

Einsatzwerte Walzenstirnfräser HSSE (Co5) (Art.-Nr. 1017478 101-105)



| ae x D | ap x D | Faktor |
|--------|--------|--------|
| 0.1 | 2 | 1 |
| 0.5 | 1 | 0.8 |
| 0.5 | 0.5 | 0.5 |

| Materialgruppen für Schnittwerte | Festigkeit [N/mm²] | Bezeichnung nach DIN | Vc [m/min] | fz [mm/Z] bei Durchmesser | |
|-------------------------------------|-----------------------|-------------------------|---------------|---------------------------|--|
| | | | | 40-100 | |
| 1. Stähle | | | | | |
| 1.1 | < 900 | 9 S 20 | 50-60 | 0.18-0.2 | |
| 1.2 | <500 | ST 37-2 | 50-60 | 0.18-0.2 | |
| 1.3 | > 500 | ST 60-2 | 40-50 | 0.13-0.15 | |
| 1.4 | <1000 | 42 CrMo 4 | 40-50 | 0.13-0.15 | |
| 1.5 | <1000 | GS-45 | 30-40 | 0.1-0.12 | |
| 1.6 | <1200 | 16 MnCr 5 | 40-55 | 0.15-0.18 | |
| 1.7 | <1100 | X 10 Cr 13 | 20-30 | 0.13-0.15 | |
| 1.8 | >1000 | 43 CrMo 4 | 30-35 | 0.1-0.12 | |
| 1.9 | <1300 | 31 CrMoV 9 | 30-35 | 0.1-0.12 | |
| 1.10 | <1300 | X 38 CrMoV 5 1 | 30-35 | 0.1-0.12 | |
| 2. Rostfreie Stähle | | | | | |
| 2.1 | <1100 | G-X 2 CrNiMo 18 15 | 30-40 | 0.13-0.15 | |
| 3. NE-Metalle | | | | | |
| 3.1 | <500 | Al99.9 | 200-400 | 0.15-0.2 | |
| 3.2 | <500 | G-AlSi12 | 100-120 | 0.15-0.2 | |
| 3.3 | <1200 | CuSn4 | 50-70 | 0.1-0.12 | |
| 3.4 | <850 | CuNi12Zn24 | 50-70 | 0.1-0.12 | |
| 3.5 | <600 | Cu Zn 20 | 90-100 | 0.16-0.18 | |
| 3.6 | <600 | Cu Zn 39 Pb 3 | 70-75 | 0.14-0.15 | |
| 3.7 | <100 | PVC, Acrylglas | 150-170 | 0.13-0.15 | |
| 3.8 | <150 | Bakelit, Melamin | 80-100 | 0.1-0.12 | |
| 3.9 | <1500 | CFK, GFK | 40-50 | 0.1-0.12 | |
| 3.10 | <60 | C8000 | | | |
| 3.11 | | | | | |
| 4. Guss | | | | | |
| 4.1 | <260 HB | GG10 | 50-60 | 0.16-0.18 | |
| 4.2 | <310 HB | GGG 40 | 50-60 | 0.16-0.18 | |
| 4.3 | <280 HB | GTW-55 | 50-60 | 0.16-0.18 | |
| 5. Sonderlegierungen | | | | | |
| 5.1 | <1200 | TiAl5Sn2,5 | 10-25 | 0.08-0.11 | |
| 5.2 | <1400 | NiCr21Mo | 10-20 | 0.08-0.11 | |
| 5.3 | <1400 | X45CrSi 9 3 | 10-20 | 0.08-0.11 | |

