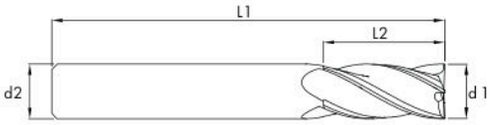
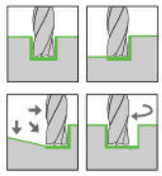
SOLID CARBIDE END MILLS

VOLLHARTMETALLFRÄSER

KARBÜR FREZE







BLITZ

<52 HRC

END MILL FRÄSER — TYPE

MG-10 — QUALITY

d1 — DIAMETER

DIN 6528 — NORM

4 FLUTES

DIN 6535 HA — SHAFT TYPE

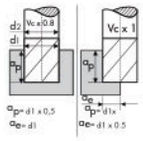
30° — HELICAL

CHAMFER

nACo MULTILAYER — COATED

d1(e8)	L2	L1	d2(h6)	Z	Uncoated Code	Coated Code
2	6	40	2-3	2	4000800	4000810
3	8	40	3	2	4000820	4000830
4	11	50	4	2	4000840	4000850
5	13	50	5	2	4000860	4000870
6	13	57	6	2	4000880	4000890
7	16	60	7	2	4000900	4000910
8	19	63	8	2	4000920	4000930
9	19	67	9	2	4000940	4000950
10	22	72	10	2	4000960	4000970
11	26	83	11	2	4000980	4000990
12	26	83	12	2	4001000	4001010
13	26	83	13	2	4001020	4001030
14	26	83	14	2	4001040	4001050
15	32	92	15	2	4001060	4001070
16	32	92	16	2	4001080	4001090
18	32	92	18	2	4001100	4001110
20	38	104	20	2	4001120	4001130
22	38	104	22	2	4001140	4001150
24	40	110	24	2	4001160	4001170
25	40	110	25	2	4001180	4001190
2	6	40	2-3	3	4000400	4000410
3	8	40	3	3	4000420	4000430
4	11	50	4	3	4000440	4000450
5	13	50	5	3	4000460	4000470
6	13	57	6	3	4000480	4000490
7	16	60	7	3	4000500	4000510
8	19	63	8	3	4000520	4000530
9	19	67	9	3	4000540	4000550
10	22	72	10	3	4000560	4000570
11	26	83	11	3	4000580	4000590

d1(e8)	L2	L1	d2(h6)	Z	Uncoated Code	Coated Code
12	26	83	12	3	4000600	4000610
13	26	83	13	3	4000620	4000630
14	26	83	14	3	4000640	4000650
15	32	92	15	3	4000660	4000670
16	32	92	16	3	4000680	4000690
18	32	92	18	3	4000700	4000710
20	38	104	20	3	4000720	4000730
22	38	104	22	3	4000740	4000750
24	40	110	24	3	4000760	4000770
25	40	110	25	3	4000780	4000790
2	6	40	2-3	4	4000000	4000010
3	8	40	3	4	4000020	4000030
4	11	50	4	4	4000040	4000050
5	13	50	5	4	4000060	4000070
6	13	57	6	4	4000080	4000090
7	16	60	7	4	4000100	4000110
8	19	63	8	4	4000120	4000130
9	19	67	9	4	4000140	4000150
10	22	72	10	4	4000160	4000170
11	26	83	11	4	4000180	4000190
12	26	83	12	4	4000200	4000210
13	26	83	13	4	4000220	4000230
14	26	83	14	4	4000240	4000250
15	32	92	15	4	4000260	4000270
16	32	92	16	4	4000280	4000290
18	32	92	18	4	4000300	4000310
20	38	104	20	4	4000320	4000330
22	38	104	22	4	4000340	4000350
24	40	110	24	4	4000360	4000370
25	40	110	25	4	4000380	4000390



	P (20-30 Hrc)	P (30-40 Hrc)	M	GG	AL	CU	Titan	< 52 HRC
	1.0050-2 1.0060-2 1.0070-2	"1.5864" 16580 1.7225	1.4405 1.4460 1.4505	0.6035 0.7080 0.8055	3.2151 3.2373 3.2382	"2.1247 2.0580 2.0598	3.7035 3.7055 3.7065	1.3255 1.3265 1.3333
	Vc = 100 m/dk.	Vc = 75 m/dk.	Vc = 55 m/dk.	Vc = 120 m/dk.	Vc = 300 m/dk.	Vc = 190 m/dk.	Vc = 50 m/dk.	Vc = 50 m/dk.

d1	ap	ae	fz	n	Vf	fz	n	Vf	fz	n	Vf	fz	n	Vf	fz	n	Vf	fz	n	Vf	fz	n	Vf	fz	n	Vf
2	1.0	1.0	0.012	15925	190XZ	0.014	11942	170xZ	0.013	8757	115xZ	0.031	19107	590xZ	0.023	47770	1100xZ	0.026	30255	785xZ	0,008	7960	65 xZ	0,007	7960	55 xZ
3	1.5	1.5	0.018	10616	190xZ	0.021	7962	170xZ	0.020	5838	115xZ	0.046	12738	590xZ	0.035	31846	1100xZ	0.039	20170	785xZ	0,012	5306	65 xZ	0,010	5306	55 xZ
4	2.0	2.0	0.024	7962	190xZ	0.028	5971	170xZ	0.026	4379	115xZ	0.062	9554	590xZ	0.046	23885	1100xZ	0.052	15127	785xZ	0,016	3980	65 xZ	0,014	3980	55 xZ
5	2.5	2.5	0.030	6370	190xZ	0.036	4777	170xZ	0.033	3503	115xZ	0.077	7643	590xZ	0.058	19108	1100xZ	0.065	12102	785xZ	0,020	3184	65 xZ	0,017	3184	55 xZ
6	3.0	3.0	0.036	5308	190xZ	0.043	3980	170xZ	0.039	2919	115xZ	0.093	6369	590xZ	0.069	15923	1100xZ	0.078	10085	785xZ	0,025	2653	65 xZ	0,020	2653	55 xZ
8	4.0	4.0	0.048	3981	190xZ	0.057	2985	170xZ	0.053	2189	115xZ	0.123	4777	590xZ	0.092	11942	1100xZ	0.104	7564	785xZ	0,033	1990	65 xZ	0,028	1990	55 xZ
10	5.0	5.0	0.060	3185	190xZ	0.071	2388	170xZ	0.066	1751	115xZ	0.154	3821	590xZ	0.115	9554	1100xZ	0.130	6051	785xZ	0,041	1592	65 xZ	0,035	1592	55 xZ
12	6.0	6.0	0.072	2654	190xZ	0.085	1990	170xZ	0.079	1460	115xZ	0.185	3185	590xZ	0.138	7962	1100xZ	0.156	5042	785xZ	0,049	1327	65 xZ	0,041	1327	55 xZ
14	7.0	7.0	0.083	2275	190xZ	0.100	1706	170xZ	0.092	1251	115xZ	0.216	2730	590xZ	0.161	6824	1100xZ	0.182	4322	785xZ	0,057	1137	65 xZ	0,048	1137	55 xZ
16	8.0	8.0	0.095	1990	190xZ	0.114	1493	170xZ	0.105	1095	115xZ	0.247	2388	590xZ	0.184	5971	1100xZ	0.207	3782	785xZ	0,065	995	65 xZ	0,055	995	55 xZ
18	9.0	9.0	0.108	1760	190xZ	0.118	1327	170xZ	0.118	973	115xZ	0.278	2123	590xZ	0.207	5308	1100xZ	0.233	3362	785xZ	0,073	885	65 xZ	0,062	885	55 xZ
20	10.0	10.0	0.119	1592	190xZ	0.131	1194	170xZ	0.131	875	115xZ	0.309	1910	590xZ	0.230	4777	1100xZ	0.260	3025	785xZ	0,082	796	65 xZ	0,069	796	55 xZ
25	12.5	12.5	0.149	1274	190xZ	0.164	955	170xZ	0.164	700	115xZ	0.386	1528	590xZ	0.288	3822	1100xZ	0.324	2420	785xZ	0,102	637	65 xZ	0.086	637	55 xZ