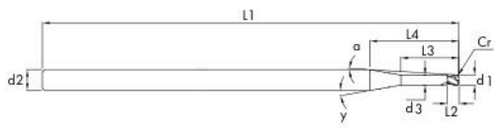
# SOLID CARBIDE END MILLS WITH CORNER RADIUS

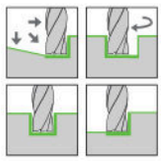
VOLLHARTMETALL SCHAFTFRASER MIT ECKENRADIUS LANG

KARBÜR KÖŞE RADYÜSLÜ FREZE UZUN ALUMIN CORNER LONG

HEIKENEI
wir produzieren industrielle lösungen





## ALUMIN CORNER LONG

<52 HRC



TYPE



QUALITY



DIAMETER



CORNER RADIUS


2 FLUTES



SHAFT TYPE



HELICAL



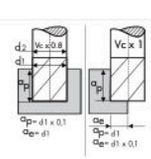
CORNER RADIUS



COATED

| d1 | L2 | L3 | L4 | d3 | L1 | d2 (h6) | Z | y° | a° | Cr | Coated Code |
|---|---|---|---|---|---|---|---|---|---|---|---|
| 0,5 | 0,8 | 1,0 | 15,55 | 0,48 | 80 | 4 | 2 | 7,00° | 6,42° | 0,10 | 4022950 |
| 0,5 | 0,8 | 2,0 | 12,18 | 0,48 | 80 | 4 | 2 | 10,00° | 8,17° | 0,10 | 4022960 |
| 0,5 | 0,8 | 4,0 | 14,18 | 0,48 | 80 | 4 | 2 | 10,00° | 7,03° | 0,10 | 4022970 |
| 0,5 | 0,8 | 6,0 | 16,18 | 0,48 | 80 | 4 | 2 | 10,00° | 6,17° | 0,10 | 4022980 |
| 0,6 | 0,9 | 1,2 | 15,35 | 0,57 | 80 | 4 | 2 | 10,00° | 6,32° | 0,10 | 4022990 |
| 0,6 | 0,9 | 2,0 | 11,95 | 0,57 | 80 | 4 | 2 | 10,00° | 8,09° | 0,10 | 4023000 |
| 0,6 | 0,9 | 4,0 | 13,95 | 0,57 | 80 | 4 | 2 | 10,00° | 6,94° | 0,10 | 4023010 |
| 0,6 | 0,9 | 8,0 | 17,95 | 0,57 | 80 | 4 | 2 | 10,00° | 5,41° | 0,10 | 4023020 |
| 0,7 | 1,1 | 1,4 | 15,18 | 0,67 | 80 | 4 | 2 | 7,00° | 6,20° | 0,10 | 4023030 |
| 0,7 | 1,1 | 2,5 | 12,21 | 0,67 | 80 | 4 | 2 | 10,00° | 7,69° | 0,10 | 4023040 |
| 0,7 | 1,1 | 5,0 | 14,71 | 0,67 | 80 | 4 | 2 | 10,00° | 6,40° | 0,10 | 4023050 |
| 0,7 | 1,1 | 8,0 | 17,71 | 0,67 | 80 | 4 | 2 | 10,00° | 5,32° | 0,10 | 4023060 |
| 0,8 | 1,2 | 1,6 | 11,10 | 0,76 | 80 | 4 | 2 | 10,00° | 8,20° | 0,15 | 4023070 |
| 0,8 | 1,2 | 3,0 | 12,50 | 0,76 | 80 | 4 | 2 | 10,00° | 7,29° | 0,15 | 4023080 |
| 0,8 | 1,2 | 6,0 | 15,50 | 0,76 | 80 | 4 | 2 | 10,00° | 5,89° | 0,15 | 4023090 |
| 0,8 | 1,2 | 10,0 | 19,50 | 0,76 | 80 | 4 | 2 | 10,00° | 4,69° | 0,15 | 4023100 |
| 1,0 | 1,5 | 2,0 | 11,01 | 0,95 | 80 | 4 | 2 | 10,00° | 7,75° | 0,20 | 4023110 |
| 1,0 | 1,5 | 4,0 | 13,01 | 0,95 | 80 | 4 | 2 | 10,00° | 6,57° | 0,20 | 4023120 |
| 1,0 | 1,5 | 8,0 | 17,01 | 0,95 | 80 | 4 | 2 | 10,00° | 5,03° | 0,20 | 4023130 |
| 1,0 | 1,5 | 12,0 | 21,01 | 0,95 | 80 | 4 | 2 | 10,00° | 4,08° | 0,20 | 4023140 |
| 1,0 | 1,5 | 16,0 | 25,01 | 0,95 | 80 | 4 | 2 | 10,00° | 3,43° | 0,20 | 4023150 |
| 1,0 | 1,5 | 20,0 | 29,01 | 0,95 | 80 | 4 | 2 | 10,00° | 2,96° | 0,20 | 4023160 |

| d1 | L2 | L3 | L4 | d3 | L1 | d2 (h6) | Z | y° | a° | Cr | Coated Code |
|---|---|---|---|---|---|---|---|---|---|---|---|
| 1,2 | 1,8 | 2,0 | 10,54 | 1,14 | 80 | 4 | 2 | 10,00° | 7,56° | 0,25 | 4023170 |
| 1,2 | 1,8 | 4,0 | 12,54 | 1,14 | 80 | 4 | 2 | 10,00° | 6,37° | 0,25 | 4023180 |
| 1,5 | 2,3 | 4,0 | 11,85 | 1,43 | 80 | 4 | 2 | 10,00° | 6,02° | 0,30 | 4023190 |
| 1,5 | 2,3 | 8,0 | 15,85 | 1,43 | 80 | 4 | 2 | 10,00° | 4,50° | 0,30 | 4023200 |
| 1,5 | 2,3 | 12,0 | 19,85 | 1,43 | 80 | 4 | 2 | 10,00° | 3,60° | 0,30 | 4023210 |
| 1,5 | 2,3 | 20,0 | 27,85 | 1,43 | 80 | 4 | 2 | 10,00° | 2,57° | 0,30 | 4023220 |
| 2,0 | 3,0 | 4,0 | 10,68 | 1,90 | 80 | 4 | 2 | 10,00° | 5,35° | 0,50 | 4023230 |
| 2,0 | 3,0 | 8,0 | 14,68 | 1,90 | 80 | 4 | 2 | 10,00° | 3,09° | 0,50 | 4023240 |
| 2,0 | 3,0 | 12,0 | 18,68 | 1,90 | 80 | 4 | 2 | 10,00° | 3,06° | 0,50 | 4023250 |
| 2,0 | 3,0 | 16,0 | 22,68 | 1,90 | 80 | 4 | 2 | 10,00° | 2,52° | 0,50 | 4023260 |
| 2,0 | 3,0 | 20,0 | 26,68 | 1,90 | 80 | 4 | 2 | 10,00° | 2,14° | 0,50 | 4023270 |
| 2,5 | 3,8 | 5,0 | 10,51 | 2,38 | 80 | 4 | 2 | 10,00° | 4,08° | 0,50 | 4023280 |
| 2,5 | 3,8 | 8,0 | 13,51 | 2,38 | 80 | 4 | 2 | 10,00° | 3,17° | 0,50 | 4023290 |
| 2,5 | 3,8 | 12,0 | 17,51 | 2,38 | 80 | 4 | 2 | 10,00° | 2,45° | 0,50 | 4023300 |
| 2,5 | 3,8 | 16,0 | 21,51 | 2,38 | 80 | 4 | 2 | 10,00° | 1,99° | 0,50 | 4023310 |
| 2,5 | 3,8 | 20,0 | 25,51 | 2,38 | 80 | 4 | 2 | 10,00° | 1,68° | 0,50 | 4023320 |
| 3,0 | 4,5 | 6,0 | 10,34 | 2,85 | 80 | 4 | 2 | 10,00° | 2,76° | 0,50 | 4023330 |
| 3,0 | 4,5 | 8,0 | 12,34 | 2,85 | 80 | 4 | 2 | 10,00° | 2,32° | 0,50 | 4023340 |
| 3,0 | 4,5 | 12,0 | 16,34 | 2,85 | 80 | 4 | 2 | 10,00° | 1,75° | 0,50 | 4023350 |
| 3,0 | 4,5 | 16,0 | 20,34 | 2,85 | 80 | 4 | 2 | 10,00° | 1,40° | 0,50 | 4023360 |
| 3,0 | 4,5 | 20,0 | 24,34 | 2,85 | 80 | 4 | 2 | 10,00° | 1,17° | 0,50 | 4023370 |




| | AL | | | CU | | | Graphit | | |
|---|---|---|---|---|---|---|---|---|---|
| | 3.2151<br>3.2373<br>3.2382 | | | 2.1247<br>2.0580<br>2.0598 | | | | | |
| | Vc = 460 m/dk. | | | Vc = 230 m/dk. | | | Vc = 500 m/dk. | | |
| dl | ap | ae | fz | n | Vf | fz | n | Vf | fz | n | Vf |
| 0.5 | 0.05 | 0.05 | 0.008 | 60000 | 960 | 0.010 | 60000 | 1200 | 0.005 | 60000 | 600 |
| 1.0 | 0.10 | 0.10 | 0.014 | 60000 | 1680 | 0.013 | 60000 | 1560 | 0.010 | 60000 | 1200 |
| 1.5 | 0.15 | 0.15 | 0.020 | 60000 | 2400 | 0.016 | 49000 | 1568 | 0.015 | 60000 | 1800 |
| 2.0 | 0.20 | 0.20 | 0.026 | 60000 | 3120 | 0.022 | 36800 | 1619 | 0.020 | 60000 | 2400 |
| 2.5 | 0.25 | 0.25 | 0.032 | 58800 | 3763 | 0.032 | 29400 | 1881 | 0.025 | 60000 | 3000 |
| 3.0 | 0.30 | 0.30 | 0.038 | 49000 | 3724 | 0.044 | 24500 | 2156 | 0.030 | 53300 | 3198 |