NEUHEIT 2024

ECO LINIE

INHALTSVERZEICHNIS

HF441 – 36°/39°

P	M	K	N	S	H
★	★	★		★	

★ 1st choice ☆ suitable

Artikelbezeichnung	EF 45°	Ø	l	L1	L	D(h6)	Z	NETTO PREIS
HF441030	0.10	3	9	15	57	6	4	CHF. 16.50
HF441040	0.10	4	11	18	57	6	4	CHF. 16.50
HF441050	0.10	5	13	19	57	6	4	CHF. 16.50
HF441060	0.10	6	13	20	57	6	4	CHF. 16.50
HF441080	0.20	8	20	26	64	8	4	CHF. 21.60
HF441100	0.20	10	22	30	72	10	4	CHF. 32.00
HF441120	0.20	12	26	36	83	12	4	CHF. 41.20
HF441160	0.30	16	32	42	92	16	4	CHF. 71.70
HF441200	0.40	20	38	50	104	20	4	CHF. 116.30

	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3	P5 M2 M3 K4 S1 S4	S2 S3 S5
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²	≤35 HRC	≤40 HRC
	ap x ae	**D x D**	**D x D**	**0.5D x D**	**0.5D x D**
	Vc (m/min)	**110÷130**	**70÷90**	**50÷70**	**30÷50**
SLOTTING	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	3	0.013	0.011	0.009	0.009
	4	0.017	0.015	0.012	0.012
	5	0.021	0.019	0.016	0.014
	6	0.024	0.022	0.018	0.017
	8	0.032	0.028	0.024	0.022
	10	0.038	0.034	0.028	0.026
	12	0.043	0.039	0.032	0.030
	14	0.049	0.044	0.036	0.034
	16	0.054	0.049	0.041	0.038
	20	0.066	0.059	0.049	0.046
ap x ae	**≤ D5**	0.5D x D	0.5D x D	0.25D x D	0.25D x D

	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3	P5 M2 M3 K4 S1 S4	S2 S3 S5
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²	≤35 HRC	≤40 HRC
	ap x ae	**1.5D x 0.5D**	**1.5D x 0.5D**	**1.2D x 0.3D**	**1.2D x 0.3D**
	Vc (m/min)	**130÷150**	**90÷110**	**60÷80**	**40÷60**
SIDE MILLING	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	3	0.015	0.014	0.012	0.017
	4	0.020	0.018	0.016	0.022
	5	0.025	0.022	0.020	0.027
	6	0.029	0.026	0.023	0.032
	8	0.038	0.034	0.030	0.042
	10	0.045	0.041	0.036	0.050
	12	0.052	0.047	0.041	0.057
	14	0.058	0.052	0.047	0.064
	16	0.065	0.058	0.052	0.071
	20	0.079	0.071	0.063	0.087
ap x ae	**≤ D5**	1.5D x 0.25D	1.5D x 0.25D	1.2D x 0.1D	1.2D x 0.1D

	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3	P5 M2 M3 K4 S1 S4	S2 S3 S5
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²	≤35 HRC	≤40 HRC
	α° x ae	**5° x 0.4D**	**5° x 0.4D**	**3° x 0.4D**	**3° x 0.4D**
	Vc (m/min)	**110÷130**	**70÷90**	**50÷70**	**30÷50**
HELICAL	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	3	0.009	0.009	0.008	0.007
	4	0.012	0.011	0.010	0.009
	5	0.015	0.014	0.012	0.012
	6	0.018	0.016	0.015	0.014
	8	0.023	0.021	0.019	0.018
	10	0.028	0.026	0.023	0.021
	12	0.031	0.029	0.026	0.024
	14	0.035	0.033	0.029	0.027
	16	0.039	0.037	0.032	0.030
	20	0.048	0.045	0.039	0.037
α° x ae	**≤ D5**	2° x 0.4D	2° x 0.4D	1° x 0.4D	1° x 0.4D

	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3	P5 M2 M3 K4 S1 S4	S2 S3 S5
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²	≤35 HRC	≤40 HRC
	α° x ae	**15° x D**	**10° x D**	**5° x D**	**5° x D**
	Vc (m/min)	**100÷120**	**60÷80**	**45÷65**	**30÷40**
RAMPING	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	6	0.019	0.018	0.017	0.023
	8	0.025	0.023	0.022	0.030
	10	0.030	0.028	0.026	0.036
	12	0.034	0.032	0.030	0.042
	14	0.039	0.036	0.034	0.047
	16	0.043	0.040	0.038	0.052
	20	0.052	0.048	0.046	0.063

	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3		
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²		
	α° x ae	**30° x D**	**15° x D**		
	Vc (m/min)	**80÷100**	**50÷70**		
RAMPING	D (mm)	fz (mm/z)	fz (mm/z)		
	10	0.025	0.023		
	12	0.028	0.026		
	14	0.032	0.029		
	16	0.035	0.032		
	20	0.043	0.039		

HF443 – 36°/39° Eckradius

Artikelbezeichnung	ER	Ø	l	L1	L	D(h6)	Z	NETTO PREIS
HF44303030	0.30	3	9	15	57	6	4	CHF. 18.10
HF44305030	0.50	3	9	15	57	6	4	CHF. 18.10
HF44303040	0.30	4	11	18	57	6	4	CHF. 18.10
HF44305040	0.50	4	11	18	57	6	4	CHF. 18.10
HF44305060	0.50	6	13	20	57	6	4	CHF. 18.10
HF44310060	1.00	6	13	20	57	6	4	CHF. 18.10
HF44305080	0.50	8	20	26	64	8	4	CHF. 23.80
HF44310080	1.00	8	20	26	64	8	4	CHF. 23.80
HF44305100	0.50	10	22	30	72	10	4	CHF. 35.10
HF44310100	1.00	10	22	30	72	10	4	CHF. 35.10
HF44305120	0.50	12	26	36	83	12	4	CHF. 45.30
HF44310120	1.00	12	26	36	83	12	4	CHF. 45.30
HF44310160	1.00	16	32	42	92	16	4	CHF. 78.90

HF443

	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3	P5 M2 M3 K4 S1 S4	S2 S3 S5
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²	≤35 HRC	≤40 HRC
	ap x ae	**D x D**	**D x D**	**0.5D x D**	**0.5D x D**
	Vc (m/min)	**110÷130**	**70÷90**	**50÷70**	**30÷50**
SLOTTING	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	3	0.013	0.011	0.009	0.009
	4	0.017	0.015	0.012	0.012
	5	0.021	0.019	0.016	0.014
	6	0.024	0.022	0.018	0.017
	8	0.032	0.028	0.024	0.022
	10	0.038	0.034	0.028	0.026
	12	0.043	0.039	0.032	0.030
	14	0.049	0.044	0.036	0.034
	16	0.054	0.049	0.041	0.038
	18	0.059	0.053	0.045	0.042
	20	0.066	0.059	0.049	0.046
ap x ae	**≤ D5**	0.5D x D	0.5D x D	0.25D x D	0.25D x D

	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3		
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²		
	ap x ae	**1.5D x D**	**1.5D x D**		
	Vc (m/min)	**85÷105**	**55÷75**		
SLOTTING	D (mm)	fz (mm/z)	fz (mm/z)		
	8	0.025	0.023		
	10	0.030	0.027		
	12	0.035	0.031		
	14	0.039	0.035		
	16	0.043	0.039		
	18	0.048	0.043		
	20	0.053	0.047		

	Material Group ISO 513	P1 P2 P7 K1			
	Hardness/Rm	≤700 N/mm²			
	ap x ae	**2D x D**			
	Vc (m/min)	**60÷80**			
SLOTTING	D (mm)	fz (mm/z)			
	10	0.023			
	12	0.026			
	14	0.029			
	16	0.032			
	18	0.036			
	20	0.039			

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	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3	P5 M2 M3 K4 S1 S4	S2 S3 S5
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²	≤35 HRC	≤40 HRC
	ap x ae	**1.5D x 0.5D**	**1.5D x 0.5D**	**1.2D x 0.3D**	**1.2D x 0.3D**
	Vc (m/min)	**130÷150**	**90÷110**	**60÷80**	**40÷60**
SIDE MILLING	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	3	0.015	0.014	0.012	0.017
	4	0.020	0.018	0.016	0.022
	5	0.025	0.022	0.020	0.027
	6	0.029	0.026	0.023	0.032
	8	0.038	0.034	0.030	0.042
	10	0.045	0.041	0.036	0.050
	12	0.052	0.047	0.041	0.057
	14	0.058	0.052	0.047	0.064
	16	0.065	0.058	0.052	0.071
	18	0.071	0.064	0.057	0.078
	20	0.079	0.071	0.063	0.087
ap x ae	**≤ D5**	1.5D x 0.25D	1.5D x 0.25D	1.2D x 0.1D	1.2D x 0.1D

	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3	P5 M2 M3 K4 S1 S4	S2 S3 S5
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²	≤35 HRC	≤40 HRC
	α° x ae	**5° x 0.4D**	**4° x 0.4D**	**3° x 0.4D**	**3° x 0.4D**
	Vc (m/min)	**110÷130**	**70÷90**	**50÷70**	**30÷50**
HELICAL	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	3	0.009	0.009	0.008	0.007
	4	0.012	0.011	0.010	0.009
	5	0.015	0.014	0.012	0.012
	6	0.018	0.016	0.015	0.014
	8	0.023	0.021	0.019	0.018
	10	0.028	0.026	0.023	0.021
	12	0.031	0.029	0.026	0.024
	14	0.035	0.033	0.029	0.027
	16	0.039	0.037	0.032	0.030
	18	0.043	0.040	0.036	0.033
	20	0.048	0.045	0.039	0.037
α° x ae	**≤ D5**	2° x 0.4D	2° x 0.4D	1° x 0.4D	1° x 0.4D

	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3	P5 M2 M3 K4 S1 S4	S2 S3 S5
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²	≤35 HRC	≤40 HRC
	α° x ae	**15° x D**	**10° x D**	**5° x D**	**5° x D**
	Vc (m/min)	**100÷120**	**60÷80**	**45÷65**	**30÷40**
RAMPING	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	6	0.019	0.018	0.017	0.023
	8	0.025	0.023	0.022	0.030
	10	0.030	0.028	0.026	0.036
	12	0.034	0.032	0.030	0.042
	14	0.039	0.036	0.034	0.047
	16	0.043	0.040	0.038	0.052
	18	0.047	0.044	0.042	0.057
	20	0.052	0.048	0.046	0.063

HF443

	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3		
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²		
	α° x ae	**30° x D**	**15° x D**		
RAMPING	Vc (m/min)	**80÷100**	**50÷70**		
	D (mm)	fz (mm/z)	fz (mm/z)		
	10	0.025	0.023		
	12	0.028	0.026		
	14	0.032	0.029		
	16	0.035	0.032		
	18	0.039	0.036		
	20	0.043	0.039		

	Material Group ISO 513	P1 P2 P7 K1			
	Hardness/Rm	≤700 N/mm²			
	α° x ae	**45° x D**			
RAMPING	Vc (m/min)	**60÷80**			
	D (mm)	fz (mm/z)			
	10	0.024			
	12	0.028			
	14	0.031			
	16	0.035			
	18	0.038			
	20	0.042			

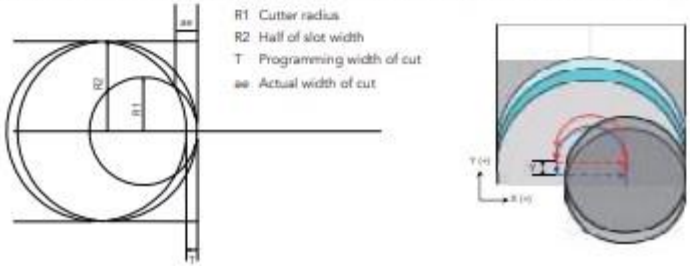
	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3	P5 M2 M3 K4 S1 S4	S2 S3 S5
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²	≤35 HRC	≤40 HRC
	ap x ae	**D x 0.4D**	**D x 0.4D**	**D x 0.25D**	**D x 0.25D**
VERTICAL	Vc (m/min)	**100÷120**	**60÷80**	**45÷65**	**30÷40**
	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	6	0.024	0.022	0.018	0.017
	8	0.032	0.028	0.024	0.022
	10	0.038	0.034	0.028	0.026
	12	0.043	0.039	0.032	0.030
	14	0.049	0.044	0.036	0.034
	16	0.054	0.049	0.041	0.038
	18	0.059	0.053	0.045	0.042
	20	0.066	0.059	0.049	0.046

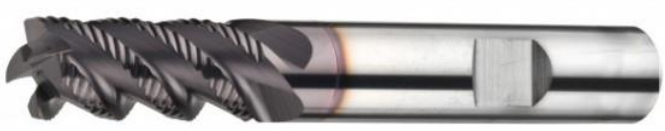
HF443

	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3	P5 M2 M3 K4 S1 S4	S2 S3 S5
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²	≤35 HRC	≤40 HRC
	ap x ae	**D x D**	**D x D**	**0.5D x D**	**0.5D x D**
	Vc (m/min)	**85÷105**	**55÷75**	**40÷60**	**20÷40**
DRILLING	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	3	0.006	0.006	0.005	0.007
	4	0.008	0.007	0.007	0.009
	5	0.010	0.009	0.008	0.011
	6	0.012	0.011	0.010	0.013
	8	0.016	0.014	0.013	0.017
	10	0.019	0.017	0.015	0.021
	12	0.022	0.019	0.017	0.024
	14	0.024	0.022	0.019	0.027
	16	0.027	0.024	0.022	0.030
	18	0.030	0.027	0.024	0.033
	20	0.033	0.030	0.026	0.036
ap x ae	**≤ D5**	0.5D x D	0.5D x D	0.25D x D	0.25D x D

	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3	P5 M2 M3 K4 S1 S4	S2 S3 S5
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²	≤35 HRC	≤40 HRC
	ap x ae	**2D x 0.2D**	**2D x 0.1D**	**1.5D x 0.1D**	**1.5D x 0.1D**
	Vc (m/min)	**160÷200**	**110÷130**	**80÷100**	**50÷70**
TROCHOIDAL	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	3	0.032	0.028	0.025	0.035
	4	0.042	0.037	0.033	0.046
	5	0.052	0.047	0.041	0.057
	6	0.061	0.055	0.049	0.067
	8	0.079	0.071	0.063	0.087
	10	0.095	0.085	0.076	0.104
	12	0.108	0.097	0.086	0.119
	14	0.122	0.109	0.097	0.134
	16	0.135	0.122	0.108	0.149
	18	0.149	0.134	0.119	0.163
	20	0.164	0.148	0.131	0.181
ap x ae	**≤ D5**	1.5D x 0.1D	1.5D x 0.1D		

NOTES:
Down milling CNC programming is required.
"ae" value max 0.2xD - "T" value max 0.1xD.
The use of end mill with diameter 30-40% smaller than the width of the slot is recommended.
The cutting conditions are based on CNC programming with medium dynamic speed.
With lower CNC dynamic speed, use the same cutting conditions or reduce the cutting speed Vc.
With higher CNC dynamic speed, reduce the "T" value by approximately -30 -50% and apply the maximum available cutting speed Vc.





HF445 – 36°/39° Schruppfräser HR

Artikelbezeichnung	EF 45°	Ø	l	L1	L	D(h6)	Z	NETTO PREIS
HF445060	0.10	6	13	20	57	6	4	***CHF. 28.00***
HF445080	0.20	8	20	26	64	8	4	***CHF. 29.60***
HF445100	0.20	10	22	30	72	10	4	***CHF. 42.20***
HF445120	0.20	12	26	36	83	12	4	***CHF. 59.20***
HF445140	0.20	14	26	36	83	14	4	***CHF. 72.70***
HF445160	0.30	16	32	42	92	16	4	***CHF. 89.20***
HF445200	0.40	20	38	50	104	20	4	***CHF. 143.10***

HF445

SLOTTING	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3	P5 M2 M3 K4 S1 S4	S2 S3 S5
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²	≤35 HRC	≤40 HRC
	ap x ae	**D x D**	**D x D**	**0.5D x D**	**0.5D x D**
	Vc (m/min)	**110÷130**	**70÷90**	**50÷70**	**30÷50**
	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	6	0.026	0.024	0.020	0.018
	8	0.034	0.031	0.026	0.024
	10	0.041	0.037	0.031	0.029
	12	0.047	0.042	0.035	0.033
	14	0.052	0.047	0.039	0.037
	16	0.058	0.052	0.044	0.041
	20	0.071	0.064	0.053	0.050

SLOTTING	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3		
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²		
	ap x ae	**1.5D x D**	**1.5D x D**		
	Vc (m/min)	**85÷105**	**55÷75**		
	D (mm)	fz (mm/z)	fz (mm/z)		
	8	0.027	0.024		
	10	0.033	0.029		
	12	0.037	0.034		
	14	0.042	0.038		
	16	0.047	0.042		
	20	0.057	0.051		

SLOTTING	Material Group ISO 513	P1 P2 P7 K1			
	Hardness/Rm	≤700 N/mm²			
	ap x ae	**2D x D**			
	Vc (m/min)	**60÷80**			
	D (mm)	fz (mm/z)			
	10	0.024			
	12	0.028			
	14	0.031			
	16	0.035			
	20	0.043			

HF445

	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3	P5 M2 M3 K4 S1 S4	S2 S3 S5
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²	≤35 HRC	≤40 HRC
	ap x ae	**1.5D x 0.5D**	**1.5D x 0.5D**	**1.2D x 0.3D**	**1.2D x 0.3D**
	Vc (m/min)	**130÷150**	**90÷110**	**60÷80**	**40÷60**
SIDE MILLING	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	6	0.031	0.028	0.025	0.035
	8	0.041	0.037	0.033	0.045
	10	0.049	0.044	0.039	0.054
	12	0.056	0.050	0.045	0.062
	14	0.063	0.057	0.050	0.069
	16	0.070	0.063	0.056	0.077
	20	0.085	0.077	0.068	0.094

	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3	P5 M2 M3 K4 S1 S4	S2 S3 S5
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²	≤35 HRC	≤40 HRC
	α° x ae	**7° x 0.4D**	**5° x 0.4D**	**3° x 0.4D**	**3° x 0.4D**
	Vc (m/min)	**110÷130**	**70÷90**	**50÷70**	**30÷50**
HELICAL	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	6	0.018	0.017	0.016	0.015
	8	0.024	0.022	0.020	0.019
	10	0.029	0.027	0.025	0.023
	12	0.033	0.031	0.028	0.026
	14	0.037	0.034	0.032	0.029
	16	0.041	0.038	0.035	0.033
	20	0.050	0.046	0.043	0.040

	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3	P5 M2 M3 K4 S1 S4	S2 S3 S5
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²	≤35 HRC	≤40 HRC
	α° x ae	**15° x D**	**10° x D**	**5° x D**	**5° x D**
	Vc (m/min)	**100÷120**	**60÷80**	**45÷65**	**30÷40**
RAMPING	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	8	0.027	0.025	0.024	0.033
	10	0.033	0.030	0.029	0.039
	12	0.037	0.034	0.033	0.045
	14	0.042	0.039	0.037	0.050
	16	0.047	0.043	0.041	0.056
	20	0.057	0.052	0.050	0.068

HF445

	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3		
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²		
	α° x ae	**30° x D**	**15° x D**		
RAMPING	Vc (m/min)	**80÷100**	**50÷70**		
	D (mm)	fz (mm/z)	fz (mm/z)		
	10	0.027	0.024		
	12	0.030	0.028		
	14	0.034	0.031		
	16	0.038	0.035		
	20	0.046	0.042		

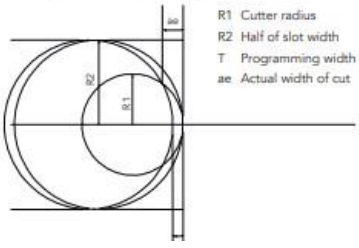
	Material Group ISO 513	P1 P2 P7 K1			
	Hardness/Rm	≤700 N/mm²			
	α° x ae	**45° x D**			
RAMPING	Vc (m/min)	**60÷80**			
	D (mm)	fz (mm/z)			
	10	0.026			
	12	0.030			
	14	0.034			
	16	0.038			
	20	0.046			

	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3	P5 M2 M3 K4 S1 S4	S2 S3 S5
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²	≤35 HRC	≤40 HRC
	ap x ae	**D x 0.4D**	**D x 0.4D**	**D x 0.25D**	**D x 0.25D**
VERTICAL	Vc (m/min)	**100÷120**	**60÷80**	**45÷65**	**30÷40**
	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	6	0.026	0.024	0.020	0.018
	8	0.034	0.031	0.026	0.024
	10	0.041	0.037	0.031	0.029
	12	0.047	0.042	0.035	0.033
	14	0.052	0.047	0.039	0.037
	16	0.058	0.052	0.044	0.041
	20	0.071	0.064	0.053	0.050

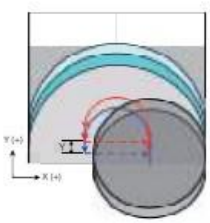
HF445

	Material Group ISO 513	P1 P2 P7 K1	P3 P4 M1 K2 K3	P5 M2 M3 K4 S1 S4	S2 S3 S5
	Hardness/Rm	≤700 N/mm²	600÷1000 N/mm²	≤35 HRC	≤40 HRC
	ap x ae	**2D x 0.2D**	**2D x 0.1D**	**1.5D x 0.1D**	**1.5D x 0.1D**
TROCHOIDAL	Vc (m/min)	**160÷200**	**110÷130**	**80÷100**	**50÷70**
	D (mm)	fz (mm/z)	fz (mm/z)	fz (mm/z)	fz (mm/z)
	6	0.066	0.059	0.052	0.072
	8	0.085	0.077	0.068	0.094
	10	0.102	0.092	0.082	0.112
	12	0.117	0.105	0.093	0.128
	14	0.131	0.118	0.105	0.144
	16	0.146	0.131	0.117	0.160
	20	0.177	0.160	0.142	0.195

NOTES:
Down milling CNC programming is required.
"ae" value max 0.2xD - "T" value max 0.1xD.
The use of end mill with diameter 30-40% smaller than the width of the slot is recommended.
The cutting conditions are based on CNC programming with medium dynamic speed.
With lower CNC dynamic speed, use the same cutting conditions or reduce the cutting speed Vc.
With higher CNC dynamic speed, reduce the "T" value by approximately -30 -50% and apply the maximum available cutting speed Vc.



R1 Cutter radius
R2 Half of slot width
T Programming width of cut
ae Actual width of cut



DAM VHM Mikrobohrer

P	M	K	N	S	H
★	★	★		★	

★ 1st choice ☆ suitable

Artikelbezeichnung	Ø	l	L	D	Z	NETTO PREIS
DAM 005	0.5	4.6	38	3	2	CHF. 17.10
DAM 006	0.6	4.8	38	3	2	CHF. 17.10
DAM 007	0.7	5	38	3	2	CHF. 17.10
DAM 008	0.8	5.2	38	3	2	CHF. 17.10
DAM 009	0.9	5.4	38	3	2	CHF. 17.10
DAM 010	1.0	6	38	3	2	CHF. 14.30
DAM 011	1.1	12	50	3	2	CHF. 14.30
DAM 012	1.2	12	50	3	2	CHF. 14.30
DAM 013	1.3	12	50	3	2	CHF. 14.30
DAM 014	1.4	12	50	3	2	CHF. 14.30
DAM 015	1.5	12	50	3	2	CHF. 14.30
DAM 016	1.6	12	50	3	2	CHF. 14.30
DAM 017	1.7	12	50	3	2	CHF. 14.30
DAM 018	1.8	12	50	3	2	CHF. 14.30
DAM 019	1.9	12	50	3	2	CHF. 14.30
DAM 020	2.0	12	50	3	2	CHF. 14.30
DAM 021	2.1	18	60	3	2	CHF. 16.20
DAM 022	2.2	18	60	3	2	CHF. 16.20
DAM 023	2.3	18	60	3	2	CHF. 16.20
DAM 024	2.4	18	60	3	2	CHF. 16.20
DAM 025	2.5	18	60	3	2	CHF. 16.20
DAM 026	2.6	18	60	3	2	CHF. 16.20
DAM 027	2.7	18	60	3	2	CHF. 16.20
DAM 028	2.8	18	60	3	2	CHF. 16.20
DAM 029	2.9	18	60	3	2	CHF. 16.20
DAM 030	3.0	18	60	3	2	CHF. 16.20

Trochoidalfräser mit Spanteiler

P	M	K	N	S	H
★	★	★		★	

★ 1st choice ☆ suitable

Artikelbezeichnung	Ø	l	L1	L	D(h6)	Z	NETTO PREIS
LEF 0605	6	18	-	60	6	5	***CHF. 21.00***
LEF 0605M	6	24	-	65	6	5	***CHF. 24.00***
LEF 0605L	6	30	-	75	6	5	***CHF. 30.00***
LEF 0805	8	24	-	75	8	5	***CHF. 35.30***
LEF 0805M	8	32	-	75	8	5	***CHF. 39.00***
LEF 0805L	8	40	-	100	8	5	***CHF. 45.80***
LEF 1005	10	30	-	80	10	5	***CHF. 46.50***
LEF 1005M	10	40	-	100	10	5	***CHF. 56.30***
LEF 1005L	10	50	-	100	10	5	***CHF. 60.00***
LEF 1205	12	36	-	100	12	5	***CHF. 69.80***
LEF 1205M	12	48	-	100	12	5	***CHF. 87.00***
LEF 1605	16	50	-	120	16	5	***CHF. 147.80***
LEF 1605L	16	70	-	150	16	5	***CHF. 180.80***

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