

62514



FRAISE ÉBAUCHE EN ACIER FRITTÉ

SCHRUPPFRÄSER AUS SINTERSTAHL

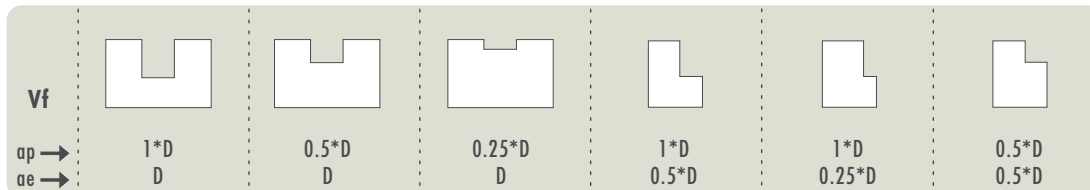
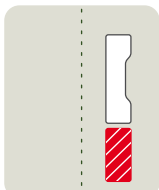
ROUGHING ENDMILL HSS POWDER METALLURGY

Vc (m/min)

Avance • Vorschub • Feed

Vf (mm/min)

3<D≤5: Vf*0.8
6<D<12: Vf
12<D: Vf*0.7



	Vc (m/min)	Avance (mm/min)	Vorschub (mm/min)	Feed (mm/min)	Vf (mm/min)	Vf (mm/min)
1a	56	130	220	260	220	310
1b	52	120	170	200	170	230
1c	49		160	180	160	210
1d	32		100	110	100	130
2a	40	90	130	140	130	170
2b	32		100	110	100	130
2c	24		70	80	70	100
3a						
3b						
4a						
4b						
5	80	130	200	230	200	270
6a	28	60	90	100	90	110
6b	24	50	70	80	70	100
7a	24		60	70	60	80
7b	16		40	40	40	50
8a	32		80	90	80	100
8b	24		40	40	40	50
9a	88	200	280	320	280	370
9b	60	140	190	220	190	250
10a	160	380	750	950	750	1050
10b	128	300	600	750	600	850
10c	72	170	340	420	340	490
11a	80	190	380	470	380	500
11b	80	190	380	470	380	500
12a	48	110	150	170	150	200
12b	48	110	150	170	150	200
13a	72	170	230	260	230	300
13b						