

Einsatzwerte VHM Schruppfräser (Art.-Nr. 1016734 101-106)



| ae x D | ap x D | Faktor |
|--------|--------|--------|
| 0.1 | 99 | 1 |
| 0.25 | 1.5 | 0.8 |
| 0.25 | 1 | 0.7 |
| 0.75 | 0.75 | 0.5 |
| 1 | 0.5 | 0.4 |

| Materialgruppen für Schnittwerte | Festigkeit [N/mm ²] | Bezeichnung nach DIN | Vc [m/min] | fz [mm/Z] bei Durchmesser | | | |
|---------------------------------------|------------------------------------|-------------------------|---------------|---------------------------|------------|------------|------------|
| | | | | 0.5-1 | 1-1.5 | 1.5-2 | 2-2.5 |
| 3. NE-Metalle | | | | | | | |
| 3.1 Aluminium, langspanend | <500 | Al99.9 | 400-550 | 0.009-0.016 | 0.016-0.03 | 0.03-0.035 | 0.035-0.04 |
| 3.2 Aluminium, kurzspanend | <500 | G-AlSi12 | 180-320 | 0.009-0.016 | 0.016-0.03 | 0.03-0.035 | 0.035-0.04 |
| 3.3 Kupferleg. Bronze langspanend | <1200 | CuSn4 | 250-420 | 0.009-0.016 | 0.016-0.03 | 0.03-0.035 | 0.035-0.04 |
| 3.4 Kupferleg. Bronze kurzspanend | <850 | CuNi12Zn24 | 180-320 | 0.009-0.016 | 0.016-0.03 | 0.03-0.035 | 0.035-0.04 |
| 3.5 Kupferleg. Messing langspanend | <600 | Cu Zn 20 | 250-420 | 0.009-0.016 | 0.016-0.03 | 0.03-0.035 | 0.035-0.04 |
| 3.6 Kupferleg. Messing kurzspanend | <600 | Cu Zn 39 Pb 3 | 180-320 | 0.009-0.016 | 0.016-0.03 | 0.03-0.035 | 0.035-0.04 |
| 3.7 Thermoplastic | <100 | PVC, Acrylglas | 400-550 | 0.009-0.016 | 0.016-0.03 | 0.03-0.035 | 0.035-0.04 |
| 3.8 Duroplast | <150 | Bakelit, Melamin | 300-450 | 0.009-0.016 | 0.016-0.03 | 0.03-0.035 | 0.035-0.04 |
| 3.9 Faserverstärkte Kunststoffe | <1500 | CFK, GFK | 250-420 | 0.009-0.016 | 0.016-0.03 | 0.03-0.035 | 0.035-0.04 |
| 3.10 Graphite | <60 | C8000 | | | | | |
| 3.11 Verbundwerkstoffe | | | | | | | |

