

### PRODUKTBESCHREIBUNG

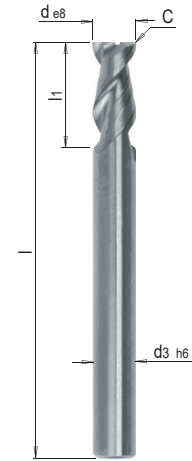
- » Hochleistungs-Fräser für Aluwerkstoffe
- » Mit Zentrumschnitt

### MATERIAL

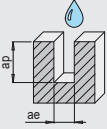
» VHM, poliert



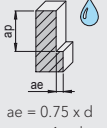
Z	d3	l	C	l1	d	Nr.	EUR
2	6	57	0,03	7	3	WZF 12846/ 3	<>
2	6	57	0,03	8	4	WZF 12846/ 4	<>
2	6	57	0,03	10	5	WZF 12846/ 5	<>
2	6	57	0,03	10	6	WZF 12846/ 6	<>
2	8	63	0,05	16	8	WZF 12846/ 8	<>
2	10	72	0,05	19	10	WZF 12846/10	<>
2	12	83	0,1	22	12	WZF 12846/12	<>



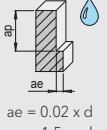
## RICHTWERTE NUTEN

WZF 12846	Werkstoff	Festigkeit	Vc <sup>1</sup> m/min.	d						
				3	4	5	6	8	10	12
				fz <sup>2</sup> (mm/z)						
 <p>ae = 1 x d ap = 1 x d</p>	3.3547 / EN AW-5083	270N/mm <sup>2</sup>	300	0.019	0.025	0.030	0.037	0.050	0.065	0.078
	3.4365 / EN AW-7075	520N/mm <sup>2</sup>	300	0.019	0.025	0.030	0.037	0.050	0.065	0.078
	Kupfer	280N/mm <sup>2</sup>	175	0.010	0.017	0.021	0.025	0.034	0.046	0.055
	Buntmetalle	< 800N/mm <sup>2</sup>	175	0.010	0.017	0.021	0.025	0.034	0.046	0.055

## RICHTWERTE SCHRUPPEN

WZF 12846	Werkstoff	Festigkeit	Vc <sup>1</sup> m/min.	d						
				3	4	5	6	8	10	12
				fz <sup>2</sup> (mm/z)						
 <p>ae = 0.75 x d ap = 1 x d</p>	3.3547 / EN AW-5083	270N/mm <sup>2</sup>	350	0.021	0.029	0.036	0.043	0.057	0.075	0.090
	3.4365 / EN AW-7075	520N/mm <sup>2</sup>	350	0.021	0.029	0.036	0.043	0.057	0.075	0.090
	Kupfer	280N/mm <sup>2</sup>	290	0.014	0.019	0.024	0.029	0.039	0.053	0.063
	Buntmetalle	< 800N/mm <sup>2</sup>	290	0.014	0.019	0.024	0.029	0.039	0.053	0.063

## RICHTWERTE SCHLICHTEN

WZF 12846	Werkstoff	Festigkeit	Vc <sup>1</sup> m/min.	d						
				3	4	5	6	8	10	12
				fz <sup>2</sup> (mm/z)						
 <p>ae = 0.02 x d ap = 1.5 x d</p>	3.3547 / EN AW-5083	270N/mm <sup>2</sup>	600	0.020	0.027	0.034	0.041	0.055	0.072	0.086
	3.4365 / EN AW-7075	520N/mm <sup>2</sup>	600	0.020	0.027	0.034	0.041	0.055	0.072	0.086
	Kupfer	280N/mm <sup>2</sup>	500	0.014	0.018	0.023	0.028	0.037	0.051	0.061
	Buntmetalle	< 800N/mm <sup>2</sup>	500	0.014	0.018	0.023	0.028	0.037	0.051	0.061

1) Vc: Schnittgeschwindigkeit (m/min.)

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