geglüht | |
| | L6 | 5KHNV | | | geglüht | |
| | 5045 | | | | geglüht | |
| | 3135 | | | | vergütet | |
| | 3435 | | | | geglüht | |
| | 9840 | | | | vergütet | |
| F.1280 | 4340 | 38H2N2MA | 16 343 | | geglüht | |
| | 5132 | 35KH | | | vergütet | |
| | 5140 | 40H | 14 140 | | vergütet | |
| F.1251 | 4130 | 20KHM | 15 130 | | vergütet | |
| F.1252 | 4142, 4140 | 38HM | 15 142 | | geglüht | |
| F.1252 | 4142, 4140 | 38HM | 15 142 | | vergütet | |
| | | | | | vergütet | |
| F.143 | 6150 | 50KHFA | 15 260 | | vergütet | |
| F.1740 | A355 Cl. A | | | | geglüht | |
| F.5103 | 1070 | 70 | | | geglüht | |
| F.5117 | 1095 | | | | geglüht | |
| F.5118 | W1 | U10A | | | geglüht | |
| | | U10 | | | geglüht | |
| | W1 | U13 | | | geglüht | |

SMG

| SMG | EN | EN-Nr | W.-Nr | DIN | AFNOR | BS | UNI | JIS | SS | UNS | | |
|---------------------|----------------------|--------|---------------------|------------------------|---------------------------|-----------|---------------------|--------------------|---------|--------|--------|--------|
| P7 | 107 CrV 3 | 1.2210 | 1.2210 | 115 CrV 3 | 100 C 3 | | 107 CrV 3 KU | | | T61202 | | |
| | | | 1.2510 | 100 MnCrW 4 | 90 MWCV 5 | BO 1 | 95 MnWCr 5 KU | SKS 3 | 2140 | T31501 | | |
| | 90 MnCrV 8 | 1.2842 | 1.2842 | 90 MnCrV 8 | 90 MV 8 | BO 2 | 90 MnVCr 8 KU | | | T31502 | | |
| | 100 Cr 6 | 1.3505 | 1.3505 | 100 Cr 6 | 100 C 6 | 534 A 99 | 100 Cr 6 | SUJ 2 | 2258 | G51986 | | |
| P8 | X 210 Cr 12 | 1.2080 | 1.2080 | X 210 Cr 12 | Z 200 C 12 | BD 3 | X 210 Cr 13 KU | SKD 1 | | T30403 | | |
| | | | 1.2343 | X 38 CrMoV 5 1 | Z 38 CDV 5 | BH 11 | X 37 CrMoV 5 1 KU | SKD 6 | | T20811 | | |
| | X 40 CrMoV 5 1 | 1.2344 | 1.2344 | X 40 CrMoV 5 1 | Z 40 CDV 5 | BH 13 | X 40 CrMo 5 1 1 KU | SKD 61 | 2242 | T20813 | | |
| | X 100 CrMoV 5 | 1.2363 | 1.2363 | X 100 CrMoV 5 1 | Z 100 CDV 5 | BA 2 | X 100 CrMoV 5 1 KU | SKD 12 | 2260 | T30102 | | |
| | | | 1.2365 | X 32 CrMoV 3 3 | 32 DCV 28 | BH 10 | 30 CrMoV 12 27 KU | SKD 7 | | T20810 | | |
| | | | 1.2436 | X 210 CrW 12 | | | X 215 CrW 12 1 KU | SKD 2 | | 2312 | | |
| | | | 1.2601 | X 165 CrMoV 12 | | | X 165 CrMoW 12 KU | | | 2310 | | |
| | | | 1.2713 | 55 NiCrMoV 6 | 55 NCDV 7 | | | SKT 4 | | | T61206 | |
| | HS 6-5-2-5 | 1.3243 | 1.3243 | S 6-5-2-5 | Z 85 WDKCV 06-05-05-04-02 | | HS 6-5-2-5 | SKH 55 | | 2723 | | |
| | HS 2-10-1-8 | 1.3247 | 1.3247 | S 2-10-1-8 | Z 110 DKCWW 09-08-04 | BM 42 | HS 2-9-1-8 | SKH 51 | | | T11342 | |
| | HS 18-1-2-5 | 1.3255 | 1.3255 | S 18-1-2-5 | Z 80 WKCVC 18-05-04-01 | BT 4 | HS 18-1-1-5 | SKH 3 | | | T12004 | |
| HS 6-5-2 | 1.3343 | 1.3343 | S 6-5-2 | Z 85 WDCV 06-05-04-02 | BM 2 | HS 6-5-2 | SKH 9, SKH 51 | | 2722 | T11302 | | |
| HS 2-9-2 | 1.3348 | 1.3348 | S 2-9-2 | Z 100 DCWW 09-04-02-02 | | HS 2-9-2 | SKH 58 | | 2782 | T11307 | | |
| HS 18-0-1 | 1.3355 | 1.3355 | S 18-0-1 | Z 80 WCV 18-04-01 | BT 1 | HS 18-0-1 | SKH 2 | | | T12001 | | |
| P11 | X 6 Cr 13 | 1.4000 | 1.4000 | X 6 Cr 13 | Z 6 C 12 | 403 S 17 | X 6 Cr 13 | SUS 403 | 2301 | S41008 | | |
| | X 12 Cr 13 | 1.4006 | 1.4006 | X 10 Cr 13 | Z 10 C 13 | 410 S 21 | X 12 Cr 13 | SUS 410 | 2302 | S41000 | | |
| | X 6 Cr 17 | 1.4016 | 1.4016 | X 6 Cr 17 | Z 8 C 17 | 430 S 15 | X 8 Cr 17 | SUS 430 | 2320 | S43000 | | |
| | X 20 Cr 13 | 1.4021 | 1.4021 | X 20 Cr 13 | Z 20 C 13 | 420 S 37 | X 20 Cr 13 | SUS 420 J 1 | 2303 | S42000 | | |
| | X 39 Cr 13 | 1.4031 | 1.4031 | X 40 Cr 13 | Z 40 C 14 | 420 S 45 | X 40 Cr 14 | SUS 420 | 2304 | S40280 | | |
| | X 70 CrMo 15 | 1.4109 | 1.4109 | X 65 CrMo 14 | Z 70 D 14 | | | SUS 440 A | | | S44002 | |
| | X 90 CrMoV 18 | 1.4112 | 1.4112 | X 90 CrMoV 18 | Z 2 CND 18 05 | 409 S 19 | X CrTi 12 | SUS 440 B | 2327 | S44003 | | |
| | X 105 CrMo 17 | 1.4125 | 1.4125 | X 105 CrMo 17 | Z 100 CD 17 | | X 105 CrMo 17 | SUS 440 C | | | S44004 | |
| | X 3 CrNiMo 13 3 | 1.4313 | 1.4313 | X 5 CrNi 13 4 | Z 5 CN 13 4 | 425 C 11 | X 6 CrNi 13 04 | SCS 5 | | 2385 | S41500 | |
| | X 18 CrNi 28 | 1.4749 | 1.4749 | X 18 CrNi 28 | Z 18 C 25 | | | | | 2322 | S44600 | |
| P12 | X 6 NiCrTiMoV 25 15 | 1.4534 | 1.4534 | X 3 CrNiMoAl 13 8 2 | | | | | | S13800 | | |
| | X 4 CrNiCuNb 16 4 | 1.4540 | 1.4540 | X 4 CrNiCuNb 16 4 | | | | | | S15500 | | |
| | | 1.4540 | 1.4540 | X 4 CrNiCuNb 16 4 | Z 4 CNUNb 16.4 M | | | | | | S15500 | |
| | X 4 CrNiCuNb 16 4 | 1.4540 | 1.4540 | X 4 CrNiCuNb 16 4 | | | | | | | S15500 | |
| | X 5 CrNiCuNb 16 4 | 1.4542 | 1.4542 | X 5 CrNiCuNb 16 4 | | | | SUS 630 | | | S17400 | |
| | X 5 CrNiCuNb 17 4 | 1.4548 | 1.4548 | X 5 CrNiCuNb 17 4 | Z 6 CNU 17.4 | | | SCS 24, SUS 630 | | | S17400 | |
| | X 7 CrNiAl 17 7 | 1.4564 | 1.4564 | X 7 CrNiAl 17 7 | Z 9 CAN 17.7 | 301 S 81 | X 7 CrNiAl 17 7 | SUS 631 | 2388 | | S17700 | |
| | X 2 NiCoMoTi 18 12 4 | 1.6356 | 1.6356 | X 2 NiCoMoTi 18 12 4 | | | | | | | K93160 | |
| | X 2 NiCoMoTi 18 9 5 | 1.6358 | 1.6358 | X 2 NiCoMoTi 18 9 5 | Z 2 NKD 19-09 | | | | | | K93120 | |
| | X 2 CrNiMoAl 18 9 5 | 1.6358 | 1.6358 | X 2 NiCoMoTi 18 9 5 | Z 2 NKD 19-09 | | | | | | K93120 | |
| | X 2 CrNiMoAl 18 8 5 | 1.6359 | 1.6359 | X 2 CrNiMoAl 18 8 5 | | S 162 | | | | | K92890 | |
| X 2 CrNiMoAl 18 8 5 | 1.6359 | 1.6359 | X 2 CrNiMoAl 18 8 5 | | S 162 | | | | | K92890 | | |
| M1 | X 10 CrNiS 18 9 | 1.4305 | 1.4305 | X 10 CrNiS 18 9 | Z 10 CNF 18.09 | 303 S 31 | X 10 CrNi 18 09 | SUS 303 | | 2346 | S30300 | |
| | X 2 CrNi 19 11 | 1.4306 | 1.4306 | X 2 CrNi 19 11 | Z 2 CN 18.10 | 304 S 12 | X 3 Cr Ni 18 11 | SUS 304 L | | 2352 | S30403 | |
| M2 | X 5 CrNi 18 10 | 1.4301 | 1.4301 | X 5 CrNi 18 10 | Z 6 CN 18.09 | 304 S 31 | X 5 CrNi 18 11 | SUS 304 | | 2333 | S30400 | |
| | X 5 CrNiMo 17 12 2 | 1.4401 | 1.4401 | X 5 CrNiMo 17 12 2 | Z 3 CND 17.11.1 | 316 S 31 | X 5 CrNiMo 17 12 | SUS 316 | | 2347 | S31600 | |
| | X 6 CrNiNb 18 10 | 1.4550 | 1.4550 | X 6 CrNiNb 18 10 | Z 6 CNNb 18.10 | 347 S 31 | X 6 CrNiNb 18 11 | SUS 347 | | 2338 | S34700 | |
| | X 9 CrNi 18 8 | 1.4310 | 1.4310 | X 12 CrNi 17 7 | Z 12 CN 17.07 | 301 S 21 | X 12 CrNi 17 07 | SUS 301 | | (2331) | S30100 | |
| | X 12 CrNi 18 8 | 1.4300 | 1.4300 | X 12 CrNi 18 8 | Z 12 CN 18 | 302 S 25 | | SUS 302 | | | 2331 | S30200 |
| | X 2 CrNiMo 18 14 3 | 1.4435 | 1.4435 | X 2 CrNiMo 18 14 3 | Z 2 CND 17.13 | 316 S 12 | X 2 CrNiMo 17 13 2 | SCS 16, SUS 316 L | | | 2353 | S31603 |
| M3 | X 2 CrNiMoN 17 13 3 | 1.4429 | 1.4429 | X 2 CrNiMoN 17 13 3 | Z 2 CND 17.13 Az | 316 S 62 | X 2 CrNiMoN 17 13 3 | SUS 316 LN | | | 2375 | S31653 |
| | X 2 CrNiN 18 10 | 1.4311 | 1.4311 | X 2 CrNiN 19 11 | Z 2 CN 18 .10 Az | 304 S 62 | X 2 CrNiN 18 11 | SUS 304 LN | | | 2371 | S30453 |
| | X 3 CrNiMo 18 12 3 | 1.4466 | 1.4466 | X 5 CrNi 18 15 | | 317 S 16 | X 5 CrNi 18 15 | SUS 317 | | | 2366 | S31700 |
| | X 9 CrNiSiN 21 11 2 | 1.4835 | 1.4893 | X 9 CrNiSiN 21 11 2 | | 310 S 31 | | | | | 2368 | S30815 |
| | X 12 CrNi 25 21 | 1.4335 | 1.4335 | X 12 CrNi 25 21 | Z 12 CN 25.20 | 310 S 24 | X 6 CrNi 26 20 | SUH 310, SUS 310 S | | | 2361 | S31008 |
| M4 | X 2 CrNiMoN 22 5 3 | 1.4462 | 1.4462 | X 2 CrNiMoN 22 5 | Z 2 CND 22.05 Az | 332 S 15 | X 2 CrNiMoN 22 5 | | | | 2377 | S31803 |
| | X 2 CrNiMoSi 19 5 | 1.4424 | 1.4417 | X 2 CrNiMoSi 19 5 | Z 2 CND 18.05.03 | | | | | | 2376 | S31500 |
| | X 2 NiCrMoCu 25 20 5 | 1.4539 | 1.4539 | X 2 NiCrMoCu 25 20 5 | Z 2 NCDU 25 20 | 904 S 13 | | | | | 2562 | N08904 |
| | X 3 CrNiMo 27 5 2 | 1.4460 | 1.4460 | X 4 CrNiMo 27 5 2 | Z 3 CND 25.7 Az | | X 3 CrNiMo 27 5 2 | SUS 329 J 1 | | | 2324 | S32900 |
| M5 | X 5 CrNiCuNb 16 4 | 1.4980 | 1.4943 | X 4 NiCrTi 25 15 | Z 6 NCTDV 25.15 | HR 51 | | | | | 2570 | S66286 |
| | X 1 CrNiMoN 20 18 7 | 1.4547 | 1.4529 | X 1 CrNiMoN 20 18 7 | Z 1 CNDU 20.18.05 Az | | X 1 CrNiMoN 20 18 7 | | | | 2778 | S31254 |
| | X 1 CrNiMoN 25 22 8 | 1.4652 | 1.4652 | X 2 CrNiMoN 25 22 7 | | | | | | | | S32654 |
| | X 10 NiCrAlTi 32 20 | 1.4876 | 1.4876 | X 10 NiCrAlTi 32 20 | Z 10 NC 32.21 | | | | NCF 800 | | | N08800 |
| | X 2 CrNiMoN 25 7 4 | 1.4410 | 1.4410 | X 2 CrNiMoN 25 7 4 | Z 3 CND 25.07 Az | | X 2 CrNiMoN 25 7 4 | | | | 2328 | S32750 |

SMG

| U.N.E./I.H.A. | AISI / ASTM | GOST | ČSN | Div. Marken | Ausführung | Struktur |
|---------------|-------------|----------------|--------|---------------------------|-----------------------------|-----------------------|
| F.520L | L2 | 11KHF | | | geglüht | |
| F.5220 | O1 | 9KHVG | | | geglüht | |
| | O2 | 9G2F | | | geglüht | |
| F.5230 | 52100 | SHKH15 | 14 109 | | geglüht | |
| F.5212 | D3 | KH12 | | | geglüht | |
| | H11 | 4KH5MFS | | | geglüht | |
| F.5318 | H13 | 4KH5MF1S | | | geglüht | |
| F.5227 | A2 | 9KH5VF | | | geglüht | |
| | H10 | 3KH3M3F | | | geglüht | |
| F.5213 | | KH12 | | | geglüht | |
| | | KH12MF | | | geglüht | |
| F.520.S | L6 | 5KJNM | | | geglüht | |
| F.5613 | M35 | R6M5K5 | | | geglüht | |
| | M42 | R2AM9K5 | | | geglüht | |
| | T4 | R18K5F2 | | | geglüht | |
| F.5603 | M2 | R6M5 | | | geglüht | |
| | M7 | | | | geglüht | |
| | T1 | R18 | | | geglüht | |
| | 403 | 08KH13 | | | geglüht | fertisch |
| F.3401 | 410, -15 | 12KH13, 08KH13 | | | geglüht | martensitisch |
| F.3113 | 430 | 12KH17 | | | geglüht | fertisch |
| F.5261 | 420 | 20KH13 | 17 022 | | geglüht | martensitisch |
| F.3404 | 420 | 40KH13 | | | geglüht | martensitisch |
| | 440 A | | | | geglüht | martensitisch |
| | 440 B | 95KH18 | | | geglüht | martensitisch |
| | 440 C | 95KH18 | | | geglüht | martensitisch |
| | A182 F6NM | | | F6NM | geglüht | martensitisch |
| | 446 | 15KH28 | | | geglüht | fertisch |
| | XM-13 | | | PH 13-8 Mo | lösungsgeglüht | austenitisch |
| | XM-12 | | | 15-5-PH | ausscheidungsgehärtet H1150 | martensitisch |
| | XM-12 | | | 15-5-PH | lösungsgeglüht | martensitisch |
| | XM-12 | | | 15-5-PH | ausscheidungsgehärtet H1025 | martensitisch |
| | IN 630 | | | 17-4-PH | ausscheidungsgehärtet H1150 | martensitisch |
| | 630 | | | 17-4-PH | lösungsgeglüht | martensitisch |
| | 631 | 09KH17N7YU1 | | 17-7-PH | lösungsgeglüht | austenitisch/fertisch |
| | AMS 6515 | | | Marage 350 | lösungsgeglüht | martensitisch |
| | AMS 6521 | | | Marage 300 | lösungsgeglüht | martensitisch |
| | AMS 6514 | | | Marage 300, Vascomax C300 | lösungsgeglüht | martensitisch |
| | AMS 6512 | | | Marage 250 | lösungsgeglüht | martensitisch |
| | AMS 6512 | | | Marage 250, Vascomax C250 | lösungsgeglüht | martensitisch |
| F.3508 | 303 | 12KH19N9 | | | geglüht | austenitisch |
| F.3504 | 304 L | 03KH18N11 | | | geglüht | austenitisch |
| F.3504 | 304 | 08KH18N10 | 17 240 | | geglüht | austenitisch |
| F.3534 | 316 | 08KH17H13M2T | 17 346 | | geglüht | austenitisch |
| F.3524 | 347 | 08KH18N12B | | | geglüht | austenitisch |
| F.3517 | 301 | 07KH16N6 | | | geglüht | austenitisch |
| | 302 | 12KH18N9 | | | geglüht | austenitisch |
| F.3533 | 316 L | 03KH17N14M3 | 17 349 | | geglüht | austenitisch |
| | 316 LN | 03KH16N15M3 | | | geglüht | austenitisch |
| F.3541 | 304 LN | 03KH18N11 | | | geglüht | austenitisch |
| | 317 | 08KH17H15M3T | | | geglüht | austenitisch |
| | | | | 253 MA | geglüht | austenitisch |
| | 310 S | 12KH25N20 | | | geglüht | austenitisch |
| | 329 LN | | | SAF 2205 | geglüht | Duplex |
| | | | | 3RE60 | geglüht | Duplex |
| | 904L | | | | geglüht | Super Austenit |
| | 329 | | | | geglüht | Duplex |
| | 660 | | | A286 | lösungsgeglüht | austenitisch |
| | | | | 254 SMO | geglüht | Super Austenit |
| | | | | 654 SMO | geglüht | Super Austenit |
| | | | | Alloy 800 | geglüht | austenitisch |
| | F 53 | | | SAF 2507 | geglüht | Super Duplex |

SMG

| SMG | EN | EN-Nr | W.-Nr | DIN | AFNOR | BS | UNI | JIS | SS | UNS | |
|---------|------------------------|--------------|--------------|-------------------|------------------|--------------|-----------|-------------|------------|-------------|--------|
| K1 | EN-GJL-150 | 0.6150 | 0.6150 | GG-15 | Fl 15 D | Grade 150 | G15 | FC 150 | 01 15-00 | F11601 | |
| | EN-GJL-200 | 0.6200 | 0.6200 | GG-20 | Fl 20 D | Grade 220 | G20 | FC 200 | 01 20-00 | F12101 | |
| | EN-GJL-250 | 0.6250 | 0.6250 | GG-25 | Fl 25 D | Grade 260 | G25 | FC 250 | 01 25-00 | F12401 | |
| | EN-GJL-350 | 0.6350 | 0.6350 | GG-35 | Fl 35 D | Grade 350 | G35 | FC 350 | 01 35-00 | F13502 | |
| | EN-GJL-215 | | | GG-220 HB | | | | | 02 19 | | |
| K2 | EN-GJV-300 | | | GJV-300 | | | | | | | |
| | EN-GJV-350 | | | GJV-350 | | | | | | | |
| | EN-GJV-400 | | | GJV-400 | | | | | | | |
| | EN-GJV-450 | | | GJV-450 | | | | | | | |
| | EN-GJV-500 | | | GJV-500 | | | | | | | |
| K3 | EN-GJMB-550-4 | 0.8155 | | GTS-55-04 | P 540/5 | P 540/5 | P 55-04 | PCMP55-04 | 08 54-00 | F24130 | |
| K4 | EN-GJS-350-22 | 0.7033 | 0.7033 | DMM=-35,3 | FGS 370-17 | Grade 350/22 | | FCD 350-22L | 07 17-15 | | |
| | EN-GJS-400-15 | 0.7040 | 0.7040 | GGG-40 | FGS 400-12 | Grade 420/12 | GS 400-12 | FCD 400-18L | 07 17-02 | F32800 | |
| | EN-GJS-400-18 | 0.7043 | 0.7043 | DMM=-40,3 | FGS 370-17 | Grade 370/17 | GSO 42/17 | | 07 17-12 | F32800 | |
| | EN-GJS-500-7 | 0.7050 | 0.7050 | GGG-50 | FGS 500-7 | Grade 500/7 | GS 500-7 | FCD 500-7 | 07 27-02 | F33800 | |
| | EN-GJS-600-3 | 0.7060 | 0.7060 | GGG-60 | FGS 600-3 | Grade 600/3 | GS 600-3 | FCD 600-3 | 07 32-03 | F34100 | |
| | EN-GJS-700-2 | 0.7070 | 0.7070 | GGG-70 | FGS 700-2 | Grade 700/2 | GS 700-2 | FCD 700-2 | 07 37-01 | F34800 | |
| K5 | EN-GJS-1000-5 | | | GJS-1000-5 | | | | | | ADI grade 5 | |
| | EN-GJS-1200-2 | | | GJS-1200-2 | | | | | | ADI grade 2 | |
| | EN-GJS-1400-1 | | | GJS-1400-1 | | | | | | ADI grade 3 | |
| | EN-GJS-800-8 | | | GJS-800-8 | | | | | | ADI grade 4 | |
| K6 | EN-GJLA-XNiCr 20-2 | 0.6660 | 0.6660 | GGL-NiCr 20 2 | FGL Ni20 Cr2 | Grade F2 | | | 05 23-00 | F41002 | |
| | EN-GJLA-XNiCr 30-3 | 0.6676 | 0.6676 | GGL-NiCr 30 3 | FGL Ni30 Cr3 | Grade F3 | | | | F41004 | |
| | EN-GJLA-XNiCuCr 15-6-2 | 0.6655 | 0.6655 | GGL-NiCuCr 15 6 2 | FGL Ni15 Cu6 Cr2 | Grade F1 | | | | F41000 | |
| K7 | EN-GJSA-XNiMn 13-7 | 0.7652 | 0.7652 | GGG-NiMn 13 7 | FGS Ni13 Mn7 | Grade S6 | | | 07 72-00 | | |
| | EN-GJSA-XNiCr 20-2 | 0.7660 | 0.7660 | GGG-NiCr 20 2 | FGS Ni20 Cr2 | Grade S2 | | | | F43000 | |
| | EN-GJSA-XNiMn 23-4 | 0.7673 | 0.7673 | GGG-NiMn 23 4 | FGS Ni23 Mn4 | Grade S2M | | | | F43010 | |
| | EN-GJSA-XNiCr 30-3 | 0.7676 | 0.7676 | GGG-NiCr 30 3 | FGS Ni30 Cr3 | Grade S3 | | | | F43003 | |
| | EN-GJSA-XNi 35 | 0.7683 | 0.7683 | GGG-Ni 35 | FGS Ni35 | | | | | F43006 | |
| N1 | AW-1050A | Al99.5 | 3.0255 | Al99.5 | -S1050A | 1B | | (A1050) | 4007 | AA1050A | |
| | AW-2011 | AlCuBiPb | 3.1655 | AlCuBiPb | A-U5PbBi/2011 | FC1 | | A2011 | 4355 | AA2011 | |
| | AW-2014 | AlCuSiMn | 3.1255 | AlCuSiMn | A-U4SG/2014 | H15 | | | 4338 | AA2014 | |
| | AW-5005 | AlMg1 | 3.3315 | AlMg1 | A-G0.6 | N41 | | | 4106 | AA5005 | |
| | AW-6060 | AlMgSi0.5 | 3.3206 | AlMgSi0.5 | A-GS/6060 | (H9) | | | 4103 | AA6060 | |
| | AW-6063 | AlMgSi0.7 | 3.3210 | AlMgSi0.7 | A-GSUC/6061 | (H10) | | (A6063) | 4104, 4107 | AA6005 | |
| | AW-3103 | AlMn1 | 3.0515 | AlMn1 | | N3 | | | 4054 | AA3103 | |
| | AW-3003 | AlMn1Cu | 3.0517 | AlMn1Cu | A-M1/3003 | | | A3003 | | AA3003 | |
| | AW-7020 | AlZn4.5Mg1 | 3.4335 | AlZn4.5Mg1 | A-Z5G/7020 | H17 | | | 4425 | AA7020 | |
| | AW-7075 | | 3.4365 | AlZnMgCu1.5 | A-Z5GU/7075 | 2L95/2L96 | | | A7075 | AA7075 | |
| | AC-42000 | | 3.2341 | G-AlSi5Mg | A-S7G | LM25 | 3599 | | AC 4C | 4244 | |
| | AC-46200 | AlSi8Cu3(Si) | 3.2161 | G-AlSi8Cu3 | | | | | | 4251 | A13800 |
| | MG-P-63 | MgAl6Zn | 3.5612 | G-MgAl6Zn | G-A6-Z1 | MAG-E-121 | | | | | M11600 |
| | MG-P-61 | MgAl8Zn | 3.5812 | G-MgAl8Zn | (G-A7-Z1) | | | | | | |
| | MN65120 | MgSe3Zn2Zr1 | 3.5103 | G-MgSe3Zn2Zr1 | ZRE1 | MAG6-TE | | | | | M12330 |
| | N2 | AC-43400 | AlSi10Mg(Fe) | 3.2381 | G-AlSi10Mg | A-S10G | LM9 | | | 4253 | A13600 |
| | | AC-44200 | AlSi12 | 3.2382 | GD-AlSi12 | | | | | | |
| AW-6082 | | AlMgSi1 | 3.2315 | AlMgSi1 | A-SGM0.7/6082 | H30 | | | 4212 | AA6082 | |
| N3 | | AlSi17Cu5 | | | | | | ADC14 | | | |
| | | | | | | | | | | | |
| N11 | CC331G | | 2.0940.01 | CuAl10Fe | CuAl10Fe | AB1 | | | 5710 | C95200 | |
| | CC333G | | 2.0975.01 | CuAl10Ni | CuAl10Ni5Fe5 | AB2 | | | 5716 | C95500 | |
| | | CuNi10Fe1Mn | 2.0872 | CuNi10Fe1Mn | CuNi10Fe1Mn | CN102 | | | 5667 | C70600 | |
| | | | | CuNi10Zn45 | | | | | | | |
| | | CW408J | 2.0790 | CuNi18Zn19Pb | CuNi18Zn19Pb1 | | | | | | C76300 |
| | CW352H | | 2.1176 | CuPb10Sn | CuSn10Pb10 | LB2 | | | 5640 | C93700 | |
| | CC480K | | 2.1050.01 | CuSn10 | CuSn10 | CT1 | | | 5443 | C90700 | |
| | | | 2.1087 | CuSn10Zn | | | | | 5458 | C90500 | |
| | CW452K | CuSn6 | 2.1020 | CuSn6 | CuSn6 | PB103 | | C5191 | 5428 | C51900 | |
| | CW502L | CuZn15 | 2.0240 | CuZn15 | CuZn15 | CZ102 | | C2300 | 5112 | C23000 | |
| | CW706R | CuZn28Sn1 | 2.0470 | CuZn28Sn1 | CuZn29Sn1 | | | | 5220 | C44300 | |
| | CW508L | CuZn37 | 2.0321 | CuZn37 | CuZn37 | CZ108 | | | 5150 | C27200 | |
| | CW717R | CuZn38Sn1 | 2.0530 | CuZn38Sn1 | | | | | | C46400 | |
| | CW614N | CuZn39Pb3 | 2.0401 | CuZn39Pb3 | CuZn39Pb3 | CZ121 | | | 5170 | C38500 | |
| | CW612N | CuZn40Pb2 | 2.0402 | CuZn40Pb2 | CuZn39Pb2 | CZ120 | | | 5168 | C37800 | |
| | CW622N | CuZn44Pb2 | 2.0410 | CuZn44Pb2 | | CZ104 | | | 5272 | C68700 | |

SMG

| SMG | EN | EN-Nr | W.-Nr | DIN | AFNOR | BS | UNI | JIS | SS | UNS | |
|---------------|----------------------|--------|---------------|----------------------|---------------------------|-----------------|---------------------|---------------|------------|--------|--------|
| S1 | | | | | | | | | | | |
| S2 | | | | | | | | | | | |
| S3 | NiMo30 | | 2.4810 | | | | | | | N10002 | |
| | NiMo16Cr15W | | 2.4819 | | | | | | | N10276 | |
| | NiCr19Fe19Nb5Mo3 | | 2.4668 | | | | | | | N07718 | |
| | | | 2.4669 | | | | | | | N07750 | |
| | NiCr20TiAl | | 2.4631 | | | | | | | N07080 | |
| | NiCr19Co18Mo4Ti3Al3 | | | | | | | | | N07500 | |
| | NiCr20Co13Mo4Ti3Al | | 2.4654 | | | | | | | N07001 | |
| S11 | | | 3.7024 | | | | | | | R54620 | |
| S12 | | | | | | | | | | R56320 | |
| | TiAl6V4 | | 3.7164 | | | | | | | R56400 | |
| S13 | | | | TiV10Fe2Al3 | | | | | | | |
| H3 | 16 MnCr 5 | 1.7131 | 1.7131 | 16 MnCr 5 | 16 MC 5 | 527 M 17 | 16 MnCr 5 | SCR 415 | 2511 | G51170 | |
| H5 | C 67S | 1.1231 | 1.1231 | Ck 67 | XC 68 | 060 A 67 | C 70 | | 1770 | G10700 | |
| | C 75S | 1.1248 | 1.1248 | Ck 75 | XC 75 | 060 A 78 | C 75 | | 1774, 1778 | G10780 | |
| | C 100S | 1.1274 | 1.1274 | Ck 101 | | 060 A 96 | | SUP 4 | 1870 | G10950 | |
| | C 105U | 1.1545 | 1.1545 | C 105 W1 | Y1 105 | | C 100 KU | | 1880 | | |
| | | | 1.2550 | | 60 WCrV 7 | 55 WC 20 | | 55 WCrV 8 KU | | | |
| | 55 Cr 3 | 1.7176 | 1.7176 | 55 Cr 3 | 55 C 3 | 527 A 60 | 55 Cr 3 | SUP 9 (A) | 2253 | G51550 | |
| H7 | 42 CrMo 4 | 1.7225 | 1.7225 | 42 CrMo 4 | 42 CD 4 | 708 M 40 | 42 CrMo 4 | SCM 440 (H) | 2244 | G41400 | |
| | 107 CrV 3 | 1.2210 | 1.2210 | 115 CrV 3 | 100 C 3 | | 107 CrV 3 KU | | | T61202 | |
| | | | 1.2510 | | 100 MnCrW 4 | 90 MWCV 5 | BO 1 | 95 MnWCr 5 KU | SKS 3 | 2140 | T31501 |
| | 90 MnCrV 8 | 1.2842 | 1.2842 | 90 MnCrV 8 | 90 MV 8 | BO 2 | 90 MnVCr 8 KU | | | T31502 | |
| | 100 Cr 6 | 1.3505 | 1.3505 | 100 Cr 6 | 100 C 6 | 534 A 99 | 100 Cr 6 | SUJ 2 | 2258 | G51986 | |
| | X 40 CrMoV 5 1 | 1.2344 | 1.2344 | X 40 CrMoV 5 1 | Z 40 CDV 5 | BH 13 | X 40 CrMo 5 1 1 KU | SKD 61 | 2242 | T20813 | |
| H8 | X 100 CrMoV 5 | 1.2363 | 1.2363 | X 100 CrMoV 5 1 | Z 100 CDV 5 | BA 2 | X 100 CrMoV 5 1 KU | SKD 12 | 2260 | T30102 | |
| | X 155 CrVMo 12 1 | | 1.2379 | X 155 CrVMo 12 1 | Z 160 CDV 12 | BD 2 | X 155 CrVMo 12 1 KU | SKD 11 | | T30402 | |
| | | | 1.2436 | | X 210 CrW 12 | | X 215 CrW 12 1 KU | SKD 2 | 2312 | | |
| | | | 1.2601 | | X 165 CrMoV 12 | | X 165 CrMoV 12 KU | | 2310 | | |
| | | | 1.2713 | | 55 NiCrMoV 6 | 55 NCDV 7 | | SKT 4 | | T61206 | |
| | HS 6-5-2-5 | 1.3243 | 1.3243 | S 6-5-2-5 | Z 85 WDKCV 06-05-05-04-02 | | HS 6-5-2-5 | SKH 55 | 2723 | | |
| | HS 2-10-1-8 | 1.3247 | 1.3247 | S 2-10-1-8 | Z 110 DKCWV 09-08-04 | BM 42 | HS 2-9-1-8 | SKH 51 | | T11342 | |
| | HS 18-0-1 | 1.3355 | 1.3355 | S 18-0-1 | Z 80 WCV 18-04-01 | BT 1 | HS 18-0-1 | SKH 2 | | T12001 | |
| | X 20 Cr 13 | 1.4021 | 1.4021 | X 20 Cr 13 | Z 20 C 13 | 420 S 37 | X 20 Cr 13 | SUS 420 J 1 | 2303 | S42000 | |
| | X 70 CrMo 15 | 1.4109 | 1.4109 | X 65 CrMo 14 | Z 70 D 14 | | | SUS 440 A | | S44002 | |
| X 90 CrMoV 18 | 1.4112 | 1.4112 | X 90 CrMoV 18 | Z 2 CND 18 05 | 409 S 19 | X CrTi 12 | SUS 440 B | 2327 | S44003 | | |
| X 105 CrMo 17 | 1.4125 | 1.4125 | X 105 CrMo 17 | Z 100 CD 17 | | X 105 CrMo 17 | SUS 440 C | | S44004 | | |
| H12 | X 4 CrNiCuNb 16 4 | 1.4540 | 1.4540 | X 4 CrNiCuNb 16 4 | | | | | | S15500 | |
| | X 5 CrNiCuNb 16 4 | 1.4542 | 1.4542 | X 5 CrNiCuNb 16 4 | | | | SUS 630 | | S17400 | |
| | X 5 CrNiCuNb 16 4 | 1.4542 | 1.4542 | X 5 CrNiCuNb 16 4 | | | | SUS 630 | | S17400 | |
| | X 7 CrNiAl 17 7 | 1.4568 | 1.4568 | X 7 CrNiAl 17 7 | Z 9 CAN 17.7 | 301 S 81 | X 7 CrNiAl 17 7 | SUS 631 | 2388 | S17700 | |
| | X 8 CrNiMoAl 15 7 5 | 1.4574 | 1.4574 | X 8 CrNiMoAl 15 7 5 | | | | | | S15700 | |
| | X 6 NiCrTiMoV 25 15 | 1.4980 | 1.4943 | X 4 NiCrTi 25 15 | Z 6 NCTDV 25.15 | HR 51 | | SUH 660 | 2570 | S66286 | |
| | X 2 CrNiMoAl 18 8 5 | 1.6359 | 1.6359 | X 2 CrNiMoAl 18 8 5 | | S 162 | | | | K92890 | |
| | X 2 NiCoMoTi 18 9 5 | 1.6358 | 1.6358 | X 2 NiCoMoTi 18 9 5 | Z 2 NKD 19-09 | | | | | K93120 | |
| | X 2 NiCoMoTi 18 9 5 | 1.6358 | 1.6358 | X 2 NiCoMoTi 18 9 5 | Z 2 NKD 19-09 | | | | | K93120 | |
| | X 2 NiCoMoTi 18 12 4 | 1.6356 | 1.6356 | X 2 NiCoMoTi 18 12 4 | | | | | | K93160 | |
| H21 | X 120 Mn 12 | 1.3401 | 1.3401 | X 120 Mn 12 | Z 120 M 12 | BW 10 | | SC MnH 1 | 2183 | | |
| H31 | EN-GJN-HV520 | 0.9620 | 0.9620 | G-X330 NiCr 4 2 | FB Ni4 Cr2 BC | Grade 2 A | | | 05 12-00 | F45001 | |
| | EN-GJN-HV550 | 0.9625 | 0.9625 | G-X260 NiCr 4 2 | FB Ni4 Cr2 HC | Grade 2 B | | | 05 13-00 | F45000 | |
| | EN-GJN-HV600(XCr11) | 0.9630 | 0.9630 | G-X300 CrNiSi 9 5 2 | FB Cr9 Ni5 | Grade 2 C, D, E | | | 04 57-00 | F45003 | |

SMG

| U.N.E./ I.H.A. | AISI / ASTM | GOST | ČSN | Div. Marken | Ausführung | Struktur |
|----------------|-------------------|-------------|--------|---------------------|------------------------------|---------------|
| | | | | Discolloy | ausscheidungsgehärtet | |
| | | | | Haynes 25 | | |
| | | | | Stellite 21 | | |
| | | | | Hastelloy C | | |
| | | KHN65MV | | Hastelloy C-276 | | |
| | | | | IN 100 | | |
| | | | | Inconel 718 | | |
| | | | | Inconel -750 | lösungsgeglüht | |
| | | | | Nimonic 80A | | |
| | | | | René 41 | | |
| | | | | Udimet 500 | | |
| | | | | Waspalloy | | |
| | | | | Ti | technisch rein | Ti (α) |
| | AMS 4919 | | | Ti 6-2-4-2 | geglüht | Ti (α) |
| | AMS 4943 | | | Ti 3Al-2.5V (grd 9) | geglüht | Ti (α+β) |
| | AMS 4920, Grd 5 | VT6 | | Ti 6Al-4V | geglüht | Ti (α+β) |
| | AMS 4986 | | | Ti 10V-2Fe-3Al | geglüht | Ti (β) |
| F.1516 | 5115 | 12KHN2 | 14 220 | | einsatzgehärtet | |
| F.5103 | 1070 | 70 | | | vergütet | |
| F.5107 | 1078, 1080 | 75 | | | vergütet | |
| F.5117 | 1095 | | | | vergütet | |
| F.5118 | W1 | U10A | | | vergütet | |
| | S1 | 5KHV2SF | | | vergütet | |
| | 5155 | | | | vergütet | |
| F.1252 | 4142, 4140 | 38HM | 15 142 | | vergütet | |
| F.520L | L2 | 11KHF | | | vergütet | |
| F.5220 | O1 | 9KHVG | | | vergütet | |
| | O2 | 9G2F | | | vergütet | |
| F.5230 | 52100 | SHKH15 | 14 109 | | vergütet | |
| F.5318 | H13 | 4KH5MF1S | | | vergütet | |
| F.5227 | A2 | 9KH5VF | | | vergütet | |
| F.5211 | D2 | KH12MF | | | vergütet | |
| F.5213 | | KH12 | | | vergütet | |
| | | KH12MF | | | vergütet | |
| F.520.S | L6 | 5KHNM | | | vergütet | |
| F.5613 | M35 | R6M5K5 | | | vergütet | |
| | M42 | R2AM9K5 | | | vergütet | |
| | T1 | R18 | | | vergütet | |
| F.5261 | 420 | 20KH13 | 17 022 | | vergütet | martensitisch |
| | 440 A | | | | vergütet | martensitisch |
| | 440 B | 95KH18 | | | vergütet | martensitisch |
| | 440 C | 95KH18 | | | vergütet | martensitisch |
| | XM-12 | | | 15-5-PH | ausscheidungsgehärtet H900 | martensitisch |
| | IN 630 | | | 17-4-PH | ausscheidungsgehärtet H1025 | martensitisch |
| | IN 630 | | | 17-4-PH | ausscheidungsgehärtet H900 | martensitisch |
| | AMS 5528 | 09KH17N7YU1 | | 17-7-PH | ausscheidungsgehärtet TH1050 | martensitisch |
| | 632 | | | PH 15-7 Mo | ausscheidungsgehärtet TH1050 | martensitisch |
| | 660 | | | A286 | ausscheidungsgehärtet | austenitisch |
| | AMS 6512 | | | Marage 250 | ausscheidungsgehärtet | martensitisch |
| | AMS 6521 | | | Marage 300 | ausscheidungsgehärtet | martensitisch |
| | AMS 6521 | | | Marage 300 | ausscheidungsgehärtet | martensitisch |
| | AMS 6515 | | | Marage 350 | ausscheidungsgehärtet | martensitisch |
| | A128 Grade A | | | Hadfield | | |
| | A532 IB (NiCr-LC) | | | Ni-Hard 2 | | Weißhartguss |
| | A532 IA (NiCr-HC) | | | Ni-Hard 1 | | Weißhartguss |
| | A532 ID (Ni-HiCr) | | | Ni-Hard 4 | | Weißhartguss |

In dieser Broschüre stellt Ihnen Seco Tools technische Informationen zur Metallschneidspannung zur Verfügung. Für spezifische Bearbeitungsaufgaben empfehlen wir die Kontaktaufnahme mit Ihren zuständigen Beratern.

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