

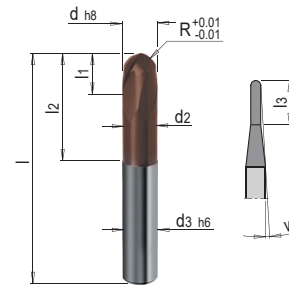


### PRODUKTBESCHREIBUNG

- » Hochleistungs-Fräser mit Zentrumsschnitt für 3D-Bearbeitung
- » Freigestellt nach der Schneide

### MATERIAL

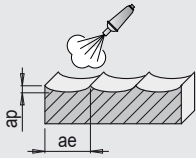
» VHM, TiAlSiN-beschichtet



| Z | d2   | d3 | l  | l1  | l2 | l3  | R   | w   | d  | Nr.          | EUR |
|---|------|----|----|-----|----|-----|-----|-----|----|--------------|-----|
| 2 | 1,8  | 6  | 57 | 3   | 20 | 6,2 | 1   | 5,7 | 2  | WZF 18416/ 2 | < > |
| 2 | 2,8  | 6  | 57 | 3,5 | 20 | 8,4 | 1,5 | 4,3 | 3  | WZF 18416/ 3 | < > |
| 2 | 3,8  | 6  | 57 | 4   | 20 | 9,4 | 2   | 2,9 | 4  | WZF 18416/ 4 | < > |
| 2 | 5,6  | 6  | 57 | 6   | 20 | -   | 3   | -   | 6  | WZF 18416/ 6 | < > |
| 2 | 7,6  | 8  | 63 | 7   | 26 | -   | 4   | -   | 8  | WZF 18416/ 8 | < > |
| 2 | 9,6  | 10 | 72 | 8   | 30 | -   | 5   | -   | 10 | WZF 18416/10 | < > |
| 2 | 11,5 | 12 | 83 | 10  | 35 | -   | 6   | -   | 12 | WZF 18416/12 | < > |

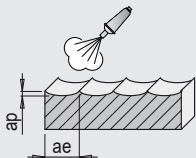
## RICHTWERTE SCHRUPPEN

| WZF 18416<br>WZF 18426 | Werkstoff              | Festigkeit | Vc <sup>1</sup><br>m/min. | d                      |       |       |       |       |       |    |
|------------------------|------------------------|------------|---------------------------|------------------------|-------|-------|-------|-------|-------|----|
|                        |                        |            |                           | 2                      | 3     | 4     | 6     | 8     | 10    | 12 |
|                        |                        |            |                           | fz <sup>2</sup> (mm/z) |       |       |       |       |       |    |
| 1.1730                 | 640 N/mm <sup>2</sup>  | 250        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2083                 | 780 N/mm <sup>2</sup>  | 165        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2083                 | 52 HRC                 | 120        | 0.020                     | 0.030                  | 0.035 | 0.040 | 0.050 | 0.070 | 0.080 |    |
| 1.2085                 | 1080 N/mm <sup>2</sup> | 165        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2162                 | 660 N/mm <sup>2</sup>  | 250        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2162                 | 52 HRC                 | 180        | 0.020                     | 0.030                  | 0.035 | 0.040 | 0.050 | 0.070 | 0.080 |    |
| 1.2311                 | 1080 N/mm <sup>2</sup> | 185        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2312                 | 1080 N/mm <sup>2</sup> | 190        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2316                 | 1010 N/mm <sup>2</sup> | 165        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2343                 | 780 N/mm <sup>2</sup>  | 200        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2343                 | 52 HRC                 | 180        | 0.020                     | 0.030                  | 0.035 | 0.040 | 0.050 | 0.070 | 0.080 |    |
| 1.2379                 | 780 N/mm <sup>2</sup>  | 165        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2714HH               | 1350 N/mm <sup>2</sup> | 165        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2767                 | 830 N/mm <sup>2</sup>  | 190        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2767                 | 52 HRC                 | 180        | 0.020                     | 0.030                  | 0.035 | 0.040 | 0.050 | 0.070 | 0.080 |    |
| 1.2842                 | 775 N/mm <sup>2</sup>  | 190        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| Stahl                  | 1400 N/mm <sup>2</sup> | 165        | 0.020                     | 0.030                  | 0.035 | 0.040 | 0.050 | 0.070 | 0.080 |    |
| ap (mm)                |                        |            | 0.10                      | 0.15                   | 0.20  | 0.40  | 0.60  | 0.75  | 1.00  |    |
| ae (mm)                |                        |            | 0.15                      | 0.15                   | 0.30  | 0.50  | 0.75  | 1.00  | 1.50  |    |



## RICHTWERTE SCHLICHTEN

| WZF 18416<br>WZF 18426 | Werkstoff              | Festigkeit | Vc <sup>1</sup><br>m/min. | d                      |       |       |       |       |       |    |
|------------------------|------------------------|------------|---------------------------|------------------------|-------|-------|-------|-------|-------|----|
|                        |                        |            |                           | 2                      | 3     | 4     | 6     | 8     | 10    | 12 |
|                        |                        |            |                           | fz <sup>2</sup> (mm/z) |       |       |       |       |       |    |
| 1.1730                 | 640 N/mm <sup>2</sup>  | 300        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2083                 | 780 N/mm <sup>2</sup>  | 280        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2083                 | 52 HRC                 | 180        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2085                 | 1080 N/mm <sup>2</sup> | 280        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2162                 | 660 N/mm <sup>2</sup>  | 300        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2162                 | 52 HRC                 | 200        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2311                 | 1080 N/mm <sup>2</sup> | 280        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2312                 | 1080 N/mm <sup>2</sup> | 280        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2316                 | 1010 N/mm <sup>2</sup> | 280        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2343                 | 780 N/mm <sup>2</sup>  | 300        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2343                 | 52 HRC                 | 200        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2379                 | 780 N/mm <sup>2</sup>  | 280        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2714HH               | 1350 N/mm <sup>2</sup> | 230        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2767                 | 830 N/mm <sup>2</sup>  | 300        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2767                 | 52 HRC                 | 200        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| 1.2842                 | 775 N/mm <sup>2</sup>  | 300        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| Stahl                  | 1400 N/mm <sup>2</sup> | 230        | 0.030                     | 0.040                  | 0.045 | 0.050 | 0.070 | 0.100 | 0.120 |    |
| ap (mm)                |                        |            | 0.05                      | 0.07                   | 0.10  | 0.14  | 0.16  | 0.18  | 0.20  |    |
| ae (mm)                |                        |            | 0.05                      | 0.05                   | 0.07  | 0.10  | 0.15  | 0.20  | 0.25  |    |



1) Vc: Schnittgeschwindigkeit (m/min.)

2) fz: Vorschub pro Schneide (mm/z)

**i** Weitere Materialien und Schnittwerte finden Sie im Schnittdaten-Kalkulator