

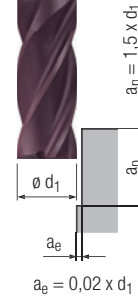
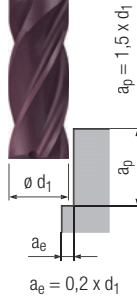
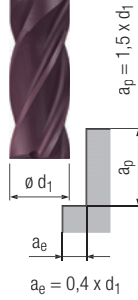
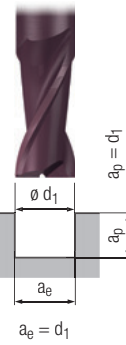
- Product Finder
- NR
- NF
- N
- HF
- H
- WR
- WF
- W
- V_c / f_z**



Hartmetall-Schafffräser – lange Ausführung

Solid carbide end mills – long design

N



Gültig für · Valid for

1813A	1999A	2698A
1864A	1999AZ	2698AZ
1998A	2512A	2699A
1998AS	2513A	2699AZ
1998AT	2518A	
1998AZ	2519A	

	V_c [m/min]	f_z [mm]	V_c [m/min]	f_z [mm]	V_c [m/min]	f_z [mm]	V_c [m/min]	f_z [mm]
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P	1.1	140	$0,005 \times d_1$	150	$0,005 \times d_1$	170	$0,006 \times d_1$	200	$0,007 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.1	130	$0,004 \times d_1$	140	$0,005 \times d_1$	160	$0,005 \times d_1$	180	$0,006 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	3.1	110	$0,004 \times d_1$	120	$0,004 \times d_1$	130	$0,005 \times d_1$	150	$0,005 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	4.1	100	$0,003 \times d_1$	110	$0,003 \times d_1$	120	$0,004 \times d_1$	140	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	5.1	90	$0,003 \times d_1$	100	$0,003 \times d_1$	110	$0,003 \times d_1$	130	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
M	1.1	70	$0,003 \times d_1$	80	$0,003 \times d_1$	80	$0,004 \times d_1$	100	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.1	60	$0,003 \times d_1$	70	$0,003 \times d_1$	70	$0,004 \times d_1$	80	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	3.1	40	$0,002 \times d_1$	40	$0,003 \times d_1$	50	$0,003 \times d_1$	60	$0,003 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	4.1	30	$0,002 \times d_1$	30	$0,003 \times d_1$	40	$0,003 \times d_1$	40	$0,003 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
K	1.1	140	$0,005 \times d_1$	150	$0,006 \times d_1$	170	$0,006 \times d_1$	200	$0,007 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	1.2	140	$0,005 \times d_1$	150	$0,006 \times d_1$	170	$0,006 \times d_1$	200	$0,007 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	2.1	130	$0,004 \times d_1$	140	$0,005 \times d_1$	160	$0,005 \times d_1$	180	$0,006 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	2.2	130	$0,004 \times d_1$	140	$0,005 \times d_1$	160	$0,005 \times d_1$	180	$0,006 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	3.1	110	$0,004 \times d_1$	120	$0,005 \times d_1$	130	$0,005 \times d_1$	150	$0,006 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	3.2	110	$0,004 \times d_1$	120	$0,005 \times d_1$	130	$0,005 \times d_1$	150	$0,006 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	4.1	90	$0,003 \times d_1$	100	$0,003 \times d_1$	110	$0,004 \times d_1$	130	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	4.2	70	$0,003 \times d_1$	80	$0,003 \times d_1$	80	$0,004 \times d_1$	100	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
N	1.1	430	$0,009 \times d_1$	470	$0,010 \times d_1$	520	$0,011 \times d_1$	600	$0,013 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	1.2	430	$0,008 \times d_1$	470	$0,009 \times d_1$	520	$0,010 \times d_1$	600	$0,011 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	1.3	430	$0,007 \times d_1$	470	$0,008 \times d_1$	520	$0,009 \times d_1$	600	$0,010 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	1.4	290	$0,008 \times d_1$	320	$0,009 \times d_1$	350	$0,010 \times d_1$	410	$0,011 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	1.5	270	$0,007 \times d_1$	300	$0,008 \times d_1$	320	$0,009 \times d_1$	380	$0,010 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	1.6	190	$0,006 \times d_1$	210	$0,007 \times d_1$	230	$0,008 \times d_1$	270	$0,008 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.1	130	$0,005 \times d_1$	140	$0,006 \times d_1$	160	$0,006 \times d_1$	180	$0,007 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.2	130	$0,005 \times d_1$	140	$0,006 \times d_1$	160	$0,006 \times d_1$	180	$0,007 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.3	130	$0,005 \times d_1$	140	$0,006 \times d_1$	160	$0,006 \times d_1$	180	$0,007 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.4	120	$0,004 \times d_1$	130	$0,005 \times d_1$	140	$0,005 \times d_1$	170	$0,006 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.5	120	$0,004 \times d_1$	130	$0,005 \times d_1$	140	$0,005 \times d_1$	170	$0,006 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.6	120	$0,004 \times d_1$	130	$0,005 \times d_1$	140	$0,005 \times d_1$	170	$0,006 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.7	70	$0,003 \times d_1$	80	$0,003 \times d_1$	80	$0,004 \times d_1$	100	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	2.8	70	$0,003 \times d_1$	80	$0,003 \times d_1$	80	$0,004 \times d_1$	100	$0,004 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	3.1	290	$0,009 \times d_1$	320	$0,010 \times d_1$	350	$0,011 \times d_1$	410	$0,013 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
	3.2	290	$0,007 \times d_1$	320	$0,008 \times d_1$	350	$0,009 \times d_1$	410	$0,010 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>
4.1	290	$0,008 \times d_1$	320	$0,009 \times d_1$	350	$0,009 \times d_1$	410	$0,011 \times d_1$	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
4.2	430	$0,008 \times d_1$	470	$0,009 \times d_1$	520	$0,009 \times d_1$	600	$0,011 \times d_1$			<input type="checkbox"/>	<input checked="" type="checkbox"/>	
4.3													
4.4													
5.1													
5.2	70	$0,003 \times d_1$	80	$0,003 \times d_1$	80	$0,004 \times d_1$	100	$0,004 \times d_1$				<input checked="" type="checkbox"/>	
5.3													
S	1.1	70	$0,004 \times d_1$	80	$0,004 \times d_1$	80	$0,004 \times d_1$	100	$0,005 \times d_1$				<input checked="" type="checkbox"/>
	1.2	60	$0,003 \times d_1$	70	$0,003 \times d_1$	70	$0,004 \times d_1$	80	$0,004 \times d_1$				<input checked="" type="checkbox"/>
	1.3	40	$0,003 \times d_1$	40	$0,003 \times d_1$	50	$0,003 \times d_1$	60	$0,004 \times d_1$				<input checked="" type="checkbox"/>
	2.1	60	$0,002 \times d_1$	70	$0,002 \times d_1$	70	$0,003 \times d_1$	80	$0,003 \times d_1$				<input checked="" type="checkbox"/>
	2.2	20	$0,002 \times d_1$	20	$0,002 \times d_1$	15	$0,003 \times d_1$	30	$0,003 \times d_1$				<input checked="" type="checkbox"/>
	2.3	20	$0,002 \times d_1$	25	$0,002 \times d_1$	25	$0,003 \times d_1$	30	$0,003 \times d_1$				<input checked="" type="checkbox"/>
	2.4	20	$0,002 \times d_1$	25	$0,002 \times d_1$	25	$0,003 \times d_1$	30	$0,003 \times d_1$				<input checked="" type="checkbox"/>
2.5	20	$0,002 \times d_1$	20	$0,002 \times d_1$	20	$0,003 \times d_1$	30	$0,003 \times d_1$				<input checked="" type="checkbox"/>	
2.6	20	$0,002 \times d_1$	20	$0,002 \times d_1$	20	$0,003 \times d_1$	30	$0,003 \times d_1$				<input checked="" type="checkbox"/>	
H	1.1	90	$0,003 \times d_1$	100	$0,003 \times d_1$	110	$0,003 \times d_1$	130	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	1.2	70	$0,003 \times d_1$	80	$0,003 \times d_1$	80	$0,003 \times d_1$	100	$0,004 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	1.3			70	$0,003 \times d_1$	70	$0,003 \times d_1$	80	$0,003 \times d_1$	<input type="checkbox"/>	<input checked="" type="checkbox"/>		
	1.4												
	1.5												

- Product Finder
- NR
- NF
- N
- HF
- H
- WR
- WF
- W
- v_c / f_z

Wegweiser

Bitte beachten:

Die Eignung der Hartmetall-Schaft- und Langlochfräser ist folgendermaßen gekennzeichnet:

- = sehr gut geeignet
- = gut geeignet

Die zugehörigen Schnittwerte sind auf den Seiten 70 - 91 zu finden.

Product finder

Please note:

The suitability of the solid carbide end mills and slot drills is indicated as follows:

- = very suitable
- = suitable

Please find the cutting conditions on pages 70 - 91.



		Einsatzgebiete – Material Applications – material		Material-Beispiele Material examples	Material-Nummern Material numbers
P	Stahlwerkstoffe		Steel materials		
	1.1	Kaltfließpressstähle, Baustähle, Automatenstähle, u.a.	Cold-extrusion steels, Construction steels, Free-cutting steels, etc.	≤ 600 N/mm ²	Cq15 1.1132 S235JR (St37-2) 1.0037 10SPb20 1.0722 E360 (St70-2) 1.0070 16MnCr5 1.7131 GS-25CrMo4 1.7218
	2.1	Baustähle, Einsatzstähle, Stahlguss, u.a.	Construction steels, Case-hardened steels, Steel castings, etc.	≤ 800 N/mm ²	20MoCr3 1.7320 42CrMo4 1.7225 102Cr6 1.2067 50CrMo4 1.7228 X45NiCrMo4 1.2767 31CrMo12 1.8515
	3.1	Einsatzstähle, Vergütungsstähle, Kaltarbeitsstähle, u.a.	Case-hardened steels, Heat-treatable steels, Cold work steels, etc.	≤ 1000 N/mm ²	X38CrMoV5-3 1.2367 X100CrMoV8-1-1 1.2990 X40CrMoV5-1 1.2344
	4.1	Vergütungsstähle, Kaltarbeitsstähle, Nitrierstähle, u.a.	Heat-treatable steels, Cold work steels, Nitriding steels, etc.	≤ 1200 N/mm ²	
5.1	Hochlegierte Stähle, Kaltarbeitsstähle, Warmarbeitsstähle, u.a.	High-alloyed steels, Cold work steels, Hot work steels, etc.	≤ 1400 N/mm ²		
M	Nichtrostende Stahlwerkstoffe		Stainless steel materials		
	1.1	Ferritisch, martensitisch	Ferritic, martensitic	≤ 950 N/mm ²	X2CrTi12 1.4512
	2.1	Austenitisch	Austenitic	≤ 950 N/mm ²	X6CrNiMoTi17-12-2 1.4571
	3.1	Austenitisch-ferritisch (Duplex)	Austenitic-ferritic (Duplex)	≤ 1100 N/mm ²	X2CrNiMoN22-5-3 1.4462
4.1	Austenitisch-ferritisch hitzebeständig (Super Duplex)	Austenitic-ferritic heat-resistant (Super Duplex)	≤ 1250 N/mm ²	X2CrNiMoN25-7-4 1.4410	
K	Gusswerkstoffe		Cast materials		
	1.1	Gusseisen mit Lamellengrafit (GJL)	Cast iron with lamellar graphite (GJL)	100-250 N/mm ²	EN-GJL-200 (GG20) EN-JL-1030
	1.2	Gusseisen mit Kugelgrafit (GJS)	Cast iron with nodular graphite (GJS)	250-450 N/mm ²	EN-GJL-300 (GG30) EN-JL-1050
	2.1	Gusseisen mit Kugelgrafit (GJS)	Cast iron with nodular graphite (GJS)	350-500 N/mm ²	EN-GJS-400-15 (GGG40) EN-JS-1030
	2.2	Gusseisen mit Kugelgrafit (GJS)	Cast iron with nodular graphite (GJS)	500-900 N/mm ²	EN-GJS-700-2 (GGG70) EN-JS-1070
	3.1	Gusseisen mit Vermiculargrafit (GJV)	Cast iron with vermicular graphite (GJV)	300-400 N/mm ²	GJV 300
	3.2	Gusseisen mit Vermiculargrafit (GJV)	Cast iron with vermicular graphite (GJV)	400-500 N/mm ²	GJV 450
4.1	Temperguss (GTMW, GTMB)	Malleable cast iron (GTMW, GTMB)	250-500 N/mm ²	EN-GJMW-350-4 (GTW-35) EN-JM-1010	
4.2	Temperguss (GTMW, GTMB)	Malleable cast iron (GTMW, GTMB)	500-800 N/mm ²	EN-GJMB-450-6 (GTS-45) EN-JM-1140	
N	Nichteisenwerkstoffe		Non-ferrous materials		
	Aluminium-Legierungen		Aluminium alloys		
	1.1	Aluminium-Knetlegierungen	Wrought aluminium alloys	≤ 200 N/mm ²	EN AW-ALMn1 EN AW-3103
	1.2	Aluminium-Knetlegierungen	Wrought aluminium alloys	≤ 350 N/mm ²	EN AW-ALMgSi EN AW-6060
	1.3	Aluminium-Knetlegierungen	Wrought aluminium alloys	≤ 550 N/mm ²	EN AW-AlZn5Mg3Cu EN AW-7022
	1.4	Aluminium-Knetlegierungen	Wrought aluminium alloys	Si ≤ 7%	EN AC-ALMg5 EN AC-51300
	1.5	Aluminium-Gusslegierungen	Aluminium cast alloys	7% < Si ≤ 12%	EN AC-AISi9Cu3 EN AC-46500
	1.6	Aluminium-Gusslegierungen	Aluminium cast alloys	12% < Si ≤ 17%	GD-AISI17Cu4FeMg
	Kupfer-Legierungen		Copper alloys		
	2.1	Reinkupfer, niedriglegiertes Kupfer	Pure copper, low-alloyed copper	≤ 400 N/mm ²	E-Cu 57 EN CW 004 A
	2.2	Kupfer-Zink-Legierungen (Messing, langspanend)	Copper-zinc alloys (brass, long-chipping)	≤ 550 N/mm ²	CuZn37 (Ms63) EN CW 508 L
	2.3	Kupfer-Zink-Legierungen (Messing, kurzspanend)	Copper-zinc alloys (brass, short-chipping)	≤ 550 N/mm ²	CuZn36Pb3 (Ms58) EN CW 603 N
	2.4	Kupfer-Aluminium-Legierungen (Alubronze, langspanend)	Copper-aluminium alloys (alu bronze, long-chipping)	≤ 800 N/mm ²	CuAl10Ni5Fe4 EN CW 307 G
	2.5	Kupfer-Zinn-Legierungen (Zinnbronze, langspanend)	Copper-tin alloys (tin bronze, long-chipping)	≤ 700 N/mm ²	CuSn8P EN CW 459 K
	2.6	Kupfer-Zinn-Legierungen (Zinnbronze, kurzspanend)	Copper-tin alloys (tin bronze, short-chipping)	≤ 400 N/mm ²	CuSn7 ZnPb (Rg7) 2.1090
	2.7	Kupfer-Sonderlegierungen	Special copper alloys	≤ 600 N/mm ²	(Ampco 8)
2.8	Kupfer-Sonderlegierungen	Special copper alloys	≤ 1400 N/mm ²	(Ampco 45)	
Magnesium-Legierungen		Magnesium alloys			
3.1	Magnesium-Knetlegierungen	Magnesium wrought alloys	≤ 500 N/mm ²	MgAl6Zn 3.5612	
3.2	Magnesium-Gusslegierungen	Magnesium cast alloys	≤ 500 N/mm ²	EN-MCMgAl9Zn1 EN-MC21120	
Kunststoffe		Synthetics			
4.1	Duroplaste (kurzspanend)	Duroplastics (short-chipping)		Bakelit, Pertinax	
4.2	Thermoplaste (langspanend)	Thermoplastics (long-chipping)		PMMA, POM, PVC	
4.3	Faserverstärkte Kunststoffe (Faseranteil ≤ 30%)	Fibre-reinforced synthetics (fibre content ≤ 30%)		GFK, CFK, AFK	
4.4	Faserverstärkte Kunststoffe (Faseranteil > 30%)	Fibre-reinforced synthetics (fibre content > 30%)		GFK, CFK, AFK	
Besondere Werkstoffe		Special materials			
5.1	Grafit	Graphite		C 8000	
5.2	Wolfram-Kupfer-Legierungen	Tungsten-copper alloys		W-Cu 80/20	
5.3	Verbundwerkstoffe	Composite materials		Hyllite, Alucobond	
S	Spezialwerkstoffe		Special materials		
	Titan-Legierungen		Titanium alloys		
	1.1	Reintitan	Pure titanium	≤ 450 N/mm ²	Ti1 3.7025
	1.2	Titan-Legierungen	Titanium alloys	≤ 900 N/mm ²	TiAl6V4 3.7165
	1.3	Titan-Legierungen	Titanium alloys	≤ 1250 N/mm ²	TiAl4Mo4Sn2 3.7185
	Nickel-, Kobalt- und Eisen-Legierungen		Nickel alloys, cobalt alloys and iron alloys		
	2.1	Reinnickel	Pure nickel	≤ 600 N/mm ²	Ni 99.6 2.4060
	2.2	Nickel-Basis-Legierungen	Nickel-base alloys	≤ 1000 N/mm ²	Monel 400 2.4360
	2.3	Nickel-Basis-Legierungen	Nickel-base alloys	≤ 1600 N/mm ²	Inconel 718 2.4668
	2.4	Nickel-Basis-Legierungen	Nickel-base alloys	≤ 1000 N/mm ²	Udimet 605
2.5	Kobalt-Basis-Legierungen	Cobalt-base alloys	≤ 1600 N/mm ²	Haynes 25 2.4964	
2.6	Eisen-Basis-Legierungen	Iron-base alloys	≤ 1500 N/mm ²	Incoloy 800 1.4958	
H	Harte Werkstoffe		Hard materials		
	1.1	Hochfeste Stähle, gehärtete Stähle, Hartguss	High strength steels, hardened steels, hard castings	44 - 50 HRC	Weldox 1100
	1.2	Hochfeste Stähle, gehärtete Stähle, Hartguss	High strength steels, hardened steels, hard castings	50 - 55 HRC	Hardox 550
	1.3	Hochfeste Stähle, gehärtete Stähle, Hartguss	High strength steels, hardened steels, hard castings	55 - 60 HRC	Armax 600T
	1.4	Hochfeste Stähle, gehärtete Stähle, Hartguss	High strength steels, hardened steels, hard castings	60 - 63 HRC	Ferro-Titanit
1.5	Hochfeste Stähle, gehärtete Stähle, Hartguss	High strength steels, hardened steels, hard castings	63 - 66 HRC	HSSE	