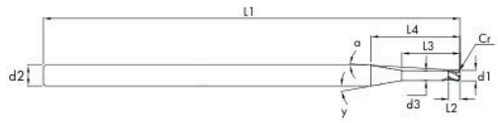
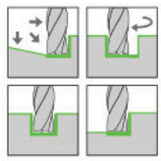
# SOLID CARBIDE END MILLS WITH CORNER RADIUS

VOLLHARTMETALL SCHAFTFRASER MIT ECKENRADIUS

KARBÜR KÖŞE RADYÜSLÜ FREZE UZUN DURAMINI CORNER LONG





## DURAMINI CORNER LONG

52-68 HRC

END MILL FRÄSER — TYPE

MG-08 — QUALITY

d1 — DIAMETER

HEIKENEI SPECIAL — CORNER RADIUS

2 FLUTES

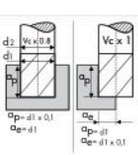
DIN 6535 HA — SHAFT TYPE

30° — HELICAL

R — CORNER RADIUS

nACo MULTILAYER — 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 | 4026010 |
| 0,5 | 0,8 | 2,0 | 12,18 | 0,48 | 80 | 4 | 2 | 10,00° | 8,17° | 0,10 | 4026020 |
| 0,5 | 0,8 | 4,0 | 14,18 | 0,48 | 80 | 4 | 2 | 10,00° | 7,03° | 0,10 | 4026030 |
| 0,5 | 0,8 | 6,0 | 16,18 | 0,48 | 80 | 4 | 2 | 10,00° | 6,17° | 0,10 | 4026040 |
| 0,6 | 0,9 | 1,2 | 15,35 | 0,57 | 80 | 4 | 2 | 10,00° | 6,32° | 0,10 | 4026050 |
| 0,6 | 0,9 | 2,0 | 11,95 | 0,57 | 80 | 4 | 2 | 10,00° | 8,09° | 0,10 | 4026060 |
| 0,6 | 0,9 | 4,0 | 13,95 | 0,57 | 80 | 4 | 2 | 10,00° | 6,94° | 0,10 | 4026070 |
| 0,6 | 0,9 | 8,0 | 17,95 | 0,57 | 80 | 4 | 2 | 10,00° | 5,41° | 0,10 | 4026080 |
| 0,7 | 1,1 | 1,4 | 15,18 | 0,67 | 80 | 4 | 2 | 7,00° | 6,20° | 0,10 | 4026090 |
| 0,7 | 1,1 | 2,5 | 12,21 | 0,67 | 80 | 4 | 2 | 10,00° | 7,69° | 0,10 | 4026100 |
| 0,7 | 1,1 | 5,0 | 14,71 | 0,67 | 80 | 4 | 2 | 10,00° | 6,40° | 0,10 | 4026110 |
| 0,7 | 1,1 | 8,0 | 17,71 | 0,67 | 80 | 4 | 2 | 10,00° | 5,32° | 0,10 | 4026120 |
| 0,8 | 1,2 | 1,6 | 11,10 | 0,76 | 80 | 4 | 2 | 10,00° | 8,20° | 0,15 | 4026130 |
| 0,8 | 1,2 | 3,0 | 12,50 | 0,76 | 80 | 4 | 2 | 10,00° | 7,29° | 0,15 | 4026140 |
| 0,8 | 1,2 | 6,0 | 15,50 | 0,76 | 80 | 4 | 2 | 10,00° | 5,89° | 0,15 | 4026150 |
| 0,8 | 1,2 | 10,0 | 19,50 | 0,76 | 80 | 4 | 2 | 10,00° | 4,69° | 0,15 | 4026160 |
| 1,0 | 1,5 | 2,0 | 11,01 | 0,95 | 80 | 4 | 2 | 10,00° | 7,75° | 0,20 | 4026170 |
| 1,0 | 1,5 | 4,0 | 13,01 | 0,95 | 80 | 4 | 2 | 10,00° | 6,57° | 0,20 | 4026180 |
| 1,0 | 1,5 | 8,0 | 17,01 | 0,95 | 80 | 4 | 2 | 10,00° | 5,03° | 0,20 | 4026190 |
| 1,0 | 1,5 | 12,0 | 21,01 | 0,95 | 80 | 4 | 2 | 10,00° | 4,08° | 0,20 | 4026200 |
| 1,0 | 1,5 | 16,0 | 25,01 | 0,95 | 80 | 4 | 2 | 10,00° | 3,43° | 0,20 | 4026210 |
| 1,0 | 1,5 | 20,0 | 29,01 | 0,95 | 80 | 4 | 2 | 10,00° | 2,96° | 0,20 | 4026220 |
| 1,2 | 1,8 | 2,0 | 10,54 | 1,14 | 80 | 4 | 2 | 10,00° | 7,56° | 0,25 | 4026230 |
| 1,2 | 1,8 | 4,0 | 12,54 | 1,14 | 80 | 4 | 2 | 10,00° | 6,37° | 0,25 | 4026240 |
| 1,5 | 2,3 | 4,0 | 11,85 | 1,43 | 80 | 4 | 2 | 10,00° | 6,02° | 0,30 | 4026250 |
| 1,5 | 2,3 | 8,0 | 15,85 | 1,43 | 80 | 4 | 2 | 10,00° | 4,50° | 0,30 | 4026260 |
| 1,5 | 2,3 | 12,0 | 19,85 | 1,43 | 80 | 4 | 2 | 10,00° | 3,60° | 0,30 | 4026270 |
| 1,5 | 2,3 | 20,0 | 27,85 | 1,43 | 80 | 4 | 2 | 10,00° | 2,57° | 0,30 | 4026280 |
| 2,0 | 3,0 | 4,0 | 10,68 | 1,90 | 80 | 4 | 4 | 10,00° | 5,35° | 0,50 | 4026290 |
| 2,0 | 3,0 | 8,0 | 14,68 | 1,90 | 80 | 4 | 4 | 10,00° | 3,09° | 0,50 | 4026300 |
| 2,0 | 3,0 | 12,0 | 18,68 | 1,90 | 80 | 4 | 4 | 10,00° | 3,06° | 0,50 | 4026310 |
| 2,0 | 3,0 | 16,0 | 22,68 | 1,90 | 80 | 4 | 4 | 10,00° | 2,52° | 0,50 | 4026320 |
| 2,0 | 3,0 | 20,0 | 26,68 | 1,90 | 80 | 4 | 4 | 10,00° | 2,14° | 0,50 | 4026330 |
| 2,5 | 3,8 | 5,0 | 10,51 | 2,38 | 80 | 4 | 4 | 10,00° | 4,08° | 0,50 | 4026340 |
| 2,5 | 3,8 | 8,0 | 13,51 | 2,38 | 80 | 4 | 4 | 10,00° | 3,17° | 0,50 | 4026350 |
| 2,5 | 3,8 | 12,0 | 17,51 | 2,38 | 80 | 4 | 4 | 10,00° | 2,45° | 0,50 | 4026360 |
| 2,5 | 3,8 | 16,0 | 21,51 | 2,38 | 80 | 4 | 4 | 10,00° | 1,99° | 0,50 | 4026370 |
| 2,5 | 3,8 | 20,0 | 25,51 | 2,38 | 80 | 4 | 4 | 10,00° | 1,68° | 0,50 | 4026380 |
| 3,0 | 4,5 | 6,0 | 10,34 | 2,85 | 80 | 4 | 4 | 10,00° | 2,76° | 0,50 | 4026390 |
| 3,0 | 4,5 | 8,0 | 12,34 | 2,85 | 80 | 4 | 4 | 10,00° | 2,32° | 0,50 | 4026400 |
| 3,0 | 4,5 | 12,0 | 16,34 | 2,85 | 80 | 4 | 4 | 10,00° | 1,75° | 0,50 | 4026410 |
| 3,0 | 4,5 | 16,0 | 20,34 | 2,85 | 80 | 4 | 4 | 10,00° | 1,40° | 0,50 | 4026420 |
| 3,0 | 4,5 | 20,0 | 24,34 | 2,85 | 80 | 4 | 4 | 10,00° | 1,17° | 0,50 | 4026430 |




| | | | < 50 HRC | | | < 53 HRC | | | < 56 HRC | | | < 59 HRC | | | < 61 HRC | | | < 63 HRC | | | < 65 HRC | | | < 68 HRC | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | 1.5860-1.6587<br>1.6587-1.7326 | | | 1.1520 - 1.1525<br>1.1545 - 1.1820 | | | 1.2002 - 1.2003<br>1.2082 - 1.2344 | | | 1.1563 - 1.2004<br>1.2056 - 1.2057 | | | 1.2365 - 1.2379<br>1.2601 - 1.2622 | | | 1.3343 - 1.3344<br>1.3348 - 1.3355 | | | 1.3302 - 1.3318<br>1.3333 - 1.3334 | | | 1.2067 - 1.3343<br>1.3344 - 1.3355 | | |
| | | | Vc = 45 m/dk. | | | Vc = 42 m/dk. | | | Vc = 39 m/dk. | | | Vc = 36 m/dk. | | | Vc = 33 m/dk. | | | Vc = 30 m/dk. | | | Vc = 27 m/dk. | | | Vc = 24 m/dk. | | |
| dl | 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 |
| 0.5 | 0.5 | 0.05 | 0.006 | 28800 | 346 | 0.005 | 26880 | 269 | 0.006 | 24960 | 300 | 0.005 | 23040 | 230 | 0.005 | 21120 | 211 | 0.005 | 19200 | 192 | 0.004 | 17280 | 138 | 0.004 | 15360 | 123 |
| 1.0 | 1.0 | 0.10 | 0.009 | 14400 | 259 | 0.009 | 13440 | 242 | 0.009 | 12480 | 225 | 0.007 | 11520 | 161 | 0.007 | 10560 | 148 | 0.006 | 9600 | 115 | 0.005 | 8640 | 86 | 0.005 | 7680 | 77 |
| 1.5 | 1.5 | 0.15 | 0.012 | 9600 | 230 | 0.012 | 8960 | 215 | 0.012 | 8320 | 200 | 0.009 | 7680 | 138 | 0.010 | 7040 | 141 | 0.008 | 6400 | 102 | 0.006 | 5760 | 69 | 0.006 | 5120 | 61 |
| 2.0 | 2.0 | 0.20 | 0.015 | 7200 | 216 | 0.015 | 6720 | 202 | 0.015 | 6240 | 187 | 0.011 | 5760 | 127 | 0.012 | 5280 | 127 | 0.009 | 4800 | 86 | 0.008 | 4320 | 69 | 0.007 | 3840 | 54 |
| 2.5 | 2.5 | 0.25 | 0.019 | 5760 | 219 | 0.019 | 5376 | 204 | 0.019 | 4992 | 190 | 0.013 | 4608 | 120 | 0.015 | 4224 | 127 | 0.011 | 3840 | 84 | 0.009 | 3456 | 62 | 0.008 | 3072 | 49 |
| 3.0 | 3.0 | 0.30 | 0.023 | 4800 | 221 | 0.023 | 4480 | 206 | 0.023 | 4160 | 191 | 0.015 | 3840 | 115 | 0.017 | 3520 | 120 | 0.013 | 3200 | 83 | 0.010 | 2880 | 58 | 0.009 | 2560 | 46 |