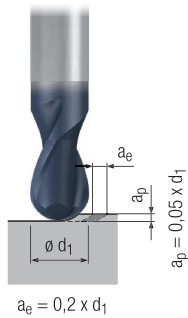
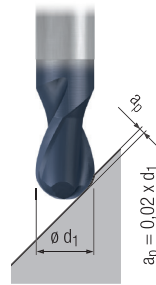



Hartmetall-Kugelfräser – extra kurze, lange und extra lange Ausführung
 Solid carbide ball nose end mills – extra short, long and extra long design

N

 Schruppen
 Roughing

 Schlichten
 Finishing


Gültig für · Valid for

 RG18-20A
 MED-Ti.RD4S
 MED-Ti.RD4L

		V_c [m/min]	f_z [mm]	V_c [m/min]	f_z [mm]			MMS MQL	
P	1.1	200	$0,014 \times d_1$	270	$0,010 \times d_1$	☐	☒	☐	☒
	2.1	170	$0,013 \times d_1$	230	$0,009 \times d_1$	☐	☒	☐	☒
	3.1	140	$0,011 \times d_1$	200	$0,008 \times d_1$	☐	☒	☐	☐
	4.1	110	$0,010 \times d_1$	160	$0,007 \times d_1$	☐	☒	☐	☐
	5.1	100	$0,008 \times d_1$	130	$0,006 \times d_1$	☐	☒	☐	☐
M	1.1	100	$0,008 \times d_1$	130	$0,006 \times d_1$			☐	☒
	2.1	80	$0,008 \times d_1$	110	$0,006 \times d_1$			☐	☒
	3.1	60	$0,006 \times d_1$	80	$0,005 \times d_1$			☐	☒
	4.1	40	$0,006 \times d_1$	60	$0,005 \times d_1$			☐	☒
K	1.1	200	$0,014 \times d_1$	270	$0,010 \times d_1$	☐	☒		☐
	1.2	200	$0,014 \times d_1$	270	$0,010 \times d_1$	☐	☒		☐
	2.1	180	$0,011 \times d_1$	230	$0,008 \times d_1$	☐	☒		☐
	2.2	180	$0,011 \times d_1$	230	$0,008 \times d_1$	☐	☒		☐
	3.1	140	$0,011 \times d_1$	200	$0,008 \times d_1$	☐	☒		☐
	3.2	140	$0,011 \times d_1$	200	$0,008 \times d_1$	☐	☒		☐
	4.1	110	$0,008 \times d_1$	160	$0,006 \times d_1$	☐	☒		☐
	4.2	100	$0,008 \times d_1$	130	$0,006 \times d_1$	☐	☒		☐
N	1.1								
	1.2								
	1.3								
	1.4								
	1.5								
	1.6								
	2.1	180	$0,014 \times d_1$	230	$0,010 \times d_1$			☐	☒
	2.2	180	$0,014 \times d_1$	230	$0,010 \times d_1$			☐	☒
	2.3	180	$0,014 \times d_1$	230	$0,010 \times d_1$	☐	☐	☐	☒
	2.4	140	$0,011 \times d_1$	200	$0,008 \times d_1$			☐	☒
	2.5	140	$0,011 \times d_1$	200	$0,008 \times d_1$			☐	☒
	2.6	140	$0,011 \times d_1$	200	$0,008 \times d_1$	☐	☐	☐	☒
	2.7	90	$0,008 \times d_1$	120	$0,006 \times d_1$			☐	☒
	2.8	90	$0,008 \times d_1$	120	$0,006 \times d_1$			☐	☒
	3.1	400	$0,025 \times d_1$	500	$0,018 \times d_1$	☐	☐	☐	☒
	3.2	400	$0,020 \times d_1$	500	$0,014 \times d_1$	☐	☐	☐	☒
	4.1	290	$0,020 \times d_1$	400	$0,015 \times d_1$		☐	☐	☒
	4.2	430	$0,020 \times d_1$	580	$0,015 \times d_1$		☐	☐	☒
	4.3								
	4.4								
	5.1								
	5.2	100	$0,008 \times d_1$	130	$0,006 \times d_1$			☐	☒
	5.3	180	$0,017 \times d_1$	270	$0,012 \times d_1$	☐	☒		☒
S	1.1	100	$0,010 \times d_1$	130	$0,007 \times d_1$			☐	☒
	1.2	80	$0,008 \times d_1$	110	$0,006 \times d_1$			☐	☒
	1.3	40	$0,007 \times d_1$	60	$0,005 \times d_1$			☐	☒
	2.1	70	$0,008 \times d_1$	100	$0,006 \times d_1$			☐	☒
	2.2	25	$0,006 \times d_1$	40	$0,004 \times d_1$			☐	☒
	2.3	25	$0,006 \times d_1$	30	$0,004 \times d_1$			☐	☒
	2.4	25	$0,006 \times d_1$	30	$0,004 \times d_1$			☐	☒
	2.5	15	$0,006 \times d_1$	25	$0,004 \times d_1$			☐	☒
	2.6	25	$0,006 \times d_1$	30	$0,004 \times d_1$			☐	☒
H	1.1								
	1.2								
	1.3								
	1.4								
	1.5								

 ■ = sehr gut geeignet · very suitable
 □ = gut geeignet · suitable

HM

